

 Ranipet	Technical Delivery Condition(TDC) FOR WELDABLE FINE GRAIN STEEL PLATES NORMALISED (P355NH OF EN 10028-3)	Doc Ref:	TDC:RTP:311
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1.0 SCOPE

- 1.1 This TDC is applicable for weldable fine grain steel plates in normalized Condition to grade P 355 NH of EN 10028 Part 3.
- 1.2 Plates shall be supplied as per EN 10028-3. Only special requirement are specified in this TDC.

2.0 CHEMICAL& MECHANICAL PROPERTIES

- 2.1 Impact Test: This test shall be conducted at + 20° C.
- 2.2 Hot Tensile Test: This test shall be done at + 300°C
- 2.3 Through thickness Property: Z 35, test for reduction of area Perpendicular to plate's surface shall be done as per EN 10164 for Thickness > 15 and < 63 mm alone.
- 2.3.1 Chemistry shall be as per spec.

3.0 TOLERANCES

- 3.1 Tolerances on thickness shall be as per the table given below & other Tolerance shall be as per EN 10029.

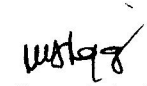
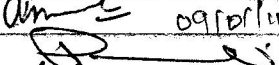
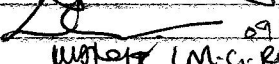
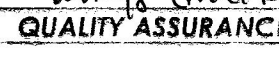
Thickness(mm)			Tolerances(mm)	
3	to	5	-0	to + 1.2
5	to	8	-0	to + 1.5
8	to	15	-0	to + 1.7
15	to	25	-0	to + 1.9
25	to	40	-0	to + 2.2
40	to	80	-0	to + 2.8

4.0 SOUNDNESS

- 4.1 All the plates shall be ultrasonically examined on surface and edge as Per EN 10160 and acceptance norms is E1 & S1 of EN10160.

5.0 PAINTING

- 5.1 Plates shall be painted with rust inhibitive painting to withstand marine corrosion
- 5.2 Melt No., plate no., specification and maker's emblem shall be hard stamped and stenciled on every plate.

Prepared by 	Reviewed by	signature	Approved by  (Head/QA) (M.C. RADASANICAR)
	Engg (Fns)		
	QC(Proc)		
	MPL.		
	PUR		
	QA	 (M.C. RADASANICAR)	
Issued by QUALITY ASSURANCE			

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6.0 SURFACE REQUIREMENTS:

- 6.1 Surface conditions shall be class B and repair
Condition shall be class B3 as per EN 10163-2.

7.0 INSPECTION & TEST CERTIFICATE

- 7.1 The items manufactured within India, shall be subjected to inspection by
BHEL or authorized agency.
- 7.2 Test certificate for the following properties shall be submitted as per 3.1
Of EN 10204,

a	Chemistry	Melt wise
b	Tensile properties	Melt wise and heat treatment batch wise.
c	Impact properties	
d	Internal soundness	As per cll no 4.1
e	Elevated temperature (+ 300 deg C) yield strength)	As per cl 2.2

Rev No	Clause revised	Revision made	Date
00	--	Original issue	29 05 95
01	5.0	Amendment requirements included & painting requirements added	17 01 00
02	--	Totally modified	02 05 02
03	5.1,5.2	Modified based on discussions	15 05 09