

PSGSG/16-17/05	Specifications for Rupture Disk Assembly	Drg.No.	RD 99 320 600
		Date	12.05.16
		Product	GSM-420
			vendor compliance
1.0	APPLICATION: Rupture disk assembly (drg. No. RD 99 320 600) for a gas insulated system. The gas pressure in this metal enclosure is maintained at 0.75 MPa. This leak tight assembly shall meet following specification.		yes/no
2.0	SPECIFICATIONS:		yes/no
2.1	Material : Low Carbon Austenetic stainless steel conforming to AISI-304 .		yes/no
2.2	Flanges shall be MIG welded with suitable SS electrode.		yes/no
2.3	The welded sections shall be sized as per drawing and verified /tested using Dye Penetration (D.P.) technique at all stages of welding. Inside edges/weld shall be fused to obtain near smooth weld surface.		yes/no
2.4	The top and bottom flanges shall be welded co-axial in the limits of manufacturing drawing.		yes/no
2.5	The assembly should be cleaned, degreased and prepared for pressure test. The assembly shall be tested at 8.5 bar pressure for 4 hours and pressure drop shall be recorded and communicated to BHEL. The leak shall be rectified and the test repeated to satisfaction. Components indicating drop in pressure during this test will not be accepted. The arrangement shall be kept at 15 bar for 15 minutes prior to this test to verify pressure withstanding capabilities.		yes/no
2.6	Necessary metal enclosure/dish end will be provided by BHEL for required pressure test.		yes/no
2.7	The supplier shall stress relieve tested component to ensure zero post supply deformation.		yes/no
2.8	Stress relieved component shall be electro-polished on the inside surface using moderate current densities.		yes/no
2.9	The assembly further shall be sandblasted on the outer surface and powder coated (> 50 Micron) to shade RAL 6032 . During this operation all flanges shall be masked at the sealing surfaces and at the rim.		yes/no
2.10	The accepted component shall be packed in wooden boxes with suitable PVC covers on the flanges to prevent transit damages.		yes/no
2.11	Following certificates shall be furnished for acceptance of the component:		yes/no
	a. Material source certificate,		yes/no
	b. Material test certificate ,		yes/no
	c. Pressure drop test and pressure withstand test report,		
	d. Electro-polishing schedule		yes/no
2.12	A certified copy of above documents shall be sent along with the delivery note.		yes/no
3.0	The components shall be guaranteed against all manufacturing defects.		yes/no
4.0	In case of doubts in specifications, the supplier shall contact BHEL for clarifications.		yes/no