 बीएचईएल Ranipet	Technical Delivery Condition (TDC) For Rectangular / Square Hollow Sections	Doc Ref:	TDC:RTE:252
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1.0 Scope:

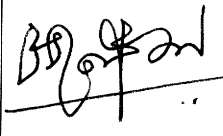
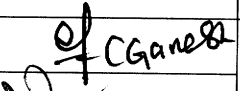

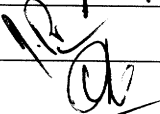
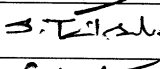

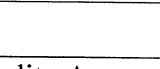
- 1.1 This TDC details the requirements for the supply of ERW square and rectangular hollow sections.
- 1.2 The applicable specification are a) ASTM A 500 GR B b) ASTM A 501 GRB and c) YST 310 of IS:4923.
- 1.3 The size, length, Quantity and specification as per the Enquiry/Purchase Order.
- 1.4 The process of manufacture, chemical and mechanical properties and identification on material shall be as per the applicable specification requirements.

2.0 Design requirements:


- 2.1 In case of rectangular hollows, the electric resistance weld seam shall be at the center of the largest side. This requirement is to avoid weld over weld of hooks and seams during further fabrication.
- 2.2 The permissible variation for the shift of the weld seam from the center of the side can be maximum 25% of the side.

3.0 Dimensional Tolerances:

- 3.1 The minimum Wall thickness at the centre of the flats of Square/Rectangular hollow sections shall be not less than two (2) percent than the specified wall thickness.

Prepared by	Reviewed by	Signature	Approved by
	Engg(AQCS)		
	Matl. Png		
	Purchase		
	QC(Procurement)		
	QA		Head(QA)

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- 3.2 Weight of 10 Tons lots should not be less than two (2) percent of the weights of the respective Square / Rectangular hollow sections.
- 3.3 For specific lengths, length tolerance shall be: (+) 15mm and (-) 0.0mm
- 3.4 For unspecified length, Lengths shall be of ten(10) mtr with Length tolerance of (+) 15mm and (-) 5.0mm
- 3.5 Straightness = 2mm per Meter max.
- 3.6 Twist:
Length less than or equal to 6.5Mtr is 2mm +0.5mm per meter
Length more than 6.5Mtr is 3mm +0.5mm per meter
- 3.7 The ends of square/rectangular hollow sections shall be square cut and Smooth without burrs.
- 4.0 Packing:**
- 4.1 The Hollows shall be suitably packed to withstand transit and handling damages. The weight of each bundle/crate shall not exceed one metric ton. The ends of the pieces shall be protected so that no damage or corner cracks occur during transit.
- 4.2 Rust preventive coating of hollows shall be done by dipping process (both inside & outside) to withstand corrosion for a least one year.
- 5.0 Test Certificate:**
- 5.1 Detailed correlated Test certificates in English, to be submitted along with the supply, for the tests conducted as required in the respective specification and in this TDC.
- 5.2 BHEL reserves the right to carry out tests and to reject the items wherever non Conformance to the TDC/Specification is observed in the supply.

03	16-02-2011	Dimension and weight tolerance revised for clause no. 3.2 to 3.6
02	15-05-2002	Totally reviewed and reissued based on feedbacks.
01	31-12-1998	All amendments to TDC were merged and revised and reissued.
00	15-07-1995	Totally reviewed and reissued based on feedbacks.
Rev. No.	Date	Revision Details

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