
	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS			STANDARD QUALITY PLAN				SPEC. NO : PE-TS-XXX-571-A001		DATE: XX.XX.XXXX				
				CUSTOMER :				QP NO.: PE-V0-XXX-571-A001, REV 01		DATE: 09.10.2020				
				PROJECT:				PO NO.:		DATE:				
				ITEM: GYPSUM DEWATERING SYSTEM		SYSTEM: FGD		SECTION:		SHEET 9 of 10				
SL NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY		REMARKS		
1	2	3	4	5	6		7	8	9	*	**			
					M	C/ N				D	M	C	N	
5.2(b)	Rubber Lining of tank	Hardness testing	MA	Physical	100%	100%	Approved datasheet	Approved datasheet	IR	√	P	W	V	Shore hardness value shall be within 60. NOTE-5
5.3	Junction Box													Refer Junction Box SQP for details
5.4	Painting & Marking	Paint Finish, Thickness, HV porosity test	MA	Visual	100%	100%	Appd. Drg /Data Sheet	Appd. Drg /Data Sheet	IR	√	P	V	V	NOTE-5
5.5	Packing	Proper Packing	MA	Visual	100%	100%	BHEL packing specification	BHEL packing specification	Packing List	√	P	W	V	NOTE-5,8
5.6	Quality Dossier	Document	MA	Visual	100%	100%	Compilation of documents	Compilation of documents	Quality Dossier	√	P	V	V	

LEGENDS:

*RECORDS, IDENTIFIED WITH "TICK"(√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION,
 ** M: SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, C: MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, N: CUSTOMER,
 P: PERFORM, W: WITNESS, V: VERIFICATION, AS APPROPRIATE
 MA: MAJOR, MI: MINOR, CR: CRITICAL
 IR: INTERNAL REPORT D: DOCUMENTATION
 RT: RADIOGRAPHY TEST UT: ULTRASONIC TEST DPT: DIE PENETRANT TEST MPI: MAGNETIC PARTICLE INSPECTION

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
	Sign	Name		Sign & Date	Name	Seal			Sign & Date	Name	Seal
Prepared by:		VIVEK V HEMROM	Checked by:		ASHISH PANIGRAHI			Reviewed by:			
Reviewed by:		RAJESH RANJAN	Reviewed by:		RK JAISWAL			Approved by:			

Rajesh Ranjan


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Rajesh Ranjan
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Date: 2020.10.09 16:35:24 +05'30'

Ashish Panigrahi

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RITESH KUMAR JAISWAL

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Date: 2020.10.09 17:24:41 +05'30'

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS			STANDARD QUALITY PLAN				SPEC. NO : PE-TS-XXX-571-A001		DATE: XX.XX.XXXX	
								CUSTOMER :		QP NO.: PE-V0-XXX-571-A001, REV 01	
				PROJECT:				PO NO.:		DATE:	
				ITEM: GYPSUM DEWATERING SYSTEM		SYSTEM: FGD		SECTION:		SHEET 10 of 10	
SL NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY	REMARKS	
1	2	3	4	5	6	7	8	9	*	**	
					M C/ N				D	M	C N

NOTES:

1. ORIGINAL TCS/ PHOTOCOPIES CERTIFIED IN ORIGINAL BY MILL SHALL BE FURNISHED FOR REVIEW.
2. IN CASE OF FOREIGN SUPPLIER, ALL TEST CERTIFICATES SHALL BE FURNISHED BY THE SUPPLIER, DULY WITNESSED/ VERIFIED BY SUPPLIER'S TPI.
3. BHEL RESERVES THE RIGHT FOR CONDUCTING REPEAT TEST, IF REQUIRED.
4. DURING TESTING ONLY CALIBRATED MEASURING AND TESTING INSTRUMENT IS TO BE USED AND. CALIBRATION CERTIFICATES ARE NEEDED TO BE FURNISHED DURING INSPECTION.
5. THESE TESTS/CHECKS ARE INDICATIVE ONLY. FURTHER TESTS MAY BE ADDED BASED ON END CUSTOMER REQUIREMENT AND WILL BE FINALISED DURING DETAILED ENGINEERING.
6. ALL PIPES AND FITTINGS SHALL BE TESTED AS PER APPLICABLE CODE.
7. NDT REQUIREMENT:
 - DPT: 100% DPT ON ROOT RUN OF BUTT WELD, NOZZLE WELDS AND FINISHED FILLET WELDS BY MANUFACTURER. REPORTS TO BE FURNISHED FOR REVIEW DURING INSPECTION. 10% DPT ON ALL FINISHED BUTT WELDS TO BE WITNESSED BY INSPECTING AGENCY.
 - MPI: FOR STRUCTURAL STEEL WELDS: PLATES OF 25MM<=THICKNESS<32MM- 100% MPI; FOR PLATES OF THICKNESS <25MM-10% MPI. EDGE FOR SHOP WELD SHALL BE EXAMINED BY MPI FOR PLATE THICKNESS >= 32MM
 - RT: BUTT WELDS OF DISHED ENDS SHALL BE STRESS RELIEVED AND SUBJECTED TO 100% RT. 10% RT (COVERING ALL 'T'/CROSS JOINTS) OF BUTT WELDS. FOR STRUCTURAL STEEL WELDS: 100% RT ON BUTT-WELDS OF PLATE THICKNESS>= 32MM
8. MATERIAL SHALL BE PACKED SUITABLY IN ORDER TO AVOID DAMAGE DURING TRANSIT AND ALSO DURING STORAGE AT SITE IN TROPICAL CLIMATE CONDITIONS.
9. LATEST REVISION/ YEAR OF ISSUE OF ALL THE STANDARDS (IS/ ASME/ IEC ETC.) INDICATED IN QP SHALL BE REFERRED.

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
Prepared by:	Sign	Name	Checked by:	Sign & Date	Name	Seal		Sign & Date	Name	Seal	
		VIVEK V HEMROM			ASHISH PANIGRAHI						
Reviewed by:		RAJESH RANJAN	Reviewed by:		RK JAISWAL						

Rajesh Ranjan


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Date: 2020.10.09
16:35:47 +05'30'

Ashish Panigrahi

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RITESH KUMAR JAISWAL

Digitally signed by RITESH KUMAR
JAISWAL
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ou=BHEL / PS-PEM, postalCode=201301,
st=Uttar Pradesh,
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serialNumber=8cfaddf001b4875a8b03a3
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09bc448, cn=RITESH KUMAR JAISWAL
Date: 2020.10.09 17:25:17 +05'30'

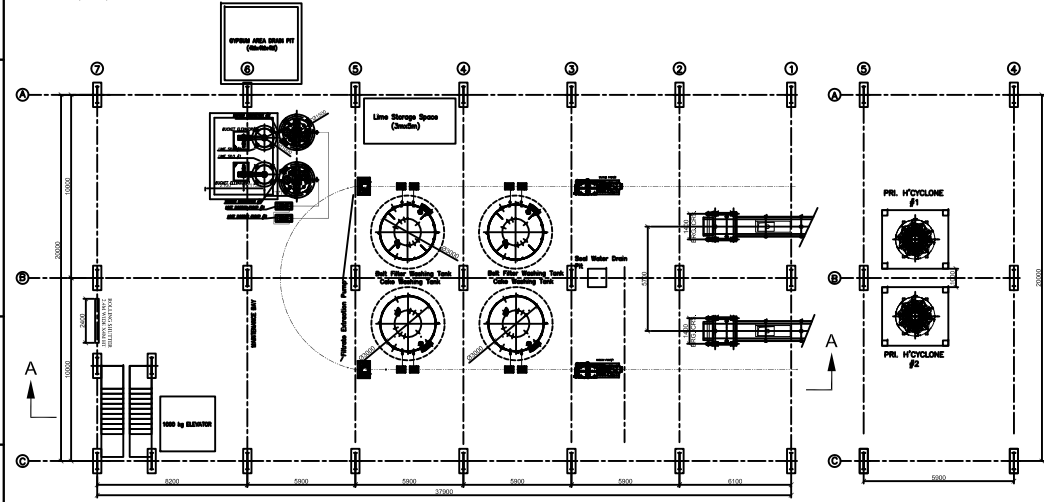
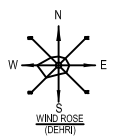
	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A001	
		ANNEXURE-IV	
		REV 00	MAY 21

ANNEXURE-IV

INPUT DRAWINGS/DOCUMENTS BY BHEL

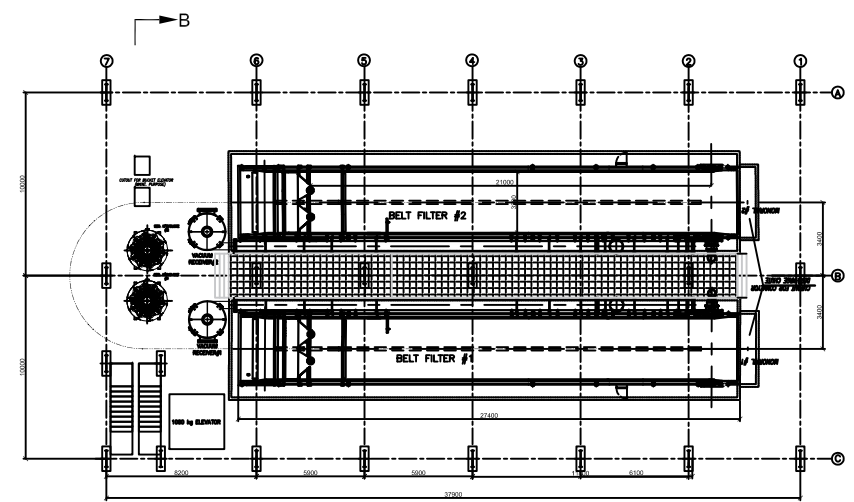
Sl.No.	Drawing/Document Title	Drawing No.
1.	General Arrangement of Dewatering building	PE-DG-481-571-A001
2.	P&ID - Primary Hydrocyclone feed tank	4200-109-RPT-PVM-F-016 (SH 1 OF 11)
3.	P&ID - Primary Hydrocyclone	4200-109-RPT-PVM-F-016 (SH 2 OF 11)
4.	P&ID of Vacuum Belt filter	4200-109-RPT-PVM-F-016 (SH 3, 4 OF 11)
5.	P&ID of Belt filter washing tank	4200-109-RPT-PVM-F-016 (SH 5, 6 OF 11)
6.	P&ID of Clarified water tank	4200-109-RPT-PVM-F-016 (SH 7,8 OF 11)
7.	P&ID - Secondary Hydrocyclone feed tank	4200-109-RPT-PVM-F-016 (SH 9 OF 11)
8.	P&ID of Secondary Hydrocyclone	4200-109-RPT-PVM-F-016 (SH 10 OF 11)
9.	Filtrate water tank	4200-109-RPT-PVM-F-016 (SH 11 OF 11)
10.	Filtrate Extraction Pump Scheme	PE-FEP-00
11.	Plant Layout of FGD System	4200-109-001-RPT-PVM-B-010A

