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SPECIFICATION FOR TUBE SHEET FORGING FOR HIGH PRESSURE FEED WATER HEATERS.

1. The forging shall conform in all respect to SA-350 LF2 CL.1, ASME sec. II part-A, year of edition & addenda as mentioned in drawing/enquiry/P.0.

2. Both heat & product analysis shall be certified.

3. Location of Test specimen for tensile testing shall be as per fig. UW-13.3(a) of ASME Sec.VIII Div.1. It should meet material specification.

4. Impact test shall be carried out on each forging as per A370 and the acceptance values shall be as follows

Test Temp.	Average of 3 Specimens (J)	Individual Min. (J)
-45.6ºC	20	16

5. Forging shall be ultrasonically tested. Acceptance shall be as per Std. HE71044.

6. Surface to be overlayed shall be MT tested.

7. Along with each tube sheet one attested test coupon of size as per drawing from the same heat/cast shall be supplied for proving C-seam at BHEL.

8. Inspection and certification:

a) where the material is sourced from suppliers other than India, the certification shall be in IBR form III G duly signed by BHEL Approved Third Party Inspection Agency (BHEL TPIA). BHEL TPIA shall be authorised by Central Boiler Board for that country.

b) Where the material is sourced from Indigenous Suppliers, the certification shall be by Director of Boilers in form III G and also by BHEL Approved Third Party Inspection Agency (BHEL TPIA) as per ASME SEC.II Part A. Edition & Addenda as indicated in the drawing/P. O & enclosed quality plan.

9. All Quality requirements and certification shall be as per Quality Plan No. HY/HE/001 Tube Sheet.

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RECORD OF REVISIONS

REV NO:	DATE	REVISION DETAILS	REVISED	APPROVED
07	10-09-93	STANDARD REWRITTEN AS PER NEW FORMAT.	**B.U.G**	**D.S**
08	10-07-03	Cl.NO1,6 & 8 ARE REVISED. & Cl.NO.9 ADDED.	**KKK**	**BS**
09	12-01-07	Cl.NO.08 Revised.		
10	19-01-17	Cl.NO.08 Revised.	**A K SAHOO**	**K. KISHORE KUMAR**

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