

Enquiry No 4202600008 dt 15.05.2026

Procurement of TG Cycle Piping of IBR & Non IBR Systems for MEL Mahan (Ph III) project

Date- 03.06.2026

Dear Sir / Madam,

Sub: Procurement of TG Cycle Piping of IBR & Non IBR Systems for MEL Mahan (Ph III) project as per BHEL Enquiry No 4202600008 dt 15.05.2026.

With regard to the subject Enquiry for Procurement of TG Cycle Piping of IBR & Non IBR Systems for MEL Mahan (Ph III) project as per BHEL Enquiry No 4202600008 dt 15.05.2026, Corrigendum 1 dt 03.06.2026 is issued for the following.

a) In Annexure C to the Enquiry, Project Name mentioned as

- MEL Mahan Unit 1 shall be read as MEL Mahan Unit 3.
- MEL Mahan Unit 2 shall be read as MEL Mahan Unit 4.

b) Welded Pipes of SA672 Specification shall be manufactured / procured as per TDG 08 Rev 03. For Welded Pipes of SA672 Specification under Schedules covering IBR Piping, all the requirements of TDG 08 Rev 03 shall be complied with. For Welded Pipes of SA672 Specification under Schedules covering Non IBR Piping, all the requirements of TDG 08 Rev 03 excepting IBR requirements shall be complied with. TDG 08 Rev 03 is enclosed along with this corrigendum.

c) Technical Specification PIP ENGG:TSP:PPFDSPM:003 Rev 00 has been revised to Rev 01. Accordingly, Rev 00 of the Technical Specification stands withdrawn. Revised Technical Specification is enclosed along with this corrigendum.

d) Welding consumables shall be procured from BHEL approved makes. List of BHEL approved makes is enclosed along with this corrigendum.

e) For grade and applicable thicknesses, Post Weld Head Treatment (PWHT) as applicable shall be as per document 'Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)'. Document 'Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)' is enclosed along with this corrigendum.

Prospective bidders are requested to take note and submit their quote before the tender due date.

Enclosures:

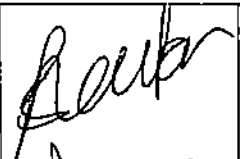

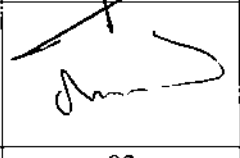
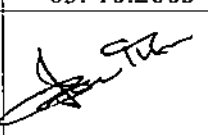

1. TDG 08 Rev 03
2. PIP ENGG:TSP:PPFDSPM:003 Rev 01
3. Approved Welding Consumable List
4. Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)

For BHEL Trichy,

Anil Sree
Manager / MM / RM
BHEL Trichy, Tamil Nadu, India

**BHARAT HEAVY ELECTRICALS LIMITED
PIPING CENTRE, CHENNAI – 600 017.**

Title :	Technical Delivery Conditions for plate formed pipes to ASME SA 672.
Specification No:	TDG : 08 Rev : 03
Project :	ALL PROJECTS
Material :	ASME SA 515
Equipment :	Pipes.

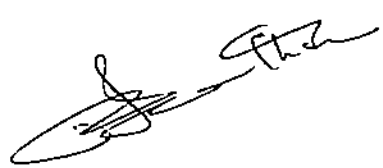
Accepted By:- Engineering				
Materials Management				
OP & C				
Rev : NO:-	03	04	05	06
Date :-	03. 10.2005			
Prepared / Revised by				
Reviewed / Approved by				

Issued by Piping Centre / Quality Assurance

Page 1 of 5

TECHNICAL DELIVERY CONDITION FOR PLATE FORMED : TDG:08:03
PIPES TO ASME SA 672 : 03/10/2005

REV NO	REVISED CLAUSE	DESCRIPTION
2	6.1	Heat Treatment as per specification added.
2	---	Other clauses Re- worded for better clarity.
3	4.1 Modified	Cirseam weld included



1.0 **SCOPE**

- 1.1 This technical delivery condition specifies the additional requirements for the delivery of Electric Fusion Welded pipes conforming to ASME SA 672
- 1.2 The grades covered are B60, B65 and B70
- 1.3 The class of the pipes shall be Cl.22 (Stress Relieved condition).
- 1.4 These pipes are intended for power piping services at stress levels and temperature allowed by ASME B31.1 and IBR.
- 1.5 The pipes shall conform to size, grade and quantity as specified in the enquiry/purchase order.

2.0 **APPLICABLE CODES AND PROCEDURES**

- 2.1 The pipes shall also conform to INDIAN BOILER REGULATIONS, 1950.
- 2.2 All welders, welding procedures shall be qualified as per ASME Section IX, and IBR.
- 2.3 Non-Destructive Examination procedures shall be as per ASME Section V.

3.0 **MATERIAL**

- 3.1 The chemical composition of the steel plates shall be as per ASME SA 515 Gr.60 for B60, Gr.65 for B65 and Gr.70 for B70 except that the carbon percentage shall be limited to 0.25% irrespective of plate thickness.
- 3.2 The steel shall be of fully killed plain carbon steel.
- 3.3 The plate shall be in control rolled or normalised condition. The heat treatment condition of the plate shall be recorded in the Test Certificate.

4.0 **WELDING**

- 4.1 The joints which includes longitudinal and circumferential welds shall be full penetration welds made in accordance with the qualified procedures as per ASME Section IX. Longitudinal seams on adjacent pipe shell shall be offset by at least 90 deg.
- 4.2 One production test coupon per size/per melt shall be made for every 60 meters as per Chapter IX of IBR.

5.0 **NON-DESTRUCTIVE EXAMINATION**

- 5.1 All the plates used for the manufacture of pipe shall be ultrasonically tested. UT testing shall be done as per A435 and acceptance standard shall be as per A-578 Level-B.
- 5.2 The full length of each weld shall be radiographically examined in accordance with ASME SA 672 and accepted as per ASME Section VIII - paragraph UW -51.

5.3 Weld repairs shall be carried out as per ASME SA 672 and accepted as per ASME Section VIII.

5.4 When two long seam pipes are joined to make the required length, the long seams shall be at least 90deg apart from each other. 100% RT shall be carried out on the circumferential and "T" joint.

6.0 **HEAT TREATMENT**

6.1 All the pipes shall be heat treated as per SA 672 specification.

7.0 **MECHANICAL TESTS**

7.1 Wherever applicable, the plate shall be subjected to tensile test at 350deg C and a bend test as per IBR.

7.2 Mechanical and metallurgical test shall be carried out as per Chapter XII of IBR on each welded test plate. The tests to be conducted are listed below:

<u>Type of test</u>	<u>No. of tests</u>	<u>Reference Standard</u>
a) Tension test for weld seam	1	ASME Section IX-QW-422
b) All weld metal tension test	1	IBR Reg.259
c) Guided bend test (Face & Root)	2 each	ASME Sec.IX-QW-462 (a)
d) Macro & Micro structure test	1 each	IBR & ASME Sec.IX
e) Impact test Charpy-V	1 set	ASTM A370 Type-A

7.3 One test plate may represent a lot of pipes up to 60 meters in length.(also refer 4.2above) Test plate shall be of the same grade of material, same melt, and same thickness of the pipe and shall be subjected the same heat treatment of the pipe.

8.0 **HYDRAULIC PRESSURE TEST**

8.1 Each length of pipe shall be subjected to a hydraulic test pressure as per ASME SA530, but in no case the test pressure shall be less than 1.5 times the design pressure or the HTP value indicated in the purchase order.

9.0 **DIMENSIONAL TOLERANCES**

9.1 The tolerance on length, outside diameter, out of roundness, wall thickness and weight shall be as per ASME SA 672.

9.2 Dimensional report supported with the necessary sketch/details shall be included in Test Certificate.

10.0 WORKMANSHIP

10.1 All pipes shall have smooth surfaces, free from loose scales and defects like laps, seams, folds, cracks, pitting etc. The surface imperfection beyond the permissible limit of ASME SA 672 shall be removed mechanically without affecting the minimum thickness and workmanlike finish. All pipes shall be coated with resin type translucent rust preventive or rust inhibitor on the inside and outside.

11.0 COLOUR CODE:-

11.1 Each pipe shall be colour coded longitudinally.
SA 672 B60 Cl.22 – Red & White
SA 672 B65 Cl.22 – Red & Blue
SA 672 B70 Cl.22 – Red & Aluminum

12.0 MARKING AND PACKING

12.1 P.O.No, SIZE, LENGTH, QTY, SPECIFICATION, GRADE, MELT/HEAT No, MAKER'S MARK AND INSPECTOR SEAL shall be hard punched and paint stenciled on the pipe 100mm away from both ends. All pipes shall be sent as loose with proper sling marks and end stiffeners .

13.0 CERTIFICATES

13.1 Three original test certificates typed in English shall be given along with the pipes.

13.2 The pipes must be delivered along with test certificates legibly written in English.

13.3 The test certificates shall furnish the following details:

- a. Purchase Order Reference.
- b. Test Certificate Number.
- c. Specification, grade, size and dimension.
- d. Steel making process of the plate .
- e. Heat number of the plate.
- f. Ladle analysis of plate.
- g. Heat treated condition of plate.
- h. Mechanical test results of the plate.
- i. Mechanical and metallurgical test results of the weld test coupons.
- j. Radiography test reports with acceptance standard.
- k. Heat treated condition of pipe.
- l. Hydraulic test pressure results.
- m. Ultrasonic test results with acceptance standard.

13.4 All the plates and pipes must be inspected at the mills and the test certificates in IBR Form IV and IIIA shall be countersigned by an inspecting authority recognised under Appendix-C of IBR.

13.5 The pipes shall be subjected to inspection by authorities nominated by BHEL and the test certificate shall be countersigned by them.



BHARAT HEAVY ELECTRICALS LIMITED

Piping Engineering/HPBP/Trichy

Technical Specification Document
PIP ENGG : TSP : PPFDSPM:003 Rev 01
For

Supply of TG Cycle Piping materials
4-80-999-A1030

REVISION HISTORY

RE V. NO	PAGE	REVISION HISTORY	DATE	PRPD	CHED	APPD
00	ALL	ORIGINAL RELEASE	13-12-25	I.D.B.RAJU	P SURESH	VENKAT RAMANA E
01	Page-05	Revision in SI 2.1,3.5 & 3.14	01-06-26	I.D.B.RAJU	P SURESH	VENKAT RAMANA E
02						


Prepared

Checked

Approved

Clause No.	DESCRIPTION
1.0	Scope of Work in brief
1.1	Work content involves Supply of materials for indicated Input fabrication Drawings/BOM's (Bill of Materials) in respective PGMAs by BHEL.
1.2	<p>The vendor will be issued fabrication drawings/Part drawings/BOM by BHEL in PDF format. Input Drawings provided by BHEL for applicable cases includes Item numbering of pipes, fittings & related components, Bill of material details, design of component/attachments, relevant production & erection notes etc. and attachment details for Instrument connections, Drains, Vents & Piping Supports with detailing.</p> <p>Wherever fabrication drawing is not provided, vendor to supply the piping components as per BOM provided by BHEL. Vendor shall follow relevant piping standard for such cases.</p> <p>A sample Input Fabrication drawing/Part drawings is attached as Annexures-B for reference.</p>
1.3	Deliverables from Vendor given below
1.3.1	Manufacturing & Supply based on input Fabrication drawings/Part drawings/BOM. Preparation & Submission of IBR Documents, getting Approval for applicable fabrications Drawings/Part drawings/Systems from Regulating Authority i.e. IBR
2.0	Piping Systems Covered
	01. Auxiliary Steam System-IBR 02. Auxiliary Steam System-Non IBR 03. Condensate System-Non IBR 04. Drain & Vent System- Non IBR 05. Extraction Steam System-IBR 06. Heater Drain & Vent-Non IBR 07. Spray/Feed Water System-IBR 08. Spray/Feed Water System-Non IBR

