

Tender ID No. 2026_BHEL_60685_1

Ref.: ASC/Corrigendum/01

Dt: 06.05.2026

Sub: 1st Corrigendum to Tender NIT Number : NIT_99458, Tender notification no. : E2563006, Tender Id : 2026_BHEL_60685_1, Tender Description : Fabrication of Stay Ring in Halves (Labour Basis).

A corrigendum has been issued against said tender for following changes as below-

Revised Annexure-1 includes the latest approved consumable electrode/wire list (FWM/WD&T/010126 dt.01.01.2026) along with approved list of electrodes.

Rest all other terms and conditions of the original tender shall remain same.

Note:- Online bids submitted by suppliers before this extension of due date will be available in system and to be considered for further procurement action. So all the suppliers who had submitted their online bids before this extension are requested to please re-check their offer and if you wish to any change in it, you can & re-submit it.

Ram Janak,
Sr. Manager (ASC),
Phone: 0755-2503302
Email Id: ramjanak@bhel.in

FABRICATION DIVISION

WELDING DEVELOPMENT AND TECHNOLOGY

FBM/WD&T/010126

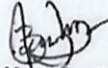
Date: 01-01-2026

Sub: List of approved electrodes for use on the job of BHEL, Bhopal being welded at its Ancillaries

Enclosed please find the list of approved electrodes for use on the jobs of BHEL Bhopal (Other than jobs for NPCIL) being welded at its ancillaries which have been tested by WRI, Trichy or shop trial of these electrodes have been carried out at BHEL Bhopal as per WI No-FB-006 (system for initial approval of welding consumables).

The validity of above mentioned list is from 01-01-2026 to 01-01-2028.

Also, the aforementioned list may be updated (with new additions or deletions) as and when required.


Pallawit Dubey

Dy. Manager, WD&T, FWM


Manager, WD&T, FWM

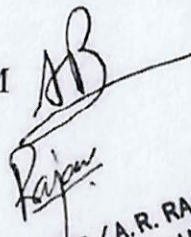
Sr. DGM, FWM

AGM, FWM

Cc:


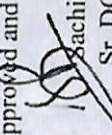
1) AGM (ASC)

2) Sr. MANAGER (QIX)


ए. आर. राजीव / A.R. RAJEEV
अपर महाप्रबंधक / Addl. General Manager
एफ. डब्ल्यू. एम. / FWM
बी.एच.ई.एल., भोपाल / B.H.E.L., BHOPAL

WELDING DEVELOPMENT & TECHNOLOGY

APPROVED LIST OF WELDING CONSUMABLES

FWM/2026 (REF. WI NO.: FB-006)		VALIDITY: 01-01-2026 TO 01-01-2028		Date of Issue: 01-01-2026
S. NO.	AWS CLASS	BRAND NAME	MANUFACTURER	APPLICATIONS
1	E 6013	MONARC-S	BAGHERWAL	
		STEELON ULTRA/STD	MODI	
		REGULAR-S	HONAVAR	
		VORDIAN/VORTIC	ESAB (I)	
		MEDIO	D&H (S)	
		STANDARD	D&H(S)	
		GREECON PINK	GEE LTD.	
		UNICORD-135	UNIVERSAL	
		OVERCORD-S	SCHWEISSTECHNIK HARYANA	
		MARUTI-44	MARUTI WELD NEW DELHI	
		SUN WELD	JAIN WELDING	
		GM20	M/S MODI HITECH INDIA LTD.	
		OMNIA46	LINCOLN	
		ATLAS-13	COSMOS ELECTRODES INDORE	
2a	E 7018	SUPRATHERME	D&H (S)	FOR CARBON STEEL PRESSURE PARTS OF RADIOGRAPHIC QUALITY.
		GRICON GREEN	GEE LTD.	
		DK-18	DWEKAM	
		ESAB-36H	ESAB(I)	
		ULTIMATE-18	HONAVAR	
		MODI-7018	MODI	
		EASYARC 7018	LINCOLN ELECTRIC	
		SUPER-LH	D&H(I)	
		MAILARC-18	MAILAM INDIA LTD.	
		This list does not absolve the fabricator of their responsibility to ensure the quality of the batch of the specified welding consumables before using it at their works.		
Prepared by: Pallawit Dubey Dy. Manager, WD&T, FWM		Reviewed by:  Kshitij Shrivastava Manager, WD&T, FWM		
		Approved and Issued by:  Sachin Bhartiya Sr. DGM, FWM		

