



CORPORATE PURCHASING SPECIFICATION

AA 77 303

Rev. No. 00

PREFACE SHEET

ALUMINIUM SILICON ALLOY MODIFIER
(FOR HIGH TEMPERATURE APPLICATION)

FOR INTERNAL USE ONLY
Remove this preface before issue to suppliers

Comparable standards: Nil

Suggested / Probable Suppliers:

1. M/s IVP
2. M/s Foseco
3. M/s AFCIL
4. GARGI
5. CERAFLUX

User Plants / References:

1. BHOPAL
2. HYDERABAD

Revisions: As per email received from Md
Nazeer Ahmed, Foundry Materials, HPEP on
21.6.2011

APPROVED :
INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (FN)

Rev. No. 00	Amd.No.	Reaffirmed	Prepared	Issued	Dt. of 1st Issue
Dt: 22.06. 2011	Dt :	Year :	Hyderabad	Corp. R&D	22 nd June 2011

**ALUMINIUM SILICON ALLOY MODIFIER****1. GENERAL :**

This specification governs the requirement of sodium salt base modifying agent for Aluminium silicon alloy melting. Equivalent product : COVERAL-29 A of FOSECO LTD.

2. APPLICATION :

The material is used for the modification treatment of Aluminium Silicon (LM6) melt for sand and Die Casting material shall be melted in the range of 740°C to 780°C.

3. COMPLIANCE WITH NATIONAL STANDARD :

There is no national standard covering the material.

4. SHAPE AND SIZE :

The material shall be supplied in white coloured powder form.

5. ACCEPTANCE. :

Shop trial shall be done to ensure proper modification treatment on Aluminium Silicon alloy melt and mechanical properties shall be checked for final clearance of the material from new source.

6. INSPECTION, DEVIATION& REPLACEMENT

6.1 BHEL reserves the right to inspect material at site before despatch. However inspection at BHEL shall be final. The supplier shall offer BHEL's representative all reasonable test 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 test elsewhere. The supplier shall notify BHEL in advance about the readiness of the material for inspection and testing.

6.2 If the material received at BHEL is not found in accordance with the requirements, it shall be rejected and the supplier will have to replace it free of cost at the earliest.

Revisions : As per email received from Md Nazeer Ahmed, Foundry Materials,HPEP on 21.6.2011

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**7. TEST CERTIFICATES :**

- 7.1 Unless otherwise specified, one original and three copies of original manufacturer's test certificates must be supplied along with each consignment. In addition, the supplier shall ensure to send one copy of test certificates along with the dispatch documents to facilitate quick change of the material.

The certificates shall bear the following information:

- a. Specification No. & item description
 - b. BHEL PO No. with Date
 - c. Supplier reference / trade mark, if any
 - d. Identification No. / Batch No.
 - e. Date of manufacture
 - f. Shelf life
 - g. Any other specific information which the supplier would like to convey.
- 7.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificate with linkage to supplier's invoice stating the batch No., Lot No., etc. of the supply.

8. PACKING AND MARKING:

1. The material shall be packed in polythene lined gunny bags to avoid moisture pick up. Weight of content of each bag should be 50 Kg max.

Each consignment should bear:

- (a) Supplier's name and trade mark, if any.
- (b) Name of the product
- (c) Date of manufacture
- (d) Shelf life
- (e) Batch No. / Identification No.
- (f) Net Weight