	09. SG Integral Piping-IBR 10. SG Integral Piping-Non-IBR
2.1	Material Specifications Covered
	SA335P22,SA672,SA335P12,SA335P11,SA106GRC,SA106GRB, and associated equivalent specification for Fittings, Forgings & components, etc.,
3.0	Work scope Details
3.1	It is the responsibility of the Contractor to collect all relevant input from PIPING ENGG/FB, BHEL design office and get any doubts clarified prior to taking up the work
3.2	It is the responsibility of the Vendor to understand the BOM, input Fabrication drawings & reference part drawings/documents and detailing practice of BHEL
3.3	<p>Pipes/Fittings/components shall be supplied in exact length requirement as per the input Fabrication Drawing/Part drawing (for applicable cases) with Edge Preparation at Vendor works. Vendor to Follow BHEL EP standard Drawing 3-80-300-19825 for Pipes & Fittings. Edge Preparation Value (d1) indicated in the Fabrication Drawing/Part drawing for Pipes/Fittings shall be followed. For Running meter supply cases, specific Length of Pipe shall be in the range of 6-10M. However, additional Butt joint with 100% RT can be followed for economic/optimum utilization of raw material Pipes with Prior permission from BHEL for applicable cases.</p> <p>All components for instrument connections, attachment details for drains, vents & piping supports shall be welded to the main Pipe at Vendor Works & Supplied as an assembly (i.e. as Dispatchable Unit) as per the Fabrication Drawings provided by BHEL.</p> <p>Fittings shall be supplied as per standard B16.9/B16.11/IS1239 (Heavy)/IS3589 as applicable (as indicated in the BHEL Fabrication drgs/BOM) with BHEL Edge Preparation details as per the Drawing 3-80-300-19825 to site. Fittings shall be Socket Welded for size NB50 & Below and Butt welded with EP for Size above NB50. Material Specification shall be followed as per Input Drawings provided by BHEL.</p> <p>For the cases of BOM items with no fabrication/part drawing i.e. running meter BOM cases, Vendor can proceed with Specific Length of 6-10M with EP at Vendor works as per BHEL drg 3-80-300-19825.</p>
3.4	BOM will be Furnished along with the Input Drawings & Tender Specification. Quantity Indicated in the BOM is per Unit Unless otherwise mentioned. Suitable Cushion +/-15 % in Quantity/Weight shall be considered by the Vendor in Tender.

	<p>Pipe Size/Pipe Thickness/Specification mentioned in the Drawing/BOM may vary for very few cases during issue of Final drawings at PO stage.</p> <p>All Input Drawings are attached along with BOM in Tender. Vendor shall follow latest applicable material standards for material supply.</p>
3.5	<p>Pipe OD, Thickness, specification shall be followed as per input drawings/BOM. Material substitutions if any shall be taken up with BHEL on case to case basis. However, BHEL Shall reserve the right to take final decision regarding acceptance for substitutions based on requirements of the subject contract. And the price implication is not envisaged for material substitutions proposed by vendor. Heavy grade shall be followed for All piping/fittings of IS1239 for applicable cases. Seamless construction shall only be followed for Pipes/Fittings of material specifications SA106GRB, SA106GRC, SA335P22 & corresponding fittings. Seamless construction is also technically acceptable in place of welded for all the sizes of IS1239 & IS3589 and 65NB & above sizes of SA312TP304H & SA312TP316L. However Seamless construction shall only be followed for Pipes/Fittings of Sizes NB50 & below for SA312TP304H & SA312TP316L cases. Welded Pipes of ASTM A672 Specification is also acceptable in place of Welded Pipes of SA672 Specification. However, Material grade shall be as per Drg/BOM</p>
3.6	<p>Pipe/Fittings Weight indicated in the tender drawings are based on T-Nominal and are finished weights. Same will be followed in Group Manufacturing specification/Shipping list by BHEL. Vendor to follow/consider the same for quotation/billing.</p>
3.7	<p> Flag symbol indicates site weld. All other welds indicated in fabrication drawing for stub/attachment welding other than the flag symbol welds are in Vendor scope. Weld Size for all attachment welding at Vendor works shall be maintained as per the drawing. Any Excess/shortage in weld size for attachment welding other than indicated in fabrication drawing during manufacturing stage shall report to BHEL for review & approval. Electrode specification details shall be provided by Vendor for all attachment welding shown in the fabrication drawing.</p>
3.8	<p>Indicator-A in drawing/BOM represents Attested i.e. IBR category. Indicator-C in drawing/BOM represents Certified i.e. Non-IBR category</p>
3.9	<p>Orientation of Stubs/attachments/branch connections on main pipe for assembly at vendor works shall be maintained as per the BHEL fabrication drawings.</p>

3.10	Length/dimensions indicated for Pipes/Bends/fittings/components in fabrication drawings are finished dimensions. Total quantity requirement of Raw material for Pipes/Bends/fittings/components of each size considering cutting plan, cutting allowance, machining, thinning, Bend process allowance, etc., shall be taken care by Vendor during raw material procurement to maintain the final dimensions as per the fabrication drawings/BOM provided by BHEL.
3.11	Lifting Lug & Spider arrangement shall be provided by Vendor for Pipe sizes NB1000 & above. Refer Drawing no- 3-80-468-A0848 for the same. Being a temporary arrangement, Material for the Lifting lug & Spider arrangement is not covered in BOM/Main Drawing. Vendor shall take care of the same.
3.12	Material substitution of equivalent/higher grade specification for stubs, components, Support pipes, plates, etc. is technically acceptable. However same shall be taken up with BHEL for approval before procurement/manufacturing.
3.13	Suitable end protection cover shall be provided at Pipe/fittings ends after manufacturing for storage & transportation
3.14	Vendor Shall follow applicable TDC/TDG (Technical Delivery Conditions for Material Procurement, Fabrication QP (for Manufacturing, Inspection & Testing) & Painting schemes applicable for the Project/Tender. Dimensional Tolerances as per applicable standard. Vendor to Follow below indicated BHEL TDC/TDGs 01.TDC: 0:101/Rev-21 02.TDG:07/Rev-08 03.TDG :12/ Rev-01 04.TDG :102/ Rev-10 05.TDG 08 Rev 03 and 06.PC:PKG:01/Rev-00 for applicable packing & Shipping requirements
3.15	In case of any discrepancy between the Drawing & BOM, PGMA specific input drawing furnished stands final. However, Vendor can contact Engineering for such clarifications/confirmation on drawings/BOM. Any other details/clarifications/reference documents required for manufacturing & supply shall be obtained from BHEL by the Vendor during Tender execution stage
4.0	Technical requirements.
4.1	Knowledge of ASME/IBR/IS1239/IS3589 & Equivalent standard codes are essential
5.0	Infrastructure facilities:

	Vendor shall possess the following infrastructure:
5.1	Vendor should have/demonstrate the necessary infrastructure for carrying out piping fabrication.
6.0	<p>All documents provided by BHEL, including drawings, standards etc., must be treated as strictly confidential and shall not, under any circumstances, be disclosed to third parties or used by them in any manner.</p> <p>Such documents shall be returned to us on demand after completion. This secrecy clause is binding on the employees of the vendors also. Action against defaulting subcontractors shall be taken in accordance with BHEL latest Guidelines for Suspension of Business dealings with suppliers/ contractors.</p> <p>Refer link http://www.bhel.com/vender_registration/vender.php.</p>
7.0	Statutory requirements
7.1	Vendor shall confirm his compliance with all statutory requirements, rules, regulations, notifications in relation to employment of his employees issued from time to time by the concerned authorities. Preparation & Submission of Drawings/supporting calculation sheets/ Other Relevant Docs and getting Approval for Procurement, Manufacturing & Supply from IBR is in Vendor Scope. Submission of IBR design calculations for BHEL review is not mandatory
7.2	All the final Input drawings will be issued at the time of Tendering

Enclosures-

Annexure – A - Edge Preparation Drawing

Annexure – B –System wise Fabrication/Part drawings

Annexure –C –BOM/GMS

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
10081	ESAB INDIA LTD	DRMFL	WELDING FLUX-DRUM	NOT APPLICABLE	OK FLUX 10.71L	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	DRMFL	WELDING FLUX-DRUM	NOT APPLICABLE	MAXFLUX SAF-723	Manufacturer
10785	ADOR WELDING LIMITED	DRMFL	WELDING FLUX-DRUM	NOT APPLICABLE	AUTOMELT B71	Manufacturer
11712	TAPADIA ENGINEERS & TRADERS P.LTD.	DRMFL	WELDING FLUX-DRUM	NOT APPLICABLE	TAPADIA GR-80(M)	Manufacturer
13211	D&H INDIA LIMITED	DRMFL	WELDING FLUX-DRUM	NOT SPECIFIEF	SUPERMELT-MO	Manufacturer
20047	KANEMATSU TRADING CORPORATION	DRMFL	WELDING FLUX-DRUM	NOT APPLICABLE	MF-38	Foreign Agent
11712	TAPADIA ENGINEERS & TRADERS P.LTD.	FINFL	WELDING FLUX-FIN	NOT APPLICABLE	BRAND NAME : TPD-50S	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	GVW01	WELDING ELECTRODES	WELD: SMAW:SS E410-15	MOLYTHERME	Manufacturer
10785	ADOR WELDING LIMITED	GVW01	WELDING ELECTRODES	WELD: SMAW:SS E410-15	E410-BETACHROME 13CR, E430-BETACHROME 17CR	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	GVW01	WELDING ELECTRODES	WELD: SMAW:SS E410-15	MAILARC -18 PLUS	Manufacturer
13211	D&H INDIA LIMITED	GVW01	WELDING ELECTRODES	WELD: SMAW:SS E410-15	E410-BRAND:SV-CR-13, E430-BRAND:SV-17-CR	Manufacturer
80218	Modi Arc Electrodes Co.	GVW01	WELDING ELECTRODES	WELD: SMAW:SS E410-15		Manufacturer
14400	ADOR WELDING LIMITED	GVW02	WELDING WIRE	DIA UPTO 4 MM FOR BOTH ER410 & E	SAW 127 FOR ER410 & SAW 128 FOR ER 430	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	GVWFX	WELDING FLUX	FULL RANGE		Manufacturer
10785	ADOR WELDING LIMITED	GVWFX	WELDING FLUX			Manufacturer
15810	NOUVEAUX INDUSTRIES (P) LTD.,	GVWFX	WELDING FLUX	FULL RANGE		Manufacturer
20563	VOESTALPINE BOHLER WELDING	MIGA2	GTAW WIRE FOR T92	DIA.0.8,1.0 & 1.2MM	THERMANIT 616	Manufacturer
10081	ESAB INDIA LTD	MIGA4	ER80S-B2 BPGMAW WIRE	DIA. 1.2MM	UNION ER 80S B2	Manufacturer
10785	ADOR WELDING LIMITED	MIGA4	ER80S-B2 BPGMAW WIRE	DIA 1.20 MM	AUTOMIG 80 S B2	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGA4	ER80S-B2 BPGMAW WIRE	DIA.1.2 MM	MG-S80B2F	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	MIGA4	ER80S-B2 BPGMAW WIRE	DIA.1.2MM	UNION ER 80S B2	Manufacturer
21991	SPECIAL METALS WELDING PRODUCTS	MIGN1	GMAW WIRE ERNiCRFe-7A	DIA.0.8,0.9 & 1.0MM	INCONEL 52M	Manufacturer
10785	ADOR WELDING LIMITED	MIGW1	ER 70S-A1 GMAW WIRE	DIA 0.8MM	AUTOMIG 70SA1	Manufacturer
13690	GEE LIMITED,	MIGW1	ER 70S-A1 GMAW WIRE	DIA: 0.8 MM (700 GM -1KG SPOOL)	GM 70SA1	Manufacturer
18705	MODI HITECH INDIA LTD.,	MIGW1	ER 70S-A1 GMAW WIRE	DIA 0.8 MM	GMM MIG 70 S A1	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGW1	ER 70S-A1 GMAW WIRE	DIA.0.8,0.9,1.0,1.2 & 1.6MM	MG-S70SA1	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	MIGW1	ER 70S-A1 GMAW WIRE	DIA.0.8,1.0 & 1.2MM	UNION I MO	Manufacturer
21461	INDUSTRIA NAZIONALE ELETTRODI S.p.A	MIGW1	ER 70S-A1 GMAW WIRE	DIA. 0.8MM	INEFILG2MO	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	MIGW2	ER 80S-B2 GMAW WIRE	DIA.1.2 & 1.6MM	AUTOTHERME-CR-MO1	Manufacturer
13690	GEE LIMITED,	MIGW2	ER 80S-B2 GMAW WIRE	DIA. 1.2MM	GM80S-B2	Manufacturer
14791	ANAND ARC LTD.,	MIGW2	ER 80S-B2 GMAW WIRE	DIA. 0.8 MM	ER 80S-B2	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGW2	ER 80S-B2 GMAW WIRE	DIA.1.0,1.2 & 1.6MM	MG-S 80 B2F	Foreign Agent
91875	Arya Engineering	MIGW2	ER 80S-B2 GMAW WIRE	DIA. 1.20MM	SMG-80B2	Indian Agent
10785	ADOR WELDING LIMITED	MIGW3	ER 90S-B3 GMAW WIRE	DIA: 0.8 MM		Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGW3	ER 90S-B3 GMAW WIRE	DIA 0.8, 0.9, 1.0, 1.2, 1.4 & 1.6 MM		Foreign Agent
20563	VOESTALPINE BOHLER WELDING	MIGW3	ER 90S-B3 GMAW WIRE	DIA.0.8,1.0 & 1.2MM		Manufacturer
21411	METRODE PRODUCTS LIMITED,	MIGW3	ER 90S-B3 GMAW WIRE	DIA.0.8,0.9,1.0 & 1.2MM		Manufacturer
21461	INDUSTRIA NAZIONALE ELETTRODI S.p.A	MIGW3	ER 90S-B3 GMAW WIRE	DIA. 1.0,1.2 & 1.6MM	INEFIL B3	Manufacturer
11784	VENUS WIRE INDUSTRIES PVT LTD	MIGW4	WELDG.WIRE-MIG ER347	DIA.0.8,0.9,1.0 & 1.2MM	VENUS 347SI	Manufacturer
14400	ADOR WELDING LIMITED	MIGW4	WELDG.WIRE-MIG ER347	DIA.0.8MM	MIG-120S SI	Manufacturer
18705	MODI HITECH INDIA LTD.,	MIGW4	WELDG.WIRE-MIG ER347	DIA 0.8 MM	GMM MIG 374 SI	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGW4	WELDG.WIRE-MIG ER347	DIA.0.8,1.0, & 1.2MM	MG-S347S	Foreign Agent
10785	ADOR WELDING LIMITED	MIGW5	WELDG.WIRE-MIG ERNiC	DIA 0.8 MM	AUTOMIG NICR-3	Manufacturer

