



CORPORATE PURCHASING SPECIFICATION

AA54407

Rev No. 01

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CARBON DIOXIDE GAS – GRADE: 1

1.0 GENERAL

This specification governs the quality requirements of Carbon dioxide gas, grade 1.

2.0 APPLICATION

Used for welding.

3.0 COMPLIANCE WITH NATIONAL STANDARDS

The material shall comply with the requirements of the following national standard and also meet the requirements of this specification.

IS : 307 – 1966, Gr.: 1 | Carbon dioxide

4.0 TEST SAMPLES

One cylinder from each consignment shall be taken for testing and approval.

5.0 PROPERTIES:

When tested as per the test methods shown against each, the gas shall show the following properties:

5.1 Carbon Dioxide (Appendix A-2 of IS: 307 or Gas chromatograph):

99.7%, min. by volume

5.2 Moisture (Appendix A-6 of IS: 307 or Dew point):

0.001%, max. by volume.

6.0 TEST CERTIFICATES

Three copies of test certificates shall be supplied along with each consignment, giving the following information:

In addition, the supplier shall ensure to enclose one copy of the test certificate along with the despatch documents to facilitate quick clearance of the material.

Revisions:

Cl 32.11.29 of MOM of MRC-CPO

APPROVED:

INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC(CPO+NM)

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BHEL Order No.

Batch / Lot No.

Suppliers/ Manufacturer's Name and Grade

Test results of clause 5.0.

7.0 PACKING & MARKING

The gas shall be supplied compressed in cylinders. The design of cylinders, pressure of gas in cylinders, packing, marking, painting, labelling and transport of cylinders shall be in accordance with the 'Gas Cylinder Rules - 1940' of the Government of India with such modifications as may be ordered from time to time by the Chief Inspector of Explosives, Government of India or other duly constituted authority.

The cylinder ground colour shall be black and the cylinder band shall be white or aluminium (as per IS: 5).

The cylinders shall also be marked with the BIS certification mark.

All cylinders shall be securely tagged with the following information:

AA54407 : CARBON DIOXIDE GAS – GRADE: 1

BHEL Order NO.

Suppliers / Manufacturer's Name & Grade

No. of Cylinders

Net & Gross weight

8.0 ENVIRONMENTAL REQUIREMENTS:

The supplier shall furnish Material Safety Data Sheet (**MSDS**) covering all information relating to human safety and environmental impacts of the hazardous materials particularly during their transportation, storage, handling and disposal along with each supply.

Each container shall be marked with corresponding symbol and minimum worded cautionary notice for flammable / corrosive / toxic / harmful / irritant and oxidizing etc. as applicable.

9.0 REFERRED STANDARDS (Latest Publications Including Amendments):

1. IS : 5

2. IS: 307