

दिनांक एवं हस्ताक्षर  
SIGN & DATE



संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)

FF 77184 Rev 03

पृष्ठ का  
Page 1 of 5

**PLANT PURCHASE SPECIFICATION**  
(CFFP - HARDWAR)

SUPERSEDES  
INVENTORY NO.

आवृत्ति सूची संख्या  
को अधिष्ठापित करना

**GOUGING ELECTRODE HOLDER**

**1. Scope :**

This purchase specification specifies the requirements and tests for gouging electrode holder (used for removal of material from steel castings with the help of gouging carbon electrodes ), in order to optimize the safety of the welder and to ensure satisfactory condition of use during heavy duty manual electric arc gouging on carbon steel and different alloy steel castings.

**2. Compliance with National & International Standard :**

The gouging electrode holder shall be in general as per IS 2641:1993 suitable for current range at 100% duty cycle use with the characteristics as stated under Technical specifications.

**3. Technical Specifications:**

3.1 Type of Gouging Holder and their current capacity.

Type of Gouging Holder	Suitable for Gouging Electrode	Current Rating at 100% duty cycle	Length of heavy duty cable
Gouging Holder 1000 Amps	Ø9mm and Ø12mm	1000 amps	2 meter long
Gouging Holder 1800 Amps	Ø18mm	1800 amps	3 meter long

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**स्वातंत्र्यधिकार एवं गोपनीयता**  
 इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रलेख एवं अपरिष्कृत रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।



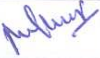
- 3.2 The gouging Electrode Holder shall be suitable for use on circuit with OCV up-to and including 100 V (RMS).
- 3.3 The gouging holder shall be made of copper/copper alloy, free from blow holes, cracks and defect which impair the electrical conductivity.
- 3.4 The gouging electrode holder shall be open mouth-jaw and shall be as light as possible.
- 3.5 The gouging electrode holder shall be fitted with unitized standard cable & hose, air cooled & swivel type terminating in rubber/jacketed air-power connection and insulation boot. Provision shall be there for connection of pneumatic hose.


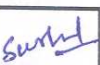

हस्ताक्षर एवं  
दिनांक




RMI	SN GHOSH	अनुवादक	TRANSLATED BY	
MPIC	SHANTANU	निर्मायक	WORKED BY	SUSHANT
CHAIRMAN CPSC	R PARTHA SARTHI	जांचकर्ता	CHECKED BY	ANIL KUMAR
सहमत विभाग AGREED DEPT.	नाम NAME	दिनांक एवं हस्ताक्षर DATE & SIGNATURE	पर्यवेक्षणकर्ता SUPERVISED BY	V.K.AGARWAL


आवृत्ति सूची संख्या  
INVENTORY

APPROVED : <b>PLANT STANDARDS COMMITTEE</b>		
PREPARED : WELDING TECH	ISSUED : WELDING TECHNOLOGY	दिनांक : DATE : 03.08.10

दिनांक एवं हस्ताक्षर SIGN & DATE		<b>संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार)</b>  <b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)	<b>FF 77184 Rev 03</b>			
सुपरसेडिड इन्वेंट्री नं. SUPERSEDES INVENTORY NO.	रामजी सूची संख्या को अधिकतम करता Rajji Sanchi Number ko Adhikartam Kartata	3.6 The gouging holder shall have provision for 360° free revolving movement of the holder around air hose/cable without twisting the air hose/cable for maximum maneuverability.	पृष्ठ Page	का of 5		
<b>COPYRIGHT AND CONFIDENTIAL</b> The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.		3.7 The gouging electrode holder along with coaxial unitized standard cable and air hose assembly shall be able to work continuously at the maximum current (rated for 100% duty cycle) with 7kg/cm <sup>2</sup> air pressure without any air leakage through jaws and the air switch of the holder.	3.8 The handle lever and handle covers shall be made in tough heat resistant and electrical insulating material and shall be so constructed that no dirt of foreign particles (likely to cause danger by electrical shock) can lodge in joints, holes & other services and that the live ends of screws, pins etc can not be exposed in use.			
<b>स्वत्वाधिकार एवं गोपनीयता</b> इस प्रलेख में दी गई सूचना भारत देशी इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रयोग कर से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।		3.9 Grip of handle (OD) shall be such that operator can grip it easily and comfortably. The temperature of the grip of the handle shall not exceed 30° C above ambient temperature when continuously used at rated current for 100% duty cycle for 30 minutes minimum.	3.10 Spring, if used, shall be insulated electrically so that they do not carry ,welding current unless designed to do so.			
दिनांक एवं हस्ताक्षर SIGN & DATE	4. Test Certificate:	4.1 Unless otherwise specified, one original and three copies of original manufacturer's test certificates shall be supplied with each consignment bearing the following information. In order to facilitate quick clearance of material, the supplier shall ensure to send a copy of test certificate along with dispatch document ( Supplier shall submit test certificates in line with IS2641:1989)	4.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to supplier's invoice stating the batch No., lot No., etc of the supply.			
रामजी सूची संख्या Rajji Sanchi Number			निर्माणाकर्ता WORKED BY	SUSHANT		06.08.10
			जांचकर्ता CHECKED BY	ANIL KUMAR		06.08.10

