



PS-WR

Bharat Heavy Electricals Limited
A Govt. of India Undertaking)

POWER SECTOR - WESTERN REGION
REGIONAL SERVICE CENTRE
568/1 , PARPIA COMPOUND, R.C. DUTT ROAD
VADODARA- 390007
Gujarat, India
Phones: 0265-2340691
Fax No.0265-2336108

Ref: BHE/PW/BRD/SER/PUR/COH & RUNNER BLADE/KHEP UNIT #3/2012-13
DATE: 22/08/2012

TENDER FOR COH & ATTENDING RUNNER BLADE PROBLEM, of 60 MW Kadana HEP Unit-3

SUB: Work of COH & Attending RUNNER BLADE PROBLEM, of 60 MW Kadana HEP Unit-3 at Kadana Hydro Power Station.

Dear Sir,

Customer GSECL has award the above work to BHEL, SAS Baroda. Work is to be carried out immediately(Machine is in shutdown condition). You are requested to submit your competitive offer for the following works separately for Price Bid and Technical Bid. The bid is to be submitted before 15.00 hrs on 06/09/2012 accepting our terms and condition and signed copies of above has to be submitted by courier/messenger. Bid will open on 07/09/2012 at 17:00PM. Letter of intent shall be given to lowest bidder by fax/courier to mobilise site immediately.

Part- I Cover should only contain this enquiry document signed on each page, proof of one time EMD deposit and service tax registration. If one time is not maintained then DD of Rs200000/-(Two Lakh only) is to be enclosed in favour of "BHARAT HEAVY ELECTRICALS LIMITED" payable at Baroda (As per Annexure-V)

Part- II Cover should only contain price bid sheet duly filled in and signed with company seal.

1. SCOPE OF WORK:

As per annexure-1

2. Period of completion:

The entire work as per scope of work given in Annexure-I is to be completed within a period of 130 days. If any equipment is required to be sent at manufacturing unit for repair/rectification then completion period will be extend. No compensation shall be payable to the contractor for the delay due to unforeseen reasons.

3. Manpower: You shall arrange the manpower required for carrying out the above work for scope of work given in Annexure-I. The work has to be carried out on round the clock basis in the specified period as above. Arrangement for additional

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manpower required for completing the job within stipulated period shall be the responsibility of the contractor and shall be arranged by contractor. The list of the tentative manpower proposed for the work is also to be submitted with the tender document. Please note that no workmen shall be allowed to work more than 12 hrs. Contractor shall manage to work two shifts round the clock from day one. Name of all skilled Technician is to be enclosed.

In addition to that following expert is required to be deputed during execution of work as per intimation by BHEL.

Estimated payment for expert

Sr no	Area of expert	Rate /Day	Estimated Days
1	Specialist for Governor mechanical work	16500	40
2	Runner Expert	5000	120
3	Mechanical expert for dismantling & assembly	4500	130

4. Terms of Payment:

40% On completion of dismantling work at site.

50% On completion of entire work and synchronizing of machine.

10% After one month of synchronization and full loading of machine, Completion of all the works, Clearing of site, handing over of all T &P taken from customer, no dues certificate from customer store and township incharge , proof of wage and PF payments,

5. T&Ps.

All T&P required for the above mentioned job should be arranged by you before commencement of the job.. An indicative list of tools is enclosed as per Annexure-III. Tools brought by contractor should have latest test certificates and instruments with calibration certificates. Any T & P apart from list is required to be arrange by contractor as per requirement. The T&P available with customer supplied as standard tools of BHEL will be handed over to you during execution of work as where is condition on returnable basis

6. Consumables

All consumable items shall be arranged by you before commencement of the job as per Annexure-II.

7. Earnest Money Deposit:

Earnest Money is to be paid by each tenderer. DD Amount of Rs.200000/- (Two Lakh Only) in favour of "BHARAT HEAVY ELECTRICALS LIMITED" payable at Baroda is to be submitted along with technical bid.

8. Rate

You should quote your lowest lump sum rate as in schedule "A" for the scope of work mentioned in Annexure I. No extra work will be paid to you while execution of work.



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A copy of tender document with each page duly signed and stamped, as a token of acceptance of the terms and conditions of this enquiry should be enclosed with your technical offer to be put in a separate cover.

9.Expected date of commencement

The above job is expected in in the month of September-2012.The requisite manpower/T&P etc. have to be mobilised immediatly on placement of our letter of intent for the above work. You shall arrange accommodation and transport for your staff,Expert and transport of material at site during the course of execution of above job.

