



## CORPORATE PURCHASE SPECIFICATION

AA 544 04

Rev. No. 02

PAGE 1 OF 2

### COMPRESSED OXYGEN GAS – 99.0% PURE

#### 1.0 GENERAL

This specification governs the quality requirements of compressed Oxygen Gas having a purity of 99.0%, minimum. The oxygen gas shall have no free moisture and shall have a dew point of minimum 0<sup>0</sup> C.

#### 2.0 APPLICATION

Used for cutting, welding and other technological purposes.

#### 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 : 309 - 1992 | COMPRESSED OXYGEN GAS.

#### 4.0 TEST SAMPLES

One gas cylinders shall be selected at random from the lot for testing Oxygen content.

#### 5.0 PROPERTIES

When tested as per IS 309, the oxygen content in compressed oxygen gas shall be minimum 99.0% , by volume.

#### 6.0 TEST CERTIFICATES

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

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

Revisions :  
CI 32.11.29 of MOM of MRC-CPO

APPROVED :  
INTERPLANT MATERIAL  
RATIONALISATION COMMITTEE-MRC (CPO)

Rev. No. 02

Amd.No.

Reaffirmed

Prepared

Issued

Dt. of 1st Issue

Dt. 15.02.2004

Dt :

Year :

BHOPAL

Corp. R&D

AUGUST, 1988

AA 544 04

Rev. No. 02

PAGE 2 OF 2

**CORPORATE PURCHASE SPECIFICATION**



AA 544 04, Rev. 02 : Compressed Oxygen Gas – 99.0% pure  
BHEL Order No.  
Batch / Lot No.  
Supplier's/ Manufacturer's Name & 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, labeling 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 cylinders shall also be marked as per IS: 1260 and IS: 4379.

The cylinder shall be painted with black colour (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:

AA 544 04: Compressed Oxygen Gas – 99.0% pure  
BHEL Order NO.  
Supplier's / Manufacturer's Name & Grade  
No. of Cylinders  
Net and 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 alongwith 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 : 309

3. IS:1260

4. IS:4379