

**MATERIALS MANAGEMENT (MM/MFG)**  
**BHARAT HEAVY ELECTRICALS LIMITED**  
**TIRUCHY – 620014**

Annexure – I

Ref: MM/MFG/PSS/EOI dt.26.03.12

Notice inviting expression of interest for registration of additional vendors for alloy steel coiled flats – SA387 Gr12/G22 to the TDC 303 Rev 05.

**Introduction:**

BHEL Tiruchy requires alloy steel coiled flats of various sizes as per TDC 303 Rev 05 to the specifications SA387 Gr12 & Gr22. Annual requirement of various sizes per annum are as mentioned below. The requirement is likely to increase in future.

SI No	Description	PROCUREMENT IN MTs	
		2010-11	2011-12
1	FIN FLAT 24 X 6 - SA387GR22	2	
2	FIN FLAT 64.5 X 6 - SA387GR22	70	
3	FIN FLAT 102.2 X 6 - SA387GR12	39	
4	FIN FLAT 68.8 X 6 - SA387GR12CL2	42	
5	FIN FLAT 51.8 X 6 - SA387GR12CL2	18	
6	FIN FLAT 58.1 X 6 - SA387GR12CL2	44	
7	FIN FLAT 13.7 X 6 - SA387GR12CL2	34	
8	FIN FLAT 13.7 X 6 - SA387GR12CL1	60	
9	FIN FLAT 50.8 X 6 - SA387GR12CL2	12	
10	FIN FLAT 14.9 X 6 - SA387GR12CL2	52	
11	FIN FLAT 16.9 X 6 - SA387GR12CL2	213	389
12	FIN FLAT 47.85 X 9.5 - SA387GR12CL2	19	
13	FIN FLAT 52.2 X 6 - SA387GR12CL2	91	
14	FIN FLAT 68.5 X 6 - SA387GR12CL2	37	26
15	FIN FLAT 86.2 X 6 - SA387GR12CL2	134	170
16	FIN FLAT 64.5 X 8 - SA387GR22CL2	111	
17	FIN FLAT 72 X 6 - SA387GR12CL2	20	16
18	FIN FLAT 15.9 X 6 - SA387GR12CL2		212
19	FIN FLAT 53.2 X 6 - SA387GR12CL2		283
20	FIN FLAT 49.85 X 10 - SA387GR12CL2		70
GRAND TOTAL		997	1,166

BHEL Tiruchy is presently seeking expression of interest from reputed manufacturers for registration as additional vendors for the above mentioned requirement to the TDC 303 Rev 05.

**REGISTRATION FORM SUBMISSION:**

Interested suppliers are requested to send the filled in supplier registration forms available in the website – [www.bhel.com](http://www.bhel.com) along with the necessary enclosures requested and send it to the below address

**SENIOR MANAGER/SDC/MM/MFG,  
BLDG 24, HPBP,  
BHEL TIRUCHY – 620 014  
TAMILNADU - INDIA**

Ph no: 0431 257 7448

Fax: 0431 252 7019

Email: [ebi@bheltry.co.in](mailto:ebi@bheltry.co.in)

Based on the supplied documents and assessment, techno commercially qualified suppliers will enlisted in our vendor base.

BHEL reserves the right to take a stand on inclusion of suppliers at its discretion.

Product: Hot / Cold Rolled Coiled Flats For Fin Welded Panels To ASTM A576 & SA 387 GR 12 & GR 22  
For Boilers

Document No.: **TDC:0:303**Rev. No.: **05**Effective date: **05-03-07**

Page 1 of 2

**Revision record:**

Rev:01: Clause 5.0 to 11.0 Edited and renumbered. Requirement for packing enhanced.

Rev:02: Text re-written, Criteria for finish clarified.

Rev:03: Clause 4.0, 5.0, 7.0 &amp; 8.0 altered.

Rev:04: Cold rolled permitted. Cl. No.2.0, 4.0 modified

REV 05: Cl 1 and title of TDC modified.

**1.0 MATERIAL SPECIFICATION**

ASTM{Latest on date of Purchase Order (PO)}: SA 576 Gr.1008, 1010, 1012, 1015, 1016  
and SA 387 Gr 12 And SA 387 Gr 22.

Test certificate to indicate actual grade supplied.

Additional Requirement: As listed below (supplementary to Specification).Size grade and Qty.:  
As per PO

**2.0 PROCESS**

Flats to be in hot / cold rolled coiled form and shall be of weldable quality.

**3.0 DIMENSIONAL TOLERANCES**

Thickness : As per specification

Coil ID: 508 mm

Width : +/- 0.5 mm

Coil OD: 1800 mm (max.)

Coil weight : 2 Tonnes (max.)

**4.0 FINISH AND REPAIRS**

Flats to have a workman like finish, be free of harmful defects like cracks, laminations, scrabs etc., and surfaces to be free from scales, rust, pitting, wrinkles etc.

For hot rolled coils the edges of coils to be of machine cut (cold slit) ends in order to ensure squareness of edges & flatness of width. Edges cut by shearing or hot saw cut are not acceptable.

Flats to be without fish tails. Coils should not contain any weld seams.

Repair by fusion welding is prohibited. When Defects are rectified by mechanical means, min. thickness as per specification shall be met and the rectified areas to be smoothly dressed up.

**5.0 MARKING**

Following details to be marked on the flats at ends of coils &amp; on the packing by paint stenciling.

1. Specification and grade      2. Melt number      3. Purchase order No.

4. Maker's emblem/code      5. Coil number and Weight 6. Size (width &amp; thickness).

**6.0 PRESERVATION AND PACKING**

It is the responsibility of the supplier to ensure that no damage occurs during transit.

Coils to be applied with a suitable rust preventive to avoid rusting during transportation & storage, which will not produce defects like porosity in welding.

Individual coils to be packed in air/water tight polythene covering of sufficient thickness and strength to withstand rigorous handling.

Further, the coils to be rigidly packed with Galvanised Iron sheets along the circumference and end caps at both ends. Coils to be wrapped with 1 inch hoop iron bands at one place along the circumference and at 8 places through the eye of the coil and supported on suitable wooden skids/ steel crates. A handling hook to be provided for lifting by crane.

Product: Hot / Cold Rolled Coiled Flats For Fin Welded Panels To ASTM A576 & SA 387 GR 12 & GR 22  
For Boilers

Document No.: **TDC:0:303**Rev. No.: **05**Effective date: **05-03-07**

Page 2 of 2

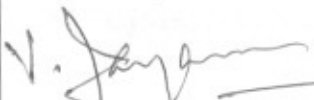
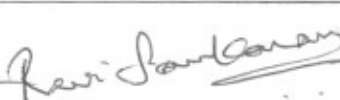


**7.0 INSPECTION AND CERTIFICATION**

Products must be inspected and tested at works and the details as below furnished in mill's test certificate legibly, in English language only:

1. Purchase Order No.(BHEL),TDC No. & Test certificate number
2. Specification and Grade with applicable year of Standard, Quantity ,Heat Number, Plate number.
3. Steel making & finishing process
4. Chemistry including incidental elements.
5. Dimension report (Width, thickness,flatness,squareness)

**8.0 END USE**

The coils are for use as fins by welding to tubes to form in fin-welded tubular panels by automatic submerged arc welding machines.

Prepared by	Reviewed by		Approved by
 V.JAYARAMAN	 U.REVISANKARAN	 K.RENGACHARI	 C.R.RAJU