10. Validity

Your offer should remain valid for a minimum of 180 days from the date of opening of tender.

11. Statutory Obligations, Safety and Security:

Contractor and all his personnel deployed on the work shall adhere to and abide by the safety provision/norms specified and as required by BHEL and their Customer. In case of violation of any provision is noticed at any time, a fine at the discretion of our Engineer-In- Charge or as levied by BHEL and/or their Customer shall be imposed for each of such violation and shall be recovered from the contractor's Running Account Bills or any other payments due. The contractor shall submit his safety plan to BHEL Site In charge. The contractor shall maintain and submit the following records for inspection anytime by BHEL/their Client/any statutory Authority.

- a) Attendance Register of Workers. b)Pay/Wages Register.
- c) Advance Payment Register. d) O.T. Register.
- e) Identity Card Register. f) Privilege Leave Register.
- g) Workers List Register. h)Fine Register
- i) Leave Register. j)Provident Fund Register.
- k) Bonus Register. l)Labour license

Contractor shall arrange round the clock security and watch & ward for the safety and security of materials, items. Tools and Plants & Spares issued to him during execution of the work. He shall also maintain proper lock & key arrangement for storing the items dismantled from Unit or issued to him by customer. In case of any loss and/or damage to any of the equipment / spares the contractor will be held responsible.

12.Other terms and conditions:

- (1)Contractor should arrange proper and adequate Insurance covers for the entire employee deputed/deployed by him at the site for the work.
- (2)Contractor has to furnish establishment code numbers and deduct EPF as per rules and submit a proof of its remittance to BHEL.
- (3)Necessary Labour Licence should be obtained based on the Form-5 issue by the Principal Employer in your name. The copy should be submitted to BHEL site I/c.
- (4) Wage payment to the employees should be witnessed by BHEL site I/C or his nominee and a copy of wage register duly certified are submitted to BHEL site I/C.
- (5)Proper records are required to be maintained by the contractor on the material drawn from the stores (Includes BHEL's supply as well as spares issued from GSECL).



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(6) Security and safety of the labour of the contractor to be ensured as per statutory requirements particularly use of PPE's such as helmets, safety shoes, safety belts, welding goggles, safety hand gloves etc must be ensured.

(7) All the logistics and procedural formalities required to be done at the Hydro Power Station for mobilization and to be followed during the course of execution are to be taken care of by Contractor. You may visit the Site and ascertain the same before quoting.

(8) **Contractor must have the experience of COH of Hydro Turbine capacity having capacity 60MW and above. Experience of capacity less than 60MW will be considered as technically disqualified.**

(9) **Runner dismantling is a must exercise for rectification of runner blade problem hence experience of runner dismantling and assembly of capacity greater than 60 MW Hydro turbine will be required.**

13. Performance Guarantee:

The contractor shall guarantee against any defects attributable to faulty workmanship/ procedure adopted/ deterioration in performance of machine in the overhaul for items covered in the contract for a period of 12 months from the date of synchronisation of the machine. The guarantee should cover all the defects noticed during this period and shall have to be attended by the contractor free of cost immediately or at the time our clients are able to give shut down of the machine for the required period when necessary.

14. Security deposit: SD will be deducted as per our GCC and works policy.

15. Release of security deposit:

Security deposit deducted shall be refunded after 12 months from the date of completion certificate subject to recoveries if any. The request for refund of SD should be submitted along with the prescribed format in duplicate duly filled in and signed by you.

All other terms and condition regarding this tender shall be as per our general conditions of contract enclosed herewith.

- 1) BHEL reserves the right to reject the lowest or any or all tenders without assigning any reason whatsoever.
- 2) For any further clarification you are requested to kindly contact the undersigned on any working day.