1000-125-187-DC-2d
(As per drawing)



PLAN @ EL 0.0m

PLAN @ EL +18.0m



PLAN @ EL +10.0m

Notes:

1. All Dimensions are in millimeters and elevations in meters.
2. Drawing layout Civil drawing shall be prepared based on layout on finalized with vendor.
3. Seal pit dimension (*) shall be furnished by the bidder.
4. Bidder to confirm the capacity and layout for handling equipments.
5. This layout drawing is conceptual layout of GDW building. For scope bidder to refer technical Specification location of equipment may slightly vary as per requirement of the system and Layout shall be finalised with supplier during detailed engineering.

Rev	Date	Drawn	Checked	Approved	Remarks



PROJECT
KARALGAON SUPER THERMAL POWER PROJECT

Client: Bharat Heavy Electricals Ltd
Project Name: KARALGAON SUPER THERMAL POWER PROJECT-422-408

Scale: 1:100
Sheet No: GA of 422 of 574
Page No: 422 of 574

U 01



एनटीपी सी NTPC	नेशनल थर्मल पावर कॉर्पोरेशन लिमिटेड National Thermal Power Corporation Ltd. (A CORPORATION OF INDIA ENTERPRISE) INCORPORATED IN INDIA INCORPORATED IN INDIA
PROJECT KHALGAON SUPER THERMAL POWER PROJECT	
CS-227/D 	Bharat Heavy Electricals Ltd SOLAR ALUMINIUM PLANT BHARAT-632 40G
SHEET NO: 662	SCALE  1:100
DATE 1982	WEIGHT (KG) - *****
TITLE GA of GDWS	ORDERING NO : FE-DG-481-571-A001

LINE SYMBOLS	
SYMBOLS	NAME
	PIPE LINE
	CAPILLARY TUBING
	ELECTRIC SIGNAL
	SOFTWARE LINK
	PRESSURE LEAD
	DUCT

PIPING VALVE SYMBOLS	
SYMBOLS	NAME
	GATE VALVE (NOR.CLOSED)
	GLOBE VALVE (NOR.CLOSED)
	BALL VALVE (NOR.CLOSED)
	BUTTERFLY VALVE (NOR.CLOSED)
	DIAPHRAGM VALVE (NOR.CLOSED)
	PINCH VALVE (NOR.CLOSED)
	NEEDLE VALVE (NOR.CLOSED)
	CHECK VALVE
	CHECK VALVE (WAFER)
	PRESSURE RELIEF VALVE

INSTRUMENT VALVE SYMBOLS	
SYMBOLS	NAME
	ACTUATED BY AIR
	ACTUATED BY MOTOR
	AIR CONTROL VALVE
	SOLENOID ACTUATOR
	SELF REGULATING VALVE
	SELF REGULATING VALVE

TRENCH SYMBOLS	
SYMBOLS	NAME
	TO ABSORBER AREA DRAIN SUMP
	TO GYPSUM AREA DRAIN SUMP
	TO LIMESTONE AREA DRAIN SUMP

SYMBOLS FOR PIPING PARTS & INSTRUMENT PARTS

SYMBOLS	NAME
	STEAM TRAP
	AIR TRAP
	Y-STRAINER
	T-STRAINER
	TEMPORARY STRAINER
	REDUCER
	EXPANSION JOINT
	DUCT EXPANSION JOINT
	FLEXIBLE HOSE
	SPOOL PIECE
	VENT
	HOSE CONNECTION
	BLIND FLANGE
	REDUCING FLANGE
	CAP (BW)
	CAP (SCR)
	TRENCH
	SIGHT GLASS
	SILENCER
	ORIFICE
	DIAPHRAGM
	MAGNETIC FLOW METER
	VORTEX FLOW METER
	PH METER
	FILTER
	MANHOLE
	PITOT TUBE
	SAMPLING POT
	SAMPLING NOZZLE
	ROTOMETER TYPE FLOW METER

SYMBOLS FOR VALVE OPERATION

SYMBOLS	NAME
	FAILURE OPEN (THE VALVE OPENS WHEN AIR OR ELECTRICITY FOR ACTUATOR FAILS.)
	FAILURE CLOSE (THE VALVE CLOSES WHEN AIR OR ELECTRICITY FOR ACTUATOR FAILS.)

INSULATION SYMBOLS

SYMBOLS	DESCRIPTION
H10	THERMAL INSULATION (100°C & LOWER)
H15	THERMAL INSULATION (101°C ~ 150°C)
H20	THERMAL INSULATION (151°C ~ 200°C)
H25	THERMAL INSULATION (201°C ~ 250°C)
H30	THERMAL INSULATION (251°C ~ 300°C)
H35	THERMAL INSULATION (301°C ~ 350°C)
HF	INSULATION FOR ANTI FREEZING
ET	ELECTRIC TRACE
ST	STEAM TRACE (LOW PRESSURE STEAM)
P10	PERSONAL PROTECTION (100°C & LOWER)
P15	PERSONAL PROTECTION (101°C ~ 150°C)
P20	PERSONAL PROTECTION (151°C ~ 200°C)
P25	PERSONAL PROTECTION (201°C ~ 250°C)
P30	PERSONAL PROTECTION (251°C ~ 300°C)
P35	PERSONAL PROTECTION (350°C ~ 400°C)

DELIVERY LIMITS

SYMBOLS	NAME
	BETWEEN NTPC AND CONTRACTOR
	BETWEEN SUB CONTRACTOR AND VENDOR

SYSTEM

NUMBER	NAME
1	FLUE GAS SYSTEM
2	SO ₂ ABSORPTION OXIDATION SYSTEM
3	REHEATING SYSTEM
4	GYPSUM DEWATERING HANDLING SYSTEM
5	LIMESTONE PREPARATION SYSTEM
6	BLANK
7	SUMP SYSTEM
8	UTILITY SYSTEM

FLUID NAME

FLUID SYMBOL	FLUID NAME	FLUID SYMBOL	FLUID NAME
AC	COMPRESSED AIR	WCS	COOLING WATER SUPPLY
AF	FLUIDIZER AIR	WCR	COOLING WATER RETURN
AI	INSTRUMENT AIR	WD	DRINKING WATER
AO	OXIDATION AIR		
AS	SEAL AIR	WP	PROCESS WATER
DD	DUCT DRAIN	WR	RAW WATER
FS	FILTRATE SLURRY	WC	Ca(OH) ₂ WATER
GS	GYPSUM SLURRY	WW	WASTE WATER
LS	LIMESTONE SLURRY	VG	VACUUM PUMP VENT
		VBG	BELT FILTER VENT GAS
		LD	LIME/LIMESTONE DEDUSTING
		LOL	LUBE OIL (LOW PRESSURE)
		LOH	LUBE OIL (HIGH PRESSURE)
		CW	CLARIFIED WATER

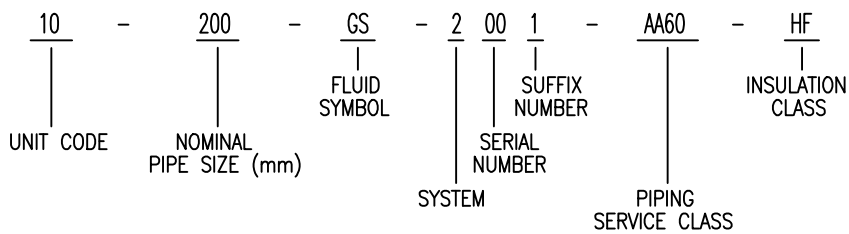
SERVICE CLASS

SERVICE CLASS	MATERIAL	FLUID SYMBOL
AA40	IIR RUBBER LINED PIPING	LS, WP, WC
AA60	IIR RUBBER LINED PIPING	GS,FS,WW,DD
BA01	Gr.304 STAINLESS STEEL PIPING	AI, LOL
BA02	Gr.304 STAINLESS STEEL PIPING	LOH
BA03	Gr.316L STAINLESS STEEL PIPING	WP, AO
CA01	CARBON STEEL GENERAL PIPING	AS,AO,AC,AF,LD
CC01	CARBON STEEL PRESSURE PIPING	WP,WR,WCS,WCR, VG, AA, CW
DA60	FRP PIPING (PIPE DIA UPTO 250 NB)	GS,FS,WW,DD
DA40	FRP PIPING (PIPE DIA UPTO 250 NB)	LS, WP, WC

UNIT CODE

SYMBOLS	UNIT IDENTIFICATION
00	COMMON
10	UNIT-1 FGD SYSTEM AND AUXILIARIES
20	UNIT-2 FGD SYSTEM AND AUXILIARIES

EXPRESSION OF PIPING LINE



CUSTOMER NOS: G213-G216, G512-G514

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	PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW) FGD SYSTEM PACKAGE			
		DEPT CODE	NAME (BHEL)	DATE
		DRN	VIDYA.V	19.08.20
		CHD	KABILASH K	19.08.20
		APPD	P.NAVEEN	19.08.20
	MITSUBISHI HITACHI POWER SYSTEMS, LTD. AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION			
	P & ID – LEGENDS AND NOTES			SCALE : NTS
	TITLE:			
	NTPC DRG NO: ----			SH 01 of 02
BHEL DRG NO	FILE NO	REV NO		
	B240 - 00100	00		

CONFIDENTIAL & PROPRIETARY INFORMATION






THIRD ANGLE PROJECTION	No. REQ'D

DRAWING No.

