



BHARATH HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014
WELDING TECHNOLOGY CENTRE

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WELDING CONSUMABLE PURCHASE INSTRUCTION FOR
LOW ALLOY STEEL SAW WIRE ASME.SEC.II.C SFA-5.23-EB-3

1.0 GENERAL:

- 1.1 The wire shall comply with requirements specified in the latest edition and addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.23, EB-3. All tests, acceptance criteria shall be in accordance with this. Additional requirements specified in this document and purchase order shall also be complied.
- 1.2 The wires shall be supplied in sizes and quantities as specified in the purchase order.
- 1.3 The wires are intended for use as filler for radiographic quality butt joints in high pressure boiler tubes and pipes.
- 1.4 Every batch of wires shall be inspected & test certificates countersigned by inspecting authority approved by IBR for the country of origin (latest).

2.0 Chemical Composition:

The chemical composition of the wires shall conform to ASME SECII.C SFA-5.23, EB-3.

3.0 SIZE:

The wire shall be supplied in diameter 2.0, 2.4, 3.2, 4.0 & 4.8 mm as specified in the purchase order. The tolerance on diameter shall be as per SFA-5.02. The net weight of the coil shall be 25/30Kg.

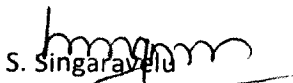
4.0 FORM :

The wires shall be appropriately wound in coils with suitable liners and shall meet the clause 4.3.3 of SFA-5.02 with dimensions 450mm maximum OD, 300mm ID and 100mm width. Alternatively Wires shall be appropriately wound in basket rim B450 as per SFA-5.02.

5.0 FINISH & UNIFORMITY:

The Wires shall meet the requirements of clause 16.2.2 and 16.2.4 of SFA-5.23.

PREPARED:


S. Singaravelu
DGM / WTC

REVIEWED & APPROVED:


Dr. K. Asokkumar
AGM/WTC



6.0 WINDING REQUIREMENTS:

The Wires shall meet the requirements of clause 16.4 of SFA-5.23.

7.0 IDENTIFICATION :

The Wires shall meet the requirements of clause 4.5.2, 4.5.4 & 4.5.5 of SFA-5.02.

8.0 MARKING:

The Wires shall meet the requirements of clause 4.6 of SFA-5.02.

9.0 PACKAGING:

9.1 The wire coils should be completely devoid of moisture or any other foreign material and shall be adequately sealed in suitable cartons to ensure against any deterioration in the wire quality during transportation by sea or long duration storage.

9.2 The liners shall meet the requirements of 4.3.3 of SFA-5.02 or the basket rim shall meet the requirements of 4.3.4 of SFA-5.02.

9.3 The cartons shall be packed in water proof boxes with crates so as to ensure no damage during shipment and normal storage conditions. Weight of each crate shall not exceed 1000kg.

9.4 The cartons shall have product information as per clause 4.6 of SFA-5.02

10.0 TESTING & CERTIFICATION:

10.1 Each consignment of wires supplied shall be from one batch only.

10.2 Batch /lot classification shall be Class S1 as per SFA-5.01 of filler metal procurement guidelines of ASME Sec.II.C (latest edition and addenda).

10.3 The level of testing shall be Schedule J as per SFA-5.01 of filler metal procurement guidelines of ASME Sec.II.C (latest edition and addenda).

10.4 Three copies of Original Test certificates in English countersigned by inspecting authority (latest) approved by IBR for country of origin giving details of the tests done in compliance with this Purchase Instruction and ASME Sec.II.C, SFA-5.23, EB-3 shall be sent.

10.5 The testing authority shall certify that supplies made against the batch conform to the requirements of the latest edition & addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.23 EB-3.