	TITLE: STANDARD TECHNICAL SPECIFICATION FOR GALVANISED STEEL CLADDING SHEET	STD. SPECIFICATION NO. PE-SS-999-169-M037	
		VOLUME II-B	
		SECTION D	
		REV. NO. 02	DATE: 05.03.2011
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1.00.01 **GENERAL**

This specification covers the requirements for supply of Galvanised steel sheet for using it as cladding or protective covering over thermal insulation.

2.00.00 **CODES AND STANDARDS**

The manufacture, inspection and testing of the galvanised steel sheet to be supplied under this specification shall comply with the requirements of the latest revision of the following codes and standards.

2.01.00 IS: 277 Specification for galvanised steel sheets (plain and corrugated)

2.02.00 IS: 513 Specification for cold rolled low carbon steel sheets and strips.

2.03.00 IS: 1079 Specification for hot rolled carbon steel sheet and strip.

2.04.00 IS: 209 Specification for zinc.

3.00.00 **MATERIAL REQUIREMENTS**

3.01.00 **Form**

Sheets shall be plain unless otherwise specified and shall be in coil form (preferably) or in cut length

3.02.00 **Freedom from defects**

The material shall be sound, flat and free from bare spots, holes, tears and other harmful defects.

3.03.00 **Chemical Composition and mechanical properties**

The base carbon steel material shall have chemical composition and mechanical properties as per Grade 'O' of IS:1079 or IS:513 and the coating zinc material shall be Grade Zn 98 of IS:209.


3.04.00 **Zinc Coating**

The mass of zinc coating shall be as per Grade 275 of IS:277

4.00.00 **DIMENSIONS AND TOLERANCES**

4.01.00 The width of the galvanised sheet shall be 900 or 1000 mm unless otherwise specified. Tolerance on width shall be as per IS:277.

4.02.00 In case of sheets supplied in cut length, the length of the galvanised sheet shall be 2200, 2500 or 2800 unless otherwise specified. Tolerances on length shall be as per IS:277.

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4.03.00 Standard thickness of the galvanised steel sheet shall be 0.4, 0.5, 0.63, 0.80, 1.00 or 1.25 mm (requirement shall be given separately).

4.04.00 Tolerance on sheet thickness shall be as per IS:1079 or IS:513 as applicable and tolerance on mass shall be as per IS:277

5.00.00 **PACKING AND MARKING.**

5.01.00 Each coil or cut length sheet shall be suitably marked for identification, with name of the manufacturer, grade of base material, grade of coating, length, width and thickness of the sheet. Alternatively the above details may be shown on a tag attached to the coil or bundle of cut length sheets.

5.02.00 The material shall be packed in polythene lined Hessian and covered with metallic sheets and finally strapped with metallic bands suitably.

5.03.00 Each packet shall have the following identification marking (legibly written on the packet).

- a) BHEL's Purchase Order Number
- b) Project Name
- c) Name of the manufacturer
- d) Grade of the material and grade of the coating.
- e) Sheet thickness
- f) Weight and contents.

6.00.00 **INSPECTION AND TESTING**

The material to be supplied under this specification shall be of tested quality. Inspection and testing of galvanised steel shall be as per IS:1079/IS:513/IS:277. Manufacturer's test certificate indicating the chemical composition, mechanical properties and zinc coating etc. shall be furnished.

1X67.5 MW RINL VIZAG STEEL PLANT TPS

Specification Ref. No. PE-SS-999-169-M037 / Rev 01

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Dated 08.07.2009

The quantities of GI sheets to be ordered, are as given below.

1) 24SWG – 42,350 Kgs