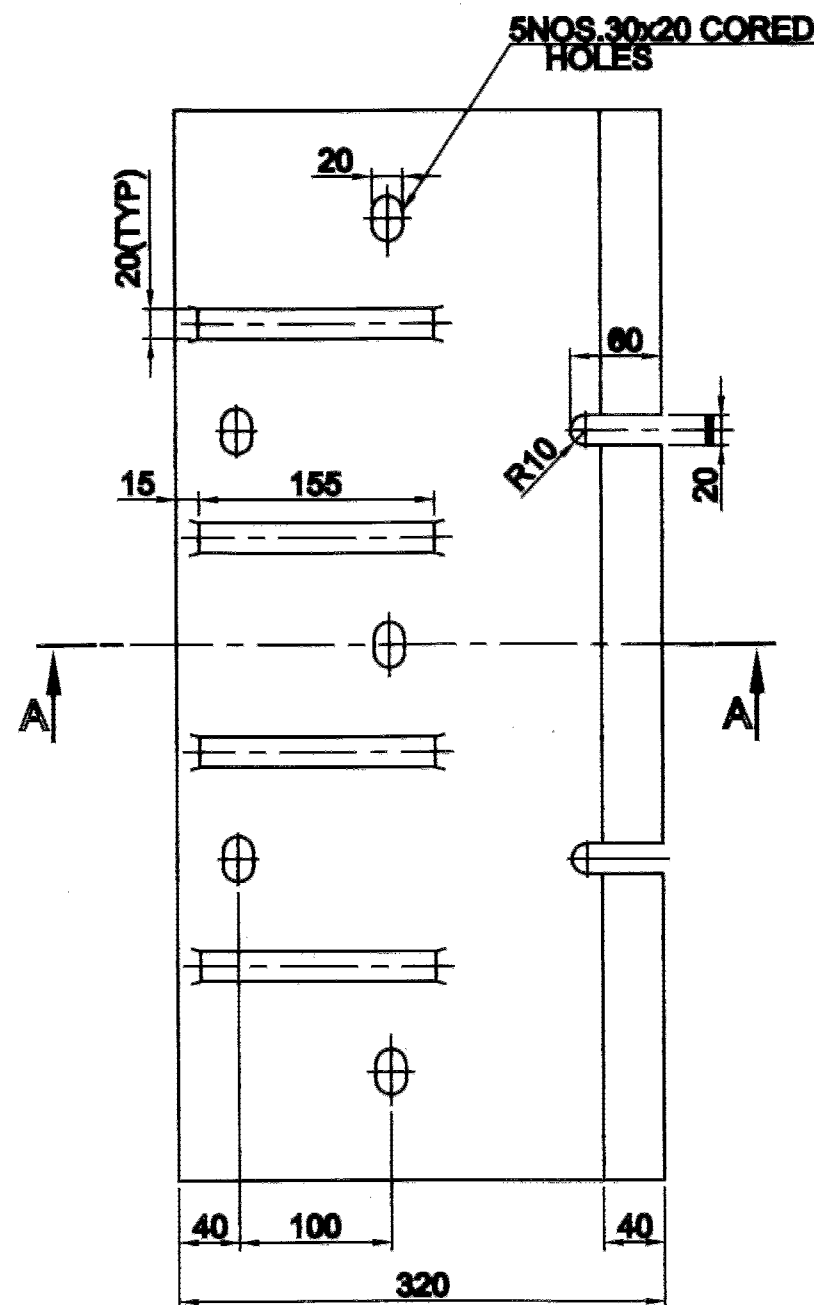


BID NO		DT	
	ANNEXURE-I		
SL NO	PRE QUALIFICATION REQUIREMENT	VENDOR COMMENTS	
1	Vendor must have a minimum of 5 years of experience in manufacturing of Iron and Steel castings. The bidder shall submit previous Purchase Order supplied to Central/ State Govt./ PSU company/ Private organization during the last five years from the date of tender. The proof of such supply (Executed Purchase Order Copy along with TDS(Tax Deducted at Source certificate) issued by the organization or Form 26 AS or Bank statement for transaction of payment for completion of supply or Performance certificate (duly signed) shall be submitted with the offer.		
	ANNEXURE -II		
SL NO	Documents requirements	VENDOR COMMENTS	
1	Signed copy of technical specification with organization seal/ stamp		
2	Executed Purchase Order Copy along with TDS(Tax Deducted at Source) certificate issued by the organization or Form 26 AS or Bank statement for transaction of payment for completion of supply or Performance certificate duly signed to meet the requirements in Annexure I S No 1. Kindly avoid sending multiple purchase orders.		
3	Filled in & signed copy of Annexure I - PQR details with organization seal / stamp		
4	Filled in & signed copy of Annexure B & C (BHEL Technical Qum Commercial Terms And Conditions) for Indigenous Vendors)with organization seal / stamp		

BID NO: _____ DT: _____

ANNEXURE - III
TECHNICAL DELIVERY
CONDITIONS:





SI No	Technical Description	Vendor Comments
1.1	Original Chemical composition and Hardness test certificate of material issued by NABL certified Lab at no extra cost.	
1.2	Detailed Dimensional inspection report of all dimensions mentioned in drawing- within tolerances as specified	
1.3	Castings with unacceptable cracks, hot tears, shrinkage, etc. to be rectified by grinding & if required by Welding. Welding, if required, is to be done by qualified welder and qualified procedure <u>as per ASME Section IX</u> .	
1.4	Dressing of castings- Free from risers, in gates, notches, undercuts and deep marks etc. a) Fused wires, parting line fins, chills etc. shall be removed by grinding. b) Castings shall be blast cleaned both inside and outside for the removal of fused sand, scales etc. c) Visual inspection of castings for surface quality.	
1.5	Material chemical composition as per drawings. dimension & tolerances, Qty, Grade/ Class: As per Purchase order & Drawings	
1.6	Rust preventive oil to be applied on castings surface	
1.7	Packaging and transportation to be good enough to ensure that the Castings arrives undamaged at SSTP/BHEL. Acceptance is subject to incoming inspection at BHEL	
1.8	Inspection report consisting of dimensions as mentioned in the BHEL approved drawing should be submitted by Vendor.	
<u>2.1</u>	INSPECTION AND CERTIFICATION:	
	Test certificates shall contain the following details. <ul style="list-style-type: none">• Purchase Order No. (BHEL), TDC No. & Test certificate number• Specification and Grade with applicable year of code, Heat Number, Quantity & Size• Steel making process, Chemistry including incidental elements - Heat wise.• Heat treatment details of the material and test bars.• Mechanical test results, NDE test results with reference & acceptance standard.• Repair details including HT, if any, Cleaning & Surface treatment details.• Any other information like clearance of sample casting.• Dimensional Inspection Report• Chemical Composition test certificate from NABL approved lab.	



VIEW-P

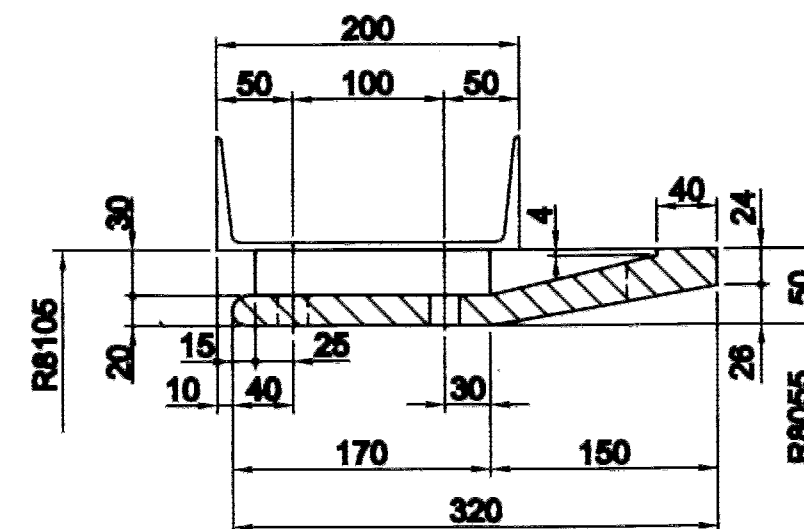
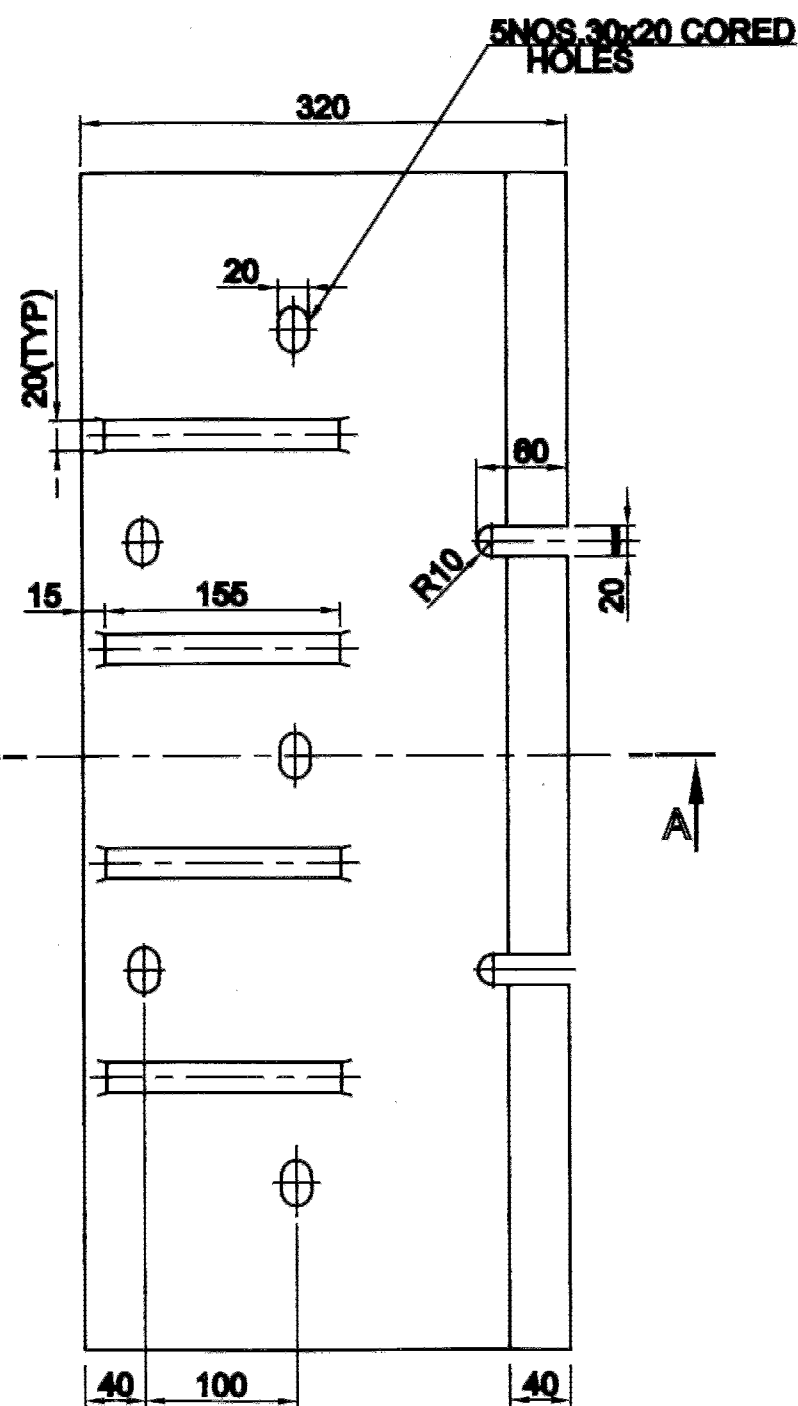
1. ALL CORNERS TO BE 3mm.RADII UNLESS STATED OTHERWISE.
2. UNSPECIFIED TOLERANCES AS PER IS:2102 MEDIUM CLASS OF DEVIATIONS.
3. ITEM NOS.TO BE PAINTED ON EACH ITEM THIS MANNER:
ITEM NO. - DRG.NO JOB.NO.
4. FOR ARRGT. OF FIXED HEARTH DIPPER PLATES
REFER DRG.NO.1-7-1101-13-00182