WELDING DEVELOPMENT & TECHNOLOGY

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VALIDITY: 01-01-2026 TO 01-01-2028

Date of Issue: 01-01-2026

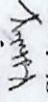
S. NO.	AWS CLASS	BRAND NAME	MANUFACTURER	APPLICATIONS
2b	E7018	MONOTHERME	BAGHERWAL	FOR CARBON STEEL PRESSURE PARTS OF NON-RADIOGRAPHIC QUALITY.
		UNIBASIC	UNIVERSAL	
		ANANDTHERME	ANAND	
		ULTRA-7018	MARUTI WELD NEW DELHI	
		SUPERCITO	SCHWEISSTECHNIK HARYANA	
		GM-18	M/S MODI HITECH INDIA LTD.	
		SUPERMAX-18	COSMOS ELECTRODES INDORE	
	SUPABASE	ADOR WELDING LTD.		
3	E7018-1	SUPERTHERME SPL	D&H(S)	BASIC COATED ELECTRODES FOR LOW TEMPERATURE SERVICES DOWN
4	E 7018-A1	MOLYTHERME	D&H (S)	LOW ELECTRODES FOR WELDING PRESSURE PARTS OF 0.5% MO STEEL.
5	E 9018G	TENSAL	D&H (S)	ELECTRODES HAVING TENSILE STRENGTH UP TO 70 KG/MM2 AND FOR LOW TEMPERATURE SERVICES DOWN TO MINUS 40 DEGREE C.
		FERROWELD 9018G	ESAB (I)	
		ULTRA-65	D&H (I)	
		GRIDUCT	GEE	
6	E 9018-B3	CHROMOTHERME-2	D&H (S)	ELECTRODES FOR WELDING PRESSURE PARTS OF CHROME, MOLY STEELS.
		MODI E9018 B-3	MODI	
		SUPER CR-2	D&H (I)	

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Prepared by:


Pallawit Dubey
Dy. Manager, WD&T, FWM

Reviewed by:


Kshitij Shrivastava
Manager, WD&T, FWM

Approved and Issued by:


Sachin Bhartiya
Sr. DGM, FWM


WELDING DEVELOPMENT & TECHNOLOGY

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S. NO.	AWS CLASS	BRAND NAME	MANUFACTURER	APPLICATIONS
7	SS Electrodes: E 308-16 / E 308 L-15 / E 309 L-16 / E 309Cb-16	BRANDS OF FOLLOWING MAKE ACCEPTABLE		
		D & H SECHERON ELECTRODES PVT.LTD;		
		ESAB INDIA LTD./ESAB SWEDEN		
		LINCOLN ELECTRIC COMPANY		
		D&H(INDIA)		
		HONAVAR ELECTRODES LTD.		
		DWEKAM ELECTRODES PVT LTD.		
		MODI ARC ELECTRODE		
		VOESTALPINE BOHLER WELDING AUSTRIA GMBH		
		MAILAM INDIA LTD.		
		SUPERON SCHWEISSTECHNIK INDUSTRIES LTD.		
		STARBLAZE GLOBAL TECHNOLOGIES PRIVATE LIMITED		
		ADOR WELDING LIMITED		
WELDFAST ELECTRODES PVT. LTD.				
ANUVRAT INDUSTRIES				
MODI HITECH INDIA LIMITED				
8	E 316L-16	SS-316 L	MODI	
		OK 63.30	ESAB (I)	
		RUTOX-D	D & H SECHERON ELECTRODES PVT LTD	
		CROMALLOY-2C	D & H INDIA	

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Prepared by:


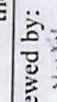
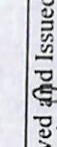

 Pallawit Dubey
 Dy. Manager, WD&T, FWM

Reviewed by:


 Kshitij Shrivastava
 Manager, WD&T, FWM

Approved and Issued by:


