






|   <p>BHEL Maharatna Company Celebrating 50 Years of Engineering Excellence (1964-2014)</p> | | PLANT PURCHASE SPECIFICATION | | No. | BHEL/FP/TS/31 | |
|---|--|--|-----------------------------------|-----------------|----------------------|--------|
| | | FABRICATION PLANT | | Rev. No. | 01 | |
| | | DEPARTMENT: PRODUCTION | | Rev. Dt. | 28.02.15 | |
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| CSU & FP, Jagdishpur | | | | | | |
| Technical Specification for Neutural Fused Flux F7P2 - EM 12 K/EH14 | | | | | | |
| Sr. No. | Description | Requirement | Vednor to Furnish/Confirm | Offered | Deviation | Remark |
| 1 | Technical Details: | | | | | |
| 1.1 | F7P2 - EM 12 K/EH14 | 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 \geq 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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| Sr. No. | Description | Requirement | Vednor to Furnish/Confirm | Offered | Deviation | Remark |
|-------------------------------|--|--|---|---------|---|--------|
| 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 characteristic: 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 | | | |
| QUALIFYING CONDITIONS: | | | | | | |
| 3.1 | Only those makes and brand shall be quoted of which atleast 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 | | | |
| 3.2 | Name of the customer / company where flux has been supplied. | | Vendor to specify | | | |
| 3.3 | Complete postal address of the customer. | | Vendor to specify | | | |
| 3.4 | Year of supply. | | Vendor to specify | | | |
| 3.5 | Application for which the Flux is supplied with details. | | Vendor to specify | | | |
| 3.6 | Name and designation of the contact person of the customer | | Vendor to specify | | | |
| 3.7 | Phone, FAX no. and email address of the contact person of the customer. | | Vendor to specify | | | |
| 3.8 | 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 | |  |  | |  | |
| Name | | V K Choudhary | Ajay Dwivedi | | Raghendra Singh | |
| Designation | | Sr. Engineer | Sr. Engineer | | Manager | |
| Date of issue | | 28.02.2015 | | | | |