

PSGSG/1 3-14/027	<b>Product Specifications For DS MOVING CONTACTS</b>		Drg. No.	RDDG 4 35 0517 2019
			Date	13.02.14
			Product	<b>GSM 245</b>
<b>1.0</b>	<b>Application</b>	:	Movable Arcing rods for Gas Insulated Switchgear Equipment	
<b>2.0</b>	<b>Configuration</b>	:	<ol style="list-style-type: none"> <li>1. Sintered W-Cu (70-30 %), welded (by electron Beam welding process) to the high conductivity copper.</li> <li>2. Machined to drawing dimensions.</li> </ol>	
<b>3.0</b>	<b>Quantity</b>	:	12 No.s	
<b>4.0</b>	<b>Specifications:</b>		<ol style="list-style-type: none"> <li>1. Dimension Drawings : Refer Drg No. RD DG 4 35 0517 2019</li> <li>2. Material: : Tungsten-Copper, ETP copper</li> </ol> <p><b>(a). W-Cu</b></p> <p>A sintered matrix of W-Cu (70-30 %) shall be produced by PM technique. The sintering shall be carried out in neutral or reducing atmosphere. The ingredient (powders) shall have high purity.</p> <p><b>(b). ETP Copper</b></p> <p>ETP copper shall have the following specifications:</p> <ol style="list-style-type: none"> <li>1) The specified copper material shall have minimum conductivity of 95 % IACS. Supplied material will be tested at BHEL for conductivity and the same will be rejected in case they do not meet specified conductivity.</li> <li>2) The material shall be good for brazing, soldering and for electrical applications where high current transfer is involved.</li> </ol>	
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<p><b>5.0</b></p> <p><b>Electron Beam Welding (EBW):</b></p> <p>The component shall be finished to size before electron beam welding at the interface. The interface will be between High conductivity copper and W-Cu Tip. The interface shall be welded to full depth. The welding joint between high conductivity copper and W-Cu tip shall exhibit minimum contact resistance. The Component shall be free from dirt, grease and loose particles.</p> <p><b>6.0</b></p> <p><b>Qualifying Requirements:</b></p> <p>The supplier shall be of national / International repute with proven record and should have supplied arcing contacts for electrical applications at least for last three years. The supplier must submit along with the quotation a few references to whom the supplier has supplied a similar material.</p> <p><b>7.0</b></p> <p><b>Tests:</b></p> <p>(a). Dimensional : All dimensions shall comply to drawing measures.</p> <p><b>8.0</b></p> <p><b>Packing :</b></p> <p>The contacts shall be packed in high density cardboard boxes, with a primary wrapped in polyethylene and packed individually in dust free boxes after degreasing. The component shall be guaranteed against all manufacturing defects.</p> <p><b>9.0</b></p> <p><b>General :</b></p> <p>1. Surface finish of the components shall be at least RA 1.6.</p> <p>2. The component shall be free from dirt, grease and loose particles.</p> <p>In case of doubts in drawings or specifications the supplier shall contact BHEL for clarifications.</p>			
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