


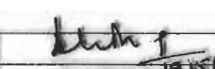
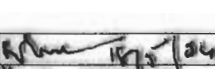
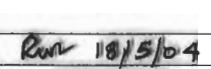
**GOVERNMENT OF INDIA
(Ministry of Railways)**

**SPECIFICATION FOR
FLUORSPAR**

(PL No. 81980401)

Issued by

**MECHANICAL DRAWING OFFICE
RAIL WHEEL FACTORY
YELAHANKA, BANGALORE-560 064
INDIA**

 CME 18/5/04	 CWE/Mfg 18/5/04	 Dy. CME/Mfg 18/5/04	 SSE/MDO 18/5/04
APPROVED BY	REVIEWED BY	VERIFIED BY	PREPARED BY

SPECIFICATION FOR FLUORSPAR**1.0 SCOPE**

The specification covers the requirements of Fluorspar used for melting of steel in Rail Wheel Factory, Yelahanka, Bangalore – 64.

2.0 DESCRIPTION

Fluorspar is used as a flux for thinning the slag generated particularly at the oxidising stage in the making of steel by ultra high power Electric Arc Furnace.

3.0 RESTRICTIVE REQUIREMENTS



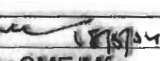
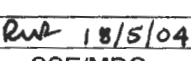
3.1 Fluorspar if supplied in briquette form should be in the size range of 35 to 45mm. In case supplies in lump form, the size range shall be 20 to 30mm without binder.

3.2 The chemical composition shall generally conform to Grade 3 of Table 1 of IS 4574:1989

1. Ca F ₂ (min)	: 80%
2. Si O ₂ (max)	: 8%
3. CaCO ₃ (max)	: 3%
4. Sulphur (max)	: 0.3%
5. Mixed oxides (max)	: 3.5%

4.0 INSPECTION NORM

4.1 Sampling for chemical analysis will be done according to the latest revision of IS 2246 "Methods of Sampling of Fluorspar".

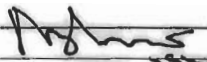
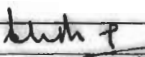

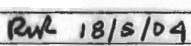
			
CME	CWE/Mfg	Dy.CME/Mfg	SSE/MDO
APPROVED BY	REVIEWED BY	VERIFIED BY	PREPARED BY

5.0 **INSPECTION NORM**

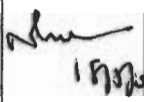
- 5.1 The supplier shall submit a test certificate pertaining to the lot supplied to Rail Wheel Factory, Bangalore, showing full conformance to the requirements.
- 5.2 The firm shall specify the shelf life in case of supply in briquettes form with binders.

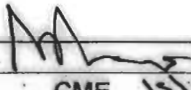
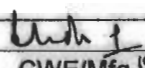
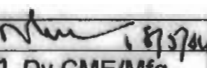
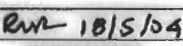
6.0 **PACKING**

- 6.1 The material shall be supplied in gunny bags of 25 kg. Each bag shall be marked with supplier's name, nomenclature, grade of the material and date of manufacture.

			
CME	CWE/Mfg 19/5/04	Dy.CME/Mfg	SSE/MDO
APPROVED BY	REVIEWED BY	VERIFIED BY	PREPARED BY

AMENDMENT SHEET

Alt	Date	Cl. No	Description	Job No	Sign
'c'	13-05-04		WAP corrected as RWF	4553	 18/5/04
		3.0	Clause 3.1 modified for clarity. Old Clause 3.2 deleted . Old clause 3.3 is modified by calling in IS 4574:1989 (New clause No. is 3.2) The other changes are: Ca F ₂ (min) : 80% was 79% Si O ₂ (max) : 8% was 8.5% Sulphur (max) : 0.3% was 0.6% Mixed oxides (max) : 3.5% was 1.8%		
		4.0	Old Clause 4.1 deleted Old Clause 4.2 renamed as Cl. 4.1 after correcting description of IS 2246		
		5.0 & 6.0	Other Clause numbers corrected after deleting Warranty clause. (Old cause No. 7)		

			
CME 15/5/04	CWE/Mfg 19/5/04	Dy.CME/Mfg 18/5/04	SSE/MDO 18/5/04
APPROVED BY	REVIEWED BY	VERIFIED BY	PREPARED BY