REV 02	DATE	ALTERED : CHECKED : APPROVED	REV 01	DATE	ALTERED : CHECKED : APPROVED
ZONE			ZONE		

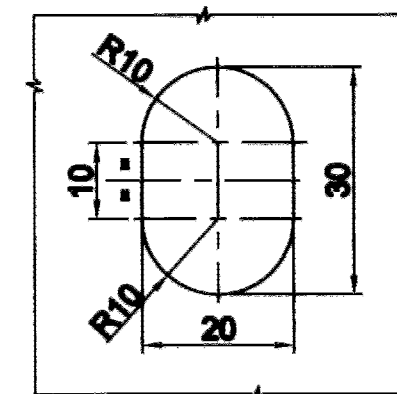
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				Gr-4 IS:4522		6
ITEM NO	DESCRIPTION		DRAWING NO		MATL CODE	UNIT WT
					MATL SPEC	QTY
EQPT: ROTARY HEARTH FURNACE						
			Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		NAME P. RAMAKRISHNAN	SIGNATURE 
					DATE 18.12.04	
					CHD SEN. KUMAR	SIGNATURE 
					APPD SHANMUGASUNDARAM S	SIGNATURE 
DEPT		GRADE OF	SCALE	WEIGHT(kg)	REF TO ASSY DWG NO	ITEM NO
MPG		UNTOL DIM	1:5			
CODE		C/M/F	1:1	40	REF TO OLD DWG NO	
					388134 2/3-4	
TITLE				CARD CODE	DRAWING NO :	REV
WALL RETAINER CASTING-I				U 01	3-7-1101-13-04701	00
OUTER WALL						



ALL DIMENSIONS ARE IN MILLIMETERS



SECTION-AA



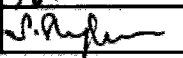



ENLARGED DETAILS OF CORED HOLES(TYPICAL)

NOTES:

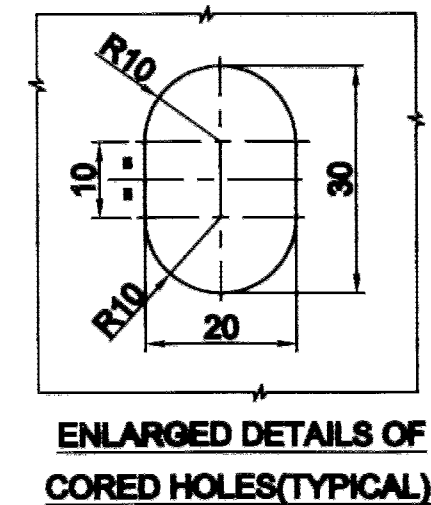
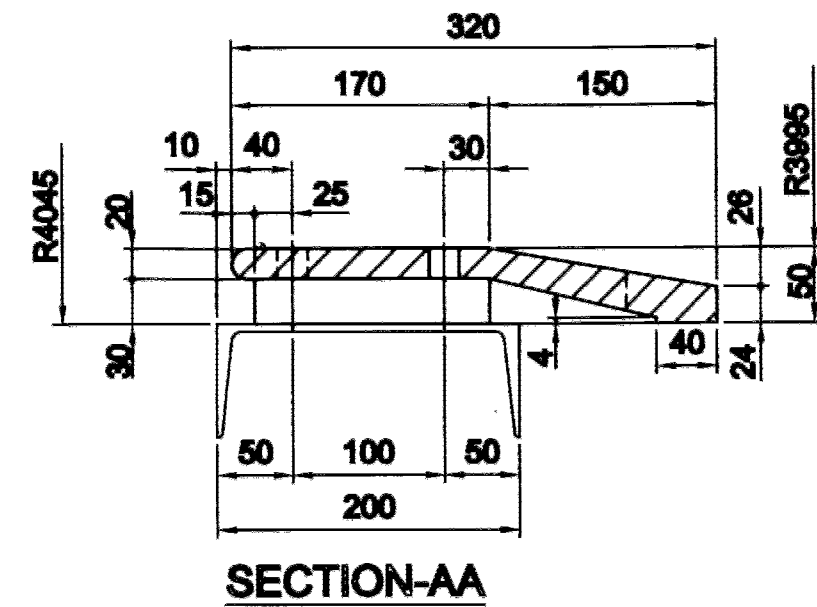
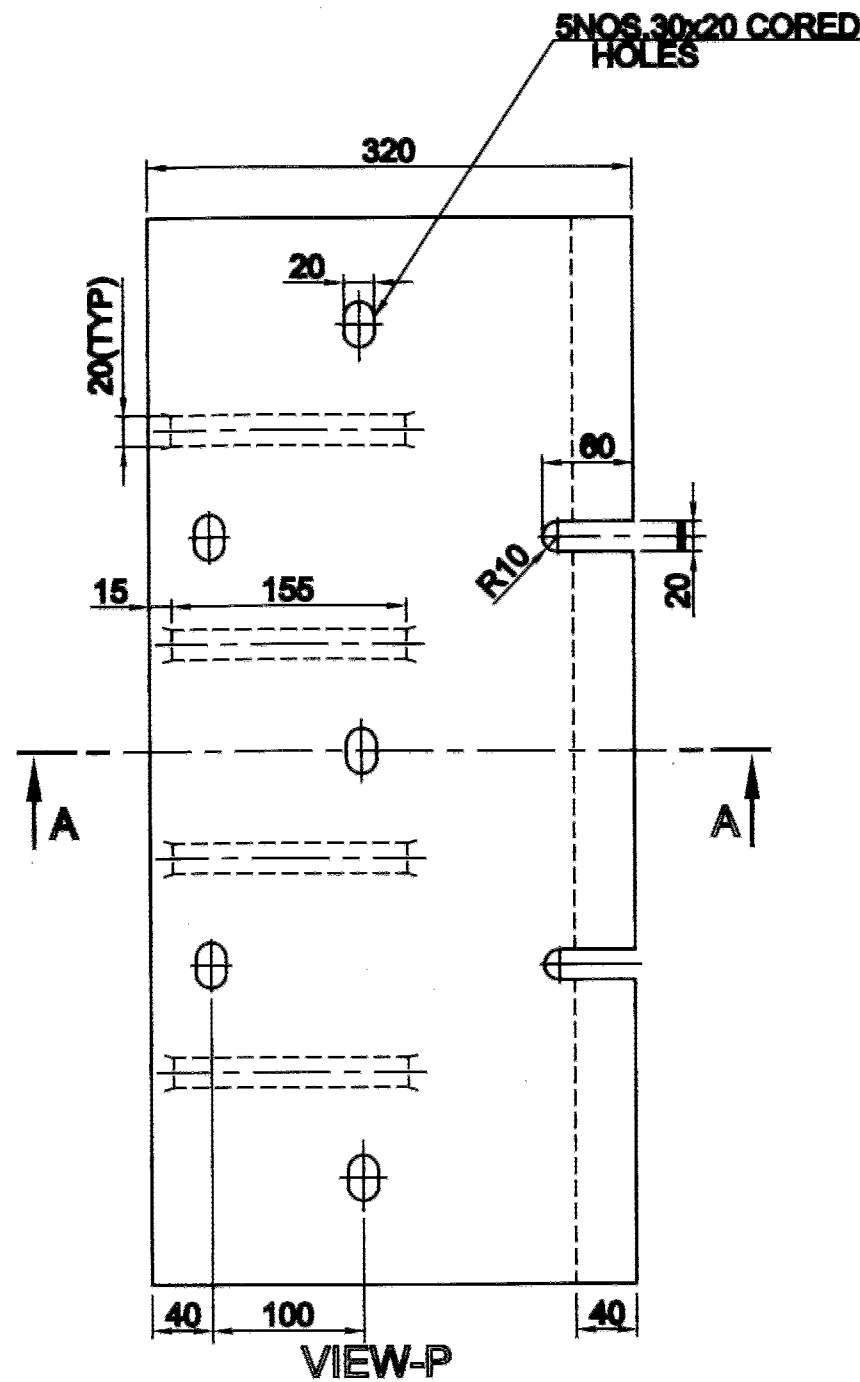
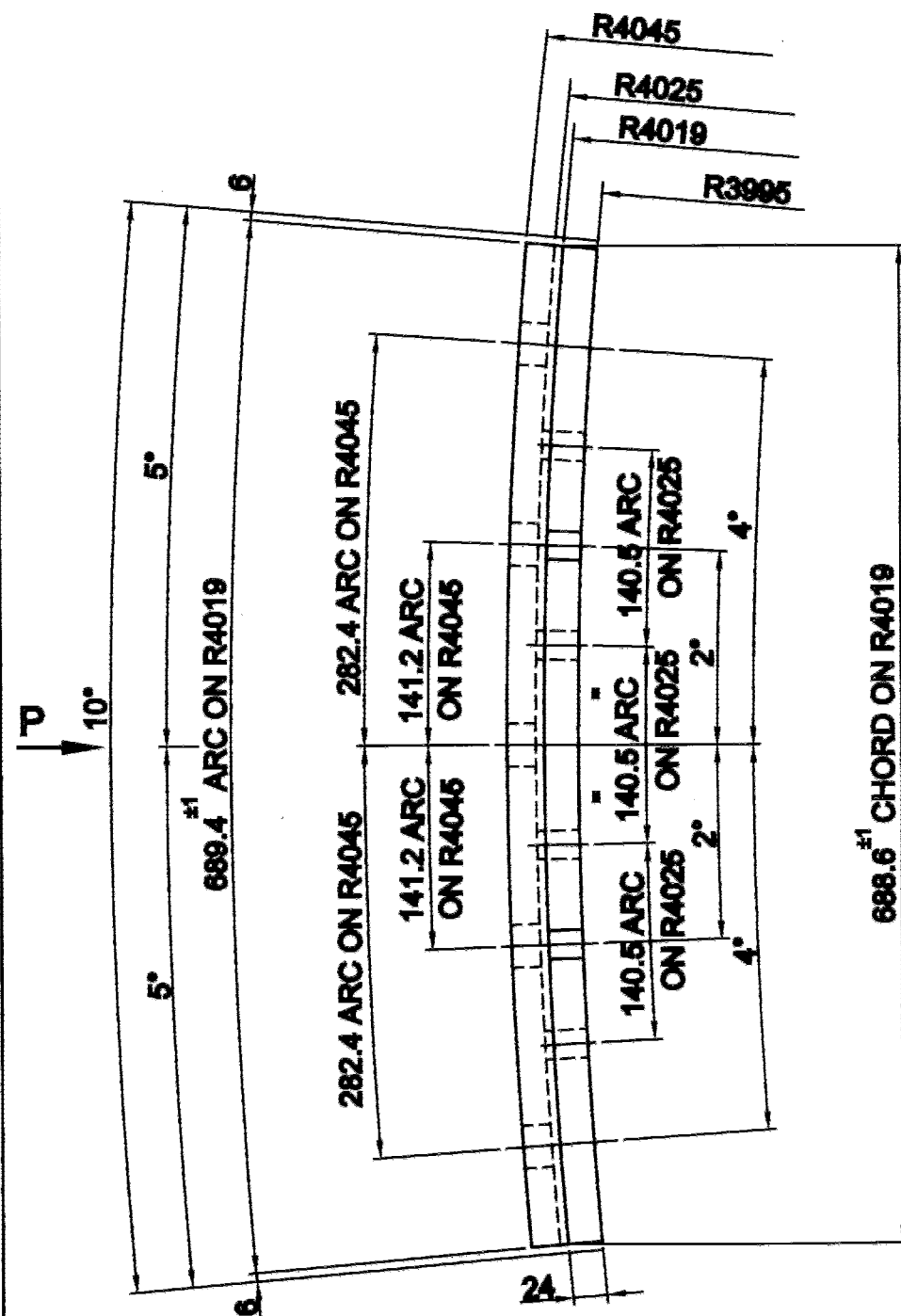
1. ALL CORNERS TO BE 3mm.RADII UNLESS STATED OTHERWISE.
2. UNSPECIFIED TOLERANCES AS PER IS:2102 MEDIUM CLASS OF DEVIATIONS.
3. ITEM NOS.TO BE PAINTED ON EACH ITEM THIS MANNER:
ITEM NO. - DRG.NO JOB.NO.
4. FOR ARRGT. OF FIXED HEARTH DIPPER PLATES
REFER DRG.NO.1-7-1101-13-00182

REV	DATE	ALTERED :	REV	DATE	ALTERED :	
02		CHECKED :	01		CHECKED :	
		APPROVED			APPROVED	
ZONE				ZONE		

				H.R.C.8			
				Gr-4 IS:4622		80	
ITEM NO	DESCRIPTION			DRAWING NO		MATL CODE	UNIT WT
						MATL SPEC	QTY
EQPT: ROTARY HEARTH FURNACE							
		Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014			DRN	NAME P. RAMAKRISHNAN	SIGNATURE 
					CHD	SEN. KUMAR	DATE 17.12.04
					APPD	SHANMUGASUNDARAM S	 18/12/04
DEPT MPG	GRADE OF UNTOL. DIM C/M/F		SCALE 1:5 1:1	WEIGHT(Kg) 43.5	REF TO ASSY DWG NO		ITEM NO
CODE					REF TO OLD DWG NO 368134 2/3-5		
TITLE WALL RETAINER CASTING-II OUTER WALL				CARD CODE U 01	DRAWING NO : 3-7-1101-13-04702		REV 00



