



**PLANT PURCHASING
SPECIFICATION
HYDERABAD**

HY 10378

REV. NO. 01

PAGE 1 OF 2

SPECIFIC GRADE OF PIG IRON

1.0 GENERAL:

This specification covers the requirements of specific grade of PIG IRON to be used as a raw material for the production of S.G. IRON Castings in ferrous foundry.

2.0 APPLICATION:

Used for production of S.G. IRON castings in ferrous foundry.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

There is no equivalent National standard for this type of material.

3.1 Vendor shall obtain prior approval in writing from BHEL for any deviation from the requirements of this specification.

4.0 SIZE AND SHAPE:

The material shall be supplied in the form of notched pigs of size 275x125x60 mm (approximately) and weighing 7.5 Kgs (approximately).

5.0 GENERAL APPEARANCE:

The material shall be clean and free from excessive sand or kish.

6.0 CHEMICAL COMPOSITION:

The material when tested in accordance with IS 12308 shall conform to the following chemical composition.

Constituent percentage:

Carbon	Silicon	Manganese	Phosphorus	Sulphur
3.9 to 4.7	0.40 Max.	0.050 Max.	0.040 Max.	0.015 Max.

Revisions:

Title and chemical composition changed and 2.0, 3.0, 5.0, 7.0 to 10.0 clauses added.

Issued :

STANDARDS ENGINEERING DEPARTMENT

Rev No. 01

Amd No.

Reaffirmed

Prepared:

Approved:

Dt.of 1st Issue

Dt. SEP. 2008

Dt.

Year:

DY. G. M.
TECH. (F&P)

MANAGER
(STDS. ENGG.)

MAR. 2002

HY10378	PLANT PURCHASING SPECIFICATION HYDERABAD	
REV. NO. 01		
PAGE 2 OF 2		

7.0 SAMPLING:

Three respective samples shall be drawn from each consignment of 10 MT or part thereof and a composite sample shall be made for testing and approval.

8.0 INSPECTION AT SUPPLIER'S WORKS:

In addition to the Manufacturer's Test Certificate, the Test Samples shall be also Tested in a Govt. Registered / BHEL Approved Laboratory and Test Certificate furnished along with the supplies made to BHEL.

Final sample Test on the materials will be carried out at BHEL-Hyderabad before final acceptance.

9.0 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificate shall 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 clearance of the material.

The test certificates shall bear the following information.

HY10378, Rev. No. 01: SPECIFIC GRADE OF PIG IRON

BHEL Order No. : -- & date.

Manufacturer's / Supplier's name

Trade Mark, if any

Consignment / Identification No.

Test results of chemical analysis

10.0 PACKING AND MARKING:

The material shall be supplied in truck / wagon loads in loose condition but shall be protected to minimize exposure of the materials from moisture / rain during transit.

From the total consignment, atleast 2 pcs. shall be marked with unwashable paint and with following information. These 2 pcs. shall be exclusively tied up with wire in a bundle and this bundle kept with the full consignment for exclusive identification of the total lot.

HY10378, Rev. No. 01: SPECIFIC GRADE OF PIG IRON

BHEL Order No. : -- & date.

Manufacturer's / Supplier's name

Heat No. :

Consignment / Identification No.

Weight :