

	TECHNICAL DELIVERY CONDITIONS (TDC) For Carbon Steel Plates	Doc Ref:	TDC:RTA:407
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1.0 SCOPE :

- 1.1 This TDC specifies the requirements for supply of Plates to material specification ASTM A515 GR.65./GR70 / ASTM A516 GR.70.

2.0 Chemical & Mechanical properties:

- 2.1 Shall be as per specification.

3.0 Supply Condition:

- 3.1 If the plates are supplied in gas cut condition, plate thickness above 50mm shall be Preheated to 110° C before gas cutting.
- 3.2 Repair by fusion welding is prohibited.
- 3.3 The out of flatness shall be within ^{RTA} 2mm/meter.
- 3.4 The steel shall be fully killed.

PREPARED BY	REVIEWED BY	SIGNATURE	APPROVED BY
J. Chitti ly.	ENGG (APH)		 (HEAD / QA)
	PURCHASE		
	MPL		
	QC/PROC		
	QA		
Issued By Quality Assurance			

 RANIPET	TECHNICAL DELIVERY CONDITIONS (TDC) For Carbon Steel Plates	Doc Ref:	TDC:RTA:407
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4.0 Non destructive Testing & Acceptance

4.1 All the plates shall be Ultrasonically tested and accepted as per ASTM A578 level C.

5.0 MARKING:

5.1 Each plate shall be hard stamped and bordered with white paint within the following Information:

- P O No.& Date
- Size & Quantity
- Specification
- Melt number
- Maker's identification

6.0 TEST CERTIFICATES:

6.1 TC shall be in English and it shall contain

- Purchase Order Number and Date
- TDC Number
- Material Specification and Grade
- Drawing No (if applicable)
- Number & weight
- Chemical Composition – Each Melt wise
- Mechanical Properties – Each Melt wise
- Ultrasonic Testing Report – HT batch wise

7.0 BHEL reserves the right to carry out tests and reject the items wherever non conformance to the contract is noticed.

Rev. No	Date	Changes made
00	26 02 02	TDC RTA 007 / REV 02 is revised and renumbered as TDC RTA 407 / REV 00
01	10 05 02	TDC totally reviewed and revised
02	29 05 12	ASTM A516 GR.70 included. In Clause 3.1, Preheating temperature was changed to 110° C in place of 100° C In Clause 3.3, The out of flatness was changed to 1 mm/metre in place of 5 mm/metre. In clause 4.1, UT acceptance norm changed to ASTM A578 level C, inline with collaborator practice.