ALL DIMENSIONS ARE IN MILLIMETERS



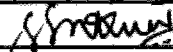




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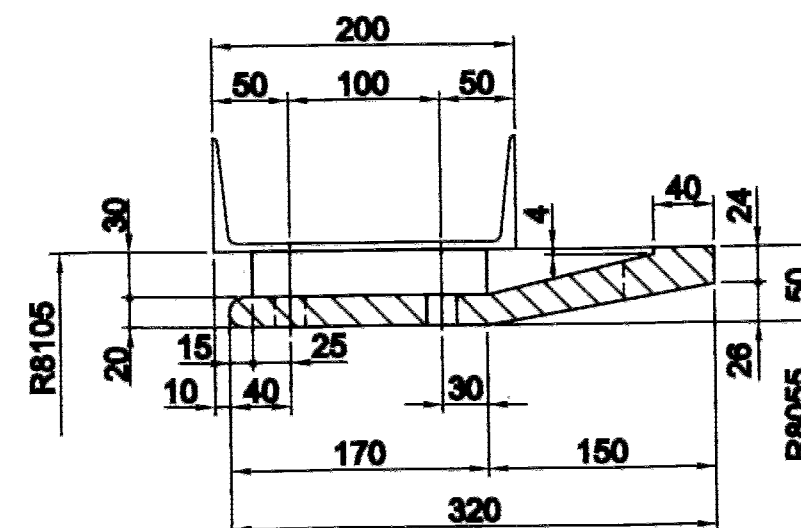
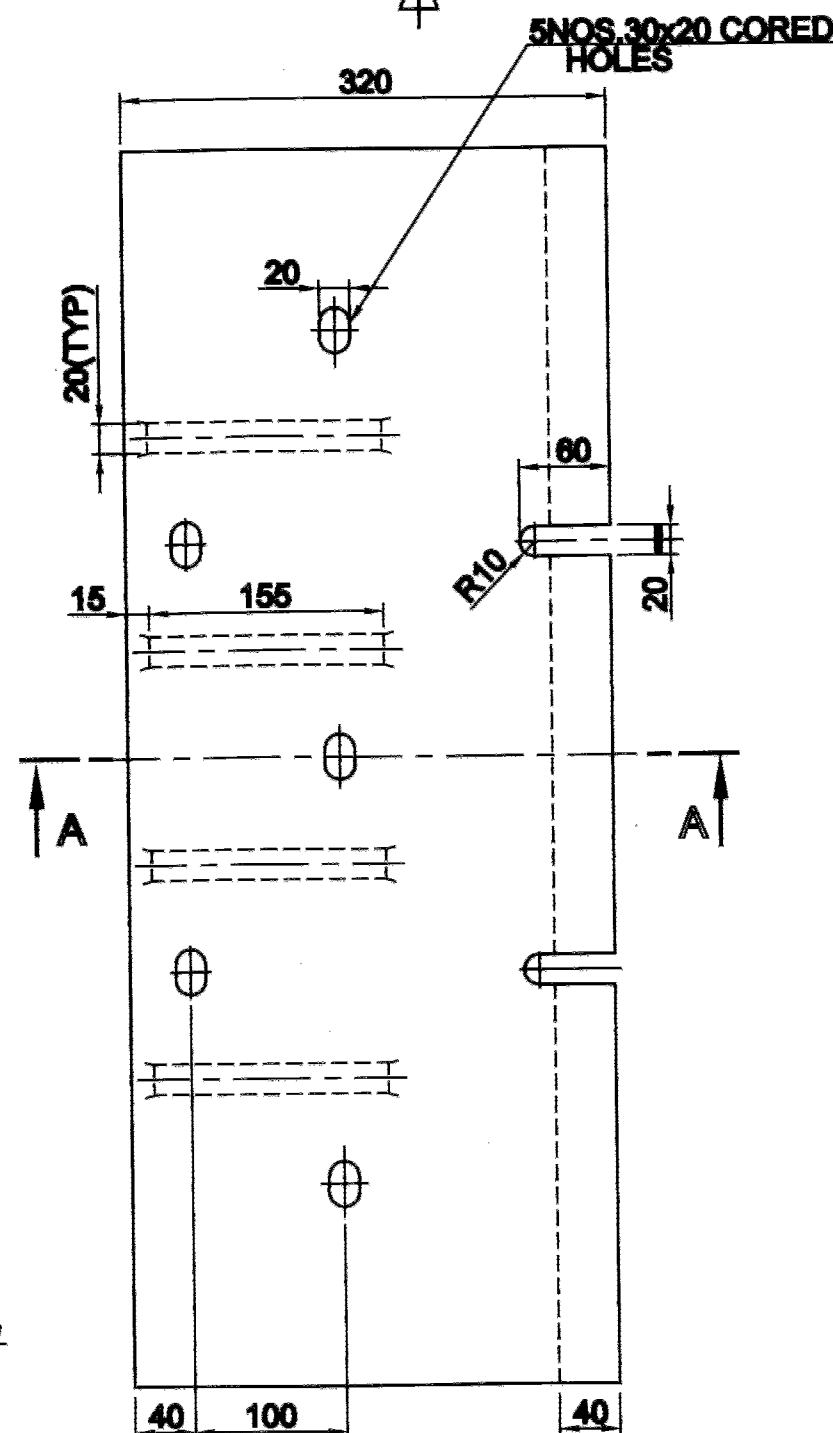
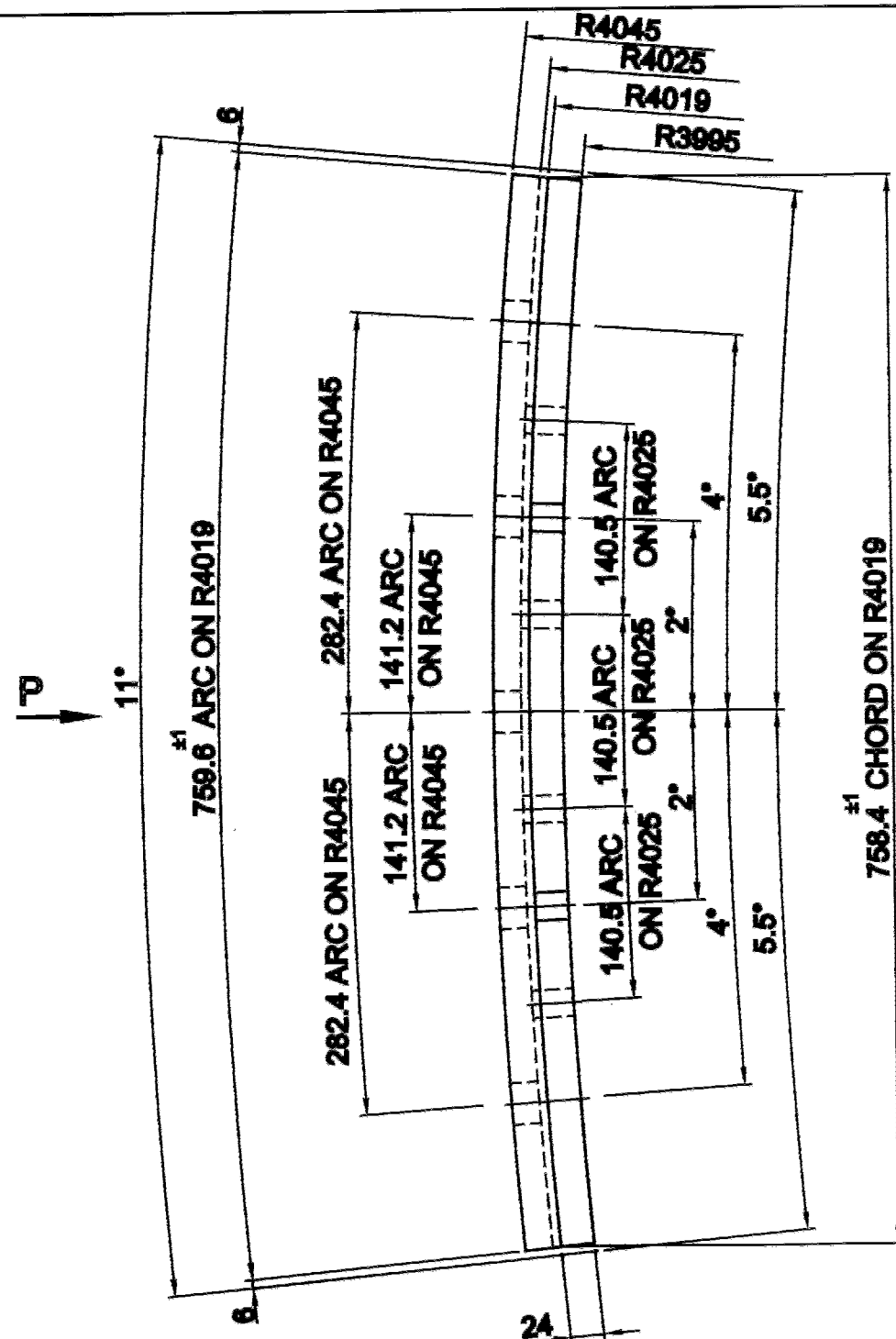
- ALL CORNERS TO BE 3mm.RADII UNLESS STATED OTHERWISE.
- UNSPECIFIED TOLERANCES AS PER IS:2102 MEDIUM CLASS OF DEVIATIONS.
- ITEM NOS.TO BE PAINTED ON EACH ITEM THIS MANNER:
ITEM NO. - DRG.NO JOB.NO.
- FOR ARRGT. OF FIXED HEARTH DIPPER PLATES
REFER DRG.NO.1-7-1101-13-00182

REV	DATE	ALTERED :	REV	DATE	ALTERED :
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		APPROVED :			APPROVED :
ZONE			ZONE		

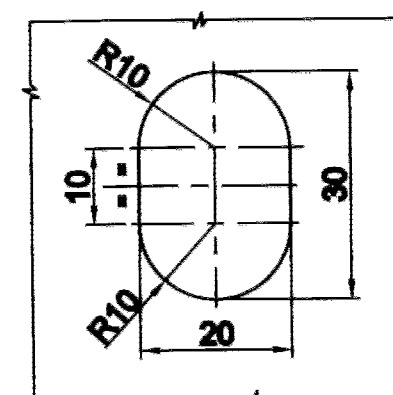
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02		CHECKED :	01		CHECKED :
		APPROVED :			APPROVED :
ZONE			ZONE		

					H.R.C.S	
					Gr-4 IS:4522	3
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE		UNIT WT	
			MATL SPEC		QTY	
EQPT: ROTARY HEARTH FURNACE						
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014			DRN	NAME P. RAMAKRISHNAN	SIGNATURE 	DATE 17.12.04
			CHD	SEN. KUMAR		18/12/07
			APPD	SHANMUGASUNDARAM S		18/12/06
DEPT MPG	GRADE OF UNTOL. DIM C/M/F		SCALE 1:5 1:1	WEIGHT(kg) 38.5	REF TO ASSY DWG NO	
CODE					REF TO OLD DWG NO 358134 2/3-6	
TITLE WALL RETAINER CASTING-III INNER WALL				CARD CODE U 01	DRAWING NO : 3-7-1101-13-04703	
					REV 00	

ALL DIMENSIONS ARE IN MILLIMETERS



SECTION-AA



ENLARGED DETAILS OF
CORED HOLES(TYPICAL)