E Suresh
E SURESH
 Engineer / ISO
 Thermal Management
 Bharat Heavy Electricals Limited
 Tiruchirappalli, Tamil Nadu - 620 014

R Ariv
R. ARIV
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 620 014

Manish Mahesh
M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals Limited
 Tiruchirappalli, Tamil Nadu - 620 014

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
13690	GEE LIMITED,	MIGW5	WELDG.WIRE-MIG ERNiC	DIA 0.8 MM	GEE GM 821	Manufacturer
14400	ADOR WELDING LIMITED	MIGW5	WELDG.WIRE-MIG ERNiC	DIA.0.8,MM	MIG-521	Manufacturer
18705	MODI HITECH INDIA LTD.,	MIGW5	WELDG.WIRE-MIG ERNiC	DIA 0.8 MM	GMM MIG NICR3	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGW5	WELDG.WIRE-MIG ERNiC	DIA.0.8,1.2 & 1.6MM	MG-S70NCB	Foreign Agent
20067	VOESTALPINE BOHLER WELDING	MIGW5	WELDG.WIRE-MIG ERNiC	DIA.0.8,1.0 & 1.2MM	UTP A 68HH	Manufacturer
22391	LINCOLN ELECTRIC FRANCE S.A.S	MIGW5	WELDG.WIRE-MIG ERNiC	DIA.0.8,1.0,1.2 & 1.6MM	NIFIL 600	Manufacturer
13211	D&H INDIA LIMITED	MIGW6	WELDG.WIRE-MIG ER90S	DIA.0.8MM	SUPERMIG-90S-B91	Manufacturer
13690	GEE LIMITED,	MIGW6	WELDG.WIRE-MIG ER90S	DIA.0.8MM	GM 90S-B9	Manufacturer
20563	VOESTALPINE BOHLER WELDING	MIGW6	WELDG.WIRE-MIG ER90S	DIA.0.8,1.0 & 1.2MM	THERMANIT MTS 3	Manufacturer
22391	LINCOLN ELECTRIC FRANCE S.A.S	MIGW6	WELDG.WIRE-MIG ER90S	DIA.0.8,1.0,1.2 & 1.6MM	CARBOFIL CRMO91	Manufacturer
10785	ADOR WELDING LIMITED	MIGW8	GMAW WIRE ER80S-G	DIA 0.8 MM	AUTOMIG 80SG	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGW8	GMAW WIRE ER80S-G	DAI.0.8,0.9,1.0 & 1.2,1.4 & 1.6MM	MG-S1CM	Foreign Agent
21461	INDUSTRIA NAZIONALE ELETTRODI S.p.A	MIGW8	GMAW WIRE ER80S-G	DIA. 0.8MM	INEFIL CROMO1	Manufacturer
91270	VEEPEES INDIA,	MIGW8	GMAW WIRE ER80S-G	DIA. 0.8MM	KC-81CMA	Indian Agent
13690	GEE LIMITED,	MIGW9	GMAW WIRE ER90S-G	AS PER WCPI-156/00 DIA OF WIRE 0.8	GM 90SG	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGW9	GMAW WIRE ER90S-G	DAI.0.8,0.9,1.0 & 1.2,1.4 & 1.6MM	MG-S2CM	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	MIGW9	GMAW WIRE ER90S-G	DAI.0.8,0.9,1.0 & 1.2,1.4 & 1.6MM	UNION I CRMO910	Manufacturer
20047	KANEMATSU TRADING CORPORATION	MIGWA	GMWA WIRE FOR T23.	DAI.0.8,0.9,1.0 & 1.2MM	TGS-2CW	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	MIGWA	GMWA WIRE FOR T23.	DIA. 0.8, 1.0 & 1.2MM	UNION I P23	Manufacturer
23730	NIPPON STEEL TRADING CORPORATION.	MIGWA	GMWA WIRE FOR T23.	DAI.0.8,0.9,1.0 & 1.2MM	T-HCM2S	Channel Partner
10081	ESAB INDIA LTD	P91FL	WELDING FLUX-P91	NOT APPLICABLE	OK 10.93	Manufacturer
13690	GEE LIMITED,	P91FL	WELDING FLUX-P91	NOT APPLICABLE	GEEFLUX 591	Manufacturer
20047	KANEMATSU TRADING CORPORATION	P91FL	WELDING FLUX-P91	NOT APPLICABLE	PF-90B9	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	P91FL	WELDING FLUX-P91	NOT APPLICABLE	MARATHON 543	Manufacturer
22391	LINCOLN ELECTRIC FRANCE S.A.S	P91FL	WELDING FLUX-P91	NOT APPLICABLE	OP 90	Manufacturer
10785	ADOR WELDING LIMITED	P92FL	SAWFLUX FOR SA335P92	NOT APPLICABLE	AUTOMELT B64	Manufacturer
91013	VOESTALPINE BOHLER WELDING	P92FL	SAWFLUX FOR SA335P92	NOT APPLICABLE	MARATHON 543	Indian Agent
10785	ADOR WELDING LIMITED	SAWA1	SAWIRE FOR SA335P92	DIA 3.20MM/3.0MM	AUTOMELT B64	Manufacturer
91013	VOESTALPINE BOHLER WELDING	SAWA1	SAWIRE FOR SA335P92	NOT APPLICABLE	THERMANIT MTS 616	Indian Agent
10015	ANITA FLUXES ALLOY SPECIALITY	SSOFL	WELD:SS-OVERLAY FLUX	FULL RANGE	ST-410	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	SSOFL	WELD:SS-OVERLAY FLUX	NOT APPLICABLE	MAXFLUX SS-4	Manufacturer
10785	ADOR WELDING LIMITED	SSOFL	WELD:SS-OVERLAY FLUX	FULL RANGE	AUTOMELT S 76	Manufacturer
15810	NOUVEAUX INDUSTRIES (P) LTD.,	SSOFL	WELD:SS-OVERLAY FLUX	NOT APPLICABLE	ASK SS410	Manufacturer
10785	ADOR WELDING LIMITED	TIGA1	GTAW ROD - T92 / P92	DIA 2.40 MM LENGTH 1000 MM	TIGFIL 90SB92	Manufacturer
13690	GEE LIMITED,	TIGA1	GTAW ROD - T92 / P92	DIA 2.40 MM	GETIG 90SB92	Manufacturer
20563	VOESTALPINE BOHLER WELDING	TIGA1	GTAW ROD - T92 / P92	DIA. 1.6,2.0,2.4 & 3.2MM	THERMANIT 616	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGS2	GTAW ROD ER309L	DIA: 2.40 MM	TG-S-309	Foreign Agent
22391	LINCOLN ELECTRIC FRANCE S.A.S	TIGS2	GTAW ROD ER309L	DIA. 2.4MM	INERT ROD 309 L	Manufacturer
23730	NIPPON STEEL TRADING CORPORATION.	TIGS2	GTAW ROD ER309L	DIA. 1.6,2.0 & 2.4MM	YT-309L	Channel Partner
10774	D&H SECHERON ELECTRODES PVT LTD.	TIGW1	ER 70S-A1 GTAW ROD	DIA.1.6,2.0,2.4,2.5 & 3.2MM	F CR MO	Manufacturer
10785	ADOR WELDING LIMITED	TIGW1	ER 70S-A1 GTAW ROD	DIA. 2.40 MM	TIGFIL 70S -A1	Manufacturer
13690	GEE LIMITED,	TIGW1	ER 70S-A1 GTAW ROD	DIA.2.40MM	GETIG 70S-A1	Manufacturer
18705	MODI HITECH INDIA LTD.,	TIGW1	ER 70S-A1 GTAW ROD	DIA 2.4/2.5MM	GMM TIG 70S A1	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGW1	ER 70S-A1 GTAW ROD	DIA. 0.8,1.0,1.2,1.6,2.0,2.4 & 3.2MM	TG-S70A1	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	TIGW1	ER 70S-A1 GTAW ROD	DIA.1.6,2.0,2.4 & 3.0MM	UNION I MO	Manufacturer
10081	ESAB INDIA LTD	TIGW2	ER 80S-B2 GTAW ROD	DIA.2.40 MM	OK TIGROD 13.16	Manufacturer

E. Suresh
E. SURESH

Engineer / SOC

Materials Management

Chemical & Safety / Production / Logistics
Tiruchirappalli, Tamil Nadu - 620 014

R. Arivazhagan
R. ARIVAZHAGAN
Dy. General Manager
Welding Technology Centre
BHEL, TRICHY - 620 014

M. Mahesh
E.M. MAHESH
Manager / Purchase / WC
Materials Management
Bharat Heavy Electricals Limited
Tiruchirappalli, Tamil Nadu - 620 014

