



CORPORATE PURCHASING SPECIFICATION

AA53612

Rev No. 02

PREFACE SHEET

GRAPHITE POWDER FOR USE IN FOUNDRY

FOR INTERNAL USE ONLY

REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS

Equivalent / Comparable Standards

1) INDIAN : IS: 1305-1984

Suggested / Probable Suppliers and Grades

As per respective Plant's PMD

User Plant References:

1) HYDERABAD : MP/24/82
2) CFFP, HARIDWAR : --

Revisions:
Clause No. 25.03 of MOM of MRC-FN

APPROVED:
INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC(FN)

Rev No.02	Amd No.	Reaffirmed	Prepared	Issued	Dt. of 1 st Issue
Dt: 19-03-2014	Dt:	Year:	HPEP, Hyderabad	Corp.R&D	01-12-1985

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AA53612

Rev No. 02

PAGE 1 of 3

GRAPHITE POWDER FOR USE IN FOUNDRY

1.0 GENERAL:

This specification governs the quality requirements of Graphite powder for use in foundries.

2.0 APPLICATION: Used as facing material in production of moulds.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply, in general, with the following national standards and also meet the requirements of this specification:

IS: 1305 – 1984: Graphite for use in Foundry coatings.

4.0 SIZE/GRAIN FINENESS:

The material when tested for dry fineness shall comply as follows:

IS sieve, micron	Percent passing through by weight, minimum
150	100
125	95
100	90
75	85

5.0 FREEDOM FROM DEFECTS:

It shall be free from contamination with foreign materials.

6.0 PHYSICAL CHARACTERISTICS:

The material when tested in accordance with IS: 1305, Appendix 'A' shall comply with the following:

Characteristics	Percent by weight, maximum
Moisture	1.0
Volatile matter	3.0
Ash	12.0
Fixed carbon (by difference) To be reported Non-graphatic carbon	1.0

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7.0 TEST SAMPLES:

Two composite samples of 1 kg shall be drawn from each batch of supply for testing and approval.

8.0 INSPECTION AT SUPPLIER'S WORKS:

8.1 BHEL reserves the right to witness the testing of the material at supplier works and therefore the supplier shall notify the readiness of the material in advance.

8.2 BHEL may also opt for third party inspection. If so, BHEL may either specify a third party or else give a list of third party inspection agencies, out of which supplier may select one of his choice.

8.3 The supplier shall offer BHEL's representative all reasonable facilities, without charge to satisfy the latter that the material is being furnished 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.

8.4 BHEL may, at its discretion, test the material after receipt and acceptance of the material will be based on the BHEL's test results.

8.5 Supplier shall ensure that the material is free from extraneous material. The material shall be rejected if it is not free from extraneous material.

8.6 For result of analysis and properties of material the decision of BHEL shall be final and binding on the supplier.

8.7 If the material received is not found suitable according to the requirements, it shall be replaced free of cost by the supplier.

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

9.0 TEST CERTIFICATES:

Unless and otherwise stated, one original and three copies of certificates from the original manufacturer shall be supplied along with each consignment.

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

Manufacturer supplying material directly to BHEL should include BHEL PO No. in the Test Certificate. Any other supplier should provide a covering letter along with original manufacturer Test Certificate as above mentioning BHEL PO No.

The certificates shall bear the followings information

AA53612, Rev.No.02: GRAPHITE POWDER FOR USE IN FOUNDRY

BHEL Order No.

Manufacturer's/ Supplier's Name.

Trade mark, if any

Batch No

Test results of clauses 4.0, 5.0 and 6.0.



CORPORATE PURCHASING SPECIFICATION

AA53612

Rev No.02

PAGE 3 of 3

10.0 PACKING AND MARKING:

The material shall be packed in water proof bags.

Each bag shall be legibly marked with the following information:

AA53612: Graphite Powder for use in foundry

BHEL Order No.

Manufacturer's/ Supplier's Name.

Trade mark, if any

Batch No

Quantity supplied

11.0 Referred Standards (Latest Publications including Amendments):

Nil