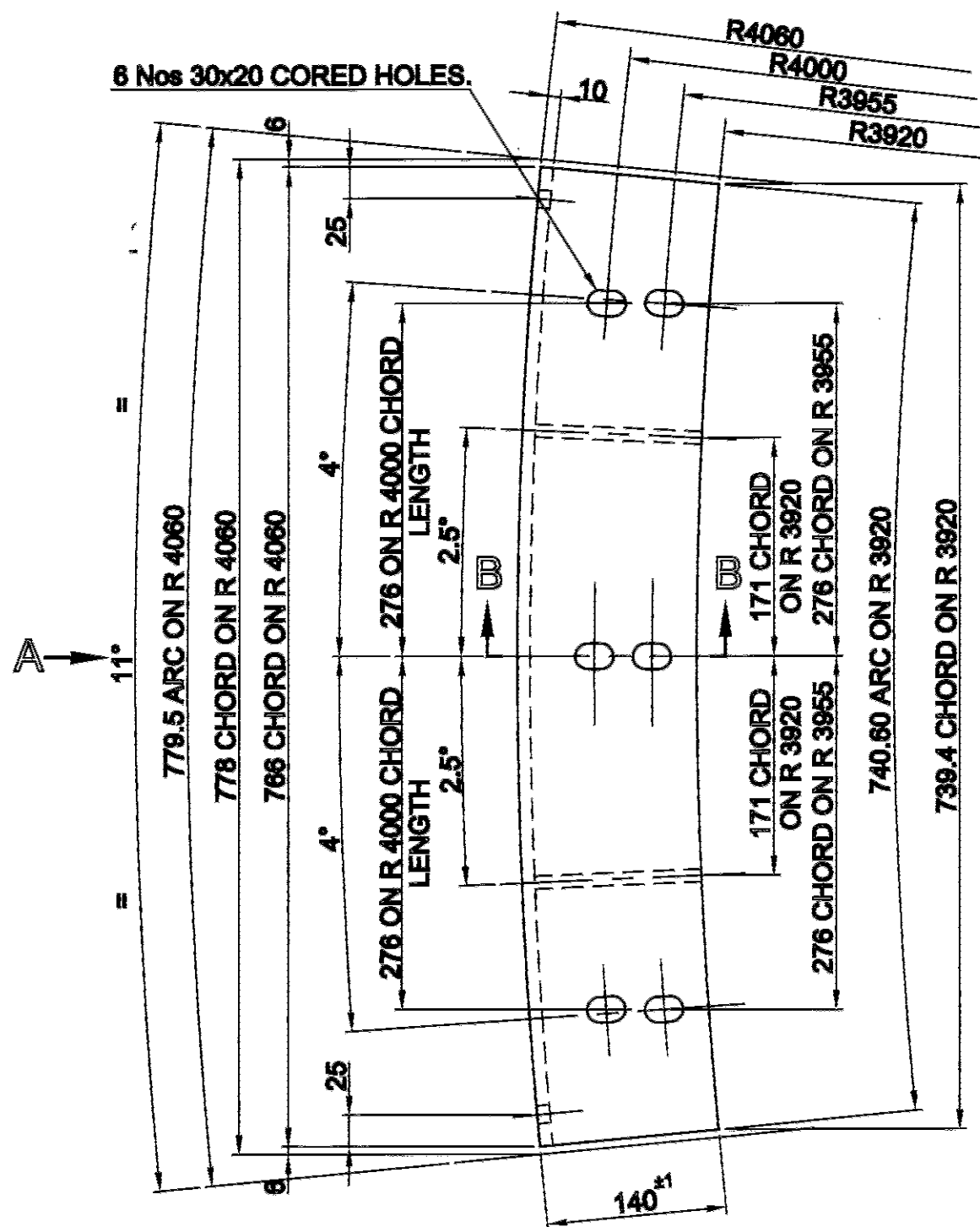
NOTES:

1. ALL CORNERS TO BE 3mm.RADII UNLESS STATED OTHERWISE.
2. UNSPECIFIED TOLERANCES AS PER IS:2102 MEDIUM CLASS OF DEVIATIONS.
3. ITEM NOS.TO BE PAINTED ON EACH ITEM THIS MANNER:
ITEM NO. - DRG.NO JOB.NO.
4. FOR ARRG.T. OF FIXED HEARTH DIPPER PLATES
REFER DRG.NO.1-7-1101-13-00182

REV	DATE	ALTERED :	REV	DATE	ALTERED :
02		CHECKED :	01		CHECKED :
		APPROVED			APPROVED
ZONE			ZONE		

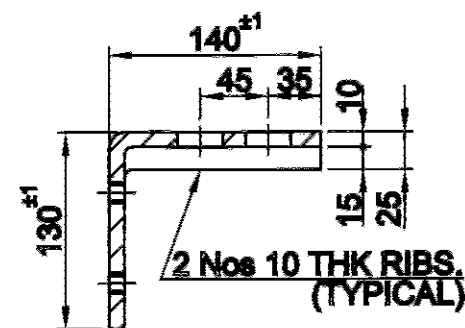
		H.R.C.8	
		Gr-4 IS:4622	
		30	
ITEM NO	DESCRIPTION	DRAWING NO	UNIT WT
			QTY
EQPT: ROTARY HEARTH FURNACE			
Bharat Heavy Electricals Ltd		DRN	NAME
SEAMLESS STEEL TUBE PLANT		CHD	P. RAMAKRISHNAN
TIRUCHIRAPALLI - 620014		APPD	SHANMUGASUNDARAM S
			SIGNATURE
			DATE
			17.12.04
			18/12/04
			18/12/04
DEPT	GRADE OF	SCALE	WEIGHT(kg)
MPG	UNTOL DIM	1:5	
CODE	C/M/F	1:1	43.2
TITLE		CARD CODE	REF TO ASSY DWG NO
WALL RETAINER CASTING-IV		U 01	REF TO OLD DWG NO
INNER WALL			358134 2/3-7
		DRAWING NO :	REV
		3-7-1101-13-04704	00

ALL DIMENSIONS ARE IN MILLIMETERS

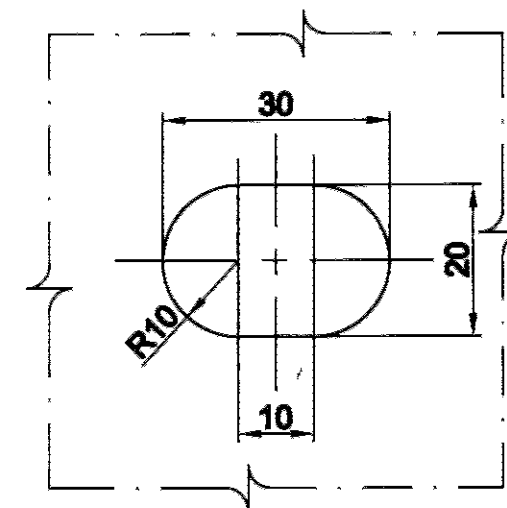


VIEW -A

4 Nos Ø14 CORED HOLES(TYPICAL)



SECTION-BB








ENLARGED DETAILS OF CORED HOLES (TYPICAL)

ALL CORNERS TO BE 3 mm.RADIUS UNLESS STATED OTHERWISE.

MATERIAL: HEAT RESISTANT CAST IRON Gr I TYPE E OF IS:3355
CHEMICAL COMPOSITION C=3.5% MIN, S=0.15%MAX,P=0.4MAX.
Cr=1.21-1.40% CARBON EQUIVALENT 3.8 TO 4.4

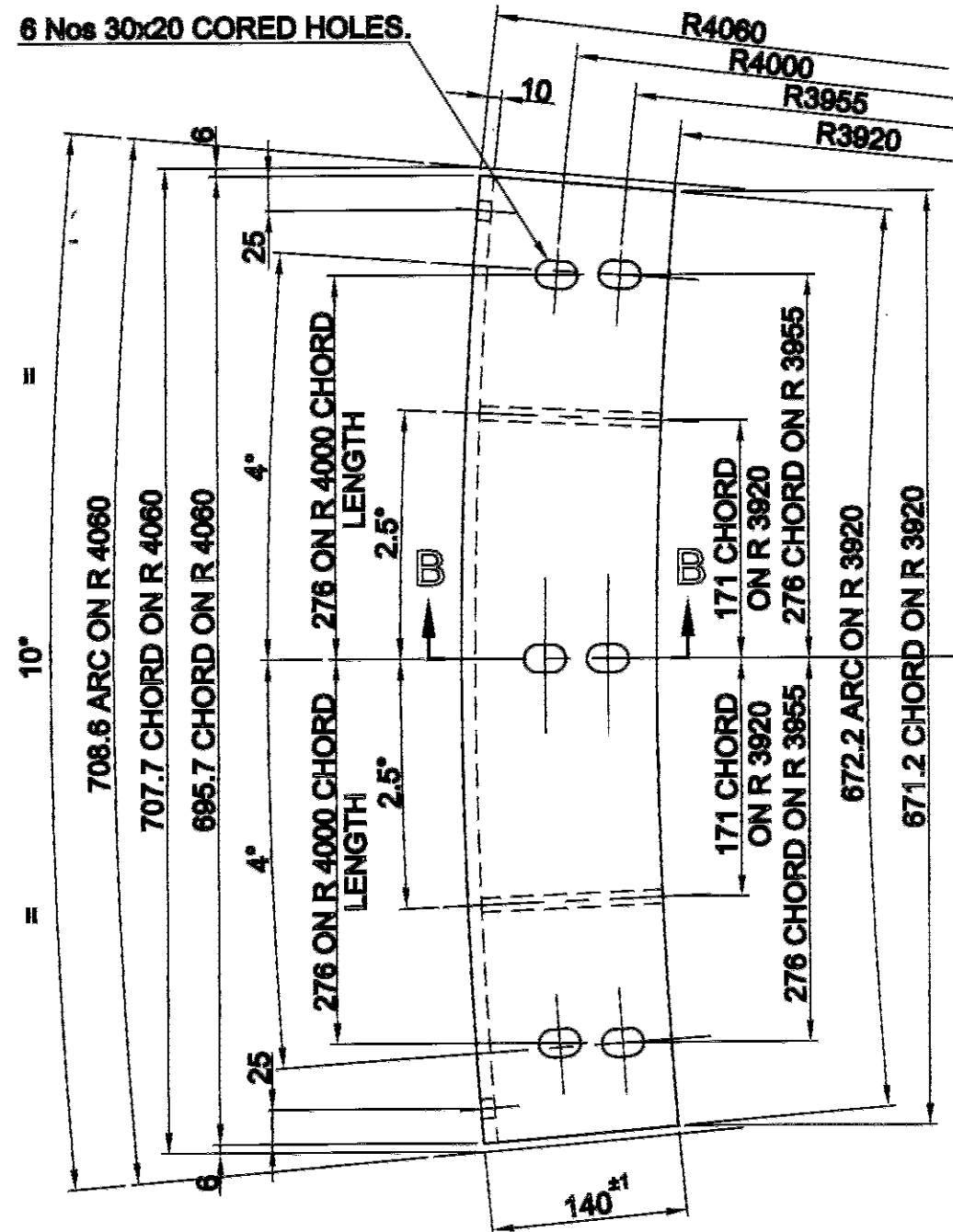
NOTE: PERMISSIBLE DEVIATIONS ON UNTOLERANCED DIMENSIONS SHOULD BE AS PER IS:5519 CLASS 2.

			REV 03	DATE	ALTERED : CHECKED : APPROVED	ITEM NO	DESCRIPTION		DRAWING NO		MATL CODE MATL SPEC	UNIT WT QTY	
			ZONE			EQPT: ROTARY HEARTH FURNACE							
							Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME BASHOKKUMAR	SIGNATURE 	DATE 04.06.02	
							CHD	SSN.KUMAR		30.5.02			
							APPD	S.SHANMUGASUNDARAM		30.05.2002			
REV 02	DATE 15.03.96	ALTERED : CHECKED : APPROVED	REV 01	DATE 24.01.96	ALTERED : CHECKED : APPROVED	DEPT	GRADE OF UNTOL. DIM C/M/F		SCALE 1:5 (1:1)	WEIGHT(kg) 15.5	REF TO ASSY DWG NO		ITEM NO
						CODE				REF TO OLD DWG NO 358134 3/3(TYPE III)			
						TITLE DIPPER PLATE CASTING (INNER FIXED)				CARD CODE U 01	DRAWING NO : 3-7-1101-13-02601		REV 02
						CORED HOLES 30x20 ON 4000 RADIUS ADDED AT 3 PLACES.							
						CHEMICAL COMPOSITION C 3.5%MIN WAS C 3.81-4.40%. CARBON EQUIVALENT 3.8 TO 4.4 AND NOTE ADDED.							

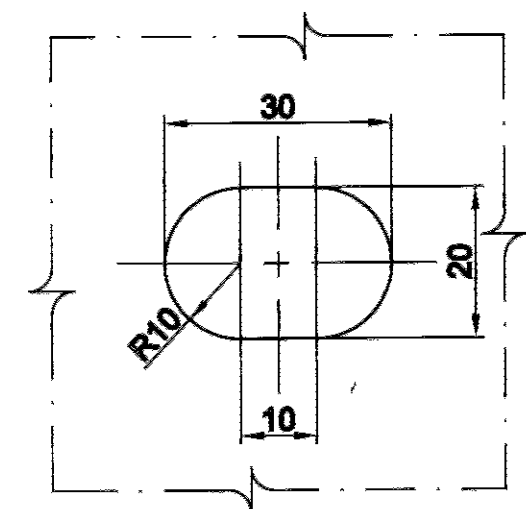
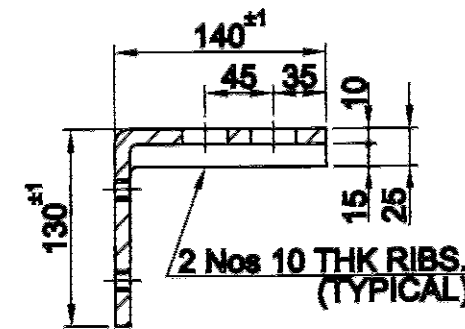
CORED HOLES 30x20 ON 4000 RADIUS ADDED AT 3 PLACES.