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
10774	D&H SECHERON ELECTRODES PVT LTD.	TIGW2	ER 80S-B2 GTAW ROD	DIA.1.6,2.0,2.4,2.5 & 3.2MM	F CR MO 1	Manufacturer
10785	ADOR WELDING LIMITED	TIGW2	ER 80S-B2 GTAW ROD	DIA.2.40 MM	TIGFIL 80S -B2	Manufacturer
13211	D&H INDIA LIMITED	TIGW2	ER 80S-B2 GTAW ROD	DIA 2.4 MM	SUPER-80S-B2	Manufacturer
13690	GEE LIMITED,	TIGW2	ER 80S-B2 GTAW ROD	SIZE DIA. 2.40 MM	GETIG 80S-B2	Manufacturer
18705	MODI HITECH INDIA LTD.,	TIGW2	ER 80S-B2 GTAW ROD	DIA 2.4/2.5MM	GMM TIG 80 SB2	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGW2	ER 80S-B2 GTAW ROD	DIA.1.6,2.0,2.4 & 3.2MM	TG-S80B2	Foreign Agent
21461	INDUSTRIA NAZIONALE ELETTRODI S.p.A	TIGW2	ER 80S-B2 GTAW ROD	DIA.2.0,2.4 & 2.5MM	INETIG B2	Manufacturer
22456	I.A.BARNES & CO. LTD,	TIGW2	ER 80S-B2 GTAW ROD	DIA.2.40MM	UNISCO 80S-B2	Foreign Agent
10774	D&H SECHERON ELECTRODES PVT LTD.	TIGW3	ER 90S-B3 GTAW ROD	DIA. 2.40MM	FCRMO-2	Manufacturer
10785	ADOR WELDING LIMITED	TIGW3	ER 90S-B3 GTAW ROD	DIA: 2.40 MM	TIGFIL 90S - B3	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	TIGW3	ER 90S-B3 GTAW ROD	DIA.2.4/2.5 MM	MAILAM TIG-21	Manufacturer
13211	D&H INDIA LIMITED	TIGW3	ER 90S-B3 GTAW ROD	DIA 2.4 MM	SUPER-90S-B3	Manufacturer
13690	GEE LIMITED,	TIGW3	ER 90S-B3 GTAW ROD	DIA.2.4MM	GEETIG 90S-B3	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGW3	ER 90S-B3 GTAW ROD	DIA.1.6,2.0,2.4 & 3.2MM	TG-S90B3	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	TIGW3	ER 90S-B3 GTAW ROD	DIA 2.0,2.4 & 3.0MM	UNION ER 90 S-B3	Manufacturer
21461	INDUSTRIA NAZIONALE ELETTRODI S.p.A	TIGW3	ER 90S-B3 GTAW ROD	DIA.2.0,2.4 & 3.2MM	INETIG B3	Manufacturer
22456	I.A.BARNES & CO. LTD,	TIGW3	ER 90S-B3 GTAW ROD	DIA.2.40MM	UNISCO 90S-B3	Foreign Agent
11378	MAILAM INDIA PRIVATE LIMITED	TIGW4	WELDG.WIRE-TIG ER347	DIA 2.4MM	TIG -347	Manufacturer
13690	GEE LIMITED,	TIGW4	WELDG.WIRE-TIG ER347	SIZE DIA.2.40MM	GETIG 347	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGW4	WELDG.WIRE-TIG ER347	DIA.1.2,1.6,2.0,2.4 & 3.2MM	TG-S347	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	TIGW4	WELDG.WIRE-TIG ER347	DIA.1.0,1.6,2.0,2.4 & 3.2MM	THERMANIT H347	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	TIGW5	WELDG.WIRE-TIG ERNiC	DIA 2.4 /2.5 MM	MAILAM TIG NICR3	Manufacturer
13211	D&H INDIA LIMITED	TIGW5	WELDG.WIRE-TIG ERNiC	DIA 2.4 /2.5 MM	SUPERTIG-NICR3	Manufacturer
14400	ADOR WELDING LIMITED	TIGW5	WELDG.WIRE-TIG ERNiC	DIA 2.40MM	TIG-521	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGW5	WELDG.WIRE-TIG ERNiC	DIA.0.8,0.9,1.0,1.2,1.6,2.0,2.4,3.2 & 4.0MM	TG-S70NCB	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	TIGW5	WELDG.WIRE-TIG ERNiC	DIA.1.6,2.0,2.4 & 3.2MM	THERMANIT NICRO 82	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	TIGW7	WELDG.WIRE - TIG ER9	DIA 2.4 MM	F CRMO 91	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	TIGW7	WELDG.WIRE - TIG ER9	DIA2.4/2.5MM	MAILAM TIG-91	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGW7	WELDG.WIRE - TIG ER9	DIA.1.6,2.0 & 2.4MM	TGS-90 B9	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	TIGW7	WELDG.WIRE - TIG ER9	DIA.1.6,2.0,2.4 & 3.2MM	THERMANIT MTS 3	Manufacturer
22391	LINCOLN ELECTRIC FRANCE S.A.S	TIGW7	WELDG.WIRE - TIG ER9	DIA.2.4MM	CARBOROD CRMO91	Manufacturer
20563	VOESTALPINE BOHLER WELDING	TIGW9	ER80S - D2 GTAW ROD	DIA.2.0,2.4 & 3.0MM	UNION I MOMN	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	TIGWB	GTAW ROD SUPER304H	0.8MM/1MM	AUTOTHERME-SUPER-304H	Manufacturer
13211	D&H INDIA LIMITED	TIGWB	GTAW ROD SUPER304H	DIA2.4MM / 2.5 MM	SUPER TIG-304H	Manufacturer
20047	KANEMATSU TRADING CORPORATION	TIGWB	GTAW ROD SUPER304H	ONLY FOR DIA.2.40MM	TG-SUPER304H	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	TIGWB	GTAW ROD SUPER304H	DIA.0.8 & 1.0 & 2.40 MM	THERMANIT 304CU	Manufacturer
23730	NIPPON STEEL TRADING CORPORATION,	TIGWB	GTAW ROD SUPER304H	DIA.0.8MM, 1.0MM & 2.40MM	YT-304H	Channel Partner
10774	D&H SECHERON ELECTRODES PVT LTD.	WCA08	WELDG.ELECTRODES:SMA	DIA.2.50,3.15,4.00,5.00 & 6.30MM	MOLYTHERME	Manufacturer
10785	ADOR WELDING LIMITED	WCA08	WELDG.ELECTRODES:SMA	DIA.2.50,3.15,5.00 MM	MOLYTEN	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCA08	WELDG.ELECTRODES:SMA	DIA:2.5, 3.15, 4.0, 5.0 & 6.30MM	ULTIMATE 18A1	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCA08	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15 & 4.00 MM	MAILARC-MO	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCA08	WELDG.ELECTRODES:SMA	DIA.2.5, 3.15, 4.0,5.0 & 6.3 MM	ROYAL THERM-MOLY	Manufacturer
15090	RAJ KESARI ELECTRODES PVT LTD.	WCA08	WELDG.ELECTRODES:SMA	DIA.2.50,4.00, & 5.00 MM	RAJWELD-18A1	Manufacturer
17451	WELDFAST ELECTRODES PVT LTD,	WCA08	WELDG.ELECTRODES:SMA	DIA; 2.5,3.15,4.0 & 5.0 MM	WELDFAST CROMO 0500	Manufacturer
18432	VIJEY ELECTRODES AND WIRES PVT.	WCA08	WELDG.ELECTRODES:SMA	DIA.2.50,3.15,4.00 & 5.00 MM	VJ-7018 A1	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCA10	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.2,4.0 & 5.0MM	CROMOTHERME-1	Manufacturer

E. Suresh
E. SURESH
 Engineer / SOC
 Materials Management
 Bharat Heavy Electricals Limited
 Bangalore, Tamil Nadu - 620 014

R. Arivazhagan
R. ARIVAZHAGAN
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 620 014

M. Mahesh
E.M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals Limited

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
10785	ADOR WELDING LIMITED	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	CROMOTEN	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.2,4.0 & 5.0MM	ULTIMATE 80B2	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.2,4.0 & 5.0MM	MAILARC 1CR	Manufacturer
13690	GEE LIMITED,	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.15, 4 & 5 MM	GRIDUCT3	Manufacturer
13906	VOESTALPINE BOHLER WELDING	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	ULTRA-CR-1	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCA10	WELDG.ELECTRODES:SMA	DIA.3.15, 4.0 & 5.0MM ONLY	ROYAL CHROME-1	Manufacturer
15090	RAJ KESARI ELECTRODES PVT LTD.	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	RAJWELD-8018B2	Manufacturer
17451	WELDFAST ELECTRODES PVT LTD,	WCA10	WELDG.ELECTRODES:SMA	DIA. 2.5MM, 3.15MM, 4.0MM & 5.0MM	WELDFAST CROMO 1500	Manufacturer
18432	VIJAY ELECTRODES AND WIRES PVT.	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.15 & 4.0 MM	VJ-8018-B2	Manufacturer
18705	MODI HITECH INDIA LTD.,	WCA10	WELDG.ELECTRODES:SMA	DIA.2.5,3.15, 4.0 & 5.0 MM	GM 80-B2	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCA12	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.2,4.0 & 5.0MM	CROMOTHERME-2	Manufacturer
10785	ADOR WELDING LIMITED	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	CROMOTEN -C	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.2,4.0 & 5.0MM	ULTIMATE 90B3	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0 MM	MAILARC 2CR	Manufacturer
13211	D&H INDIA LIMITED	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0 MM	SUPER - CR - 2	Manufacturer
13690	GEE LIMITED,	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.15, 4 & 5 MM	GRIDUCT - 4	Manufacturer
13906	VOESTALPINE BOHLER WELDING	WCA12	WELDG.ELECTRODES:SMA	DIA.3.15,4.0 & 5.0MM	ULTRA - CR-2	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	ROYAL CHROME 2	Manufacturer
17451	WELDFAST ELECTRODES PVT LTD,	WCA12	WELDG.ELECTRODES:SMA	DIA. 2.5MM, 3.15MM, 4.0MM & 5.0MM	WELDFAST CROMO 2251	Manufacturer
18432	VIJAY ELECTRODES AND WIRES PVT.	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.15 & 4.0MM	VJ-9018-B3	Manufacturer
18705	MODI HITECH INDIA LTD.,	WCA12	WELDG.ELECTRODES:SMA	DIA.2.5,3.15 & 4.0 MM	GM 90 B3	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCA23	SMAW ELECD E9015-B91	DIA 2.5 MM, 3.2 MM & 4.00 MM	CROMOTHERME-91	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCA23	SMAW ELECD E9015-B91	DIA.2.50,3.20,4.0 MM	MAILARC 95B9	Manufacturer
13690	GEE LIMITED,	WCA23	SMAW ELECD E9015-B91	DIA 2.5 & 3.15 MM	GRIDUCT 95 B9	Manufacturer
20011	VOESTALPINE BOHLER WELDING	WCA23	SMAW ELECD E9015-B91	DIA.2.5,3.2,4.0 & 5.0MM	FOX C9MV	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCA23	SMAW ELECD E9015-B91	DIA.2.6,3.2,4.0 & 5.0MM	CM-95B91	Foreign Agent
22391	LINCOLN ELECTRIC FRANCE S.A.S	WCA23	SMAW ELECD E9015-B91	DIA.2.5,3.2,4.0 & 5.0MM	CROMO E91	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCA25	SMAW ELECD - T92/P92	DIA 2.4,3.2 & 4.0 MM	CHROMOTHERME 92	Manufacturer
20011	VOESTALPINE BOHLER WELDING	WCA25	SMAW ELECD - T92/P92	DIA.2.5,3.2 & 4.0MM	THERMANIT MTS 616 & MTS	Manufacturer
91270	VEEPEES INDIA,	WCA25	SMAW ELECD - T92/P92	DIA 2.5, DIA 3.2: DIA 4.0:	K9015B9W	Indian Agent
10774	D&H SECHERON ELECTRODES PVT LTD.	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	SUPRATHERME	Manufacturer
10785	ADOR WELDING LIMITED	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00MM	SUPABASE 7018	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	ULTIMATE - 18	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	MAIL ARC 18	Manufacturer
13211	D&H INDIA LIMITED	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	SUPER LH	Manufacturer
13542	SAITRON ENGINEERS PVT. LTD,	WCC05	WELDG.ELECTRODES:SMA	DIA. 2.50,3.15,4.00 & 5.0MM	SAITRON LH-7018	Manufacturer
13690	GEE LIMITED,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	GRICON GREEN	Manufacturer
13906	VOESTALPINE BOHLER WELDING	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	ULTRA - 7018	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	ROYAL THERME	Manufacturer
14791	ANAND ARC LTD.,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	ANAND THERME	Manufacturer
15082	ROYAL WELDING WIRES PVT. LTD.,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	JACKSON 18H	Manufacturer
15085	VOLTARC ELECTRODES (P) LTD,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	SPEEDARC E-7018	Manufacturer
15090	RAJ KESARI ELECTRODES PVT LTD.	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	SUPERLET - 18.	Manufacturer
15833	THIRUMALA ELECTRODES CO.,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	SEVEN ARCS-18	Manufacturer
17451	WELDFAST ELECTRODES PVT LTD,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00 MM	WELDFAST LH 18	Manufacturer
17644	VARUN ELECTRODES PVT. LTD.,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	PRIMA7018	Manufacturer


