

**MATERIAL STANDARDS
DIESEL LOCO MODERNISATION WORKS
PATIALA**

NUMBER

MISC - 041

INDEX

MMAW
ELECTRODE

SHEET

1 OF 3

MMAW ELECTRODE SPECIFICATION

DATE

01-7-2010

1. Item P. L. No. : 76.01.9147
2. Scope : The electrode shall be used for welding of fabrication works of Plain C- Mn Structural Steel Plates/ Sections to IS- 2062 /226
3. Description : Metal arc welding Electrodes (Heavy coated).
4. Size : 6.30 x 450 mm / 4 SWG
5. AWS Classification : E - 6020
6. IS Designation : EA - 4255 X to IS 814 (Latest version)
7. Coating : Heavy to IS: 814 (Latest version)
8. Current : Should work on AC / DC .
9. Positions : HF & F .
10. Type of Joints : Butt & Fillet welding.
11. RDSO Approval : Not any, at present. However, RDSO approved Vendor Directory must be referred to, as and when released; for the class of approval, in future.
12. Electrode Identification : Size, Brand, Month & Year of manufacture , Batch number, No of pcs. etc must be legibly marked on each Carton / Packet

BASED ON DLW SPEC. - MISC -041 Rev - R3. (SUPERSEDES DMW SPEC. - MISC -041 Alt - NIL).

ISS/ID	WM/D	DATE
01	01	01/07/10
ALTERATION		
SPEC. REVISED & RE-DRAWN. (VIDE DLW Rev. - R3).		
ALT No.		
01		
VALIDATED		
WM / D		
CHD.		
ISS / D		
DRN.		
JE		

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31-7-2010

13. DMW Approval

DMW approval will be accorded to new vendors based on capability assessment of the firm to supply consistently good quality product and satisfactory after-sales service, as and when needed.

Availability of minimum Quality Assurance facilities is a must. Product approval will be based on Lab and Field trials as per Quality Plan No. L/CMT/002.

14. Packing Standard

Counted and weighed electrodes shall be kept in total moisture- proof strong polythene bags and sealed. The sealed bags shall then be kept in reasonably strong cardboard cartons, which also will be heat- shrunk sealed with strong Polythene Sheet. The cartons shall have printed on it – the name & address of the manufacturer, electrode brand-name, IRS class with IS and / or AWS code, coating factor, batch no. , date of manufacture, size, current & voltage conditions and & other welding parameters, quantity, cautionary note on safety aspects during welding and storage and other relevant parameters/recommendations.

Total weight of a carton shall not exceed 7 Kg. Each carton shall then be sealed and put in a polythene bag and sealed / shrink- sealed. Counted number of so sealed cartons shall be kept in suitable wooden or cardboard crate / box and stripped tightly to take care of any damage during transportation and storage.

The details of packing may vary from manufacturer to manufacturer but in essence, it must have two moisture proof polythene bag / layers; out of which, at least one polythene bag / layer must be shrink-packed (preferably — the outer one shrink-packed and the inner one-therms sealed).

14. Radiographic Standard

IW Blue Std.

VALIDATED WM / D	
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NOTE :

- (i). Vendors are advised to study actual application of electrodes in DMW before quoting for the first time.
- (ii). Any incompatibility or ambiguity in specification is to be brought out and clarifications sought, before quoting or obtaining orders; rather than after supply of the items.
- (iii). DMW reserves the right to verify that actual supplies do fulfill all the requirements by actual tests at DMW or RDSO. Failure to meet designated class requirements may attract blacklisting; even if as prima-facie findings, the electrodes were found satisfactory in routine observations.
- (iv). In case of rejection, Dy. COS (D) will advise the vendor, who will send his technical representative with full advice. Findings of joint inspection will be signed by AWM/SSE of concerned shop on behalf of DMW and Firm's Representative on behalf of the vendor. No extra facilities over those--normally available in shop-floor, will can be provided. In case of dispute in interpretation of joint inspection results, decision of concerned Dy.CME will be final.
- (v). The date of manufacture should not be earlier than two months from the date of receipt at DMW.
- (vi). Satisfactory Shelf life—12 months (minimum) from the date of receipt at DMW.

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