INSTRUMENT ABBREVIATION

	FIRST-LETTER		SUCCEEDING-LETTERS		
	MEASURED OR INITIATING VARIABLE	MODIFIER	READOUT OR PASSIVE FUNCTION	OUTPUT FUNCTION	MODIFIER
A	ANALYSIS		ALARM		
B	BURNER, COMBUSTION		BLANK	BLANK	BLANK
C	BLANK			CONTROL	
D	BLANK	DIFFERENTIAL			
E	VOLTAGE		SENSOR (PRIMARY ELEMENT)		
F	FLOW RATE	RATIO (FRACTION)			
G	BLANK		GLASS, VIEWING DEVICE		
H	HAND				HIGH
I	CURRENT (ELECTRICAL)		INDICATE		
J	POWER	SCAN			
K	TIME, TIME SCHEDULE	TIME RATE OF CHANGE		CONTROL STATION	
L	LEVEL		LIGHT		LOW
M	BLANK	MOMENTARY			MIDDLE, INTERMEDIATE
N	BLANK		BLANK	BLANK	BLANK
O	BLANK		ORIFICE, RESTRICTION		
P	PRESSURE, VACUUM		POINT(TEST) CONNECTION		
Q	QUANTITY	INTEGRATE, TOTALIZE			
R	RADIATION		RECORD		
S	SPEED, FREQUENCY	SAFETY		SWITCH	
T	TEMPERATURE			TRANSMIT	
U	MULTIVARIABLE		MULTIFUNCTION	MULTIFUNCTION	MULTIFUNCTION
V	VIBRATION, MECHANICAL ANALYSIS			VALVE, DAMPER, LOUVER	
W	WEIGHT, FORCE		WELL		
X	UNCLASSIFIED	X AXIS	UNCLASSIFIED	UNCLASSIFIED	UNCLASSIFIED
Y	EVENT, STATE OR PRESENCE	Y AXIS		RELAY, COMPUTE, CONVERT	
Z	POSITION, DIMENSION	Z AXIS		DRIVER, ACTUATOR, UNCLASSIFIED FINAL CONTROL ELEMENT	







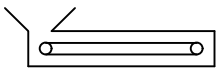
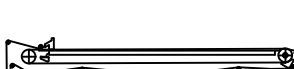



INSTRUMENT SYMBOLS

SYMBOLS	NAME
	FIELD MOUNTED
	FOR CONTROL ROOM
	FOR LOCAL CONTROL PANEL
	FOR DCS
	INTERLOCK LOGIC


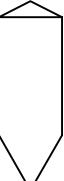








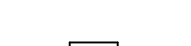



PNEUMATIC VALVE ACTUATOR

CODE NO.	ACTUATION
FLXXWA-D	DOUBLE SOLENOID NO LIMIT SWITCH
FLXXWA-DL	DOUBLE SOLENOID WITH LIMIT SWITCH
FLXXWA-S	SINGLE SOLENOID NO LIMIT SWITH
FLXXWA-SL	SINGLE SOLENOID WITH LIMIT SWITCH



MACHINARY SYMBOLS

SYMBOLS	NAME
	PUMP
	FAN / BLOWER
	AGITATOR (FLAT BLADE)
	AGITATOR (PROPELLOR)
	ROTARY VALVE
	CRUSHER
	BELT FEEDER
	BELT FILTER
	BALL MILL
	CYCLONE
	MIST ELIMINATOR



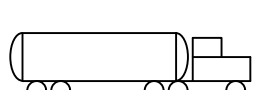
EQUIPMENT SYMBOLS

SYMBOLS	NAME
	BAG FILTER
	SILLO
	SLIDE GATE
	TANDEM LOUVER DAMPER (MULTIVANE)
	SINGLE STAGE LOUVER DAMPER (MULTIVANE)
	LOUVER DAMPER (SINGLE VANE)
	DISTRIBUTION BOX (3WAY)
	DISTRIBUTION BOX (2WAY)
	SUMP
	HEAT EXCHANGER
	SHELL AND TUBE HEAT EXCHANGER
	AIR DRYER
	FILTER
	SPRAY NOZZLE

DRIVER SYMBOLS

SYMBOLS	NAME
	AIR MOTOR
	ELECTRIC MOTOR


OTHER SYMBOLS

SYMBOLS	NAME
	INSERT PIPE / LANCE
	CHUTE
	TRUCK

CONFIDENTIAL & PROPRIETARY INFORMATION

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.
PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

 BHARAT HEAVY ELECTRICALS LIMITED, UNIT: BOILER AUXILIARIES PLANT, RANIPET-632 406.	DEPT CODE	NAME (BHEL)	DATE
	DRN	VIDYA.V	19.08.20
	CHD	KABILASH K	19.08.20
	APPD	P.NAVEEN	19.08.20

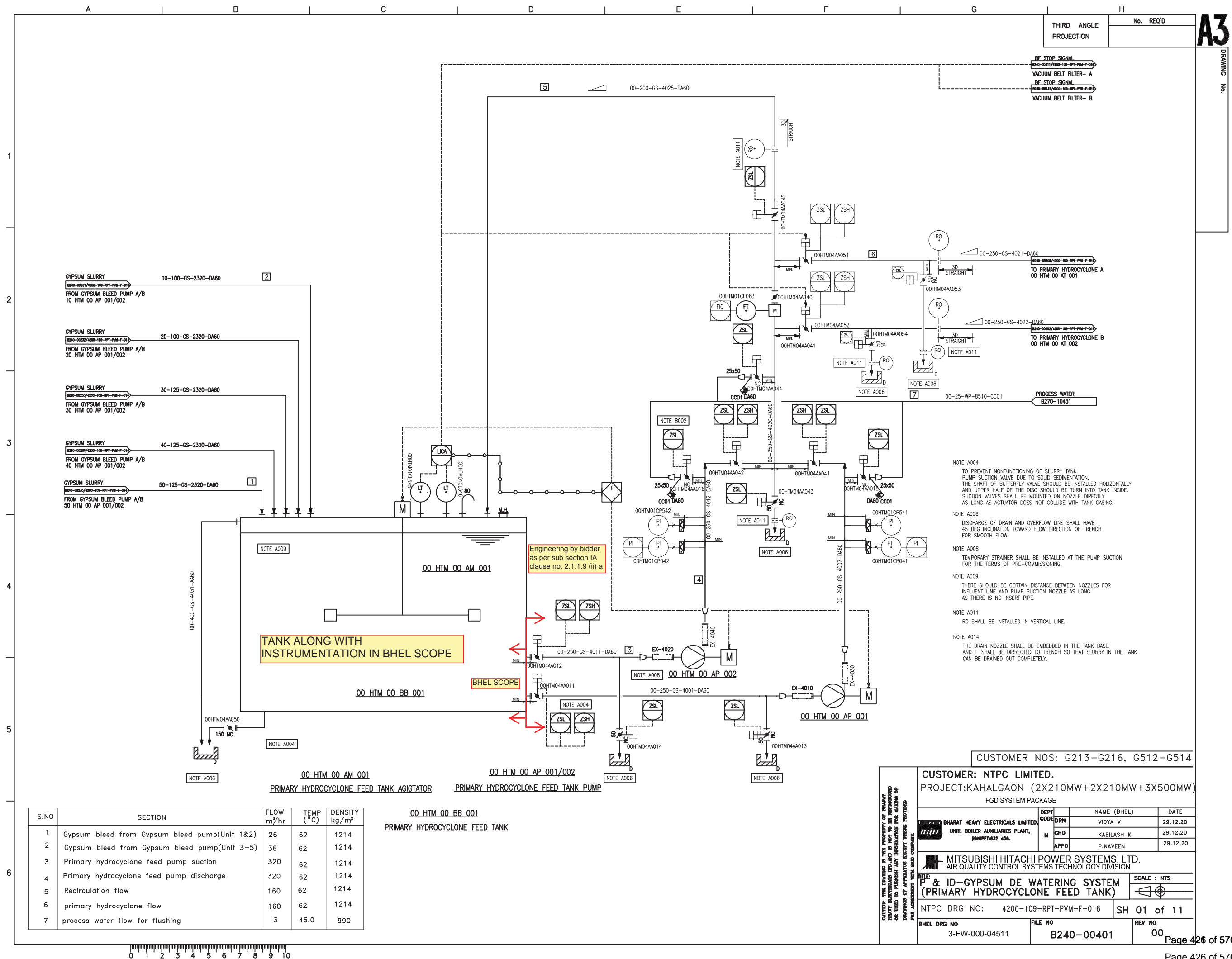
 MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION

P & ID - LEGENDS AND NOTES



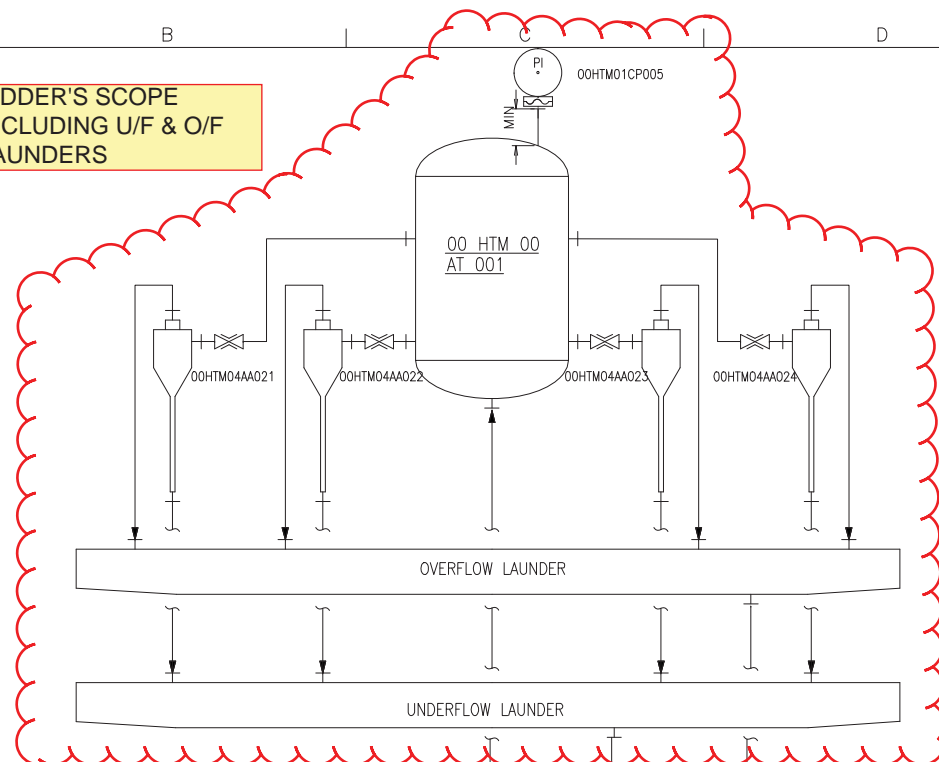
TITLE: NTPC DRG NO: ---- SH 02 of 02

BHEL DRG NO FILE NO REV NO
B240 - 00100 00
Page 426 of 576



THIRD ANGLE
PROJECTION

No. REQ'D

BIDDER'S SCOPE
INCLUDING U/F & O/F
LAUNDERSBIDDER'S SCOPE
INCLUDING U/F & O/F
LAUNDERSENGINEERING & SUPPLY
BY BIDDERENGINEERING & SUPPLY
BY BIDDEREngineering by bidder as per sub
section IA clause no. 2.1.1.9 (ii) aEngineering by bidder as per sub
section IA clause no. 2.1.1.9 (ii) b

B240-00401/4200-109-RPT-PVM-F-016

FROM PRIMARY HYDROCYCLONE FEED TANK PUMP A/B
00 HTM 00 AP 001/002

00-250-GS-4021-DA60

Engineering by bidder
as per sub section IA
clause no. 2.1.1.9 (i) a

B240-00401/4200-109-RPT-PVM-F-016

FROM PRIMARY HYDROCYCLONE FEED TANK PUMP A/B
00 HTM 00 AP 001/002

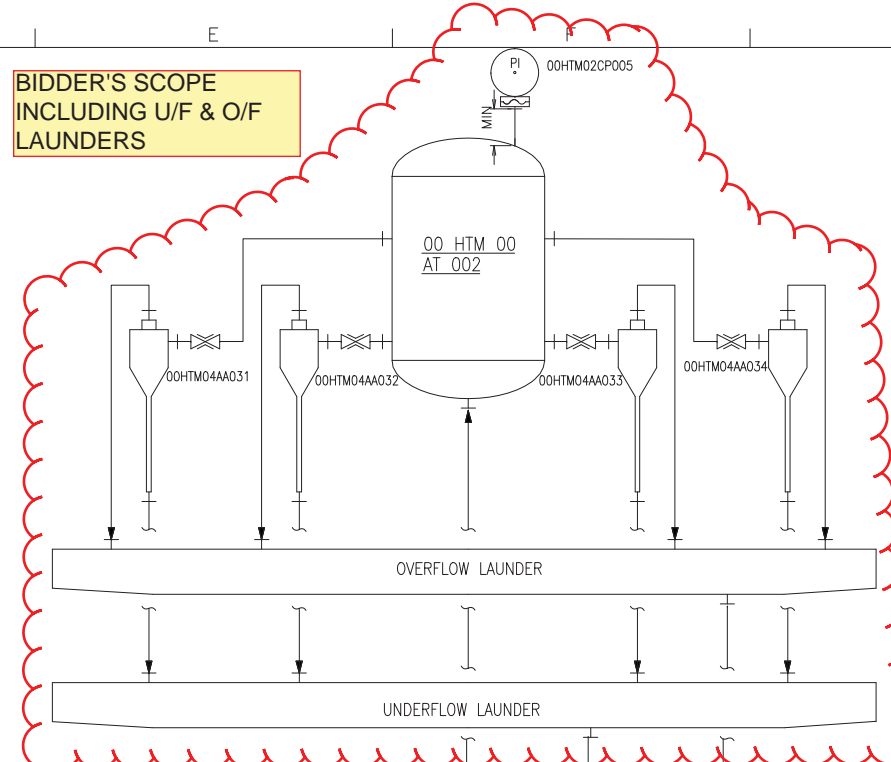
00-250-GS-4022-DA60

00 HTM 00 AT 001/002

PRIMARY HYDROCYCLONE A/B

NOTE: PIPE SIZES WILL BE CONFIRMED LATER BASED ON VENDOR DATA

S NO	SECTION	FLOW m ³ /hr	TEMP (°C)	DENSITY kg/m ³
1	Primary hydrocyclone feed flow	159.2	62	1214
2	Primary hydrocyclone underflow	67.2	62	1355
3	Primary hydrocyclone overflow	92.0	62	1110

BIDDER'S SCOPE
INCLUDING U/F & O/F
LAUNDERSENGINEERING & SUPPLY
BY BIDDER

ENGINEERING & SUPPLY BY BIDDER

Engineering by bidder as per sub section IA clause no.
2.1.1.9 (ii) bEngineering by bidder as per sub
section IA clause no. 2.1.1.9 (ii) aEngineering by bidder
as per sub section IA
clause no. 2.1.1.9 (i) a

ZSL ZSH

00HTM04AA061

00-250-GS-4051-DA60

B240-00442/4200-109-RPT-PVM-F-016
TO SECONDARY HYDROCYCLONE FEED TANK
00 HTM 04 BB 001

ZSL ZSH

00HTM04AA062

00-250-GS-4052-DA60

B240-00412/4200-109-RPT-PVM-F-016
TO GYPSUM BELT FILTER B
00 HTM 01 AT 002B240-00442/4200-109-RPT-PVM-F-016
TO SECONDARY HYDROCYCLONE FEED TANK
00 HTM 04 BB 001B240-00411/4200-109-RPT-PVM-F-016
TO VACUUM BELT FILTER A

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.
PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

DEPT CODE	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
CHD	KABILASH K	29.12.20
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISIONTITLE:
P & ID-GYPSUM DE WATERING SYSTEM
(PRIMARY HYDROCYCLONE)

SCALE : NTS

NTPC DRG NO: 4200-109-RPT-PVM-F-016 SH 02 of 11

BHEL DRG NO 3-FW-000-04511 FILE NO B240-00402 REV NO 00

THIRD ANGLE

No. REQ'D

S NO	SECTION	FLOW m ³ /hr	TEMP(C)	DENSITY kg/m ³
1	Gypsum slurry line to belt filter	67.2	62	1355
2	Gypsum outlet from belt filter to gypsum handling system	45.3TPH	57	900
3	Filtrate water from vacuum receiver to filtrate water tank		VENDOR DATA	
4	Vacuum pump flow		VENDOR DATA	
5	Seal water to vacuum pump		VENDOR DATA	
6	Seal water return		VENDOR DATA	

NOTE A001
MOTOR PID ARE NOT SHOWN.

NOTE B002
OPEN AND CLOSE CONTACT SWITCHES ARE FOR REFERENCE ONLY.
IN CASE THAT THERE IS CUSTOMER'S SPECIFICATION,
THEY SHOULD BE DECIDED BASED ON IT.

NOTE B003
SYSTEM COMPONENTS WRITTEN IN THE DRAWING ARE JUST DEFAULT.
TYPE WILL BE SUBJECT TO CHANGE DUE TO VENDOR SELECTION.

NOTE B005
PIPE SIZE WRITTEN IN THE DRAWING IS TYPICAL. IT SHOULD BE REVIEWED.

NOTE A401
SURFACE OF CONCRETE FOUNDATION SHALL BE
LINED WITH ANTI CORROSION MATERIAL.

NOTE A402
BIRD SCREEN SHALL BE INSTALLED.

NOTE A405
NOZZLE OF PRESSURE INDICATOR SHALL NOT HAVE A POCKET.
IT MAY CAUSE REMAIN OF DRAIN.

NOTE A406
CAKE WASH PIPING SHALL BE MOVABLE SO THAT ITS POSITION
CAN BE ADJUSTED WELL DURING COMMISSIONING.

NOTE A407
WASH, SEAL AND LUBRICATION WATER PIPING SHALL BE DESIGNED
TO DISTRIBUTE WATER EQUALLY (EX. TO CONNECT SUPPLY LINE
TO MIDDLE OF HEADER).

NOTE B403
STRAINER CAN BE OMITTED IF ANOTHER ONE IS APPLIED UPSTREAM.

NOTE B404
TWO VACUUM RECEIVERS MAY BE REQUIRED DEPENDING ON THE CAPACITY
OR PROCESS REQUIREMENT.

NOTE B405
GYPSUM CHUTE SHALL BE DESIGNED VERTICALLY, NOT OBLIQUELY.