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार)  <b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)	<b>FF 77184 Rev 03</b> पृष्ठ का <b>Page 3 of 5</b>		
सामग्री सूची संख्या को अधिकृतित करना SUPERSEDES INVENTORY NO.	<p><b>5.0 Acceptance</b></p> <p>5.1 For established supplier, who has supplied the designated gouging electrode holder for 2 years continuously giving trouble free service, the item can be accepted on the basis of TC &amp; GC given by the supplier.</p> <p>5.2 CFFP reserve the right to check the gouging electrode holder on surveillance basis for established supplier.</p> <p>5.3 For other suppliers, checking as per CI. No. 3 and shop trial will be required.</p> <p>5.4 Inspection at BHEL is final and will be binding on supplier.</p> <p><b>6.0 Marking :</b>          Each gouging electrode holder shall be marked with the following information.          (a) Name of manufacturer, Trademark, If any.          (b) Current rating at 100% duty cycle.</p> <p><b>7.0 Guarantee :</b>          The gouging electrode shall be guaranteed for 18 months from the date of receipt.</p> <p><b>8.0 Packing :</b>          Packing should be that of the original manufacturer. Packing should be suitable to avoid any damage during handling.</p> <p><b>9.0 Special Requirement :</b></p> <p>(a) The party shall send with offer the gouging holder catalogue/ leaflet giving details of the gouging electrode holder construction and arrangement of holding the gouging cable, in particular.</p> <p>(b) The party shall send quote for all the spares of holder for two years trouble free operation.</p> <p>(c) The party shall provide test certificate (for the test as per clause 4 above) with supply.</p> <p>(d) Party shall submit two copies of operation and maintenance manual along with detailed assembly drawing (in English language) at the time of delivery of gouging electrode.</p> <p>(e) If the material received in CFFP is found not suitable as per clause No. 5 given above. It shall be replaced free of cost by the supplier.</p> <p><b>10.0 Inspection &amp; Deviation :</b></p> <p>10.1 BHEL reserves the right to inspect material at site before dispatch. The supplier shall intimate in advance about readiness of material enclosing a copy of test certificate of</p>				
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<b>स्वत्वाधिकार एवं गोपनीयता</b> इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रयोग एवं प्रसारण इस से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।					
दिनांक एवं हस्ताक्षर SIGN & DATE					
सामग्री सूची संख्या		निर्माणकर्ता WORKED BY	SUSHANT		06-08-10
		जांचकर्ता CHECKED BY	ANIL KUMAR		06-08-10

दिनांक एवं हस्ताक्षर SIGN & DATE		<b>संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार)</b> <b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)	<b>FF 77184 Rev 03</b> पृष्ठ का Page 4 of 5	
सापेक्ष सूची संख्या को अधिकारित करना	<b>COPYRIGHT AND CONFIDENTIAL</b> The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	<p>the material offered for inspection. However inspection at BHEL shall be final. The supplier shall offer BHEL representative all reasonable test facilities without charge to satisfy the latter that the material being furnished is in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed tests elsewhere.</p> <p>10.2 For any deviation from the specification sought by the supplier, prior approval of BHEL must be obtained in writing.</p>		
<b>स्वातंत्र्यधिकार एवं गोपनीयता</b> इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रलेख एवं अनुप्रेषण रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए ।	हस्ताक्षर एवं दिनांक SIGN & DATE	निर्माणकर्ता WORKED BY	SUSHANT	 06-08-10
सापेक्ष सूची संख्या	जांचकर्ता CHECKED BY	ANIL KUMAR	 06-08-10	

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सामग्री सूची संख्या को अधिकृतित करना	SUPERSEDES INVENTORY NO.	<b>RECORD OF CHANGES</b>				
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	03	Clause 4 & 8 modified to incorporate original manufacturer's test certificate and packing conditions  Clause 5.0 & 10.0 added about acceptance, inspection & deviation  Clause 8 (e) omitted		Sheet No. 2 & 3  Sheet No. 3 & 4  Sheet No. 3		03.08.10  03.08.10  03.08.10
	<b>DISTRIBUTION OF PRINTS</b>					
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	STANDARD SECTION	✓				
	MPIC	✓				
हस्ताक्षर एवं दिनांक		निर्माणकर्ता WORKED BY	SUSHANT	<i>Sushant</i>	06.08.10	
सामग्री सूची संख्या		जांचकर्ता CHECKED BY	ANIL KUMAR	<i>Anil Kumar</i>	06.08.10	