



CSU & FP

PLANT PURCHASE SPECIFICATION

FABRICATION PLANT

DEPARTMENT: PRODUCTION

NO.: BHEL/FP/TS/20

REV NO : 00

REV .DT :

Sheet 1 of 2

COMPRESSED OXYGEN GAS**1. SCOPE**

This specification governs the quality requirements of compressed oxygen gas.

2. APPLICATION

The gas shall be used cutting of steel as well as for other industrial applications.

3. CONDITION OF DELIVERY

The gas shall be supplied compressed in liquid form.

4. COMPLIANCE WITH NATIONAL STANDARDS

As per IS 309: 1992.

5. FREEDOM FROM CONTAMINATION

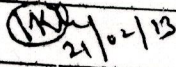
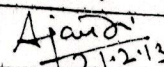
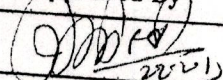
Oxygen gas shall have no free moisture and its dew point shall be minimum 0°C. There shall be no dew formation in the oxygen gas when kept at 0°C, when tested by the method Prescribed in Annex: "A" of IS 309: 1992.

6. PROPERTIES

When tested in accordance with Annex "B" of IS 309: 1992, the purity shall be minimum 99.5 % by volume.

7. INSPECTION

- BHEL reserves the right to witness the testing of the material at supplier works and therefore the supplier shall notify the readiness of the material in advance.
- BHEL may, at its discretion, test the material after receipt and acceptance of the material will be based on the BHEL'S test results.
- For any deviation from this specification prior approval shall be taken by the supplier.
- For result of analysis and properties of material the decision of BHEL shall be final and binding on the supplier.
- If the material is not conforming to this specification, it is liable to be rejected and the supplier shall replace the same.

	Prepared By	Checked by	Approved By
Signature :			
Name :	V K Choudhary, Engr.	Ajay Dwivedi, Sr. Engr.	A. Goswami, Sr. Mgr.
Date of Issue :	21.02.13		



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8. TEST CERTIFICATES

One Original and three copies of test certificate from the original manufacturer containing the following information should be provided:

Manufacturer's Name

Name of the material

Batch/ Lot No.

Quantity

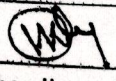
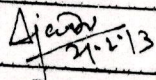
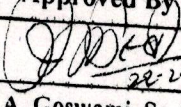
Note:

a) A manufacturer supplying directly to BHEL should include BHEL's P.O. No. and challan No. also in the TC.

b) Any other supplier should provide a covering letter along with **original** Manufacturer's TC as above mentioning BHEL's P. O. No. and Challan No.

9. PACKING AND MARKING

The gas shall be supplied compressed in liquid form in containers of approved design conforming to the requirements prescribed in "Gas Cylinder Rules, 1981". The Quantity of Oxygen gas packed shall be measured at 27°C and 760 mm of Hg and shall be expressed in cubic Meter. Packing should be such as to prevent loss / deterioration in quality during handling, Transport and storage. marking as per clause 5.2 of 309: 1992.

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Name :	V K Choudhary, Engr.	Ajay Dwivedi, Sr. Engr.	A. Goswami, Sr. Mgr.
Date of Issue :	21.02.13		22.2.13