NOTE: PIPE SIZES WILL BE FINALIZED LATER BASED ON VENDOR DATA

Complete System in Bidder scope

EXCEPT:

1. Piping with accessories from Filtrate Extraction Pump to Filtrate Water Tank. Refer Scheme No. PE-FEP-00. 2. Associated drain of vacuum belt filters (drip tray) to filtrate tanks. Refer sub

section IA, clause 2.1.1.9 (ii) f of the Specification

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.

PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

DEPT	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
CHD	KABILASH K	29.12.20
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION

TITLE:
P & ID-GYPSUM DE WATERING SYSTEM
(GYPSUM BELT FILTER A)

SCALE : NTS

NTPC DRG NO: 4200-109-RPT-PVM-F-016

SH 03 of 11

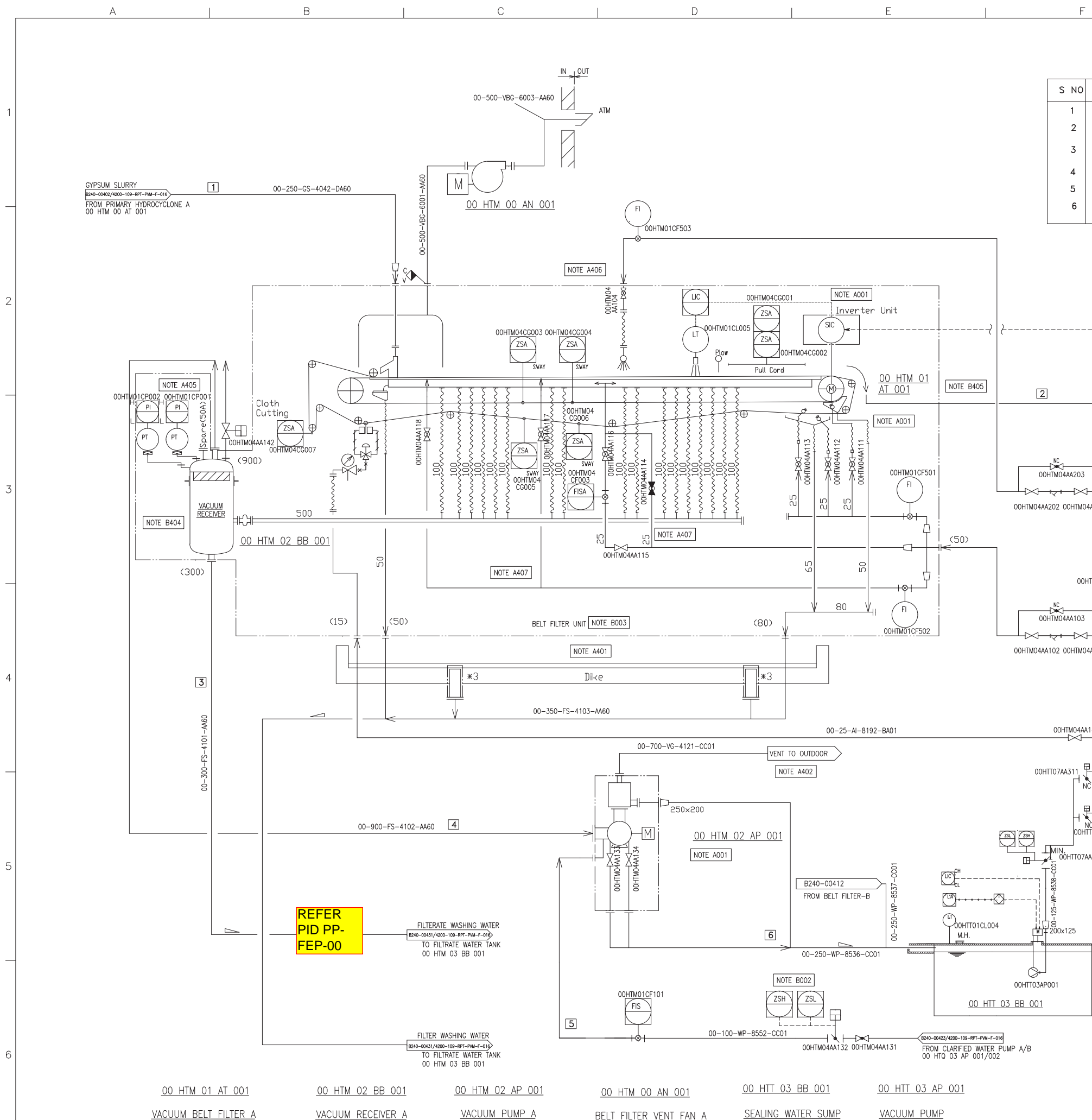
BHEL DRG NO
3-FW-000-04511

FILE NO
B240-00411

REV NO
00

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00 HTM 01 AT 001

VACUUM BELT FILTER A

00 HTM 02 BB 001

VACUUM RECEIVER A

00 HTM 02 AP 001

VACUUM PUMP A

00 HTM 00 AN 001

BELT FILTER VENT FAN A

00 HTT 03 BB 001

SEALING WATER SUMP

00 HTT 03 AP 001

VACUUM PUMP

0 1 2 3 4 5 6 7 8 9 10

THIRD ANGLE

No. REQ'D

S NO	SECTION	FLOW m ³ /hr	TEMP(°C)	DENSITY kg/m ³
1	Gypsum slurry line to belt filter	67.2	62	1355
2	Gypsum outlet from belt filter to gypsum handling system	45.3TPH	57	900
3	Filtrate water from vacuum receiver to filtrate water tank		VENDOR DATA	
4	Vacuum pump flow		VENDOR DATA	
5	Seal water to vacuum pump		VENDOR DATA	
6	Seal water return		VENDOR DATA	

NOTE A001
MOTOR PID ARE NOT SHOWN.

NOTE B002
OPEN AND CLOSE CONTACT SWITCHES ARE FOR REFERENCE ONLY.
IN CASE THAT THERE IS CUSTOMER'S SPECIFICATION,
THEY SHOULD BE DECIDED BASED ON IT.

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SYSTEM COMPONENTS WRITTEN IN THE DRAWING ARE JUST DEFAULT.
TYPE WILL BE SUBJECT TO CHANGE DUE TO VENDOR SELECTION.

NOTE B005
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NOTE A401
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LINED WITH ANTI CORROSION MATERIAL.

NOTE A402
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CAN BE ADJUSTED WELL DURING COMMISSIONING.

NOTE A407
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TO DISTRIBUTE WATER EQUALLY (EX. TO CONNECT SUPPLY LINE
TO MIDDLE OF HEADER).

NOTE B403
STRAINER CAN BE OMITTED IF ANOTHER ONE IS APPLIED UPSTREAM.

NOTE B404
TWO VACUUM RECEIVERS MAY BE REQUIRED DEPENDING ON THE CAPACITY
OR PROCESS REQUIREMENT.

NOTE B405
GYPSUM CHUTE SHALL BE DESIGNED VERTICALLY, NOT OBLIQUELY.

NOTE: PIPE SIZES WILL BE FINALIZED LATER BASED ON VENDOR DATA

Complete System in Bidder scope
EXCEPT:

1. Piping with accessories from Filtrate Extraction Pump to Filtrate Water Tank.
Refer Scheme No. PE-FEP-00. 2.
Associated drain of vacuum belt filters
(drip tray) to filtrate tanks. Refer sub
section IA, clause 2.1.1.9 (ii) f of the
Specification

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.
PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

DEPT	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
CHD	KABILASH K	29.12.20
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION

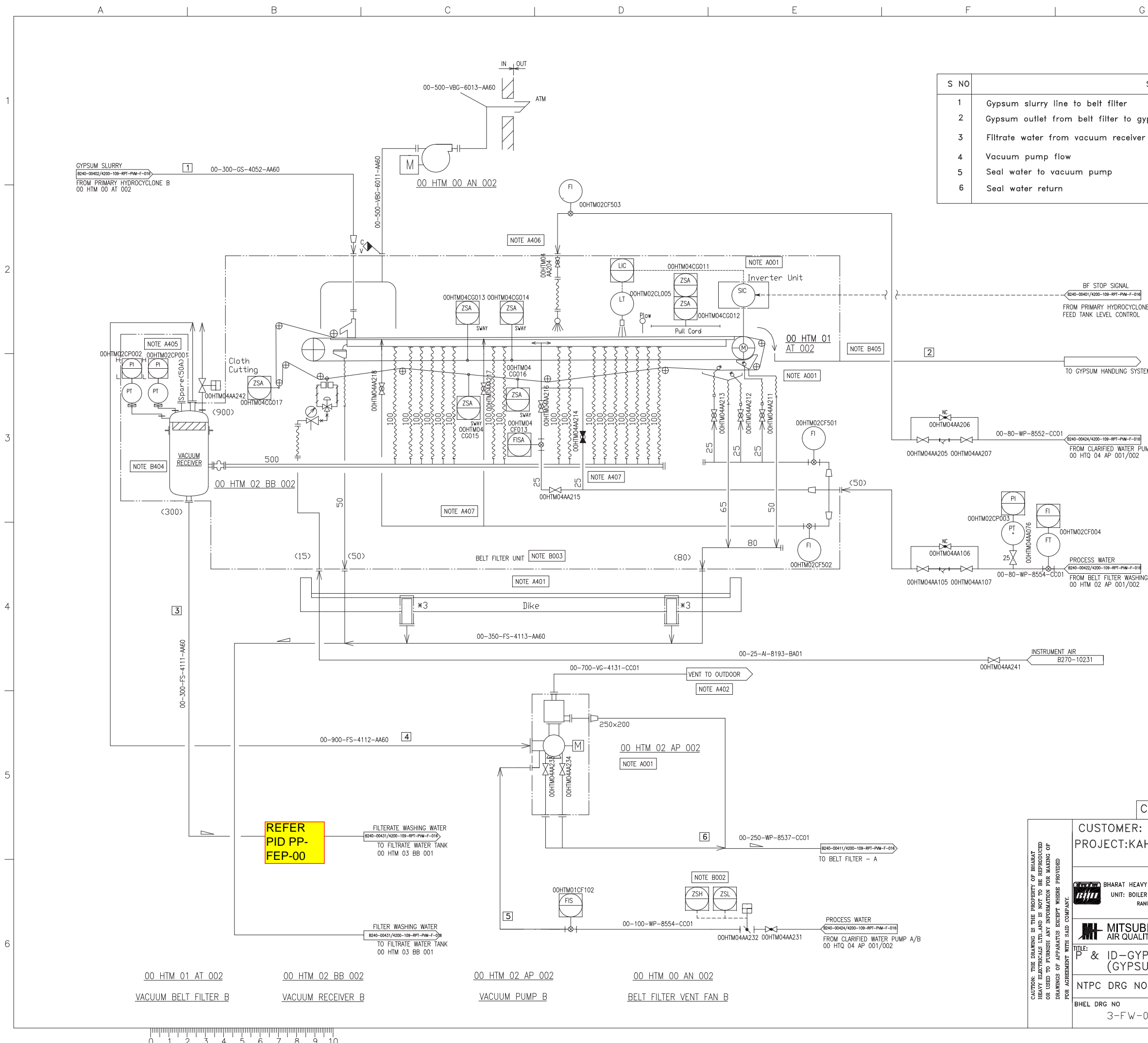
TITLE:
P & ID-GYPSUM DE WATERING SYSTEM
(GYPSUM BELT FILTER B)