CHEMICAL COMPOSITION C 3.5%MIN WAS C 3.81-4.40%. CARBON EQUIVALENT 3.8 TO 4.4 AND NOTE ADDED.

ALL DIMENSIONS ARE IN MILLIMETERS



4 Nos Ø14 CORED HOLES(TYPICAL)





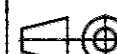


ALL CORNERS TO BE 3 mm.RADIUS UNLESS STATED OTHERWISE.

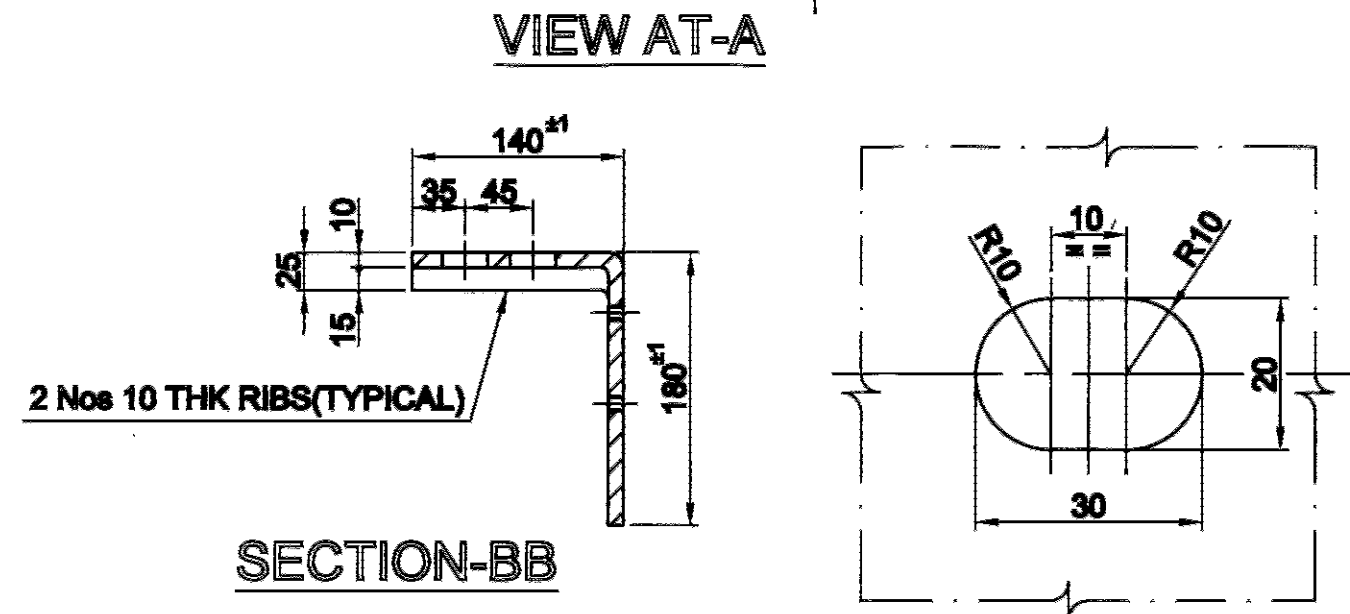
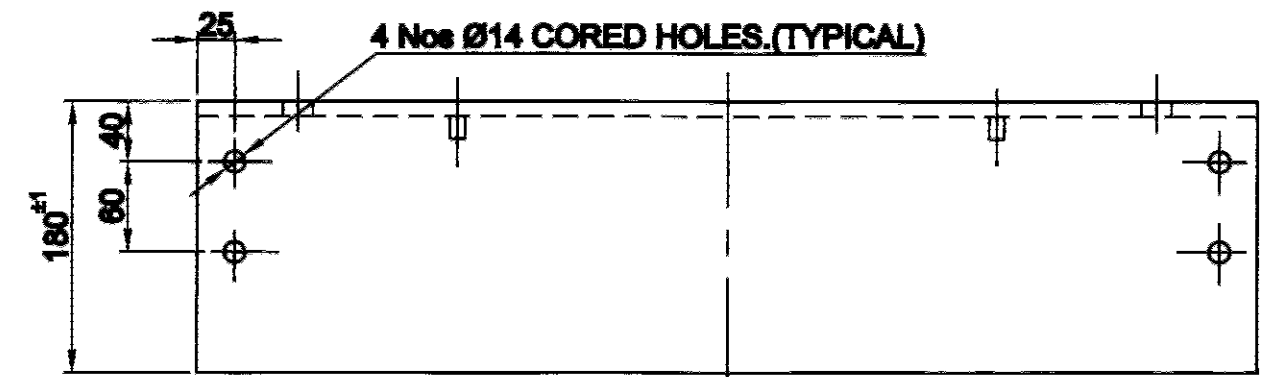
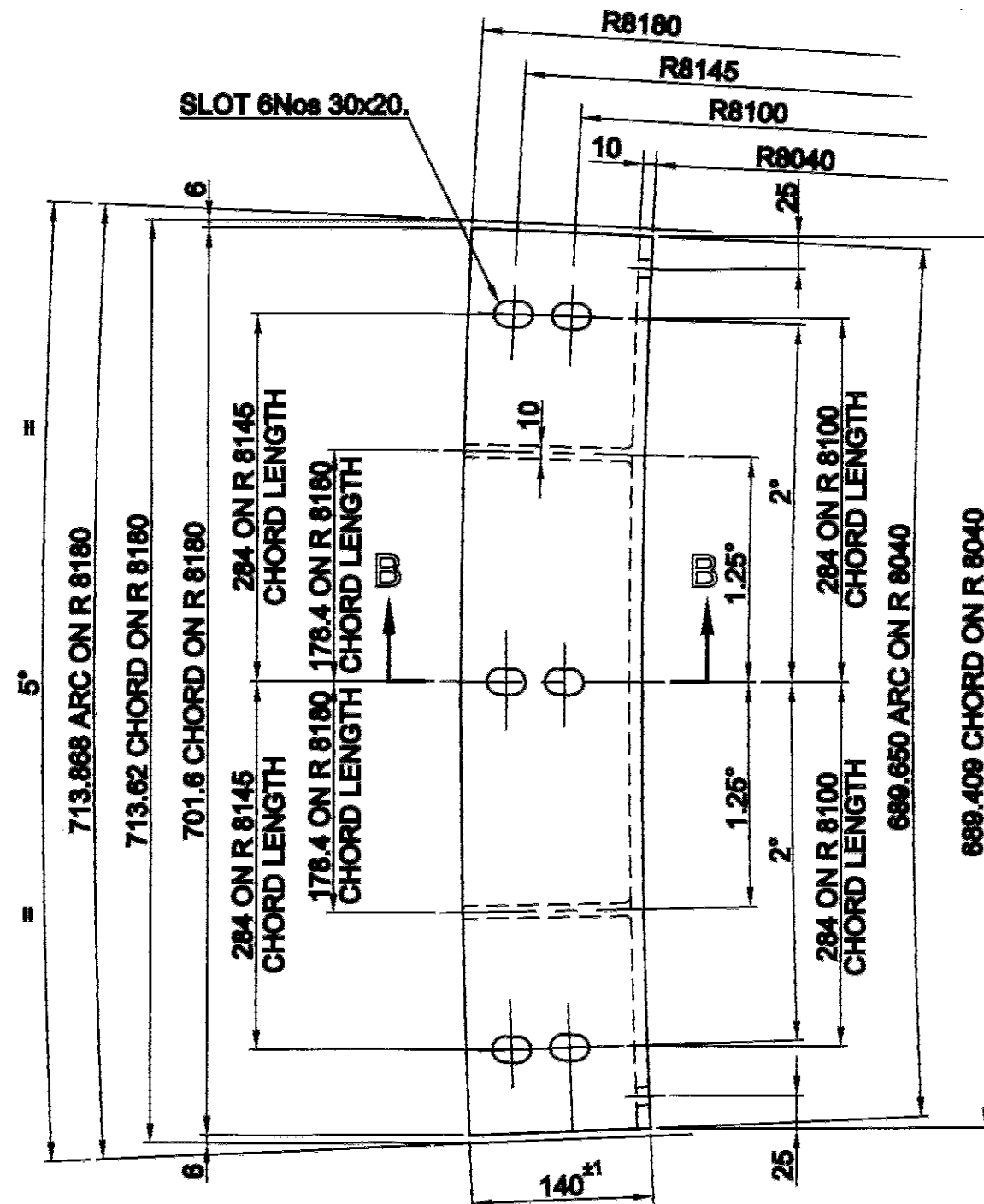
MATERIAL: HEAT RESISTANT CAST IRON Gr I TYPE E OF IS:3355
CHEMICAL COMPOSITION C=3.5% MIN, S=0.15%MAX,P=0.4MAX.
Cr=1.21-1.40% CARBON EQUIVALENT 3.8 TO 4.4

NOTE: PERMISSIBLE DEVIATIONS ON UNTOLERANCED DIMENSIONS SHOULD BE AS PER IS:5519 CLASS 2.

VIEW -A

REV 03			DATE	ALTERED : CHECKED : APPROVED	ITEM NO			DESCRIPTION			DRAWING NO			MATL SPEC			UNIT WT QTY							
ZONE						EQPT: ROTARY HEARTH FURNACE																		
									Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014			DRN	NAME B.BASHOKKUMAR		SIGNATURE 		DATE 04.05.02							
												CHD	SSN.KUMAR				30.5.02							
												APPD	S.SHANMUGASUNDARAM				30.05.2002							
REV 02			DATE 15.03.96	ALTERED : CHECKED : APPROVED	REV 01			DATE 24.01.96	ALTERED : CHECKED : APPROVED	DEPT			GRADE OF UNTOL DIM C/M/F		SCALE 1:5 (1:1)	WEIGHT(kg) 14.15		REF TO ASSY DWG NO			ITEM NO			
ZONE			CORED HOLES 30x20 ON 4000 RADIUS ADDED AT 3 PLACES.			ZONE			CHEMICAL COMPOSITION C 3.5%MIN WAS C 3.81-4.40%. CARBON EQUIVALENT 3.8 TO 4.4 AND NOTE ADDED.			CODE			TITLE DIPPER PLATE CASTING (INNER FIXED)			CARD CODE U 01	DRAWING NO : 3-7-1101-13-02602			REV 02		

ALL DIMENSIONS ARE IN MILLIMETERS

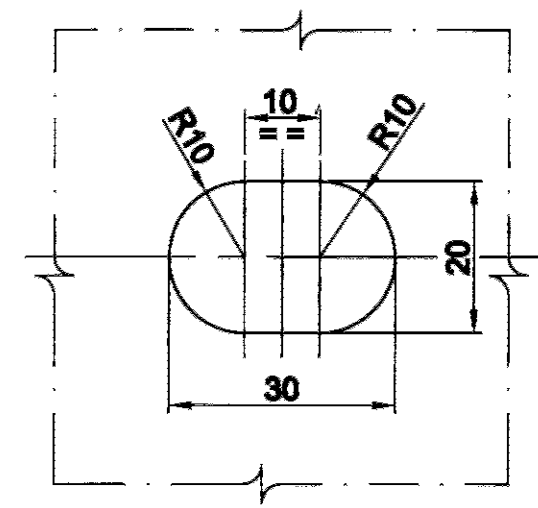


FOR ORIGINAL DESIGN REFER DRG.1-7-1101-13-00212 TYPE-I OUTER FIXED

MATERIAL: HEAT RESISTANT CAST IRON Gr I TYPE E OF IS:3355
CHEMICAL COMPOSITION C=3.5% MIN, S=0.15% MAX, P=0.4 MAX.
Cr 1.21-1.40% CARBON EQUIVALENT 3.8 TO 4.4

NOTE: PERMISSIBLE DEVIATIONS ON UNTOLERANCED DIMENSIONS SHOULD BE AS PER IS:5519 CLASS 2.

