Maharatna Company Celebrating 50 Years of Engineering Excellence (1964-2014)	PLANT PURCHASE SPECIFICATION		No.	BHEL/FP/TS/31	
	FABRICATION PLANT		Rev. No.	0	
	DEPARTMENT: PRODUCTION		Rev. Dt.		
CSU & FP, Jagdishpur					

Technical Specification for Neutural Fused Flux F7P2 - EM 12 K

Sr. No.	Description	Requirement	Vednor to Furnish/Confirm	Offered	Deviation	Remark
1	**Technical Details:**					
1.1	F7P2 - EM 12 K	As per SFA 5.17 of ASME Sec IIC Ed 2013	Vendor to Confirm			
1.2	Flux Type	Neutral Fused Flux				
1.3	Particle Size	20 to 100 mesh				
1.4	Weight of packet	25 kgs to 50 kgs				
1.5	Flux Form and particle size	As per SFA 5.17 of Clause 17.1 ASME Sec IIC Ed 2013				
1.6	Usability	As per SFA 5.17 of Clause 17.2 ASME Sec IIC Ed 2013				
1.7	Packaging	As per SFA 5.17 of Clause 17.3 ASME Sec IIC Ed 2013				
1.8	Marking of packages	As per SFA 5.17 of Clause 17.4 ASME Sec IIC Ed 2013				
1.9	Storage and Drying condition	All details regarding storage, drying condition and shelf life.	Vendor to sepecify			
2	**Tests Required for Flux**					
2.1	Radiographic test	As per SFA 5.17 of ASME Sec IIC Ed 2013	Test Certificates to be provided.			
2.2	* Tensile Test	As per SFA 5.17 of ASME Sec IIC Ed 2013				
2.3	* Impact test (Charpy): 5 Samples at - 20 °F on 2 mm V - notch	Average of three samples (Discarding Highest and lowest values): 27 J min. Two of the values used for computing average shall ≥ 27 J Single Value (Min) : 20J				
2.4	* The test mentioned at clause 2.2 and 2.3 to be done after carrying out PWHT as mentioned at clause 3		Vendor to Confirm			

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2.5	A packet 25 Kgs to be submitted along with the offer for further technical evaluation, if required. Vendor to submit samples within 7 days after intimation by BHEL. We will check the following characterstic: a) Finish and Uniformity of weld bead b) Slag Removal c) Porosity and undercut d) No smoke The parametrs for welding will be as follows: Current: 350- 500 A Voltage: 30 - 36 V Electrode extension: 25 ± 6 mm Travel speed: 250 - 450 mm /min		Vendor to Confirm			
3	Post Weld Heat Treatment	As per Clause 9.4 of SFA 5.17 of ASME Sec IIC Ed 2013	S.R graph to be provided			
QUALIFYING CONDITIONS:						
4.1	Only those makes and brand shall be quoted of which atleat 5 Ton is supplied to any heavy fabrication industiries in the past 3 years and the flux has performed satisfactorily. The following information is to be submitted by the vendor about the companies where the quoted wire has been supplied.		Vendor to Confirm			
4.2	Name of the customer / company where flux has been supplied.		Vendor to specify			
4.3	Complete postal address of the customer.		Vendor to specify			
4.4	Year of supply.		Vendor to specify			
4.5	Application for which the Flux is supplied with details.		Vendor to specify			
4.6	Name and designation of the contact person of the customer		Vendor to specify			
4.7	Phone, FAX no. and email address of the contact person of the customer.		Vendor to specify			
4.8	BHEL reserves the right to verify information provided by vendor. In case the information provided by vendor is found to be false / incorrect, the offer shall be rejected.		Vendor to specify			

	Prepared By	Checked By	Approved By
Signature			
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Designation	Sr. Engineer	Sr. Engineer	Sr. Engineer
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