SCALE : NTS

NTPC DRG NO: 4200-109-RPT-PVM-F-016 SH 04 of 11

BHEL DRG NO 3-FW-000-04511 FILE NO B240-00412 REV NO 00

CAUTION: THE DRAWING IS THE PROPERTY OF BHARAT
HEAVY ELECTRICALS LTD. AND IS NOT TO BE REPRODUCED
OR USED TO FURNISH ANY INFORMATION FOR MAKING OF
DRAWINGS OF APPARATUS EXCEPT WHERE PROVIDED
FOR AGREEMENT WITH SAID COMPANY.



THIRD ANGLE
PROJECTION

No. REQ'D

1

2

3

4

5

6

BHEL scope till terminal
point as per specificationEngineering by bidder
as per sub section IA
clause no. 2.1.1.9 (i) eRemaining in Bidder's
scope

BHEL SCOPE

TANK ALONG WITH
INSTRUMENTATION IN BHEL
SCOPE

BHEL SCOPE

ENGINEERING
BY BIDDERNOTE A001
MOTOR PID ARE NOT SHOWN.NOTE A006
DISCHARGE OF DRAIN AND OVERFLOW LINE SHALL HAVE
45 DEG INCLINATION TOWARD FLOW DIRECTION OF TRENCH
FOR SMOOTH FLOW.NOTE A008
TEMPORARY STRAINER SHALL BE INSTALLED AT THE PUMP SUCTION
FOR THE TERMS OF PRE-COMMISSIONING.NOTE A009
THERE SHOULD BE CERTAIN DISTANCE BETWEEN NOZZLES FOR
INFLUENT LINE AND PUMP SUCTION NOZZLE AS LONG
AS THERE IS NO INSERT PIPE.NOTE A011
RO SHALL BE INSTALLED IN VERTICAL LINE.NOTE B002
OPEN AND CLOSE CONTACT SWITCHES ARE FOR REFERENCE ONLY.
IN CASE THAT THERE IS CUSTOMER'S SPECIFICATION,
THEY SHOULD BE DECIDED BASED ON IT.

NOTE: PIPE SIZES WILL BE FINALIZED LATER BASED ON VENDOR DATA

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.

PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

DEPT CODE	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
M	CHD	KABILASH K
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISIONTITLE:
P & ID-GYPSUM DE WATERING SYSTEM
(BELT FILTER WASHING TANK A)

SCALE : NTS

NTPC DRG NO: 4200-109-RPT-PVM-F-016

SH 05 of 11

BHEL DRG NO
3-FW-000-04511FILE NO
B240-00421REV NO
00

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S NO	SECTION	FLOW m ³ /hr	TEMP(°C)	DENSITY kg/m ³
1	Process water to belt filter wash tank	VENDOR DATA	45.0	990
2	At the suction of belt filter wash pump	VENDOR DATA	45.0	990
3	At the discharge of belt filter wash pump	VENDOR DATA	45.0	990
4	Wash water to belt filter	25.0	45.0	990

00_HTM_01_BB_001
BELT FILTER WASHING TANK00_HTM_01_AP_001/002
BELT FILTER WASHING TANK PUMP A/B

0 1 2 3 4 5 6 7 8 9 10

THIRD ANGLE
PROJECTION

No. REQ'D

A3

DRAWING No.

PROCESS WATER
B240-00431/4200-109-RPT-PWM-F-010

1

00-65-WP-8635-CC01

00HTM04AA801

NOTE B002



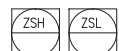
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NOTE A011

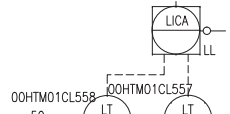
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NOTE B002

4

PROCESS WATER

B240-00412/4200-109-RPT-PWM-F-010
TO VACUUM BELT FILTER B
00 HTM 01 AT 002

NOTE A009

00-125-WP-8647-CC01

M.H.

00HTM04AA803

NC 80

00 HTM 01 BB 002

MIN

MIN

00HTM04AA804

00HTM04AA805

00-80-WP-8641-CC01

00-80-WP-8643-CC01

2

NOTE A008

00 HTM 02 AP 001

M

NOTE A001

00 HTM 02 AP 001/002

BELT FILTER WASHING TANK PUMP A/B

SAME SCOPE AS THAT OF BELT FILTER WASH
TANK-A (sh 5 OF 11)

00 HTM 02 AP 002

NOTE A001

MOTOR PID ARE NOT SHOWN.

NOTE A006

DISCHARGE OF DRAIN AND OVERFLOW LINE SHALL HAVE
45 DEG INCLINATION TOWARD FLOW DIRECTION OF TRENCH
FOR SMOOTH FLOW.

NOTE A008

TEMPORARY STRAINER SHALL BE INSTALLED AT THE PUMP SUCTION
FOR THE TERMS OF PRE-COMMISSIONING.

NOTE A009

THERE SHOULD BE CERTAIN DISTANCE BETWEEN NOZZLES FOR
INFLUENT LINE AND PUMP SUCTION NOZZLE AS LONG
AS THERE IS NO INSERT PIPE.

NOTE A011

RO SHALL BE INSTALLED IN VERTICAL LINE.

NOTE B002

OPEN AND CLOSE CONTACT SWITCHES ARE FOR REFERENCE ONLY.
IN CASE THAT THERE IS CUSTOMER'S SPECIFICATION,
THEY SHOULD BE DECIDED BASED ON IT.

NOTE: PIPE SIZES WILL BE FINALIZED LATER BASED ON VENDOR DATA

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.
PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

DEPT CODE	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
CHD	KABILASH K	29.12.20
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISIONTITLE:
P & ID-GYPSUM DE WATERING SYSTEM
(BELT FILTER WASHING TANK B)

SCALE : NTS

NTPC DRG NO: 4200-109-RPT-PVM-F-016 SH 06 of 11

BHEL DRG NO 3-FW-000-04511 FILE NO B240-00422 REV NO 00

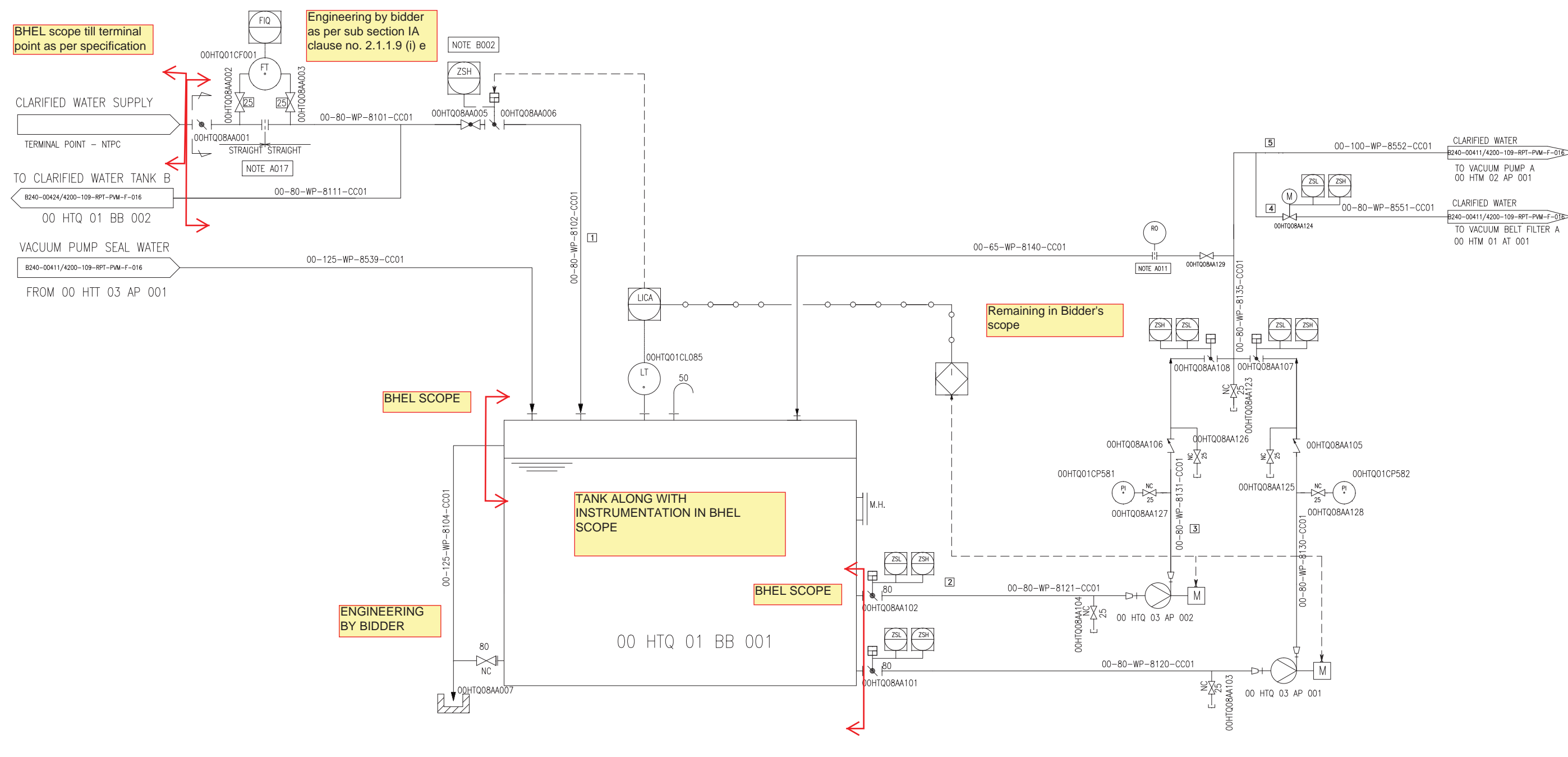
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S NO	SECTION	FLOW m3/hr	TEMP(°C)	DENSITY kg/m3
1	Process water to belt filter wash tank	VENDOR DATA	45.0	990
2	At the suction of belt filter wash pump	VENDOR DATA	45.0	990
3	At the discharge of belt filter wash pump	VENDOR DATA	45.0	990
4	Wash water to belt filter	25.0	45.0	990

