



PLANT PURCHASING SPECIFICATION

HY10498

REV. No. 01

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CARBON STEEL PRESURE VESSEL PLATES FOR LOW AND MODERATE TEMPERATURE SERVICE (ORDERING DESCRIPTION FOR ASME: SA516 GR 70)

1.0 GENERAL :

The material and other requirements shall comply with the latest versions of ASME: SA516, Gr: 70, with the following additional requirements.

2.0 APPLICATION :

For fabrication of pressure vessels and heat exchangers as per ASME Boiler and Pressure Vessel code with S8 supplementary requirement as per SA 516.

3.0 DIMENSIONS :

Size of the plates shall be as per enquiry/purchase order.

4.0 CHEMICAL COMPOSITION :

Chemical composition shall be as per SA 516 Gr: 70 but carbon content shall not exceed 0.25% max.

5.0 MECHANICAL TESTS:

Tension tests shall be as per ASME: SA 516.

6.0 ULTRASONIC TESTS:

All the plates shall be ultrasonically examined as per supplementary requirement S8 of ASME SA 516.

7.0 REPAIRS

7.1 Repair of defects by welding is not permitted.

7.2 When repairs are done by other mechanical means, the minimum plate thickness shall be met with and the surface shall be smoothly dressed up to avoid sharp edges.

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8.0 INSPECTION AT SUPPLIER’S WORKS:

8.1 BHEL representative / BHEL appointed Inspection Agency shall have free entry and access to all areas where the manufacture of the plates is carried out. All reasonable facilities shall be extended to him including labour wherever necessary.

8.2 BHEL representative / BHEL appointed Inspection Agency shall be given sufficient advance intimation to witness the various processes, tests, etc. Punching and identification of test coupons and execution of various tests shall be done in presence of BHEL representative / BHEL appointed Inspection Agency.

9.0 TEST CERTIFICATE:

Three copies of the test certificate shall be furnished in English, giving the details of the following:

a) HY 10498 Rev.01
b) ASME SA 516 Gr.70, latest Edition & Addenda.
c) Chemical, mechanical & NDT test results.
d) Melt No. / Plate Nos. etc.

10.0 MARKING

The following details shall be hard punched / stencil marked on each plate, near the edge and encircled with the white paint.

BHEL Specification No. HY 10498 Rev. 01
ASME Grade SA 516 Gr:70
BHEL Order No.
Melt No
Supplier’s Name
Inspection Authority Mark
Material Code No. as given in the Purchase Order.

11.0 REJECTION & REPLACEMENT

In the event of the material proving defective in the course of further processing at BHEL, the same shall be rejected notwithstanding any previous acceptance.

The supplier shall replace the material at his own cost and the rejected material shall be returned after all the commercial conditions are satisfied.

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