



ब्रह्मपुत्र क्रेकर और पालीमेर लिमिटेड

(भारत सरकार का उपक्रम)

Brahmaputra Cracker and Polymer Ltd.

(A Government of India Enterprise)

SECTION – V

TECHNICAL SPECIFICATION SPECIAL CONDITIONS OF CONTRACT



TECHNICAL SPECIFICATION

Description	Refillable empty Oxygen Gas Cylinder with Valve & Valve Guard	Refillable empty Argon Gas Cylinder with Valve & Valve Guard	Refillable empty Dissolved Acetylene (DA) gas cylinders with Valve & Valve Guard
Gas service	Oxygen	Argon	Dissolved Acetylene
IS standard for manufacturing	IS 7285-2	IS 7285-2	IS 7312
Cylinder type	SEAMLESS STEEL	SEAMLESS STEEL	WELDED STEEL
Water capacity (Ltr)	46.7	46.7	41
Tare weight (in Kg approx.)	50- 54 kg	50- 54 kg	53-55 kg
Test pressure (Kg/cm ²)	250	250	50
Filling Pressure (Kg/cm ²)	150	150	16
Cylinder outside Dia (mm)	232	232	258
Cylinder length (mm)	1370	1370	960
Neck internal treading	As per IS 3224		
Colour of cylinder*	Black	Peacock Blue	Maroon
Valve specification	As per IS 3224		
Valve protection guard	Metallic valve protection guard		
Filling permission	Filling permissions issued by Petroleum & Explosives Safety Organisation (PESO)		
Testing and other certification	As per relevant IS standard		

Note :

1. All cylinder must have cylinder filling permissions issued by Petroleum & Explosives Safety Organisation (PESO) and same must be submitted for all cylinders at the time of supply.
2. All Cylinders must conforms to all statutory requirement issued by Govt of India time to time.
3. All cylinders will be fitted with suitable type of valve specified in IS 3224
4. Colour of the cylinders as per IS 4379
5. Testing and certification:
 - All cylinders must be inspected and tested as per relevant IS standard by authorised inspection body and test certificate must be submitted at the time of supply.



- Following test record/ certificate is required for every cylinder

For Oxygen and Argon cylinder

- a) Hydraulic proof pressure test/ hydraulic volumetric expansion test
- b) Hardness test
- c) Leakage test;
- d) Water capacity check
- e) Ultrasonic examination

For Dissolved Acetylene Cylinder

- a) Certificate of analysis covering the material of the sheet of which the particular cylinder was made.
- b) Result of the tensile test
- c) Result of the hydrostatic stretch test indicating compliance only
- d) Result of leakage test indicating compliance only
- e) Water capacity in kg
- f) Weight of each cylinder when empty and dry plus those of fusible plugs, valve pad and foot-ring, if any, and any part permanently attached to the cylinder, but not including valve or cap
- g) Weight of complete cylinder, that is, weight of item (f) plus weight of porous filling, but not including valve or cap:
- h) Weight of cylinder in item (g) plus weight of saturation gas, solvent at atmospheric pressure and valve, but not including valve cover, if any
- i) Type of porous filling and percentage porosity of the filling material.

6. Marking: Permanent marking / stamping of each cylinder as per relevant IS guidelines . Serial number of the cylinder to be marked clearly for proper identification.

Other terms :

- **Delivery Schedule:** Material should be supplied within 90 days from the date of placement of purchase order
- **Warranty :** Material should be free from any manufacturing defects and to be guaranteed for a period of 01 (one) year from the date of delivery



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- Bidder must fill the following table and same need to be submitted along with technical bid.**

Description	Refillable empty Oxygen Gas Cylinder with Valve & Valve Guard	Refillable empty Argon Gas Cylinder with Valve & Valve Guard	Refillable empty Dissolved Acetylene (DA) gas cylinders with Valve & Valve Guard
Gas service	Oxygen	Argon	Dissolved Acetylene
IS standard for manufacturing			
Cylinder type			
Make of the offered cylinder			
Water capacity (Ltr)			
Tare weight (in Kg approx.)			
Test pressure (Kg/cm ²)			
Filling Pressure (Kg/cm ²)			
Cylinder outside Dia (mm)			
Cylinder length (mm)			
Neck internal treading			
Colour of cylinder*			
Valve specification			
Valve protection guard			
Filling permission			
Testing and other certification			

NB: Without above information technical bid will not be evaluated