THIRD ANGLE
PROJECTION

No. REQ'D



CLARIFIED WATER TANK A
00 HTQ 01 BB 001

CLARIFIED WATER PUMP A/B
00 HTQ 03 AP 001/002

NOTE: PIPE SIZES WILL BE FINALIZED LATER BASED ON VENDOR DATA

S NO	SECTION	FLOW m ³ /hr	TEMP(°C)	DENSITY kg/m ³
1	Clarified water to clarified wash tank	VENDOR DATA	45.0	990
2	At the suction of clarified wash pump	VENDOR DATA	45.0	990
3	At the discharge of clarified wash pump	VENDOR DATA	45.0	990
4	Clarified Wash water to belt filter	VENDOR DATA	45.0	990
5	Vacuum pump seal water	VENDOR DATA	45.0	990

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.			
PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)			
FGD SYSTEM PACKAGE			
DEPT	NAME (BHEL)	DATE	
DRN	VIDYA V	29.12.20	
CHD	KABILASH K	29.12.20	
APPD	P.NAVEEN	29.12.20	
MITSUBISHI HITACHI POWER SYSTEMS, LTD. AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION			
P & ID-GYPSUM DE WATERING SYSTEM			
(CLARIFIED WATER TANK A)			
NTPC DRG NO. 4200-109-RPT-PVM-F-016		SH 07 of 11	
BHEL DRG NO	FILE NO	REV NO	
3-FW-000-04511	B240-00423	00	

THIRD ANGLE
PROJECTION

No. REQ'D

1

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CLARIFIED WATER

B240-00424/4200-109-RPT-PVM-F-016

00-80-WP-8111-CC01



00HTQ08AA015

00HTQ08AA016

VACUUM PUMP SEAL WATER

B240-00412/4200-109-RPT-PVM-F-016

00-125-WP-8540-CC01

FROM 00 HTT 03 AP 001

00-125-WP-8114-CC01

80

NC

00HTQ08AA017

CLARIFIED WATER TANK B
00 HTQ 01 BB 002CLARIFIED WATER PUMP C/D
00 HTQ 04 AP 001/002

S NO	SECTION	FLOW m ³ /hr	TEMP(°C)	DENSITY kg/m ³
1	Clarified water to clarified wash tank	VENDOR DATA	45.0	990
2	At the suction of clarified wash pump	VENDOR DATA	45.0	990
3	At the discharge of clarified wash pump	VENDOR DATA	45.0	990
4	Clarified Wash water to belt filter	VENDOR DATA	45.0	990
5	Vacuum pump seal water	VENDOR DATA	45.0	990

00-80-WP-8112-CC01

LICA
00HTQ02CL085
50

00-100-WP-8141-CC01



NOTE A011

00HTQ08AA139



00HTQ08AA118

00HTQ08AA133

00HTQ08AA117

00HTQ08AA116

00HTQ02CP581

00HTQ08AA137

00-80-WP-8133-CC01

00HTQ08AA136

00HTQ08AA115

00HTQ08AA135

00HTQ02CP582

00HTQ08AA138

00-80-WP-8132-CC01

00HTQ08AA113

00 HTQ 04 AP 001

00-80-WP-8122-CC01

00HTQ08AA114

00 HTQ 04 AP 002

00-80-WP-8123-CC01

00HTQ08AA112

80

80

00HTQ08AA111

00-80-WP-8136-CC01

00HTQ08AA134

00-100-WP-8554-CC01

CLARIFIED WATER

B240-00412/4200-109-RPT-PVM-F-016

TO VACUUM PUMP B
00 HTM 02 AP 002

CLARIFIED WATER

B240-00412/4200-109-RPT-PVM-F-016

TO VACUUM BELT FILTER B
00 HTM 01 AT 002

NOTE: PIPE SIZES WILL BE FINALIZED LATER BASED ON VENDOR DATA

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.

PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)

FGD SYSTEM PACKAGE

DEPT CODE NAME (BHEL) DATE

BHEL DRG NO. 3-FW-000-04511

FILE NO B240-00424

REV NO 00

P & ID-GYPSUM DE WATERING SYSTEM

(CLARIFIED WATER TANK B)

NTPC DRG NO. 4200-109-RPT-PVM-F-016

SH 08 of 11

BHEL DRG NO. 3-FW-000-04511

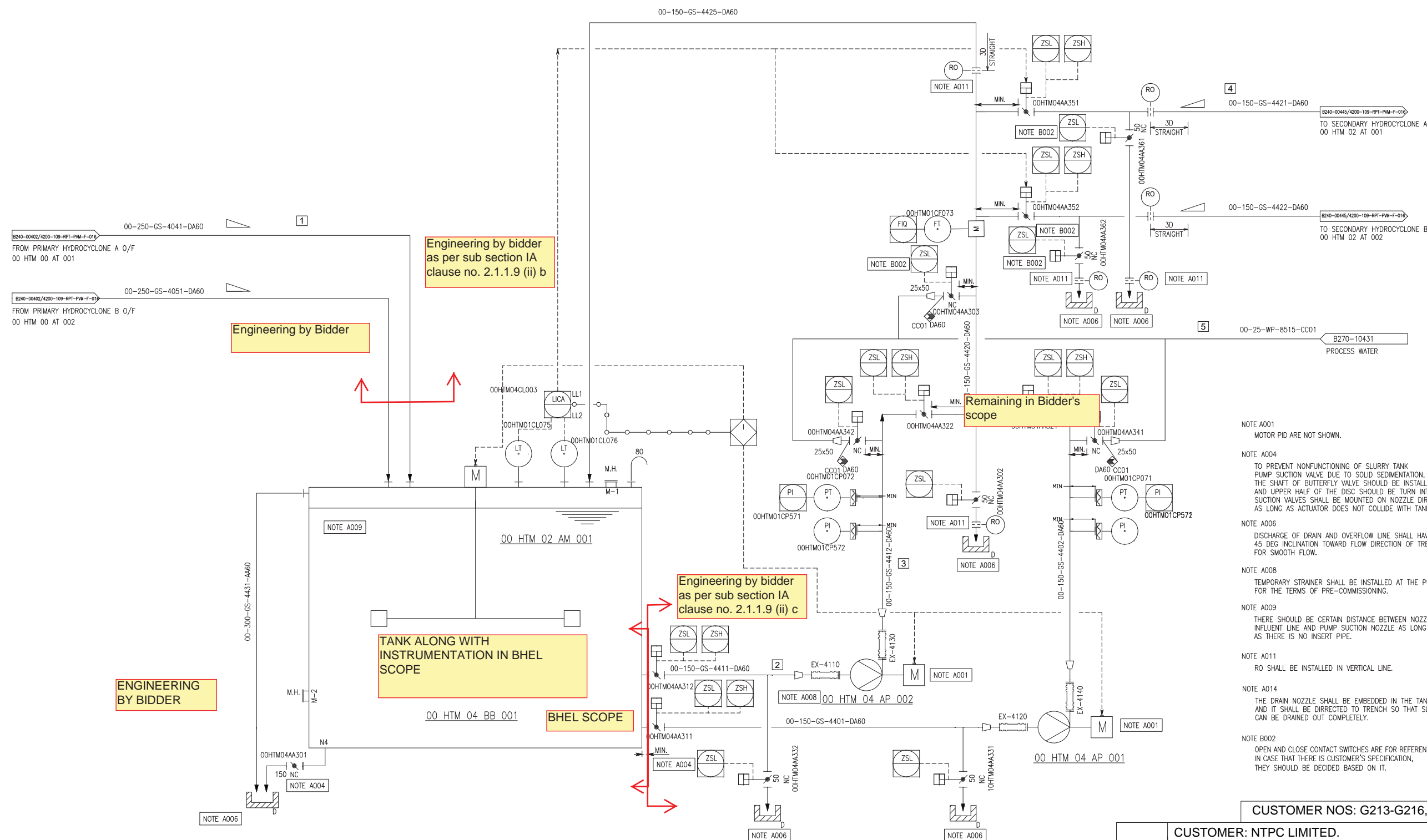
FILE NO B240-00424

REV NO 00

SAME SCOPE AS THAT OF CLARIFIED WATER TANK-A
(sh 7 OF 11)