E Suresh
E SURESH
Engineer / SDC
Materials Management
Bharat Heavy Electricals Limited
Tiruchirappalli, Tamil Nadu - 620 014

R. Arivazhagan
R. ARIVAZHAGAN
Dy. General Manager
Welding Technology Centre
BHEL, TRICHY - 620 014

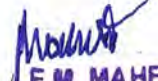
M. Mahesh
M. MAHESH
Manager / Purchase / WC
Materials Management
Bharat Heavy Electricals Limited
Tiruchirappalli, Tamil Nadu - 620 014

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
18300	SUPERON SCHWEISSTECHNIK INDUSTRI	WCC05	WELDG.ELECTRODES:SMA	DIA 3.15,4.00 & 5.00 MM	SUPERON 7018	Manufacturer
18432	VIJAY ELECTRODES AND WIRES PVT.	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00 MM	VJ-7018	Manufacturer
18705	MODI HITECH INDIA LTD.,	WCC05	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	GM 18	Manufacturer
100944	SRI LAXMI ELECTRODES CO	WCC05	WELDG.ELECTRODES:SMA	DIA 3.15 & 4.0 MM	SUPER ADTHERM E-7018	Manufacturer
101020	EXCEL CRAFT PRIVATE LTD	WCC05	WELDG.ELECTRODES:SMA	2.5, 3.15, 4.0 & 5.0 MM	MEDIOCARB-7018	Manufacturer
101180	COMINT SYSTEMS AND SOLUTIONS PVT	WCC05	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15, 4.0 & 5.0 MM	BRAVLD E 7018	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCC06	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00 & 6.30MM	SUPERATHERME-(SPL)	Manufacturer
10785	ADOR WELDING LIMITED	WCC06	WELDG.ELECTRODES:SMA	DIA 2.5MM,3.15MM & 4.0MM	TENALLOY-Z-PLUS	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCC06	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00 & 6.30MM	ULTIMATE-18 (SPL)	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCC06	WELDG.ELECTRODES:SMA	DIA 2.50,3.15 & 4.00 MM	MAILARC-18PLUS	Manufacturer
13211	D&H INDIA LIMITED	WCC06	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00 MM	SUPER-LH(SPL)	Manufacturer
13690	GEE LIMITED,	WCC06	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00,5.00 & 6.30 MM	GRICON GREEN (SPL)	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCC06	WELDG.ELECTRODES:SMA	DIA 2.5MM,3.15MM & 4.0MM	ROYAL THERME SPL	Manufacturer
18432	VIJAY ELECTRODES AND WIRES PVT.	WCC06	WELDG.ELECTRODES:SMA	DIA 2.50, 3.15, 4.00 & 5.00 MM	VJ 7018-1	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCF01	WELDG.WIRE:FLUX CORE	DIA 1.2 MM (DEVT IN DIA 1.6 MM)	MGA-12	Manufacturer
13211	D&H INDIA LIMITED	WCF01	WELDG.WIRE:FLUX CORE	DIA 1.2 & 1.6 MM	SUPERCORE71T-1	Manufacturer
13690	GEE LIMITED,	WCF01	WELDG.WIRE:FLUX CORE	DIA 1.2 MM & 1.6 MM	GFC-71	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCF01	WELDG.WIRE:FLUX CORE	DIA.1.2 MM	ROYAL FIL GS12R	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCF01	WELDG.WIRE:FLUX CORE	DIA.1.2,1.4 & 1.6MM	DW-100	Foreign Agent
20970	THE SHANGHAI LINCOLN ELECTRIC	WCF01	WELDG.WIRE:FLUX CORE	DIA.1.2 & 1.6MM	LW-71	Manufacturer
21180	TIEN TAI ELECTRODE CO., LTD,	WCF01	WELDG.WIRE:FLUX CORE	DIA 1.2 & 1.6 MM	TWE-711	Manufacturer
91270	VEEPEES INDIA,	WCF01	WELDG.WIRE:FLUX CORE	DIA.1.2 & 1.6MM	K-71T	Indian Agent
91820	SATKUL ENTERPRISES LTD.	WCF01	WELDG.WIRE:FLUX CORE	DIA.1.20MM	CSF-71T	Indian Agent
20047	KANEMATSU TRADING CORPORATION	WCF02	WELDG.WIRE:FLUX CORE	DIA.1.2 & 1.6MM	DW-309	Foreign Agent
91820	SATKUL ENTERPRISES LTD.	WCF02	WELDG.WIRE:FLUX CORE	DIA.1.20MM	CSF-309H	Indian Agent
91875	Arya Engineering	WCF02	WELDG.WIRE:FLUX CORE	DIA. 1.20 MM	SFC309L	Indian Agent
20033	KISWEL LTD.,	WCF03	WG:WIRE.FC.E309LMoTO	FULL RANGE	K-309MOLT	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCF03	WG:WIRE.FC.E309LMoTO	FULL RANGE	DW-309MOL	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	WCF03	WG:WIRE.FC.E309LMoTO	FULL RANGE	THERMIT TG 309 MO	Manufacturer
21180	TIEN TAI ELECTRODE CO., LTD,	WCF03	WG:WIRE.FC.E309LMoTO	SIZE: DIA.1.60MM	TFW-309LMO	Manufacturer
91820	SATKUL ENTERPRISES LTD.	WCF03	WG:WIRE.FC.E309LMoTO	DIA.1.60MM X 12.5 KG SPOOL	SF-309MOL	Indian Agent
10081	ESAB INDIA LTD	WCF04	WELDG: WIRE: FLUX CO	SIZE DIA.1.20MM	DUALSHIELD 8000-B2	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCF04	WELDG: WIRE: FLUX CO	DIA.1.2,1.4 & 1.6MM	DW-81B2	Foreign Agent
21065	HYUNDAI WELDING CO. LTD.,	WCF04	WELDG: WIRE: FLUX CO	DIA.1.2 & 1.6MM	SC-81B2	Manufacturer
91270	VEEPEES INDIA,	WCF04	WELDG: WIRE: FLUX CO	DIA.1.2 & 1.6MM	K-81TB2	Indian Agent
21180	TIEN TAI ELECTRODE CO., LTD,	WCF05	WELDG: WIRE: FLUX CO	DIA. 1.20MM & 1.60MM	TWE-91TB3	Manufacturer
91820	SATKUL ENTERPRISES LTD.	WCF05	WELDG: WIRE: FLUX CO	DIA.1.20MM	CSF-91B3	Indian Agent
11378	MAILAM INDIA PRIVATE LIMITED	WCFA1	BULKPACK :E551T1-B2C	DIA 1.60 MM	MGA-16	Manufacturer
13211	D&H INDIA LIMITED	WCFA1	BULKPACK :E551T1-B2C	DIA1.60MM DRUM PACK	SUPERCORE-81T1-B2	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCFA1	BULKPACK :E551T1-B2C	DIA.1.6 MM	DW-81B2	Foreign Agent
21180	TIEN TAI ELECTRODE CO., LTD,	WCFA1	BULKPACK :E551T1-B2C	DIA:1.6 MM	TWE-811B2	Manufacturer
23660	CHOSUN WELDING CO. LTD.	WCFA1	BULKPACK :E551T1-B2C	DIA 1.60 MM	CSF-81B2	Manufacturer
91270	VEEPEES INDIA,	WCFA1	BULKPACK :E551T1-B2C	DIA.1.6MM	K81TB2	Indian Agent
10309	KENNAMETAL INDIA LTD.,	WCH03	WELD:SMAW:HF-ECrA	DIA 3.2 & 4.0 MM; LENGTH 350 TO 450	STELLITE 6	Sales Office
20130	ALCONIX CORPORATION	WCH03	WELD:SMAW:HF-ECrA	FULL RANGE		Manufacturer
10309	KENNAMETAL INDIA LTD.,	WCH05	SMAW ELECTRO ECoCr-E	DIA 3.2 & 4.0 MM; LENGTH 350 TO 450	ECOCRE	Sales Office