 Sachin Bhartiya
 Sr. DGM, FWM

WELDING DEVELOPMENT & TECHNOLOGY			
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		Date of Issue: 01-01-2026	
S. NO.	AWS CLASS	BRAND NAME	MANUFACTURER
9	E410NiMo-15	FOX CN 13/4	VOESTALPINE BOHLER WELDING AUSTRIA GMBH
		GRIBINOX 134LN	GEE LTD
		OK 68.25	ESAB(SWEDEN)
		SV 430 NIMOL	LINCOLN ELECTRIC D&H (I)
BRANDS OF FOLLOWING MAKE ACCEPTABLE with essential requirement:			
a) Sulfur < 0.10			
b) Non-Synthetic (Core wire to be of similar composition as weld metal deposit)			
10	ENiCrFe-3	D & H SECHERON ELECTRODES PVT.LTD;	
		ESAB INDIA LTD./ESAB SWEEDEN(NOT IN PMD)	
		LINCOLN ELECTRIC COMPANY	
		VOESTALPINE BOHLER WELDING AUSTRIA GMBH	
GEE LIMITED,			
ADOR FONTECH LTD(AGENT)			
D&H INDIA LIMITED			
BRANDS OF FOLLOWING MAKE ACCEPTABLE			
11	ER 70S-6	D & H SECHERON ELECTRODES PVT.LTD;	
		ESAB INDIA LTD./ESAB SWEEDEN	
		LINCOLN ELECTRIC COMPANY	
		VOESTALPINE BOHLER WELDING AUSTRIA GMBH	
Royal 70S-6 of ROYAL ARC			
GM70 of GEE LTD.			
MIGFAST-1 of WELDFAST ELECTRODES PVT. LTD.			
NON- SYNTHETIC (Core wire to be of similar composition as of weld deposit)13/4 ELECTRODES FOR WELDING MARTENSTIC STAINLESS STEEL COMPONENTS			
<p>This list does not absolve the fabricator of their responsibility to ensure the quality of the batch of the specified welding consumables before using it at their works.</p> <p>Prepared by:  Pallawit Dubey Dy. Manager, WD&T, FWM</p> <p>Reviewed by:  Kshiti Shrivastava Manager, WD&T, FWM</p> <p>Approved and Issued by:  Sachin Bhartiya Sr. DGM, FWM</p>			

WELDING DEVELOPMENT & TECHNOLOGY

APPROVED LIST OF WELDING CONSUMABLES

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VALIDITY: 01-01-2026 TO 01-01-2028

Date of Issue: 01-01-2026

S. NO.	AWS CLASS	BRAND NAME	MANUFACTURER	APPLICATIONS
12	E71T-5	OK TUBROD 15.00	ESAB(S)	
		COREFIL-15R	DWEKAM	
13	E71T1-1/4	K-71T	KISWEL (KOREA)	
		TUBROD 15.14 A	ESAB (FROM KOREA)	
		LW-71TM	LINCOLN (SHANGHAI)	
		TWE-71	TIENTAI (TAIWAN)	
		SUPER CORED 71 H	HYUNDAD(KOREA)	
		DW-100	KOBELCO	
		MGA-12	MAILAM INDIA LTD.	
		ROYALFIL GS 12R	ROYAL ARC ELECTRODES LTD.	
		MAXFIL-12R	D & H SECHERON ELECTRODES PVT LTD	
		AUTOMIG FC 71T-1	ADOR WELDING LTD	
		ESAB 71T1 (SPL)	ESAB INDIA LTD	
		SUPERCORE 71 TI	D & H INDIA LIMITED	
		14(a)	E309LT1-1 /E308LT1-1	
M/S ESAB				
M/S TIEN TAI(TAIWAN)				
M/S VOESTALPINE BOHLER WELDING				
M/S CHOSUN				
M/S SOUDOKAY				
M/S KOBELCO				
M/S OERLIKON				
		ADOR WELDING LTD (MIGINOX FC 309L)		

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Dy. Manager, WD&T, FWM

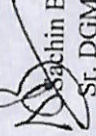
Reviewed by:



Kshitij Shrivastava

Manager, WD&T, FWM

Approved and Issued by:





