

WAP/M/SPECN-1/010/1987

ALT	DATE	JOB No	SIGN
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GOVERNMENT OF INDIA
MINISTRY OF RAILWAYS

SPECIFICATION FOR
GLAZE FOR POURING TUBE
PL No. 81981600

ISSUED BY
MECHANICAL DRAWING OFFICE
WHEEL AND AXLE PLANT YELAHANKA
BANGALORE

<i>A</i>	<i>Subbaya</i>	<i>Approved</i>
Dy.CME/W I	AWM/ MR	SUPDT./DES
APPD. BY	CHD. BY	PREPD. BY

SPECIFICATION FOR GLAZE FOR POURING TUBE**1.0 SCOPE:**

1.1 The specification covers the manufacture and supply of GLAZE for pouring tube to Wheel and Axle Plant, Yelahanka, Near Bangalore, Karnataka State, India, as per instructions and conditions of contract and tender papers.

2.0 GENERAL DESCRIPTION:

2.1 Glaze for pouring tube.

3.0 JOB REQUIREMENTS:

3.1 The ceramic pouring tube is dipped in a glaze material that fills the pores of the tube and make it air tight.

4.0 MATERIAL:

4.1 The chemical composition of the glaze material is given below (f)

SiO ₂	-	62.5±3%
Al ₂ O ₃	-	10±2%
Pb O	-	7.8±2%
KNaO ₂	-	5.4±1%

The density of the glaze is 1.53 gm/cc min.

Since lead oxide is health hazardous material, the firm shall certify that the solution is fritted/or lead free.

Be - 50 min - If given readily mixed.

4.2 The glaze should mature around 950°C so that tube gets glazing before it is introduced in steel at 1620°C.

4.3 If supplied with binder separately, the chemical composition of the binder is given below. (f)

SiO ₂ % by mass	-	33-36.5
Na ₂ O% by mass	-	13.4-14.6
Sp.Gravity	-	1.56-1.63

4.4 Shelf life: 3 months minimum.

4.5 The supplier shall produce/give a certificate for clause 4.0, 4.1 and 4.3 at the time of supply.

4.6 The supplier will have own sampling Norm for Chemical analysis.

5.0 Test certificate covering the chemical composition shall be accompanied each batch/lot.

5.0 Packing: In air tight HD plastic containers with facility for handling.

<i>D. Singh</i>	<i>Andhyan</i>	<i>A. W. Deshpande</i> 4.7.94
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