E. SURESH
 Engineer / SDC
 Materials Management
 Bharat Heavy Electricals Limited
 600 014, Tamil Nadu - 600 014


R. ARIVAZHAGAN
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 620 014


E.M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals Limited

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
11378	MAILAM INDIA PRIVATE LIMITED	WCH05	SMAW ELECTRO ECoCr-E	DIA 3.2 MM ONLY	ME-71	Manufacturer
11865	DIFFUSION ENGINEERS LTD	WCH05	SMAW ELECTRO ECoCr-E	4MM ONLY	SUPERALLOY 1021	Manufacturer
13690	GEE LIMITED,	WCH05	SMAW ELECTRO ECoCr-E	SIZE: DIA.3.2MM	GEMET ST-21	Manufacturer
14400	ADOR WELDING LIMITED	WCH05	SMAW ELECTRO ECoCr-E	DIA.4.0 MM	LH-726 E	Manufacturer
20073	WEARTECH INTL INC	WCH05	SMAW ELECTRO ECoCr-E	DIA.2.5,3.2,4.0 & 5.0MM	WT-21	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCL07	WELDG.ELECTRODES:SMA	DIA.2.5,3.2,4.0 & 5.0MM	D&H 1212 NS	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCL07	WELDG.ELECTRODES:SMA	DIA. 2.50,3.15 & 4.0MM	CRYOMATE-3NS	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCL07	WELDG.ELECTRODES:SMA	DIA 2.4 ,3.15 AND 4.0 MM	ME-40	Manufacturer
13211	D&H INDIA LIMITED	WCL07	WELDG.ELECTRODES:SMA	DIA.4.0 MM	HAST-B(NS)	Manufacturer
13690	GEE LIMITED,	WCL07	WELDG.ELECTRODES:SMA	DIA 2.50,3.15 & 4.00 MM	GEMET 821N	Manufacturer
21991	SPECIAL METALS WELDING PRODUCTS	WCL08	SMAW ELECTRODE	DIA.2.4,3.2,4.0 & 4.8	INCONEL 152M	Manufacturer
10081	ESAB INDIA LTD	WCS20	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	OK 61.50	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCS20	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.15,4.0 & 5.0MM	RUTOX-A	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCS20	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0	MAILEX-A	Manufacturer
18705	MODI HITECH INDIA LTD.,	WCS20	WELDG.ELECTRODES:SMA	DIA 3.15 MM TO 3.20 MM	GM 308	Manufacturer
10081	ESAB INDIA LTD	WCS21	WELDG.ELECTRODES:SMA	DIA.2.50, 3.15 & 4.0MM	OK 61.30	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCS21	WELDG.ELECTRODES:SMA	DIA.2.50, 3.15 AND 4.0MM	RUTOX-B	Manufacturer
10081	ESAB INDIA LTD	WCS22	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	OK 67.67	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCS22	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.15,4.0 & 5.0MM	CRONITHERME-25/12	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCS22	WELDG.ELECTRODES:SMA	DIA.2.5,3.15 & 4.0MM	SILVERSHINE - 309.	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCS22	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	MAILEX-25/12	Manufacturer
13690	GEE LIMITED,	WCS22	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15 & 4.0 MM	GRINOX-9	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCS22	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15, 4.0 & 5.0 MM.	ROYAL-D2	Manufacturer
18300	SUPERON SCHWEISSTECHNIK INDUSTRI	WCS22	WELDG.ELECTRODES:SMA	DIA 4.00 MM	SUPERON 309	Manufacturer
10081	ESAB INDIA LTD	WCS27	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	OK 67.13	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCS27	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.15,4.0 & 5.0MM	D&H 310-16	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCS27	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15 & 4.0 MM	MAILEX-25/20	Manufacturer
17644	VARUN ELECTRODES PVT. LTD.,	WCS27	WELDG.ELECTRODES:SMA	DIA 4 MM	PRIMA	Manufacturer
18705	MODI HITECH INDIA LTD.,	WCS27	WELDG.ELECTRODES:SMA	DIA 4 MM	GM 310	Manufacturer
10081	ESAB INDIA LTD	WCS28	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	OK 63 . 50	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCS28	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.15,4.0 & 5.0MM	RUTOX-MO	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCS28	WELDG.ELECTRODES:SMA	2.5, 3.15 & 4.0 MM	MAILEX-MO	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCS28	WELDG.ELECTRODES:SMA	DIA.3.15 & 4.0MM	ROYAL - 2A	Manufacturer
10081	ESAB INDIA LTD	WCS29	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	OK 63 . 30	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCS29	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.15,4.0 & 5.0MM	RUTOX-D	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCS29	WELDG.ELECTRODES:SMA	2.5, 3.15 & 4.0 MM	MAILEX-MOL	Manufacturer
13690	GEE LIMITED,	WCS29	WELDG.ELECTRODES:SMA	2.5,3.15 & 4.0 MM	GRINOX-16L	Manufacturer
18705	MODI HITECH INDIA LTD.,	WCS29	WELDG.ELECTRODES:SMA	DIA 4.0 MM	GM 316L	Manufacturer
10081	ESAB INDIA LTD	WCS30	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	OK 61.80	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCS30	WELDG.ELECTRODES:SMA	DIA.2.0,2.5,3.15,4.0 & 5.0MM	RUTOX-A (ST)	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCS30	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	SILVERSHINE - 347-16	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCS30	WELDG.ELECTRODES:SMA	DIA.2.5,3.15,4.0 & 5.0MM	MAILEX-ANB	Manufacturer
13211	D&H INDIA LIMITED	WCS30	WELDG.ELECTRODES:SMA	DIA 4.0 MM	CROMALLOY-A (ST)	Manufacturer
13690	GEE LIMITED,	WCS30	WELDG.ELECTRODES:SMA	DIA.2.50, 3.15 & 4.0MM	GRINOX 47	Manufacturer
13906	VOESTALPINE BOHLER WELDING	WCS30	WELDG.ELECTRODES:SMA	DIA.2.5,3.15 & 4.0MM	SUPERALLOY 1A(S)	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCS30	WELDG.ELECTRODES:SMA	DIA.2.5, 3.15 & 4 MM	ROYAL-1B	Manufacturer

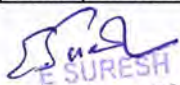

E. SURESH
 Engineer / SOC
 Materials Management
 Bharat Heavy Electricals Limited
 Trichy, Tamil Nadu - 620 014


R. ARIVAZHAGAN
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 620 014


E.M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals
 Trichy, Tamil Nadu - 620 014

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
11865	DIFFUSION ENGINEERS LTD	WCT01	WELD:HF-HAY.ALLY 25	DIA 5.0 MM AND LENGTH 1000 MM	SUPERALLOY 1025 B	Manufacturer
13690	GEE LIMITED,	WCT01	WELD:HF-HAY.ALLY 25	FULL RANGE	WT-25	Indian Agent
11865	DIFFUSION ENGINEERS LTD	WCT02	WELD:HF-HAY.ALLY 21	5 MM	SUPERALLOY 1021 B	Manufacturer
13690	GEE LIMITED,	WCT02	WELD:HF-HAY.ALLY 21	FULL RANGE	ALLOY -21	Indian Agent
20073	WEARTECH INTL INC	WCT02	WELD:HF-HAY.ALLY 21	FULL RANGE	WT-21	Manufacturer
10309	KENNAMETAL INDIA LTD.,	WCT03	WELD:HF-RCO CRA	DIA 3.2,4.0,5.0 & 6.0 MM; LENGTH 1000	STELLITE 6	Sales Office
11865	DIFFUSION ENGINEERS LTD	WCT03	WELD:HF-RCO CRA	DIA 3.2, 4.0 & 5.0 MM	SUPERALLOY 1006 B	Manufacturer
13690	GEE LIMITED,	WCT03	WELD:HF-RCO CRA	FULL RANGE	MHA NO.6	Indian Agent
20073	WEARTECH INTL INC	WCT03	WELD:HF-RCO CRA	FULL RANGE	WT-6	Manufacturer
10309	KENNAMETAL INDIA LTD.,	WCT04	WG:PWD:HF:TYP COCRA	NOT SPECIFIED	STELLITE 6	Sales Office
11865	DIFFUSION ENGINEERS LTD	WCT04	WG:PWD:HF:TYP COCRA	COBALT BASE POWDER FOR PTAW	C-06-PL	Manufacturer
16554	SANWA DIAMOND TOOLS PVT LTD,	WCT04	WG:PWD:HF:TYP COCRA	NOT APPLICABLE	SDT-6	Manufacturer
20321	HOGANAS BELGIUM SA	WCT04	WG:PWD:HF:TYP COCRA	NOT APPLICABLE	HMSP 2537-00	Manufacturer
24560	SENTESBIR	WCT04	WG:PWD:HF:TYP COCRA	AS PER WCPI 302	FORTECOAT 42006	Manufacturer
103390	LEVIGATE ALLOYS PVT LTD	WCT04	WG:PWD:HF:TYP COCRA	ALL	LEVISHIELD	Manufacturer
10309	KENNAMETAL INDIA LTD.,	WCT05	CoCre Powder	NOT SPECIFIED	KENNAMETAL STELLITE	Sales Office
20073	WEARTECH INTL INC	WCT05	CoCre Powder	N.A	WT-21	Manufacturer
20321	HOGANAS BELGIUM SA	WCT05	CoCre Powder	N.A	2528-00	Manufacturer
24560	SENTESBIR	WCT05	CoCre Powder	AS PER WCPI 307	FORTECOAT 42021S	Manufacturer
10785	ADOR WELDING LIMITED	WCW02	WELDING WIRE:SAW EB3	DIA 4.0 MM	AUTOMELT EB3R	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCW02	WELDING WIRE:SAW EB3	DIA 3.2,4.0 & 4.8 MM	US-521	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	WCW02	WELDING WIRE:SAW EB3	DIA.3.2,4.0 & 4.8MM	UNION S 1 CR MO 2	Manufacturer
91270	VEEPEES INDIA,	WCW02	WELDING WIRE:SAW EB3	DIA.4.0MM	EF-200HX KD-B3	Indian Agent
10081	ESAB INDIA LTD	WCW04	WG:WIRE:SAW ER430	FULL RANGE	O.K AUTROD 430	Manufacturer
14400	ADOR WELDING LIMITED	WCW04	WG:WIRE:SAW ER430	DIA 2.40 MM	SAW-128	Manufacturer
20033	KISWEL LTD.,	WCW04	WG:WIRE:SAW ER430	FULL RANGE	M-430	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCW04	WG:WIRE:SAW ER430	FULL RANGE	US-430	Foreign Agent
10785	ADOR WELDING LIMITED	WCW06	WELDING WIRE:SAW EB2	DIA 4 MM	AUTOMELT EB2	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCW06	WELDING WIRE:SAW EB2	DIA 2.0,3.2,4.0 & 4.8 MM	US-511	Foreign Agent
20516	LINCOLN ELECTRIC FRANCE S.A.	WCW06	WELDING WIRE:SAW EB2	DIA:2.0MM AND 4.0MM	LNS 150	Manufacturer
20563	VOESTALPINE BOHLER WELDING	WCW06	WELDING WIRE:SAW EB2	DIA.3.2,4.0 & 4.8MM	UNION S 2 CR MO	Manufacturer
21461	INDUSTRIA NAZIONALE ELETTRODI S.p.A	WCW06	WELDING WIRE:SAW EB2	DIA.2.0MM	INESUB EB2	Manufacturer
22456	I.A.BARNES & CO. LTD,	WCW06	WELDING WIRE:SAW EB2	DIA. 4.0MM	UNISCO EB2	Foreign Agent
91270	VEEPEES INDIA,	WCW06	WELDING WIRE:SAW EB2	DIA. 2.0MM & 4.0MM	EF-200HX KD-B2	Indian Agent
10774	D&H SECHERON ELECTRODES PVT LTD.	WCW08	WELDING WIRE:SAW EA4	DIA 4.00 MM	MERGEARC	Manufacturer
13211	D&H INDIA LIMITED	WCW08	WELDING WIRE:SAW EA4	DIA 4.0 MM	SUPERMELT-A-4	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCW08	WELDING WIRE:SAW EA4	DIA.2.0,2.4,3.2,4.0 & 4.8MM	US-49	Foreign Agent
10081	ESAB INDIA LTD	WCW09	WELDING WIRE:SAW EM1	DIA.1.6,2.0,2.4 & 3.2MM	OK AUTROD 12.22L	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCW09	WELDING WIRE:SAW EM1	DIA.1.6,2.0,2.4 & 3.2MM	AUTOTHERME GRADE B	Manufacturer
10785	ADOR WELDING LIMITED	WCW09	WELDING WIRE:SAW EM1	DIA.1.6,2.0,2.4 & 3.2MM	AUTOMELT EM12K	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCW09	WELDING WIRE:SAW EM1	DIA.1.6,2.0,2.4 & 3.2MM	MAILAM SAW12	Manufacturer
13211	D&H INDIA LIMITED	WCW09	WELDING WIRE:SAW EM1	DIA 4.0 MM	SUPERMELT-12K	Manufacturer
15085	VOLTARC ELECTRODES (P) LTD,	WCW09	WELDING WIRE:SAW EM1	DIA 4.0 MM	SAW WIRE EM12K	Manufacturer
15810	NOUVEAUX INDUSTRIES (P) LTD.,	WCW09	WELDING WIRE:SAW EM1	DIA.1.6,2.0,2.4 & 3.2MM	NOUVAARC S2	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCW09	WELDING WIRE:SAW EM1	DIA.1.6,2.0,2.4 & 3.2MM	US-29	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	WCW09	WELDING WIRE:SAW EM1	DIA.1.6,2.0,2.4 & 3.2MM	UNION S2SI	Manufacturer


E. SURESH

Engineer / SDC

Materials Management

Bharat Heavy Electricals Limited

7, Chinnai, Tamil Nadu - 620 014


R. ARIVAZHAGAN
Dy. General Manager
Welding Technology Centre
BHEL, TRICHY - 620 014


E.M. MAHESH
Manager / Purchase / WC
Materials Management
Bharat Heavy Electricals Limited