Sachin Bhartiya
Sr. DGM, FWM

WELDING DEVELOPMENT & TECHNOLOGY

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S. NO.	AWS CLASS	BRAND NAME	MANUFACTURER	APPLICATIONS
14(b)	E309LT0-1/E308LT0-1	D & H SECHERON ELECTRODES PVT LTD (MAXFIL-309L)		
		MAILAM INDIA LTD (MGA-309L)		
		ROYAL ARC (ROYAL FIL GS-D2)		
		ROYAL ARC (ROYAL FIL GS 1C)		
15	SAW WELDING WIRE: EH-14/EM-12K/EA3K	D & H INDIA LIMITED (SUPERCORE 309L-T1)		
		BRANDS OF FOLLOWING MAKE ARE ACCEPTABLE		
		D & H SECHERON ELECTRODES PVT LTD;		
		ESAB INDIA LTD./ESAB SWEEDEN		
		K.M CROWN WELDING CONSUMABLES PVT. LTD		
		PRECISION WELD ARC LTD.		
		AUTOMELT EM 12 K of ADOR WELDING LTD.		
		AUTOMELT EH14 of ADOR WELDING LTD.		
16	FLUX AS PER F7P2-EH-14/EM-12K	AUTOTHERME GRADE-B of D & H SECHERON ELECTRODES PVT LTD		WIRE FOR SUBMERGED ARC WELDING OF CARBON STEEL PRESSURE VESSEL.
		OK 10.71	ESAB (S)	
		TPD-80	TAPADIA	
		MAXFLUX SAF-4(SPL)	D&H SECHERON ELECTRODES PVT LTD	
		AUTOMELT B71	ADOR WELDING LTD	
		K-81TK2C	KISWEL LTD.	
17	E81T1-K2C	F70S2	D & H SECHERON ELECTRODES PVT LTD	
		TIGFIL 70S-2	ADOR WELDING LIMITED	
18	ER70S-2			

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S. NO.	AWS CLASS	BRAND NAME	MANUFACTURER
19	COPPER WIRE FOR GMAW(ERCu)	BRANDS OF FOLLOWING MAKE ACCEPTABLE	
		SAFRA	
		AMPCO	
		VOESTALPINE BOHLER WELDING	
		ESAB	
20	E410NiMoT1-1/4	LINCOLN	
		DIFF-FILL 300 of DIFFUSION ENGINEERS LIMITED	
		SM-1 of SENOR METALS PRIVATE LIMITED	
		MAHESHWARI ERCu of MAHESHWARI WIRES PVT. LTD.	
		HOBART BROTHERS MCKAY	
21	GTAW SS Electrodes: ER309L/ ER308L/ ER316L	FabCO 410NiMoT1	KOBELCO
		DW-410NiMo	VOESTALPINE BOHLER WELDING
		BOHLER CN 13/4 PW-FD	D & H SECHERON ELECTRODES PVT LTD
		FW 309-L	D & H SECHERON ELECTRODES PVT LTD
		FW 308-L	VENUS WIRE INDUSTRIES PVT. LTD
22	GMAW Electrodes: ER309L	VENUS 316L	VENUS WIRE INDUSTRIES PVT. LTD
		VENUS 309L	VENUS WIRE INDUSTRIES PVT. LTD
		VENUS 308L	MODI HITECH INDIA LIMITED
		GMM MIG 309L	


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This list does not absolve the fabricator of their responsibility to ensure the quality of the batch of the specified welding consumables before using it at their works.

NOTE:

- FOR NPCIL JOBS, ELECTRODES APPROVED BY NPCIL TO BE USED.
- FOR AWS CLASS WHICH ARE NOT MENTIONED IN THE ABOVE LIST, BATCH QUALIFICATION TO BE DONE AFTER VALIDATION OF DOCUMENTS.

Prepared by:

 Pallawit Dubey
 Dy. Manager, WD&T, FWM

Reviewed by:

 Kshitij Shrivastava
 Manager, WD&T, FWM

Approved and Issued by:

 Sachin Bhartiya
 Sr. DGM, FWM

FABRICATION DIVISION

ANNEXURE-1 Rev.01

(PI No. 232166005; Dated: 05/05/2026)

