



जवाहरलाल नेहरू एल्युमिनियम अनुसंधान विकास एवं अभिकल्प केन्द्र, नागपुर

(स्वायत संस्थान, खान मंत्रालय, भारत सरकार के आधीन), अमरावती रोड, वाडी, नागपुर - ४४० ०२३ (भारत)

Jawaharlal Nehru Aluminium Research Development and Design Centre

(Autonomous Body Under Ministry of Mines, Government of India)

Amravati Road, Wadi, Nagpur - 440 023 (India)

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JNARDDC
In the service of aluminium industry

Ref: 48 /JNARDDC/S&P/2017/ B-9

Date: 01.11.2017

As superscribed on the envelope.

Sub: Invitation of Quotation for procuring of Consumable (Alloy Billets-AA2024 & AA7075)

Dear Sir,

The Centre is interested in procuring of Consumable (Alloy Billets-AA2024 & AA7075) for JNARDDC.

SN	Scope of supply	Qty.
1.	<u>Alloy Billets - AA2024</u> <u>Alloy Billets - AA7075</u> (As per technical details given in Annexure -A)	2 tons 2 tons

You are therefore requested to send your competitive offer for above in a sealed envelope duly superscribed on top of the envelope as " Quotation for Alloy Billets-AA2024 & AA7075 with Tender No. & date." to the undersigned latest by 9th November 2017 (15 Hrs) by hard copy / email to jnarddenagpur@gmail.com

Visit www.jnarddc.gov.in for complete details

सधन्यवाद ,

आपका आभारी,

(आर. श्रीनिवासन)

सचिव एवं वरिष्ठ प्रशासनिक अधिकारी

आर. श्रीनिवासन, R. Srinivasan

सचिव एवं वरिष्ठ प्रशासनिक अधिकारी/Secretary Cum Sr. Admin. Officer
जवाहरलाल नेहरू अल्युमिनियम अनुसंधान विकास एवं अभिकल्प केन्द्र
Jawaharlal Nehru Aluminium Research Development & Design Centre,
Autonomous Body (Ministry of Mines), Gol. Amravati Road, Wadi, Nagpur-440023.

Technical specifications of Billets- JNARDDC requirement

Superior quality and intrinsic purity, Airslip cast, fully homogenized aluminium alloy billets are required for extrusion related research activity. The chemical composition and the dimension of the cut length of billets should be as mentioned below

Chemical Composition

Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Unspecified other elements		Al
									Each	Total	
AA2024	Max 0.5	Max 0.5	3.8-4.9	0.3-0.9	1.2-1.8	Max 0.10	Max 0.25	Max 0.15	Max 0.05	Max 0.15	Rem.
AA 7075	0.40	0.50	1.2-2.0	0.3	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05	0.15	Rem.

1. Alloy grades/designations are given as per "The Aluminum Association Inc" designation for wrought aluminium alloys. If supplier is using different designations then equivalent grade conforming this chemical composition can be quoted. Manufacturers Certificate of Conformance and MIL Test Report should be provided.
2. Billets should have been produced through Airslip casting technology. Supplier should clearly mention the method of casting.
3. Billets should be supplied in fully homogenized condition.
4. Billet should have uniform fine grain structure and minimum dendritic arm spacing. The billet should be free from inclusions, porosity, cracks and surface defects. All the billets should be ultrasonically tested as per specification AMS 2630 Class "AA" or AMS 2154 Class 'A' and test certificate should be enclosed.
5. Hydrogen content should be ≤ 0.10 ml/100gm of Al.
6. Alkalis should be $\leq 0.0015\%$ each.
7. Grain size of billets should be $< 200 \mu\text{m}$.
8. Shell zone should be ≤ 2.0 mm.
9. Type of grain refiner used should be clearly indicated.
10. In AA2024 Alloy, the Zr + Ti limit should not exceed 0.20 percent
11. In AA7075 Alloy, the Zr + Ti limit should not exceed 0.25 percent
12. Length: The tolerance on length must obey minimum ± 2 mm and maximum ± 5 mm
13. Diameter: The tolerance on diameter must obey ± 2 mm

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14. Bow tolerance: Less than 2 mm/m
 15. The angle formed by the cut face of the billet and the axis of the log should be $90^\circ \pm 0.5^\circ$.
 16. The supplier has to furnish sufficient references where similar alloy billets supplied earlier.
- If there are any deviations from this specification, it should be clearly indicated by the supplier