



TECHNICAL DELIVERY CONDITIONS (TDC)
For
Carbon Steel Plates

Doc Ref:	TDC:RTA:407
Rev. No.	02
Date:	18.01.2012
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1.0 SCOPE :

1.1 This TDC specifies the requirements for supply of Plates to material specification ASTM A515 GR.65./GR70 / ASTM A516 GR.70.

2.0 Chemical & Mechanical properties:

2.1 Shall be as per specification.

3.0 Supply Condition:

3.1 If the plates are supplied in gas cut condition, plate thickness above 50mm shall be Preheated to 100deg.C before gas cutting.

3.2 Repair by fusion welding is prohibited.

3.3 The out of flatness shall be within 5mm/meter.

3.4 The steel shall be fully killed.

PREPARED BY	REVIEWED BY	SIGNATURE	APPROVED BY
J. Chittappa	ENGG (APH)		 (HEAD / QA)
	PURCHASE	 12/03/2012	
	MPL	 09/03/12	
	QC/PROC		
	QA		
<i>Issued By Quality Assurance</i>			



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4.0 Non destructive Testing & Acceptance

4.1 All the plates shall be Ultrasonically tested and accepted as per ASTM A578 level C for ASTM A515 and ASTM A 516.

5.0 MARKING:

5.1 Each plate shall be hard stamped and bordered with white paint within the following Information:

- a. P O No.& Date
- b. Size & Quantity
- c. Specification
- d. Melt number
- e. Maker's identification

6.0 TEST CERTIFICATES:

6.1 TC shall be in English and it shall contain

- a) Purchase Order Number and Date
- b) TDC Number
- c) Material Specification and Grade
- d) Drawing No (if applicable)
- e) Number & weight
- f) Chemical Composition – Each Melt wise
- g) Mechanical Properties – Each Melt wise
- h) Ultrasonic Testing Report – HT batch wise

7.0 BHEL reserves the right to carry out tests and reject the items wherever non conformance to the contract is noticed.

Rev. No	Date	Changes made
00	26 02 02	TDC RTA 007 / REV 02 is revised and renumbered as TDC RTA 407 / REV 00
01	10 05 02	TDC totally reviewed and revised
02	18 01 12	As per engineering request email dtd 13/01/2012, in clause 1.1 ASTM A516 GR.70 included. In clause 4.1, The UT acceptance norm incorporated as per collaborator email dated 12.03.12