List of Approved PRESSURE PARTS Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
10081	ESAB INDIA LTD	WCW12	WELDING WIRE:SAW 3 B	DIA.2.5 & 3.2MM	OK 13.35	Manufacturer
13690	GEE LIMITED,	WCW12	WELDING WIRE:SAW 3 B	DIA 3.2 MM	GEESAW EB91	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCW12	WELDING WIRE:SAW 3 B	DIA.1.6,2.4 & 3.2 & 4.00MM	US-90B9	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	WCW12	WELDING WIRE:SAW 3 B	DIA. 1.6, 2.5 & 3.2 MM	THERMANIT MTS-3	Manufacturer
22391	LINCOLN ELECTRIC FRANCE S.A.S	WCW12	WELDING WIRE:SAW 3 B	DIA.2.4 & 3.2MM	OE-S1CRM091	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCW13	ER 309 SAW Wire	DIA: 3.20 MM	AUTOTHERME-309	Manufacturer
13690	GEE LIMITED,	WCW13	ER 309 SAW Wire	DIA: 3.20 MM	GEESAW309	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCW14	ER 347 SAW Wire	DIA: 3.20 MM	AUTOTHERME-347	Manufacturer
13690	GEE LIMITED,	WCW14	ER 347 SAW Wire	DIA: 3.20 MM	GEESAW347	Manufacturer


E SURESH
 Engineer / SDC
 Materials Management
 Bharat Heavy Electricals Limited
 Tiruchirappalli, Tamil Nadu - 620 014


R. ARIVAZHAGAN
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 620 014


E.M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals Limited
 Tiruchirappalli, Tamil Nadu - 620 014

List of Approved Structural Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
10081	ESAB INDIA LTD	MIGW7	GMAW WIRE ER70S-6	DIA.0.8,1.0,1.2 & 1.6MM	ESAB MW 1	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	MIGW7	GMAW WIRE ER70S-6	DIA.0.8,1.0,1.2 & 1.6MM	AUTO THERME - 1	Manufacturer
10785	ADOR WELDING LIMITED	MIGW7	GMAW WIRE ER70S-6	DIA.0.8,1.0,1.2 & 1.6MM	AUTOMIG - 1	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	MIGW7	GMAW WIRE ER70S-6	8	MAILAM MIG6	Manufacturer
13211	D&H INDIA LIMITED	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	MIGARC WS 6	Manufacturer
13549	ATHARV WELDING TECHNOLOGIES (INDIA)	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	ATHARV MIG WIRE	Manufacturer
13690	GEE LIMITED,	MIGW7	GMAW WIRE ER70S-6	DIA.0.8,1.0,1.2 & 1.6MM	GM 70	Manufacturer
13906	VOESTALPINE BOHLER WELDING	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	MARUTI MIG	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	ROYAL 70S6	Manufacturer
14791	ANAND ARC LTD.,	MIGW7	GMAW WIRE ER70S-6	DIA.0.8,1.0,1.2 & 1.6MM	ANAND MIG - 1	Manufacturer
15082	ROYAL WELDING WIRES PVT. LTD.,	MIGW7	GMAW WIRE ER70S-6	SIZE DIA.1.20MM	JACKSUN 70S-6	Manufacturer
15085	VOLTARC ELECTRODES (P) LTD,	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	AUTOFIL-6	Manufacturer
15810	NOUVEAUX INDUSTRIES (P) LTD.,	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	NOUVARC	Manufacturer
15924	DAYACHAND ENGINEERING INDUSTRIES	MIGW7	GMAW WIRE ER70S-6	DIA: 1.20 MM	FAIRWELD	Manufacturer
16166	EVERSHINE WIRES	MIGW7	GMAW WIRE ER70S-6	DIA.0.8,1.0,1.2 & 1.6MM	SHINE ARC - 1	Manufacturer
17451	WELDFAST ELECTRODES PVT LTD,	MIGW7	GMAW WIRE ER70S-6	DIA.0.80,1.0,1.20 & 1.60MM	MIGFAST-1	Manufacturer
17644	VARUN ELECTRODES PVT. LTD.,	MIGW7	GMAW WIRE ER70S-6	DAI.1.0,1.2 & 1.6MM	PRIMA	Manufacturer
17814	CALCUTTA ELECTRODES PVT. LTD.,	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	SHIVA-CO2	Manufacturer
18705	MODI HITECH INDIA LTD.,	MIGW7	GMAW WIRE ER70S-6	DAI.1.0,1.2 & 1.6MM	GMM	Manufacturer
91270	VEEPEES INDIA,	MIGW7	GMAW WIRE ER70S-6	DIA.1.0,1.2 & 1.6MM	KC 28	Indian Agent
13484	OSCAR AUTO FLUX,	STFL1	SAW FLUX STRUCT.WELD	NOT APPLICABLE	OSCAR AUTOFLUX GR.II	Manufacturer
13486	A V WELDTech PVT.LTD.,	STFL1	SAW FLUX STRUCT.WELD	NOT APPLICABLE	AV EZEWELD 18L	Manufacturer
15099	THERMIT ALLOYS PRIVATE LTD,	STFL1	SAW FLUX STRUCT.WELD	NOT APPLICABLE	CONWELD-AB	Manufacturer
10081	ESAB INDIA LTD	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	OK FLUX 10.81L	Manufacturer
10785	ADOR WELDING LIMITED	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	AUTOMELT GR.II	Manufacturer
11701	SUPER WELD PRODUCTS	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	SWP40T	Manufacturer
11712	TAPADIA ENGINEERS & TRADERS P.LTD.	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	TPD-50	Manufacturer
13211	D&H INDIA LIMITED	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	SUPERMELT II	Manufacturer
13484	OSCAR AUTO FLUX,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	OSCAR AUTOWELD GR. I	Manufacturer
14309	S.CHEMS & ALLIED PRODUCERS PVT LIM	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	SURE FLUX GP	Manufacturer
14791	ANAND ARC LTD.,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	ANAND MELT - 1	Manufacturer
15082	ROYAL WELDING WIRES PVT. LTD.,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	JACKSUN SFA GRADE- 1	Manufacturer
15085	VOLTARC ELECTRODES (P) LTD,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	SUBARC-1 (EL-8)	Manufacturer
15099	THERMIT ALLOYS PRIVATE LTD,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	CONWELD - RM	Manufacturer
19114	WELMET TECHNOLOGIES PVT. LTD.,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	WELMET FLUX 81-L	Manufacturer
19695	SUBMER FLUX TECHNOLOGIES,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	SHINE FLUX	Manufacturer
19735	RENUKA FLUXES COMPANY,	STRFL	SAW FLUX STRUCT.WELD	NOT APPLICABLE	RENUKA	Manufacturer
10081	ESAB INDIA LTD	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	ESAB FERROSPEED PLUS	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	NORMA	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	REGULAR-S.	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	MAILARC 13R	Manufacturer
11380	MALU ELECTRODES PVT.LIMITED	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	MANGALAM E 6013	Manufacturer
13211	D&H INDIA LIMITED	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	STANDARD	Manufacturer

E Suresh
E SURESH
 Engineer / SDC
 Materials Management
 Bharat Heavy Electricals Limited
 Trichirappalli, Tamil Nadu - 620 014

R. Arivazhagan
R. ARIVAZHAGAN
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 620 014

E.M. Mahesh
E.M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals
 Trichirappalli, Tamil Nadu

List of Approved Structural Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
13538	WELDCOM ELECTRODES PVT.LTD.,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	NOVAX - 13	Manufacturer
13549	ATHARV WELDING TECHNOLOGIES (INDIA)	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	AWT E6013	Manufacturer
13690	GEE LIMITED,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	GEECON PINK	Manufacturer
13906	VOESTALPINE BOHLER WELDING	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	MARUTI 44-	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	ROYAL S	Manufacturer
14429	ALPHA FLUX & ELETRODES,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	WELDER - G	Manufacturer
15082	ROYAL WELDING WIRES PVT. LTD.,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	JACKSON 5	Manufacturer
15085	VOLTARC ELECTRODES (P) LTD,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	SPEEDARC E-6013	Manufacturer
15087	V.N.C.ELECTRODEES,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	BEST ARC MS11-	Manufacturer
15090	RAJ KESARI ELECTRODES PVT LTD.	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	RAJCARD-13S	Manufacturer
16168	P.R.Industries	WCC01	WELDG.ELECTRODES:SMA	SIZE DIA. 2.5,3.15,4.0 & 5.0MM	ANAND-13	Manufacturer
17451	WELDFAST ELECTRODES PVT LTD,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	WELDFAST SUPER	Manufacturer
17644	VARUN ELECTRODES PVT. LTD.,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	PRIMA-6013S	Manufacturer
17814	CALCUTTA ELECTRODES PVT. LTD.,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	SHIVA-S	Manufacturer
18705	MODI HITECH INDIA LTD.,	WCC01	WELDG.ELECTRODES:SMA	DIA 2.50,3.15,4.00 & 5.00	GM 20	Manufacturer
19684	MANOHAR ELECTRODES PVT. LTD	WCC01	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15, 4.0 & 5.0 MM	MANOHAR E-6013	Manufacturer
19808	VAISHALI ELECTRODES	WCC01	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15, 4.0 & 5.0 MM	VAISHALI ADVANI 6013	Manufacturer
19809	ANUVRAT INDUSTRIES	WCC01	WELDG.ELECTRODES:SMA	DIA 2.5, 3.15, 4.0, & 5.0 MM	ANUBOND 6013	Manufacturer
100944	SRI LAXMI ELECTRODES CO	WCC01	WELDG.ELECTRODES:SMA	DIA 3.15 & 4.0 MM	ADVANI ARC E6013	Manufacturer
101180	COMINT SYSTEMS AND SOLUTIONS PVT I	WCC01	WELDG.ELECTRODES:SMA	2.5, 3.15, 4.0 & 5.0 MM.	BRAVLD E6013	Manufacturer
10081	ESAB INDIA LTD	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	ESAB-36H	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SUPRATHERME	Manufacturer
10785	ADOR WELDING LIMITED	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SUPABASE 7018	Manufacturer
11227	HONAVAR ELECTRODES PVT. LTD.,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	ULTIMATE - 18----	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	MAIL ARC 18	Manufacturer
11380	MALU ELECTRODES PVT.LIMITED	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	MANGALAM E 7018	Manufacturer
13211	D&H INDIA LIMITED	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SUPER LH	Manufacturer
13542	SAITRON ENGINEERS PVT. LTD,	WCC10	E7018 SMAW Electrode	DIA. 2.50,3.15,4.00 & 5.0MM	SAITRON LH-7018	Manufacturer
13690	GEE LIMITED,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	GRICON GREEN	Manufacturer
13906	VOESTALPINE BOHLER WELDING	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	ULTRA - 7018	Manufacturer
13911	ROYAL ARC ELECTRODES LIMITED	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	ROYAL THERM	Manufacturer
14429	ALPHA FLUX & ELETRODES,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SUPER WELD 7018	Manufacturer
14791	ANAND ARC LTD.,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	ANAND THERME	Manufacturer
15082	ROYAL WELDING WIRES PVT. LTD.,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	JACKSON 18H	Manufacturer
15085	VOLTARC ELECTRODES (P) LTD,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00 MM	SPEEDARC E-7018	Manufacturer
15087	V.N.C.ELECTRODEES,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	BESTARC-LH-18	Manufacturer
15090	RAJ KESARI ELECTRODES PVT LTD.	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SUPERLET - 18.	Manufacturer
15833	THIRUMALA ELECTRODES CO.,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SEVEN ARCS-18	Manufacturer
17451	WELDFAST ELECTRODES PVT LTD,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00 MM	WELDFAST LH 18	Manufacturer
17644	VARUN ELECTRODES PVT. LTD.,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	PRIMA7018	Manufacturer
17814	CALCUTTA ELECTRODES PVT. LTD.,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SHIVATHERME-18	Manufacturer
18300	SUPERON SCHWEISSTECHNIK INDUSTRIE	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	SUPERCITO OERLICON E	Manufacturer
18432	VIJAY ELECTRODES AND WIRES PVT.	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	VIJAY-7018	Manufacturer


Suresh
E. SURESH
 Engineer / SDC
 Bharat Heavy Electricals Limited
 Chittoor, Andhra Pradesh - 520 014

R Arivazhagan
R. ARIVAZHAGAN
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 520 014

