



CORPORATE PURCHASING SPECIFICATION

AA 113 08

Rev. No. 02

PREFACE SHEET

HIGH CARBON FERRO MANGANESE

FOR INTERNAL USE ONLY
REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS

Comparable Standards:

- | | | |
|----------|---|--------------------------------|
| 1. INDIA | : | IS : 1171-1996
Gr: Fe Mn 72 |
|----------|---|--------------------------------|

Suggested / Probable Suppliers and Grades :

User Plant References:

Revisions : As per 23rd MOM of MRC-FN

APPROVED :
INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (FN)

Rev. No.02

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Reaffirmed

Prepared
BHOPAL

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Year :



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1.0 GENERAL:

This specification governs the requirements of High Carbon Ferro Manganese for use in iron and steel melting.

2.0 APPLICATION:

Used as deoxidiser and alloying element in the manufacture of iron and steel castings.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply, in general, with the requirements of the following National standards and also comply with the requirements of this specification.

IS: 1171-1996 : " Specification for Ferro manganese".
Gr. Fe Mn 72

4.0 SIZE:

The material shall be supplied. In either of the following sizes as per BHEL order.
Lumps of size of 50-150mm
or
Lumps of size of 25 -100mm

5.0 FREEDOM FROM DEFECTS:

The lump shall be in properly cleaned form and reasonably free from slag and any foreign material.

6.0 SAMPLING :

Composite sample shall be prepared from each consignment of 1000 kg. or part there off.

7.0 CHEMICAL COMPOSITION:

Material when tested in accordance with IS: 1559, shall conform to the following:

<u>Element</u>	<u>Percentage</u>
Manganese	74. to 78.
Carbon	6.0 to 8.0 max.
Silicon	1.50 max.
Sulphur	0.05 max.
Phosphorus	0.35 max.

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8.0 ACCEPTANCE TEST:

Each consignment shall be accepted on the basis of tests carried out as per clauses as per 4, 5 and 7. Analysis of carbon, Silicon, Sulphur and phosphorus is not mandatory, however, these shall be analysed as and when required.

9.0 INSPECTION DEVIATION AND REPLACEMENT:

9.1 BHEL reverses the right to inspect the material at site before despatch. The supplier shall intimate in advance enclosing a copy of the test certificate of the material offered for inspection.

9.2 Final tests shall be carried out at BHEL and material will be accepted or rejected on this result.

9.3 If the material received is not found suitable to our requirements, it shall be replaced free of charge by the supplier.

9.4 For any deviation demanded by the supplier from the specification, prior approval of BHEL must be obtained in writing.

10.0 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied along with each consignment.

In addition the supplier shall ensure to send one copy of test certificates along with the despatch documents to facilitate quick chance of the material.

The ten certificates shall bear the followings information
 AA 113 08 (Rev.No.02) : Low Carbon Ferro Manganese
 BHEL Order No.
 Manufacturer's/Supplier's Name.
 Trade mark, if any.
 Batch No.
 Grade of Ferro manganese
 Test Results of clauses 4,5 and 7.

11.0 PACKING AND MARKING:

The material shall be supplied in gunny bags of 50kg. capacity.
 Each gunny bag shall be clearly marked with the following information:
 AA 113 08 : Low Carbon Ferro Manganese
 BHEL Order No.
 Manufacturer's/Supplier's Name.
 Trade mark, if any.
 Batch/Lot No.
 Grade of Ferro manganese
 Net weight and gross weight

12.0 REFERRED STANDARDS (Latest Publications Including Amendments):

1) IS:1171
2) IS:1559