Thanking you.
Yours faithfully,

R.K.SINHA
Regional Service Manager
BHEL-PSWR-RSC-BARODA



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ANNEXURE-I

1. Opening of spiral & draft tube manhole and closing the both after completion of work
2. Fabrication of scaffolding/platform at draft tube for the inspection of runner and removal of scaffolding/platform after completion of work.
3. Checking of operation of runner blade for checking leakage from runner before isolation of governing system.
4. Complete draining of oil from runner by opening runner cone plug.
5. Decoupling of turbine generator shaft .
6. Dismantling of ring servomotor and its servicing.
7. Dismantling of turbine assembly along with inner head cover , runner and turbine shaft .
8. Dismantling of turbine guide bearing ,inner head cover and turbine shaft from runner assembly
9. Dismantling and complete O/H of runner blade operating mechanism, modification of locking pin if required , replacement of runner blade seals .replacement /repair of stationary and rotating labyrinths.
10. Leak test of runner as BHEL procedure.
11. Servicing of servo mechanism.
12. Visual checking of runner and DP check. Minor correction by welding/grinding.
13. Hammer test of spiral casing. Pressure grouting if required .
14. Check guide vane and regulating mechanism and replacement of guide vane seals .
15. Replacement of seals of runner blade and hydro test of runner blade seals.
16. Check cup seals of guide vane and change if required.
17. Check/replace turbine sealing glands.
18. Replacement of guide vane ring servomotor seals and hydro test of ring servomotor.
19. Reassembly of runner , turbine shaft , inner head cover ,turbine guide bearing and assembly of inner head cover in turbine pit.
18. Centering of shaft is to be carried out.
19. Turbine bearing and thrust bearing cooler cleaning and testing.
20. Checking of centering, alignment and rigidity of bearings
21. Overhauling of spiral and draft tube drain valve.



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22. Replacement of defective seals to stop the leakages.
23. Centralized grease lubrication system checking/correction.
- 24.O/H and testing of break jack system.
25. Overhauling of hydraulic governing system including AP tank, OPU tank, Servo valves of GV & Runner.
- 26 Painting of all under water and external part of machine parts e.g. spiral and penstock, runner, upper bracket , lower bracket , water and oil piping by Epoxy paints. Paint will be provided by GSECL.
26. Spinning of machine and balancing if required.
27. Synchronization after dry-out and loading the unit.

B) GENERATOR

1. Dismantling of oil header assembly.
2. Draining of oil from servo system.
3. Dismantling of top- bottom air guide assembly.
4. Dismantling of upper bracket assy.
5. Dismantling of generator rotor .
6. Decoupling of turbine generator and dismantling of generator shaft .
7. Dismantling of lower bracket .
8. Dismantling of stator assembly.
9. Lifting of rotor and placement in service bay.
10. Dismantling turbine pit pumps, gland seal assembly and preparation of scaffolding in turbine pit for decoupling.
11. Dismantling of thrust pads and its cleaning, polishing, scrapping and replacement if required.
12. Dismantling all sliding wedge assembly and pivot assembly of thrust bearing pad, its blue matching and polishing if required and check height and distribution as per height.
13. Cleaning of LP oil chamber in bearing housing.
14. Checking and tightening of thrust spring base plate.
15. Correction of rotor form and pole impedance check.
16. Removal, cleaning & hydraulic testing of Air cooler of generator.
17. Physical inspection of rotor and stator for any damage.
18. Carry out electrical test i.e. measure DC resistance, impedance and Insulation resistance on rotor.
19. Demagnetisation of rotor if required.



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20. Cleaning of stator winding, inspection of magnetic circuit i.e. core, core bolts locking etc. and repair if required.
21. Inspection of stator overhang support brackets, bolts, lacing cord repair in case required.
22. Checking of stator wedges looseness and tightening their off.
23. Replace defective winding RTDs wherever possible.
24. IR, PI, Tan Delta Check of stator winding. (**BHEL SCOPE**)
25. Reassembly of thrust bearing and generator shaft leveling and throw correction.
26. Lifting of turbine guide bearing for free rotation of alignment.
27. Re-insertion of generator rotor in position. Rotor leveling and alignment.
28. Correction of throw in TGB by providing shims in TG coupling.
29. Correction of throw of TG coupling (by providing shims between thrust block and runner disc)
30. Check tightness and locking of shaft and thrust collar bolts, thrust collar and spider bolts and spider and upper shaft bolts.
31. Checking tightness of stator core bolts and checking of stator core and end packets.
32. Recheck stator and rotor form and correction by shifting stator, if required. Re dowelling of stator after correction.
33. Scrapping of GGB pads and damaged screw insert replacement if needed.
34. Setting of bearing clearances and final box up.
35. Oil header assembly and check Alpha-Beta relationship.
36. Reassembly of top- bottom air guide and stator cover plate.
37. Checking of lub oil and HS pump.
38. Calibration of pressure gauge DTT, RTD .
39. Application of locktite-290 for stator punching.
40. Measurement and recording of vibration.
41. Balancing of rotors if required after spinning.
42. Inspection & Checking Characteristic of following (**BHEL Scope**)
 - a) Digital voltage regulatory load test (AVR system including D.C and A.C Supply circuit healthiness, checking, Cards healthiness & setting of jumpers, Dummy load test of AVR)
 - b) Electronic turbine governor.
43. Winding resistance measurement work
44. Measurement of air gap between stator and rotor.