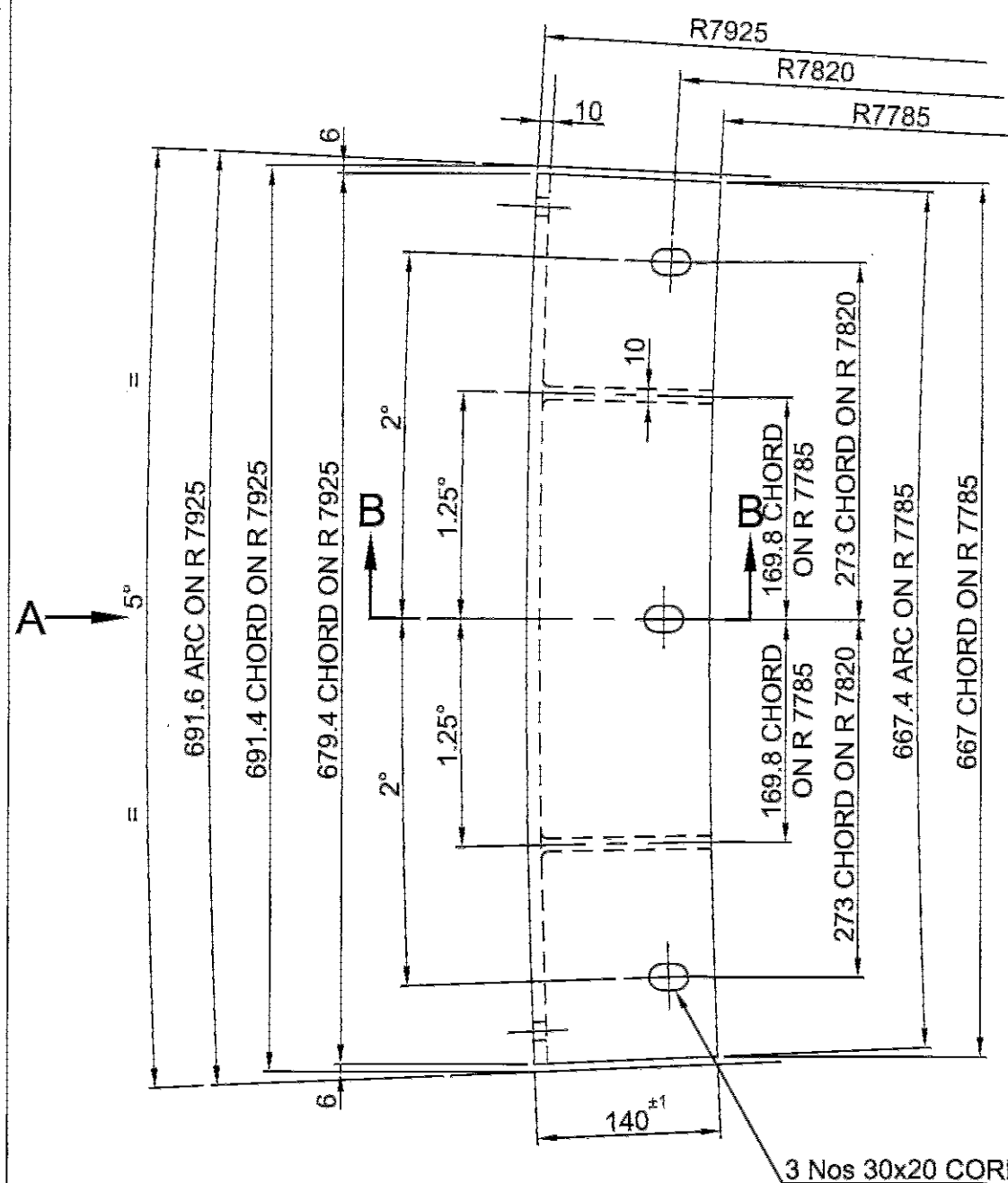
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02						CHECKED :			NO									MATL SPEC			QTY		
ZONE						APPROVED																	



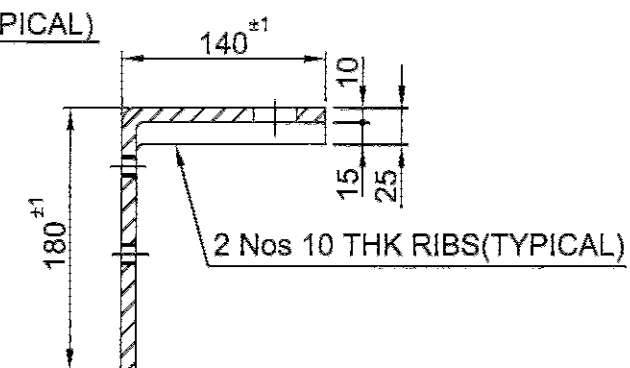
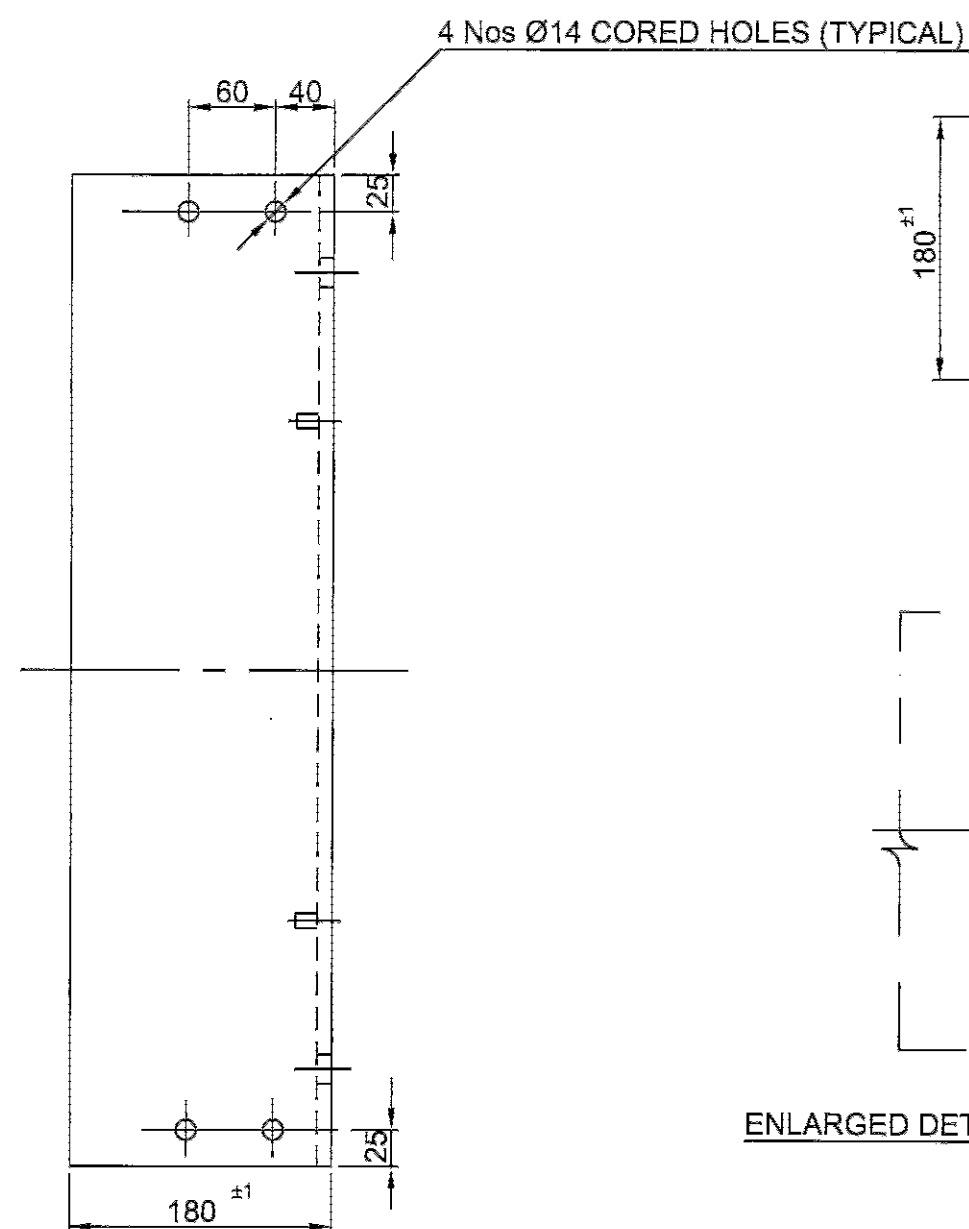
NOTE: PERMISSIBLE DEVIATIONS ON UNTOLERANCED DIMENSIONS SHOULD BE AS PER IS:5519 CLASS 2.

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD
CAUTION: IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANYWAY DETERMINAL TO INTEREST OF THE COMPANY

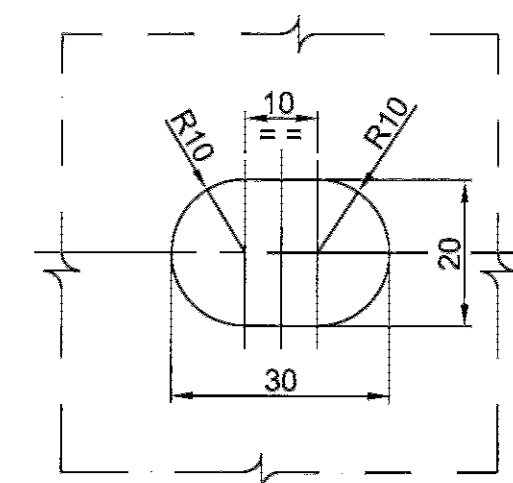
ALL DIMENSIONS ARE IN MILLIMETERS



3 Nos 30x20 CORED HOLES. VIEW-A



SECTION-BB



ENLARGED DETAILS OF CORED HOLES (TYPICAL)

FOR ORIGINAL DESIGN REFER DRG.No.1-7-1101-13-00212 TYPE V OUTER MOVABLE


MATERIAL: HEAT RESISTANT CAST IRON Gr I TYPE E OF IS:3355
CHEMICAL COMPOSITION C=3.5% MIN, S=0.15%MAX,P=0.4MAX.
Cr1.21-1.40% CARBON EQUIVALENT 3.8 TO 4.4

NOTE: PERMISSIBLE DEVIATIONS ON UNTOLERARCED DIMENSIONS SHOULD BE
AS PER IS:5519 CLASS 2.

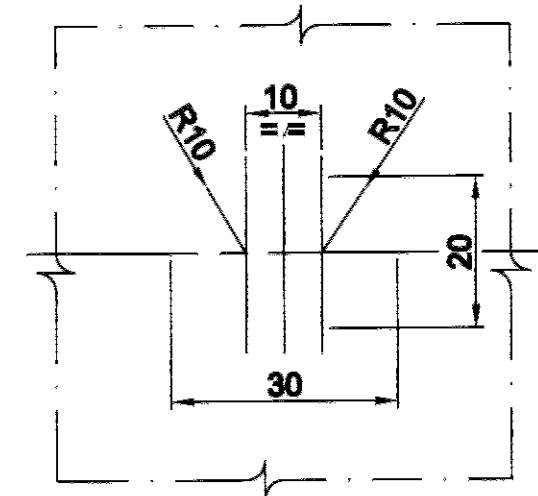
REV	DATE	ALTERED :
03		APPROVED
02	05.02.09	APPROVED