S.No.	Sections	Sub-Sections / Clause Details
1	Supply Condition	Labour Basis
2	Scope of Work	The Sub-Contractor's scope of work covers complete fabrication as per Annexure-1 & 1 A. Supplier has to quote rate in Rs./Kg basis (i.e inclusive of shot blasting and primer painting as per drawing TR). No extra charges shall be paid for shot blasting and painting.
3.1	Raw Materials (Labour Basis)	As Per Annexure -1A
3.2	Raw Materials (Finish Basis)	N.A
3.3	Raw Materials (Mixed Basis)	N.A.
4	Drawings	Supplier will work on the latest drawing supplied by BHEL, through concern engineering department. Before the start of job, supplier should obtain the concurrence from Engg. Department through fabrication division Concerned Engineering Division: Hydro turbine Engineering (HTE) Contact No. Shri Varun Pagariya - 0755 2505283 Mob : 8517052080
5	Scrap %	Up to 10%
6	Inspection Requirement	For QA Plan Please contact indenter / QAX dept. for QA plan. Records of all stages of QA Plan shall be generated during manufacturing and same is to be witness / reviewed as called in QA Plan from the Inspection Agency.
7	Fabrication	All assemblies shall be fabricated to our drawing and notes thereon. <ul style="list-style-type: none">- The technology for mfg. shall be submitted by the sub-contractor to FBM Technology Dept. for approval. The manufacturing shall be started only after the approval of technology.- All welding shall be performed as per approved WPS of BHEL by qualified welders in accordance with ASME Sec-IX. Only BHEL approved brands of electrodes shall be procured and used by the sub-contractor. For the approved Electrodes / Wires refer (FWM/WD&T/010126 Validity : 01-01-2026 TO 01-01-2028 issued by WD&T Division.

		<ul style="list-style-type: none"> - All components shall be cut as per our detail Drg. & identification will be transferred on each components. Components to be offered for inspection to BHEL QC prior to cutting & after cutting. - All inspection testing & acceptance norms shall be stated in Q.A. Plan / drgs. Test certificates to be submitted by the vendor to BHEL for sending same to customer. - Strict measure of quality control should be maintained throughout the work. The job should be free from spatters and under cuts. All dressing and cleaning shall have to be done to the satisfaction of BHEL Q.C. - The fabricator shall carry out the welding in such a manner that no distortion takes place. - Wherever machining is called, supplier has to ensure the adequate availability of machining allowance clearly marked on the job.
8	Heat Treatment (Stress Relieving)	Post weld heat treatment shall be carried out as per notes given on drawing. This facility will be provided by BHEL free of cost, for local vendors (if requirement in drawing).
9	Shot / Sand Blasting	All internal and external surfaces shall be shot blasted before painting as per the drawing requirements.
10	NDT	<ul style="list-style-type: none"> - Complete NDT will be in the scope of Subcontractor. The offer will stand rejected if above is not complied with. - N.D.T. shall be carried out by approved persons/agencies as per laid down procedures which are approved by QC, NDT BHEL. The Subcontractor should obtain approval from QC, BHEL prior to commencement of work at his works. -BHEL will have full right to review / witness NDT at any point during the course of manufacture.
11	Hydro Testing / Gravity Test	Not Applicable
12	Painting	<p>The scope of painting shall be as follows:</p> <p>Primer Coats: 1.Two coats of zinc rich primer painting on internal & external side.</p> <p>Intermediate Coats (if reqd.):.N.A.</p> <p>Finish Coats: 1. N.A</p>
13	Inspection Agency	<p>Assemblies shall be inspected at various stages by QIX/Third party/ Customer/ Customer Appointed Third Party. During manufacturing the all instruments for inspection shall be provided by the vendors.</p> <p>The Sub – contractor should maintain a separate file a history document containing all information and procedure pertaining to this order.</p>
14	Transportation	Delivery by Supplier to BHEL
15	Delivery Requirements	<p>Labour Basis:</p> <p>Delivery within 10 weeks form the date of last material issued for each set.</p>

16	Order Distribution	3:2:1
17	Quotation	Supplier has to quote rates in Rs/Kg (<i>i.e. inclusive of shot-blasting & painting</i>).
18	Any other information	<ol style="list-style-type: none"> 1. Technical requirements of drawing to be strictly followed. 2. Painting will be done as per painting specification HT00005 leaving 100MM wide band from edges to be welded 3. <u>All pre-machining, Drilling, Tapping and edge pre-preparation will be done by supplier</u> 4. Before starting the job supplier should confirm the latest drawing revision from indenter/ design group 5. All edge preparation will be done by supplier 6. Drg Enclosed <p>a) 02020122503 b) 42020122503 c) 42020122504</p>

(Seal & Signature of Indenter)