

STAINLESS STEEL 316L SEAMLESS DRAWN PIPES B.O.Q / TERMS & CONDITIONS**MATERIAL STANDARDS**

ASTM A312 TP 316L
 UNS Designation S 31603

GENERAL REQUIREMENTS

- i) The Stainless Steel 316L Pipes shall be provided in Seamless Drawn, Annealed and Pickled condition.
- ii) The Stainless Steel 316L Pipes shall conform to the general requirements of ASTM A 999/A 999M - 12.

BILL OF QUANTITIES

Sr. #	Size of Pipe	Quantity	
		No. of Lengths (6 m/length)	Weight (kg)
1.1	DN 8 Sch. 40s, L= 6M	(50 Nos.)	190 Kg
1.2	DN 15 Sch. 40s, L=6m	(40 Nos.)	300 Kg
1.3	DN 15 Sch. 80s, L=6m	(40 Nos.)	390 Kg
1.4	DN 20 Sch. 80s, L=6m	(100 Nos.)	1320 Kg
1.5	DN 20 Sch. 160s, L=6m	(20 Nos.)	872 Kg
1.6	DN 25 Sch. 40s, L=6m	(75 Nos.)	1125 Kg
1.7	DN 25 Sch. 80s, L=6m	(50 Nos.)	970 Kg
1.8	DN 40 Sch. 40s, L=6m	(100 Nos.)	2430 Kg
1.9	DN 40 Sch. 80s, L=6m	(250 Nos.)	8100 Kg
1.10	DN 50 Sch. 80s, L=6m	(20 Nos.)	895 Kg
1.11	DN 80 Sch. 10s, L=6m	(60 Nos.)	2310 Kg
1.12	DN 150 Sch. 40s, L=6m	(25 Nos.)	4280 Kg
1.13	DN 300 Sch. 10s, L=6m	(05 Nos.)	1020 Kg
1.14	DN 350 Sch. 20s, L=6m	(04 Nos.)	1080 Kg
1.15	DN 400 Sch. 20s, L=6m	(02 Nos.)	950 Kg
1.16	DN 450 Sch. 20s, L=6m	(02 Nos.)	1080 Kg

TERMS & CONDITIONS OF SUPPLY

The Stainless Steel 316L pipes shall conform to the requirements of chemical composition & mechanical properties as follow:

DIMENSIONAL REQUIREMENTS

The Stainless Steel 316L Pipe shall conform to dimensional requirements of ASME B 36.19.

CHEMICAL COMPOSITION

The steel shall conform to the requirements as to chemical composition prescribed in Table 1 ASTM A312/A312M-12.

MECHANICAL PROPERTIES:

- i) The tensile properties of the material shall conform to the requirements prescribed in Table 4, ASTM A312/A312M-12.
- ii) Mechanical Tests required shall be performed in accordance with Test Methods and Definitions ASTM A 370.

TOLERANCES

The permissible variations in mass, wall thickness, inside diameter, outside diameter and length of pipes must be according to section 9, 10, 11, 12 & 13 respectively of ASTM A999/A 999M-12a.

MILL TEST CERTIFICATE

Mill Test Certificate provided shall be in accordance with EN 10204:2004 Type 3.1

INTERGRANULAR CORROSION TEST

The material shall pass Intergranular Corrosion Tests conducted for each batch in accordance with Practice A and C of ASTM A262-02a and provide along with Mill Test Certificate.

EDDY-CURRENT TEST

The supplied pipes shall pass Eddy-current tests conducted by the manufacturer in accordance with practices ASTM E 426-12.

WORKMANSHIP, FINISH AND APPEARANCE

The finished pipes shall be reasonably straight and shall have workmanlike finish in conformance to section 14, ASTM A312/A312M-12.

PRODUCT MARKING

The finished pipes shall be marked in conformance to section 17 of ASTM A312/A312M-12 and section 26 of ASTM A999/A999M-12.

INSPECTION

- i) Inspection of material by the purchaser's representative at the production site shall be foreseen as part of the purchase order.
- ii) The manufacture shall afford the purchaser's inspector all reasonable facilities necessary to satisfy the inspector that the material being furnished is in accordance with the specifications.

PACKAGING, MARKING AND LOADING:

The packaging, marking and loading for shipment shall be in accordance with the procedures of Practices ASTM A700.