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45. Necessary checking of field breaker & excitation system.

46. Assistance in PRE COMMISSIONING TESTS.

- 1) Load rejection test.
- 2) Emergency stop test.
- 3) No load load and no excitation test.
- 4) Over speed test.
- 5) Continues operation test i.e. 72 Hrs continuous tests at full load if required head and water are available as per Requirement of Dam Irrigation Department after commissioning

Note: Contractor should take care for good workmanship to avoid any leakage and incorrect assembly. Any damage due to defective workmanship will attributed to contractor and cost for same will be deducted from contractor.



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ANNEXURE – II
LIST OF CONSUMABLES GENERALLY USED: -

Sl.No	DESCRIPTION
1	Address Tags
2	Writing Brushes / Permanent Markers
3	Plastic Bucket 15/20 Litre in adequate quantity
4	Petrol / solvent / cleaner / Rust remover/CRC-226
5	Cotton Waste / Rag Waste
6	Emery Paper for different grit
7	Emery cloth roll of different Grit
8	Emery stone (fine & coarse)
9	Valve tapping compound
10	Diamond tapping paste
11	Grinding / Buffing / sander wheels
12	Rotary burrs of different shape & size
13	High speed hack saw blades 12" x 1/2"
14	Asbestos Hand Gloves
15	Leather hand gloves
16	Lead Wire 1, 1.5, 2 & 3 mm
17	Oxygen Acetylene Argon Gas Cylinders
18	Wire Brush
19	Blue matching tubes
20	Wooden Planks 10" x 1 1/2" thick for scaffolding



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21	Welding Electrodes for special & general purposes for runner assembly and fabrication work
22	Tarpaulin
23	Pneumatic / Water hose pipe for pressurize air
24	Portable switchboards of 5 amps & 15 amps
25	Electric bulbs 24 volts & 230 volts Ac & DC
26	Flood light with suitable wires
27	Personal protective equipment

Note: Above list are indicative only. Any consumables apart from above list is required to be arrange by contractor.



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ANNEXURE - III

List of recommended Tools Work for COH & Attending RUNNER BLADE PROBLEM, of 60 MW Kadana HEP Unit-3 at Kadana Hydro Power Station.

Sl.No	DESCRIPTION
1	Angle ended slogging spanners heavy duty 27 mm, 41 mm, 46 mm, 50 mm, 55 mm, 65 mm, 75 mm, 85 mm, & 95 mm
2	D.E. Spanners heavy duty size, 5.5x7 mm, 4x6 mm, 9x10mm, 11x12 mm, 14x17 mm, 19x12 mm, 19x24mm, 24x27 mm, 30x32mm, 36x41mm, 46x50mm, 55x60mm, 65x79mm, and 75x80 mm
3	Ring Spanner Double ended size 10x11 mm, 12x13mm, 14x15mm, 16x17mm, 18x19mm, 20x21mm, 22x23mm, 24x25mm, 25x28mm & 27x32mm
4	Tubular Box Spanner Double ended Heavy Duty with Tammy Bar : 10x12 mm, 14x17mm, 19x22mm, 24x27mm, 30x32mm, 36x41mm, 46x50mm, 55x60mm, 65x70mm, 75x80mm, and 80x65mm
5	Socket Wrenches different sizes
6	Adjustable Pipe Wrenches different sizes
7	Center Punch, Chisels of different sizes
8	Hammers 2 lbs, 4 lbs, 8 lbs, 12 lbs
9	Screw Drivers of different size
11	Electrical Drilling machine, angles, piston straight upto 23 mm dia
12	Ratchet type hand drilling portable machine
13	Drill bits parallel shank & taper shank from 1.5 mm to 50 mm
14	Rough & Smooth flat files, Round Files, Half Round Files, Triangular Files, Needle Files etc
15	Bearing scrappers and surface scrappers of different tpes & sizes
16	Cylindrical hand reamers of different sizes



