



BHARATH HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014
WELDING TECHNOLOGY CENTRE

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Welding Consumable Purchase Instruction

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**PURCHASE INSTRUCTION FOR STRIGHT LENGTH COBALT BASE
WELDING RODS FOR HARD SURFACING (HAYNESS ALLOY NO.21**

1.0 SCOPE:

1.1 The rod shall conform to requirements of this specification and shall be supplied in quantities and sizes mentioned in the Purchase order.

2.0 CHEMICAL COMPOSITIONS:

2.1 Specified chemical composition of the rod shall be as below.

C	: 0.20-0.30	Fe	: 2.00 max.
Si	: 1.00 max	Cr	: 25.00-29.00
Mn	: 1.00 max	Mo	: 5.00-6.00
Ni	: 1.75-3.25	W	: 0.50 max
Co	: Balance	B	: 0.005 max

Other intentional additions shall be reported.

3.0 FINISH:

3.1 The rod shall of uniform quality and free from segregation, oxides, slivers, seams or other irregularities, which would impair their usefulness.

3.2 Diameter shall not vary from the specified size by more than $\pm 0.08\text{mm}$.

3.3 The wire shall be supplied in straight lengths of $1000\text{mm} \pm 20\text{mm}$.

4.0 PACKING AND IDENTIFICATION:

4.1 The rods shall be packed in cardboard tube or cartons.

4.2 Each carton shall not contain material more than 5 kgs. Net

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4.3 Each straight rod shall have at least one legible imprint of 'Hayness Alloy-No.21'

4.4 Four cartons, the net weight net exceeding 20kgs. Shall be packaged in a thick cardboard box facilitating easy transportation.

5.0 LABELLING AND NUMBERING:

5.3 All packages of filler metal or all individually packaged units enclosed within a larger package shall carry labels containing the following information.

- a) Brand Name
- b) Size
- c) Batch Number and date of manufacture
- d) Net Weight

6.0 TEST CERTIFICATE:

6.3 Test certificate shall be on a standard format giving details of weld metal chemistry.

6.4 Individual Test certificate shall be supplied for every batch of rods supplied.

6.5 Three copies of Test certificate shall be mailed as specified in the Purchase contract. An additional copy of this Test Report shall be supplied for each shipment of material.

6.6 Prior approval shall be obtained for any deviation to this PURCHASE INSTRUCTUION.

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