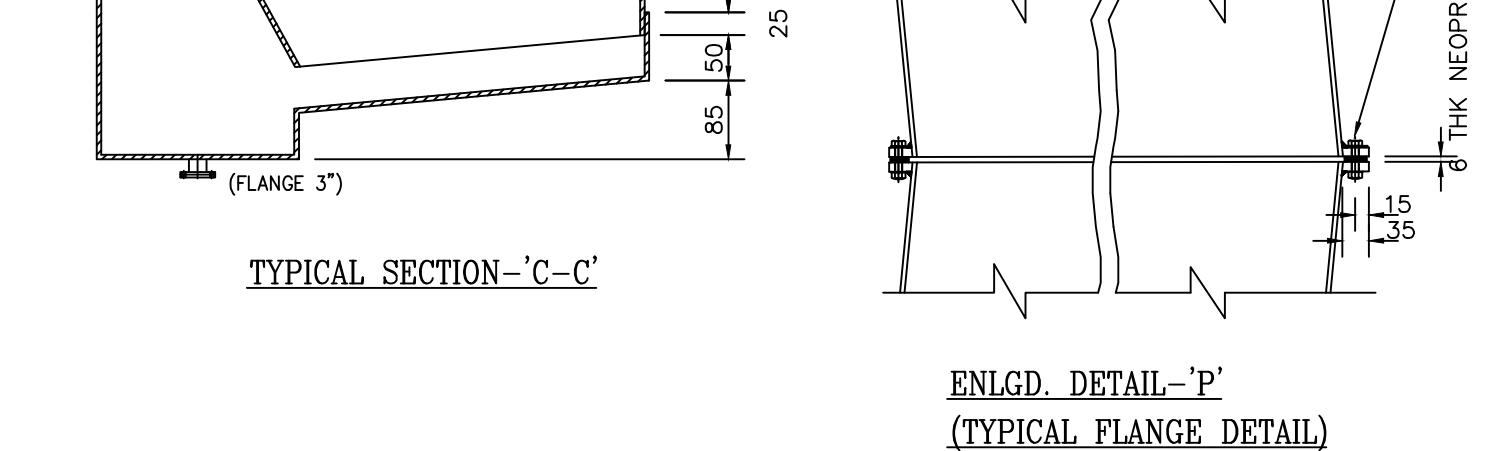
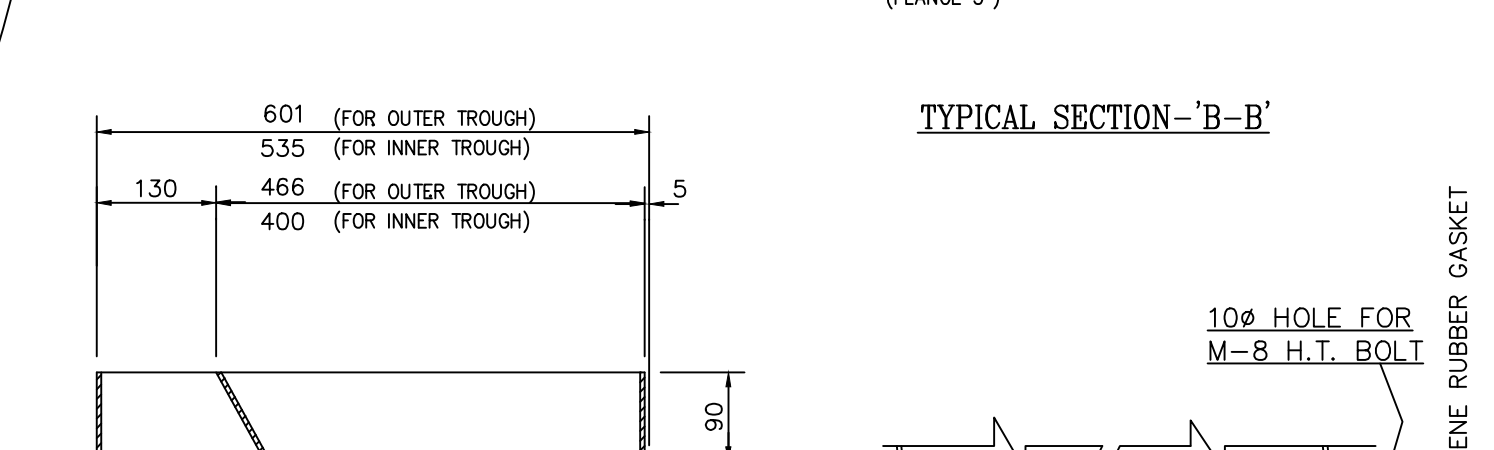
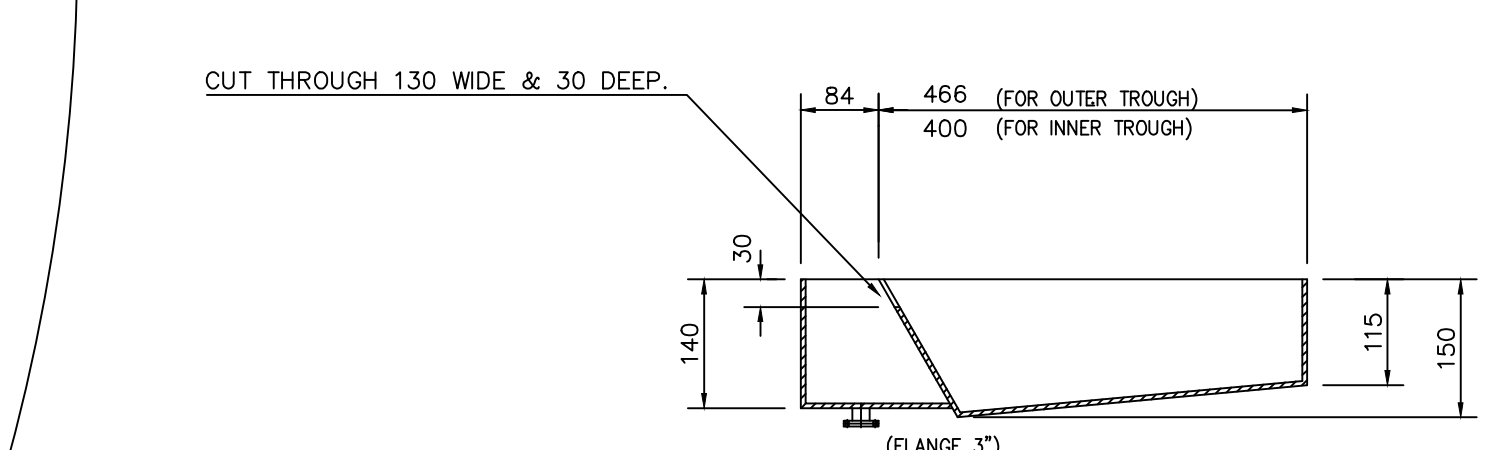
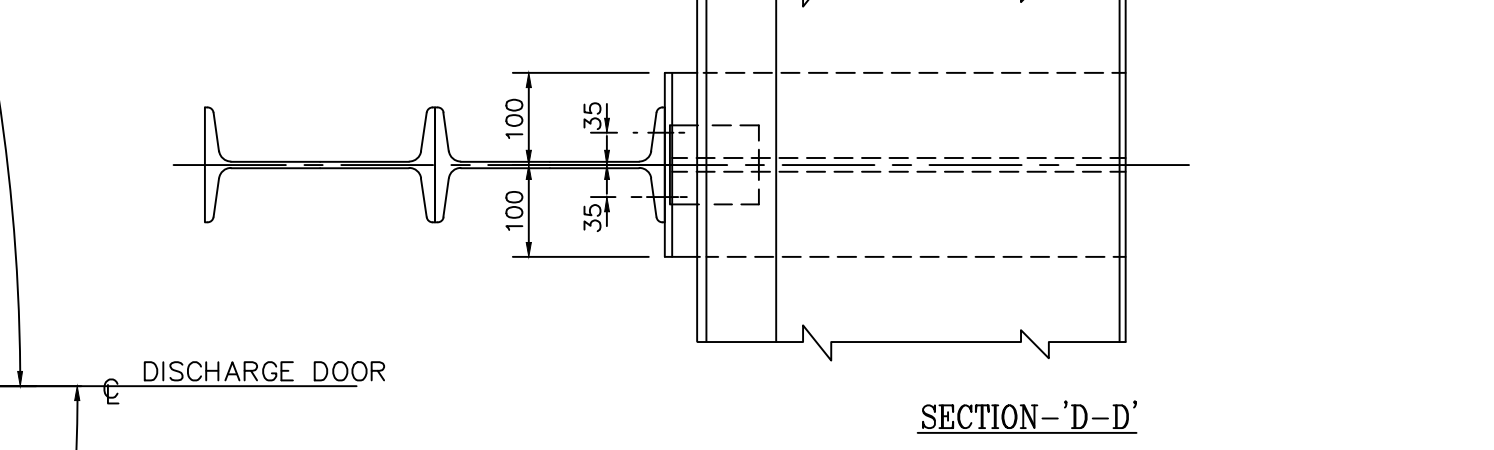
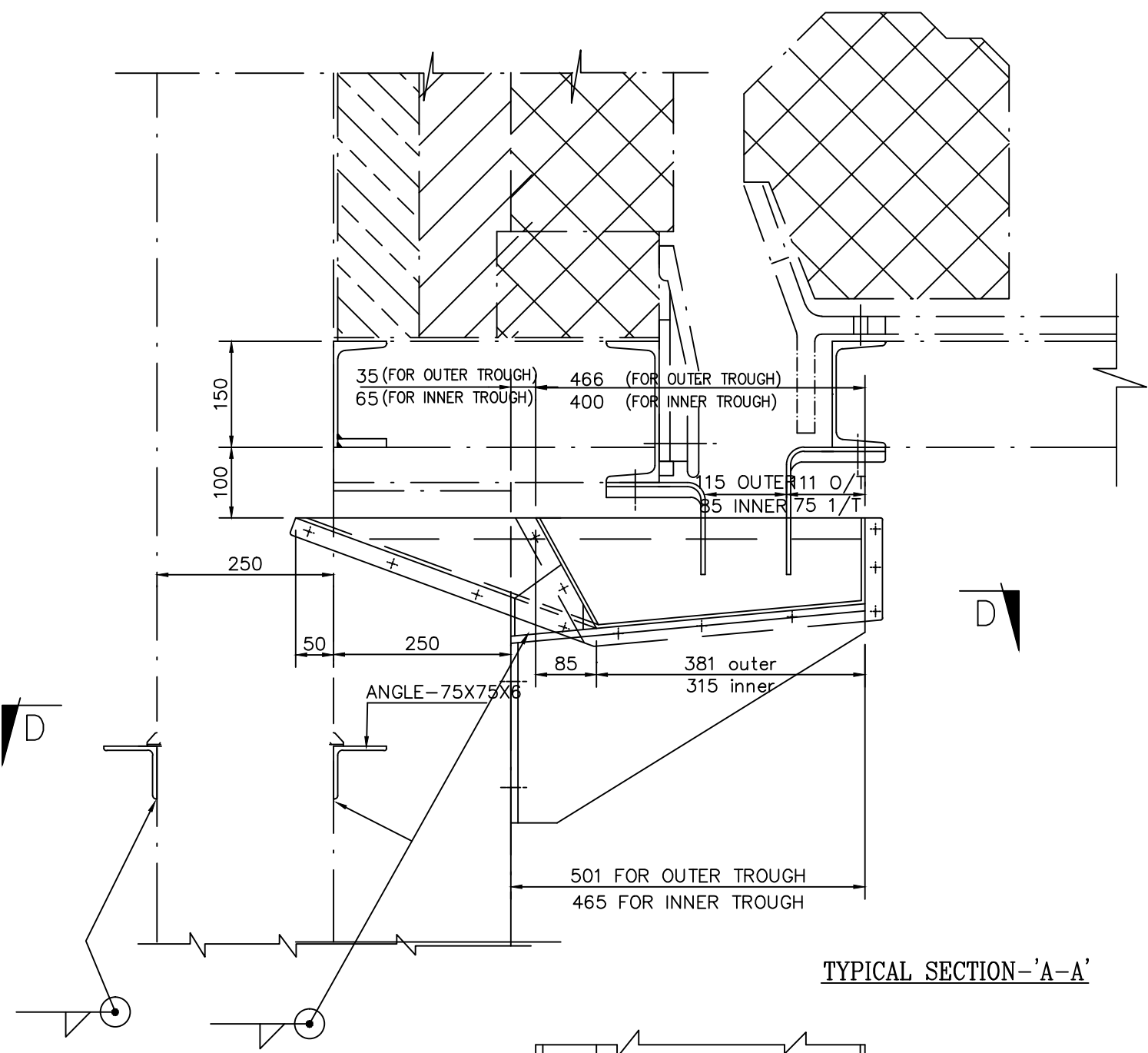
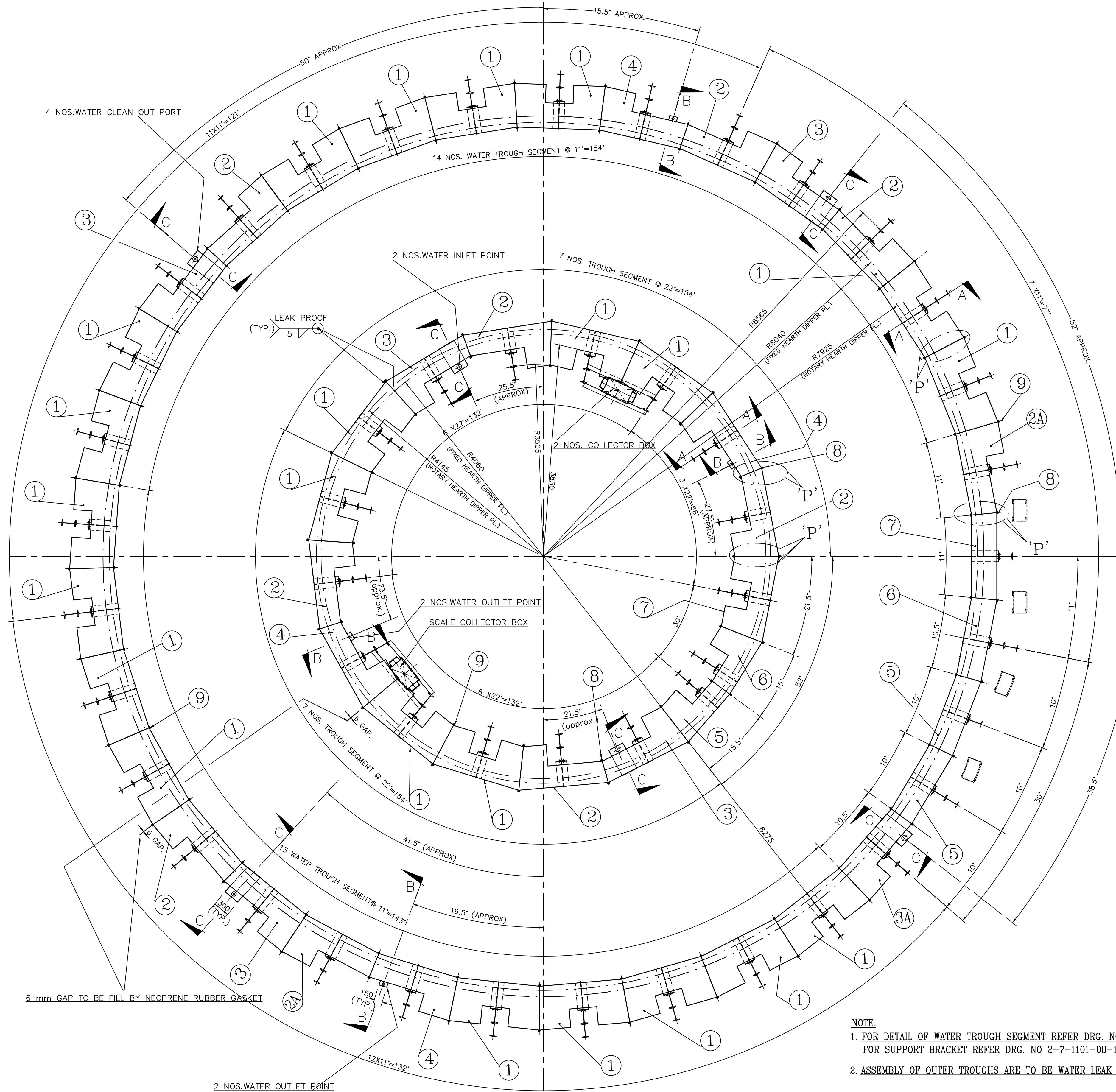
DIMN. 180 WAS 230