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17	10 mm to 30 mm size taper reamers
18	Hacksaw blades high speed alloy 12 mm x 300 mm with Hacksaw frames
19	Dial indicators range 0-5 mm, 0-10mm of least count 0.01 mm
20	Magnetic base for dial indicator
21	Depth micrometers least count 0.01 mm range 0-25, 0-50, 0-75, 0-100 mm
22	Inside Micrometer least count 0.01 mm range 50 mm to 1000 mm set
23	Outside Micrometer least count 0.01 mm range 0-25, 25-50mm, 50-75mm, 75-100 mm, & upto 400 mm
24	Feeler Gauges 100 mm, 200 mm, 300 mm length & having leaves of diff. thickness in step of 0.05 mm
25	Metallic tape 2 meter and 3 meter
26	Vernier caliper inside & Outside L.C.=0.02 mm
27	Screw Jack 1,2,3,4,5 ton capacity
28	Hydraulic Jacks 10,20,40,50 Tons as per requirement
29	Engineering spirit Level 300 mm x 0.1 mm Meter Accuracy
30	Micro Water Level
31	Welders equipments including Welding Machine Gas Cylinders etc.
32	Hand Lamp with bulbs 24 Volt, 220 Volt
33	Torches 3 Cells & 5 Cells
34	All Types of slings, shackle, eye bolts etc
35	Tape Set 6 mm to 50 mm & reamer as per requires size
36	Torque Wrench Hydraulic jack
37	Hand Grinders / Surface Grinders
38	Surface Plate 1 meter x 1 meter



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ANNEXURE - IV

A) FACILITIES AND AMENITIES TO BE ARRANGED BY CONTRACTOR

1. General area lighting only will be provided to contractor. Local lighting as required to be arranged by contractor as his own cost.
2. Compressed air supply will be made available at one point. All other arrangement and accessories to be arranged by contractor at his own cost like pipe valves etc.
3. Contractor has to make necessary arrangement of accommodation for their staff and expert at site.
5. Contractor has to make his own arrangement for transport of his own staff from residence to site and back. Similarly they have to arrange for transportation of material at site.
6. Required space near to the work spot will be provided for storing of materials and T&P but erection of temporary covering/cordoning is the responsibility of contractor only.
7. Contractor has to arrange watchmen in shift duty for security/safety of the equipment under overhaul.
8. As the site is remote area and time is very short, contractor has to arrange T&P and consumables and all other arrangements well in advance to save delay and to complete the job as per schedule.
9. Transportation is to be arranged by the contractor for materials/components from sites to work and back. Also transportation of scrap materials to stores and scrap yards to be arranged by the contractor.
10. Contractor should arrange for cleaning of working area.

B. Facilities to be provided by GSECL/BHEL free of cost

1. Workshop facility with skilled operator.
2. EOT crane with operator.
3. Structural materials required for temporary support on returnable basis to be transported from stores if available.
4. Special T&P supplied along with equipment.
5. Water supply.
6. Electrical power & service air will be given free of cost.



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PRICE BID
Schedule-A

Work of COH & Attending RUNNER BLADE PROBLEM, of 60 MW Kadana HEP Unit-3 at Kadana Hydro Power Station.

The Lump-sum price for the job

Sl. No	Description of work	Lump sum Lowest Price Quoted in Rs.
1.	As per Annexure – I of Tender Enquiry	
Total lump sum amount		

Service tax shall be payable extra as per prevailing rates.

Place:

Date:

Signature of Tenderer

Note:

- 1-Contractor has to carry out without any charge to BHEL, any such activity/activities, which are not specifically indicated in the scope of work but are essential for completing the works and to achieve a good standard of quality of work.
- 2-In case of defective workmanship or worsening of performance is noticed during trial run, rework arising due to the above shall be the liability of the contractor and no extra charges shall be paid by BHEL for such work at time convenient to the principal customer.
- 3-Any rework arising due to breaking of any part/hardware during the execution of work the above shall be the liability of the contractor and no extra charge shall be paid by BHEL for such work at time convenient to the principal customer.



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(Annexure-V)
Requirements of Technical Bid

Sr No	Detail	Remark
1	EMD	Rs.200000/- (DD only)
2	Tender Cost	Rs.2000/- (Cash or DD)
3	Certificate if incorporation	
4	Balance Sheet of last 3 Year	
5	PF & ESIC registration certificate	
6	Work order copies in area of Hydro & Completion Certificate	
7	Bar Chart	
8	List of manpower, T& P	
9	Signed tender document	
10	Income Tax return certificate & Copy of PAN	
11	Service Tax Registration certificate	

Note: These all documents are mandatory while submitting the bid.