



## CORPORATE PURCHASE SPECIFICATION

AA 544 07

Rev. No. 01

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### CARBON DIOXIDE GAS – Gr.: 1

#### 1.0 GENERAL

This specification governs the quality requirements of Carbon dioxide gas, grade 1.

#### 2.0 APPLICATION

Used for welding.

#### 3.0 COMPLIANCE WITH NATIONAL STANDARDS

The material shall comply with the requirements of the following national standard and also meet the requirements of this specification.

IS : 307 – 1966, Gr.: 1 | Carbon dioxide

#### 4.0 TEST SAMPLES

One cylinder from each consignment shall be taken for testing and approval.

#### 5.0 PROPERTIES

When tested as per the test methods shown against each, the gas shall show the following properties:

##### 5.1 Carbon Dioxide (Appendix A-2 of IS:307 or Gas chromatograph):

99.7%, min. by volume.

##### 5.2 Moisture (Appendix A-6 of IS:307 or Dew point):

0.001%, max. by volume.

#### 6.0 TEST CERTIFICATES

Three copies of test certificates shall be supplied alongwith each consignment, giving the following information:

In addition, the supplier shall ensure to enclose one copy of the test certificate alongwith the despatch documents to facilitate quick clearance of the material.

Revisions :  
Cl 32.11.29 of MOM of MRC-CPO

APPROVED :  
INTERPLANT MATERIAL  
RATIONALISATION COMMITTEE-MRC (CPO)

Rev. No. 01

Amd.No.

Reaffirmed

Prepared

Issued

Dt. of 1st Issue

Dt. 15.02.2004

Dt :

Year :

HYDERABAD

Corp. R&D

AUGUST, 1988

AA 544 07

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**CORPORATE PURCHASE SPECIFICATION**



AA 544 07, Rev. 01 : Carbon dioxide gas, Gr.: 1  
BHEL Order No.  
Batch / Lot No.  
Supplier's/ Manufacturer's Name and Grade  
Test results of clause 5.0.

**7.0 PACKING & MARKING**

The gas shall be supplied compressed in cylinders. The design of cylinders, pressure of gas in cylinders, packing, marking, painting, labeling and transport of cylinders shall be in accordance with the 'Gas Cylinder Rules - 1940' of the Government of India with such modifications as may be ordered from time to time by the Chief Inspector of Explosives, Government of India or other duly constituted authority.

The cylinder ground colour shall be black and the cylinder band shall be white or aluminium (as per IS : 5).  
The cylinders shall also be marked with the BIS certification mark.

All cylinders shall be securely tagged with the following information:

AA 544 07: Carbon dioxide gas, Gr.: 1  
BHEL Order NO.  
Supplier's / Manufacturer's Name & Grade  
No. of Cylinders  
Net & Gross weight

**8.0 ENVIRONMENTAL REQUIREMENTS :**

The supplier shall furnish Material Safety Data Sheet (**MSDS**) covering all information relating to human safety and environmental impacts of the hazardous materials particularly during their transportation, storage, handling and disposal alongwith each supply.

Each container shall be marked with corresponding symbol and minimum worded cautionary notice for flammable / corrosive / toxic / harmful / irritant and oxidizing etc. as applicable.

**9.0 REFERRED STANDARDS (Latest Publications Including Amendments):**

1. IS : 5

2. IS: 307