REV	DATE	ALTERED :
01	25.01.98	CHECKED : APPROVED
ZONE	CHEMICAL COMPOSITION C 3.5%MIN, WAS C 3.81-4.40%. CARBON EQUIVALENT 3.8 TO 4.4 AND NOTE ADDED.	

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY
EQPT: ROTARY HEARTH FURNACE				
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME B.ASHOKKUMAR	SIGNATURE
		CHD	SSN.KUMAR	DATE 03.05.02
		APPO	S.SHANMUGASUNDARAM	
DEPT	GRADE OF UNTOL. DIM C/M/F	SCALE 1:5 (1:1)	WEIGHT(kg) 13	REF TO ASSY DWG NO
CODE				REF TO OLD DWG NO
TITLE DIPPER PLATE CASTING (OUTER MOVABLE TYPE V)			CARD CODE U 01	DRAWING NO : 3-7-1101-13-02458
				REV 02

7





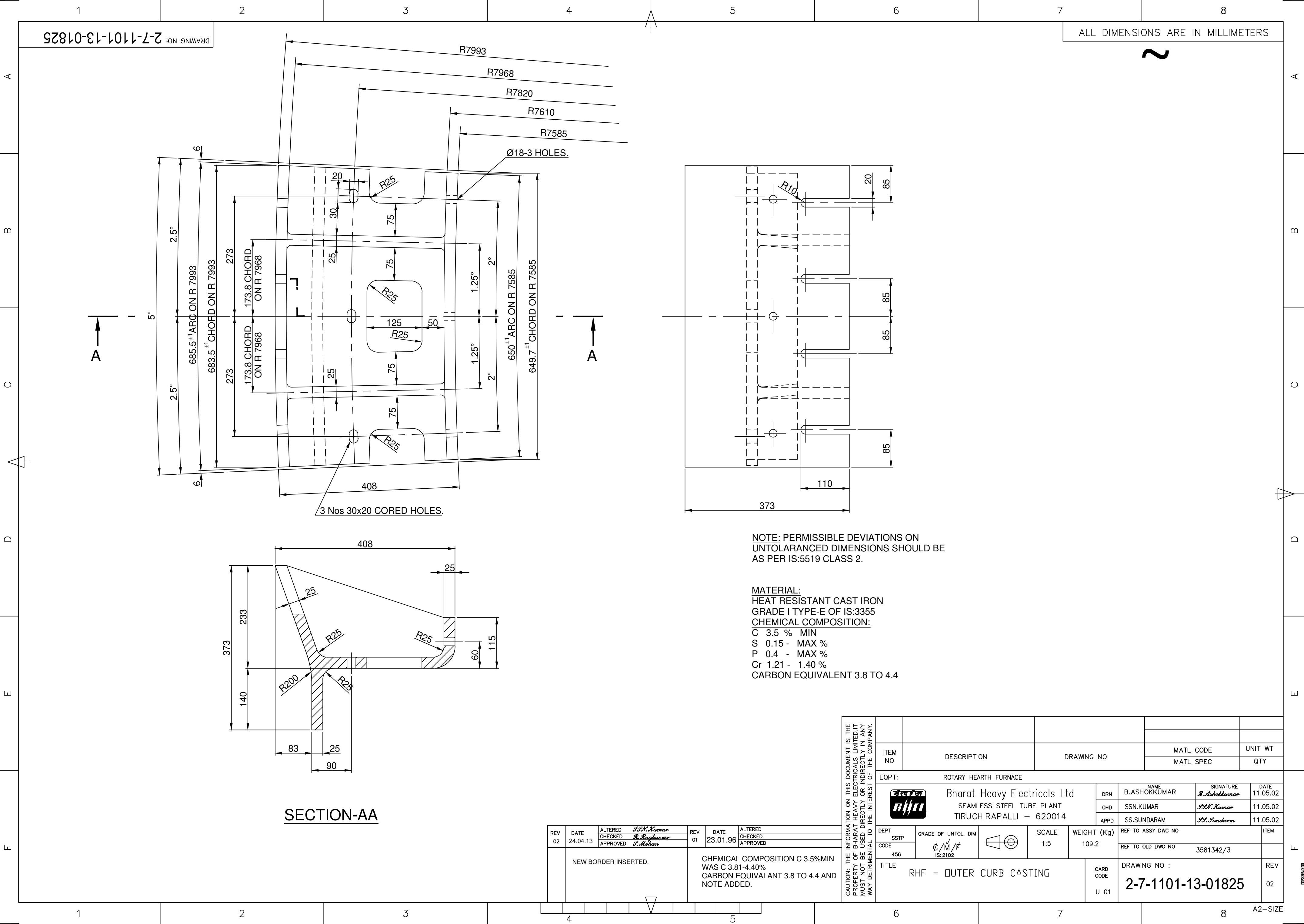
- NOTE:
1. FOR DETAIL OF WATER TROUGH SEGMENT REFER DRG. NO 1-7-1101-08-01703 & 1-7-1101-08-01709 FOR SUPPORT BRACKET REFER DRG. NO 2-7-1101-08-10154.
 2. ASSEMBLY OF OUTER TROUGHS ARE TO BE WATER LEAK TESTED.

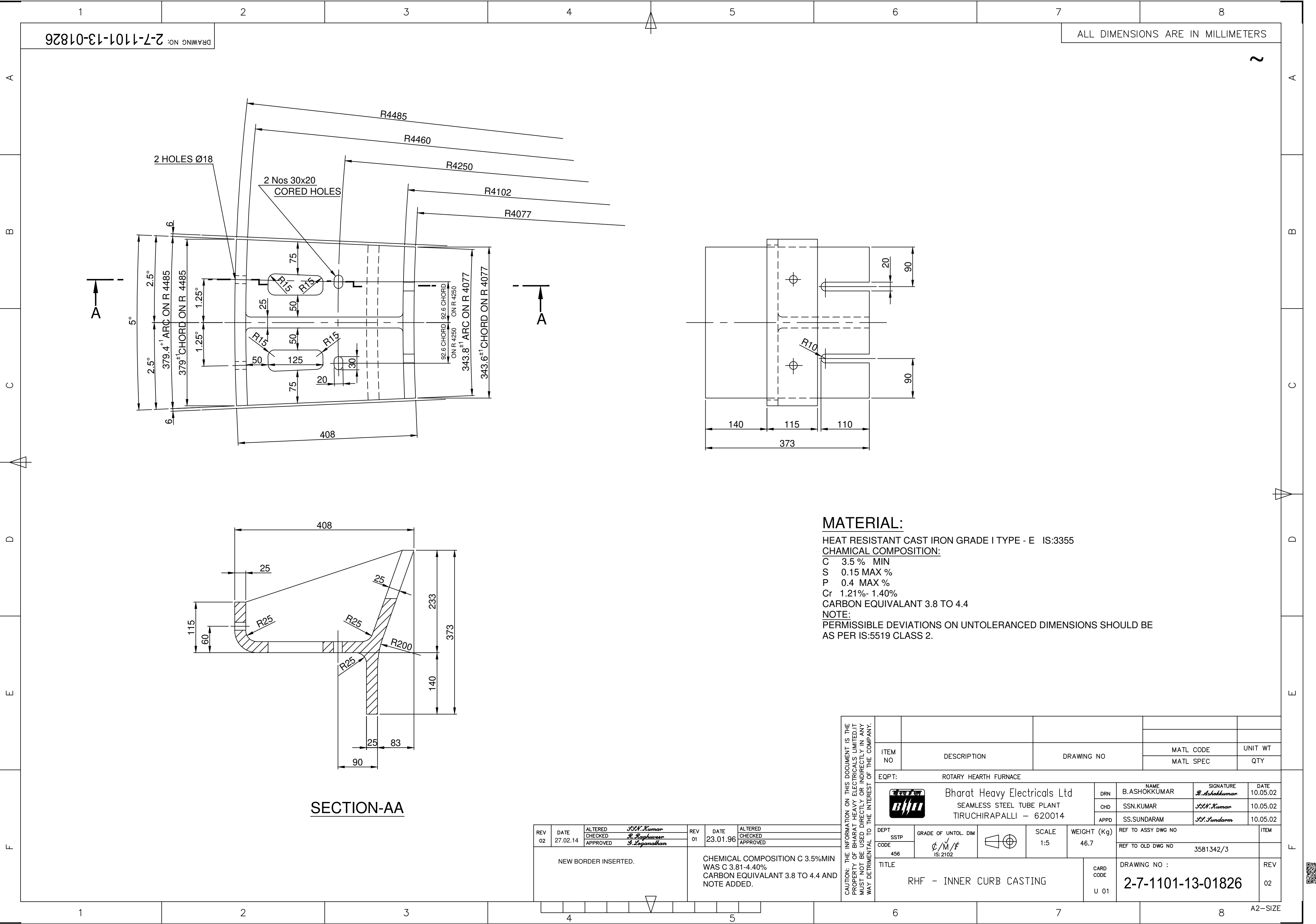
REV	DATE	ALTERED	CHECKED	APPROVED
01				

ITEM NO		DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
				MATL SPEC	QTY
EQPT: ROTARY HEARTH FURNACE					
DEPT		NAME	DRN	S.S.N.KUMAR/A.P	SIGNATURE
SSTP		CHD	D.CHANDRASEKARAN	D.Chandrasekaran	DATE
CODE		APPD	D.CHANDRASEKARAN	D.Chandrasekaran	09.09.17
TITLE		GRADE OF UNTOL DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO
		456	1:40		REF TO OLD DWG NO
		IS:2102			FA-0427-616
					DRAWING NO :
					1-7-1101-08-10232
					REV
					00

RHF - WATER TROUGH
ARRANGEMENT

1-7-1101-08-10232





REV	DATE	ALTERED	CHECKED	APPROVED	REV	DATE	ALTERED	CHECKED	APPROVED
02	27.02.14				01	23.01.96			
NEW BORDER INSERTED.					CHEMICAL COMPOSITION C 3.5%MIN WAS C 3.81-4.40% CARBON EQUIVALENT 3.8 TO 4.4 AND NOTE ADDED.				

CAUTION: THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

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