

**SPECIFICATION FOR OLEUM**  
**(TECHNICAL GRADE-'A')**

**3.0 SCOPE :**

- 1.1 This specification is meant to govern supply and inspection of Oleum (Technical Grade-'A').
- 1.2 The material should be suitable for use in manufacturing of NC Type-B & NC Type-C.

**2.0 DESCRIPTION:**

- 2.1 Colourless fuming liquid, miscible with water in any proportion without visible turbidity, free Sulphuric Trioxide (SO<sub>3</sub>) minimum 20% by mass and minimum 104.5% by strength and free from other impurities.

**3.0 SAMPLING:**

- 3.1 Sampling will be done as per relevant sampling procedure.

**4.0 INSPECTION:**

- 4.1 General Manager, Ordnance Factory Nalanda shall be the Inspection Authority.
- 4.2 The acceptance of the material shall be subject to final approval of Inspection Authority. Samples of the material will be taken from each tanker load of the consignment.
- 4.3 If, on examination/ laboratory test, any sample is found not conforming to this specification, the whole tanker load shall be rejected.

**5.0 TESTING:**

- 5.1 Samples taken from any tanker load of the supply shall be in accordance with clause (3) above and shall comply with requirements given below:

a) Requirements for Oleum Grade- 'A'

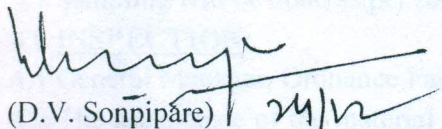
| SL.NO. | Characteristics                         | Passing standard                        | Test method                 |
|--------|-----------------------------------------|-----------------------------------------|-----------------------------|
| 01     | Appearance                              | Oleum may be off-white to brown colour. | IS:1089-1986(Rev-II)        |
| 02     | Strength                                | Min 104.5%                              | IS:1089-1986(Rev-II)        |
| 03     | Free Sulphur trioxide(SO <sub>3</sub> ) | Min 20%                                 | A-2 of IS:1089-1986(Rev-II) |
| 04     | Residue on ignition                     | Max 0.06%                               | A-3 of IS:1089-1986(Rev-II) |
| 05     | Iron (as Fe)                            | Max 0.01%                               | A-4 of IS:1089-1986(Rev-II) |

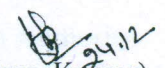
#### 6.0 LOADING/ TRANSPORTATION:

The transporter should ensure that BLIND flange will be provided on the outlet valve of the tanker after loading. Although the tanker being used for transportation shall be constructed of specific material recommended for Oleum and also adequate appliances to be used by Driver/ Cleaner.

6.1 Contractor will be responsible to bear all the responsibilities for damage/ short delivery/ non delivery and loss of stores, etc. during transit.

6.2 OUTLET of the tanker should be sealed to prevent pilferage. Any decrease in strength of the acid will go on contractor's account.

  
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