Manish
E.M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals Limited
 Chittoor, Andhra Pradesh - 520 014

List of Approved Structural Welding Consumables Vendors (as on 05.03.2026)

Vendor No	Vendor Name	Mat Group	Description	Size Detail	Brand	Vendor Type
18705	MODI HITECH INDIA LTD.,	WCC10	E7018 SMAW Electrode	DIA 2.50,3.15,4.00 & 5.00	GM 18	Manufacturer
101020	EXCEL CRAFT PRIVATE LTD	WCC10	E7018 SMAW Electrode	2.5, 3.15, 4.0 & 5.0 MM	MEDIOCARB-7018	Manufacturer
101180	COMINT SYSTEMS AND SOLUTIONS PVT I	WCC10	E7018 SMAW Electrode	DIA 2.5, 3.15, 4.0 & 5.0 MM	BRAVLD E 7018	Manufacturer
10081	ESAB INDIA LTD	WCW01	EL-8 SAW WIRE	DIA.2.4,3.2 & 4.0MM	OK AUTROD 12.08L	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCW01	EL-8 SAW WIRE	DIA.2.0 TO 5.0MM	AUTOTHERME GRADE A	Manufacturer
10785	ADOR WELDING LIMITED	WCW01	EL-8 SAW WIRE	DIA.2.4,3.2 & 4.0MM	AUTOMELT GR.A	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCW01	EL-8 SAW WIRE	DIA.2.0 TO 5.0MM	MAILAM SAW 8	Manufacturer
13211	D&H INDIA LIMITED	WCW01	EL-8 SAW WIRE	DIA.2.0 TO 5.0MM	SUPERMELT GR-A	Manufacturer
13486	A V WELDTECH PVT.LTD.,	WCW01	EL-8 SAW WIRE	DIA: 4.0 MM	AV 1	Manufacturer
14791	ANAND ARC LTD.,	WCW01	EL-8 SAW WIRE	DIA.2.0 TO 5.0MM	ANAND SAW - 1	Manufacturer
15085	VOLTARC ELECTRODES (P) LTD,	WCW01	EL-8 SAW WIRE	DIA.2.4,3.2 & 4.0MM	SAW WIRE EL - 8	Manufacturer
15810	NOUVEAUX INDUSTRIES (P) LTD.,	WCW01	EL-8 SAW WIRE	DIA.2.4,3.2 & 4.0MM	NOUVAX	Manufacturer
16166	EVERSHINE WIRES	WCW01	EL-8 SAW WIRE	DIA.2.0 TO 5.0MM	SHINE ARC	Manufacturer
16314	SUN WIRES.	WCW01	EL-8 SAW WIRE	DIA.2.50MM TO 5.0MM	SUN WIRES	Manufacturer
19114	WELMET TECHNOLOGIES PVT. LTD.,	WCW01	EL-8 SAW WIRE	DIA.2.0 TO 5.0MM	WELMET WIRE EL8	Manufacturer
10081	ESAB INDIA LTD	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	OK AUTROD 12.22L	Manufacturer
10774	D&H SECHERON ELECTRODES PVT LTD.	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	AUTOTHERME GRADE B	Manufacturer
10785	ADOR WELDING LIMITED	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	AUTOMELT EM12K	Manufacturer
11378	MAILAM INDIA PRIVATE LIMITED	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	MAILAM SAW12	Manufacturer
13486	A V WELDTECH PVT.LTD.,	WCW15	WeldWire SAW EM12K	DIA:4 MM ONLY	AV 2	Manufacturer
15810	NOUVEAUX INDUSTRIES (P) LTD.,	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	NOUVAARC S2	Manufacturer
16166	EVERSHINE WIRES	WCW15	WeldWire SAW EM12K	DIA 2.0, 2.4, 3.2 & 4.0 MM	SHINE ARC-12K	Manufacturer
19114	WELMET TECHNOLOGIES PVT. LTD.,	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	WELMET WIRE EM12K	Manufacturer
20047	KANEMATSU TRADING CORPORATION	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	US-29	Foreign Agent
20563	VOESTALPINE BOHLER WELDING	WCW15	WeldWire SAW EM12K	DIA. 1.6,2.0,2.4 & 3.2MM	UNION S2SI	Manufacturer


E SURESH
 Engineer / SDC
 Materials Management
 Bharat Heavy Electricals Limited
 Tiruchirappalli, Tamil Nadu - 620 014


R. ARIVAZHAGAN
 Dy. General Manager
 Welding Technology Centre
 BHEL, TRICHY - 620 014


E.M. MAHESH
 Manager / Purchase / WC
 Materials Management
 Bharat Heavy Electricals Limited
 Tiruchirappalli, Tamil Nadu - 620-014

Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)

Table-2: Post weld heat treatment for Butt welds/stub welds/nozzle welds (other than attachment welds)

BUTT / STUB BASE METAL	P1 Group 1 (Gr. B), P1 Group 2 (Gr.C) t<=19	P1 Group 1 (Gr. B), P1 Group 2 (Gr.C) t>19	P3 (OD <=127 & T<=13)	P3 (OD >127 or T>13)	P4 (OD <=127 & T<=13) (©©)	P4 (OD >127 or T>13) (©©)	P5A, (OD<=102 & T<=8) (©)	P5A, (OD>102 or T>8) (©)	P15 E Group 1 (P91/P92)	P8
P1 Group 1 (Gr. B), Steel 20, 15 Mo3, P1 Group 2 (Gr.C) t<=19	Pre Heat=Nil Post Heat: Nil PWHT: Nil	Pre Heat=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT:615+/-20 #	Pre Heat=150 Post Heat: Nil PWHT: If PH – Nil, Else 635+/-15	Pre Heat=150 Post Heat: Nil PWHT: 635+/-15	Pre Heat=150 Post Heat: Nil PWHT: If PH – Nil, Else 665+/-15	Pre Heat=150 Post Heat: Nil PWHT: 665+/-15	Pre Heat=150 Post Heat: Nil PWHT: If PH –Nil, Else 695+/-15	Pre Heat=150 Post Heat: Nil PWHT: 695+/-15	NA	NA
P1 Group 1 (Gr. B), Steel 20, 15 Mo3, P1 Group 2 (Gr.C) t>19	Pre Heat=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: 615+/-20 #	Pre Heat=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT:615+/-20 #	Pre Heat=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: If PH 615+/-20 #, else 635+/-15	Pre Heat=150 Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: 635+/-15	PH=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: If PH 615+/-20 #, else 665+/-15	PH=150 Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: 665+/-15	PH=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: If PH 615+/-20 #, else 695+/-15	PH=150 Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT:695+/-15	NA	NA

Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)

P4, 13CrMo44 (OD <=127 & T<=13) (©©)	PH=150 Post Heat: Nil PWHT: 665+/-15(φ)	PH=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: if PH 615+/-20, else 665+/-15	PH=150 Post Heat: Nil PWHT: If PH – Nil, Else 665+/-15	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil PWHT: If PH – Nil, Else 665+/-15	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil PWHT: If PH – Nil, Else 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	NA	NA
P4, 13CrMo44 (OD >127 or T>13)(©©)	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT:665+/-15	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	NA	NA
P5A, 10CrMo910 (OD<=102 & T<=8) (©)	PH=150 Post Heat: Nil PWHT: If PH- Nil, Else 695+/-15	PH=150 (©©©) Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT: If PH -615+/-20, else 695+/-15	PH=150 Post Heat: Nil PWHT: If PH- Nil, Else 695+/-15	PH=150 Post Heat: Nil PWHT: 635+/-15	PH=150 Post Heat: Nil PWHT: If PH- Nil, Else 695+/-15	PH=150 Post Heat: Nil PWHT: 665+/-15	PH=150 Post Heat: Nil PWHT: If PH- Nil, Else 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=220 Post Heat:280 for 2 hours PWHT: 760+/-10###	PH=150 Post Heat: Nil PWHT: 695+/-15 (φ)

Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)

P5A(OD>102 or T>8) (©)	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=150 Post Heat: Nil (150 for 2 hrs for P1 Group 2) PWHT:695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=150 Post Heat: Nil PWHT: 695+/-15	PH=220 Post Heat:280 for 2 hours PWHT: 760+/-10 ##	PH=150 Post Heat: Nil PWHT: 695+/-15
P8	NA	NA	NA	NA	NA	NA	PH=150 Post Heat: Nil PWHT: 695+/-15(φ)	PH=150 Post Heat: Nil PWHT: 695+/-15	NA	PH=Nil Post Heat=Nil PWHT=Nil
P15 E Group 1 (P91/P92)	NA	NA	NA	NA	NA	NA	PH=220 Post Heat:280 for 2 hours PWHT: 760+/-10 ##	PH=220 Post Heat:280 for 2 hours PWHT: 760+/-10 ##	PH=220 Post Heat:280 for 2 hours PWHT: 760+/-10 ##	NA

Legend for Table 2:

- © : Preheat temperature for castings and forgings of P5A shall be 220 deg. C
- ©© : Minimum SR temperature shall be 650 deg C for ASME jobs of P4 material.
- ©©©: Preheating is not required for P1 group 1 (Gr. B) materials for thickness <=25.

Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)

#: For thickness above 50mm, PWHT shall be carried out at 615+/-20 deg.C with a soaking time of one hour/ inch of T up to 50mm plus 15 minutes for every 25mm thickness above 50mm.

##: Preheat shall be maintained for P15E Group 1 (P91/P92) until the welding operation is completed. Interpass temperature for P15E group1 welding shall be limited to 350 deg C. After post heating, joints of P15 E group 1 shall be slowly cooled to room temperature and then kept at that temperature for a maximum of 72 hours before PWHT.

φ : If not preheated.

Table-3 Post weld heat treatment (PWHT) temperatures (Deg. C) for Non Pr.part Attachment welds

Base Material (Pressure Part)	Attachment material (Non-pressure part)	Preheat	Post Heat	PWHT
P1 Group 1, steel 20, 15 Mo3, P1 Group 2 (t<=19)	Any	Nil	Nil	Nil if throat thickness <=19 else 615+/-20
P1 Group 1, steel 20, 15 Mo3, P1 Group 2 (t>19)	Any	150	Nil (150 for 2 hours for P1 Group 2)	615+/-20
P3 Group (OD<=127 & t<=13)	Any	150	Nil	Nil if throat thickness <=13 else 635+/-15
P3 Group (OD>127 or >13)	Any	150	Nil	635+/-15
P4 Group (OD<=127 & t<=13)	Any	150	Nil	Nil if throat thickness <=13 else 665+/-15
P4 Group (OD>127 or t>13)	Any	150	Nil	665+/-15
P5A Group (OD<=102 & t<=8)	Any	150/ 220	Nil	1. Nil if throat thickness <=8 else 695+/-15 2. 760+/-10(only if Gr 91 attachment)

Material Grade & Thickness wise Post Weld Heat Treatment (PWHT)

P5A Group (OD>102 or t>8)	Any	150/	Nil	1. 695+/-15
		220		2. 760+/-10(only if Gr 91 attachment)
P91/P92	Any	220	280 for 2 hours	760+/-10
P8 Group	P1 Group 1, , P1 Group 2 (t<=19)	150	Nil (150 for 2 hours for P1 Group 2)	Nil if throat thickness <=19, else 615+/-20
	P1 Group 1, P1 Group 2 (t>19)	150	Nil (150 for 2 hours for P1 Group 2)	615+/-20
	P3 Group (t<=13)	150	Nil	Nil if throat thickness <=13, else 635+/-15
	P3 Group (t>13)	150	Nil	635+/-15
	P4 Group(t<=13)	150	Nil	Nil if throat thickness <=13, else 665+/-15
	P4 Group (t>13)	150	Nil	665+/-15
	P5A Group (t<=8)	150/ 220	Nil	Nil if throat thickness <=8, else 695+/-15
	P5A Group (t>8)	150/220	Nil	695+/-15
	P91/P92	220	280 for 2 hours	760+/-10
	P8	Nil	Nil	Nil