THIRD ANGLE
PROJECTION

No. REQ'D



S NO	SECTION	FLOW m ³ /hr	TEMP (°C)	DENSITY kg/m ³
1	Primary hydrocyclone overflow	92.0	62	1110
2	Secondary hydrocyclone feed pump suction	186	62	1110
3	Secondary hydrocyclone feed pump discharge	186	62	1110
4	Secondary hydrocyclone flow	92.0	62	1110
5	process water flow for flushing	3	45.0	990

00 HTM 02 AM 001
SECONDARY HYDROCYCLONE FEED TANK AGITATOR

00 HTM 04 AP 001/002
SECONDARY HYDROCYCLONE FEED TANK PUMP

00 HTM 04 BB 001
SECONDARY HYDROCYCLONE FEED TANK

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.
PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

DEPT CODE	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
CHD	KABILASH K	29.12.20
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION

TITLE:
P & ID-GYPSUM DE WATERING SYSTEM
(SECONDARY HYDROCLONE FEED TANK)

SCALE : NTS

NTPC DRG NO: 4200-109-RPT-PVM-F-016 SH 09 of 11

BHEL DRG NO: 3-FW-000-04511 FILE NO: B240-00441 REV NO: 00

**BIDDER'S SCOPE
INCLUDING U/F & O/F
LAUNDERS****BIDDER'S SCOPE
INCLUDING U/F & O/F
LAUNDERS**THIRD ANGLE
PROJECTION

No. REQ'D

1

2

3

4

5

6

GYPSUM SLURRY
B240-0044/4200-109-RPT-PVM-F-016
FROM SECONDARY HYDROCYCLONE FEED TANK PUMP A/B
00 HTM 04 AP 001/002

00-150-GS-4421-DA60

**ENGINEERING & SUPPLY
BY BIDDER****Engineering by bidder as per sub
section IA clause no. 2.1.1.9 (ii) c****Engineering by bidder
as per sub section IA
clause no. 2.1.1.9 (ii) d**

00 HTM 02 AT 001/002

SECONDARY
HYDROCYCLONE A/B

S NO	SECTION	FLOW m ³ /hr	TEMP (°C)	DENSITY kg/m ³
1	Secondary hydrocyclone feed flow	92.0	62	1110
2	Secondary hydrocyclone underflow	34.6	62	1257
3	Secondary hydrocyclone overflow	57.4	62	1020

**ENGINEERING & SUPPLY
BY BIDDER****Engineering by bidder as per sub
section IA clause no. 2.1.1.9 (ii) c****Engineering by bidder as
per sub section IA
clause no. 2.1.1.9 (ii) e****Engineering by bidder as
per sub section IA
clause no. 2.1.1.9 (ii) d****Engineering by bidder as
per sub section IA
clause no. 2.1.1.9 (ii) e**

00-250-FS-4451-DA60

SECONDARY HYDROCYCLONE B O/F
B240-0045/4200-109-RPT-PVM-F-016
TO WASTE WATER STORAGE TANK
00 HTM 05 BB 001

00-200-GS-4452-DA60

SECONDARY HYDROCYCLONE B U/F
B240-0043/4200-109-RPT-PVM-F-016
TO FILTRATE WATER TANK
00 HTM 03 BB 001SECONDARY HYDROCYCLONE A O/F
B240-0045/4200-109-RPT-PVM-F-016
TO WASTE WATER STORAGE TANK
00 HTM 05 BB 001SECONDARY HYDROCYCLONE A U/F
B240-0043/4200-109-RPT-PVM-F-016
TO FILTRATE WATER TANK
00 HTM 03 BB 001

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.

PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)

FGD SYSTEM PACKAGE

BHARAT HEAVY ELECTRICALS LIMITED,
UNIT: BOILER AUXILIARIES PLANT,
RANIPET-632 406.

DEPT CODE	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
CHD	KABILASH K	29.12.20
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION

TITLE:

**P & ID-GYPSUM DE WATERING SYSTEM
(SECONDARY HYDRO CLONE)**

SCALE: NTS



NTPC DRG NO: 4200-109-RPT-PVM-F-016

SH 10 of 11

BHEL DRG NO

3-FW-000-04511

FILE NO

B240-00445

REV NO

00

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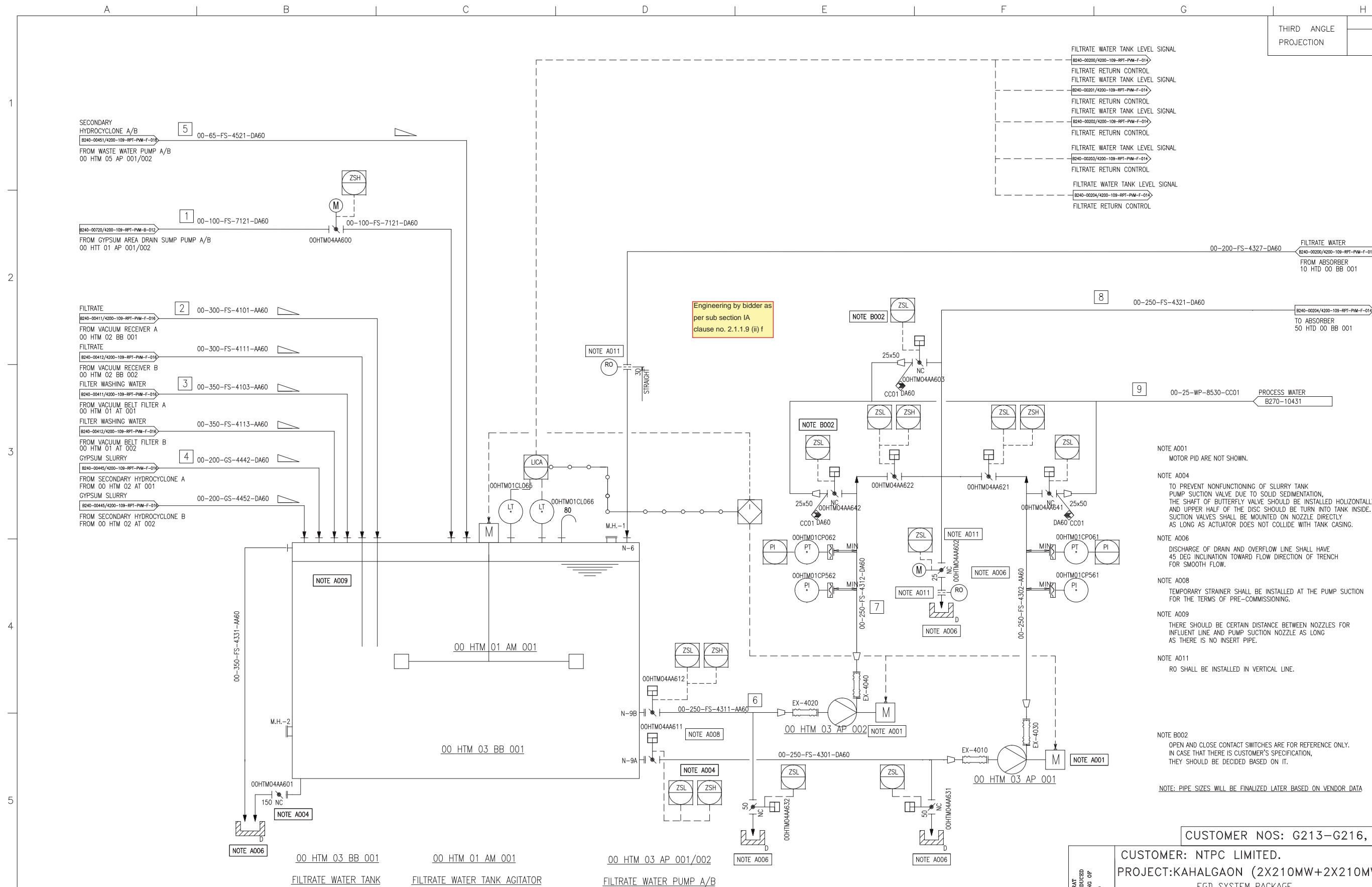
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A3

DRAWING No.

THIRD ANGLE
PROJECTION

No. REQ'D



S NO	SECTION	FLOW m ³ /hr	TEMP(°C)	DENSITY(kg/m ³)
1	Gypsum slurry from gypsum area drain sump pump	50	62	1214
2	Filtrate water from vacuum receiver	VENDOR DATA	VENDOR DATA	990
3	Wash Water from vacuum belt filter			
4	Underflow from sec waste water hydrocyclone	34.6	62	1257
5	Waste water slurry from waste water tank	13.3	62	1020
6	Suction line of filtrate tank pump	256	58.0	1072
7	Discharge line from filtrate pump	256	58.0	1072
8	Common discharge line to absorber	256	58.0	1072
9	Process water for flushing	3.0	45.0	990

CUSTOMER NOS: G213-G216, G512-G514

CUSTOMER: NTPC LIMITED.
PROJECT:KAHALGAON (2X210MW+2X210MW+3X500MW)
FGD SYSTEM PACKAGE

DEPT CODE	NAME (BHEL)	DATE
DRN	VIDYA V	29.12.20
CHD	KABILASH K	29.12.20
APPD	P.NAVEEN	29.12.20

MITSUBISHI HITACHI POWER SYSTEMS, LTD.
AIR QUALITY CONTROL SYSTEMS TECHNOLOGY DIVISION

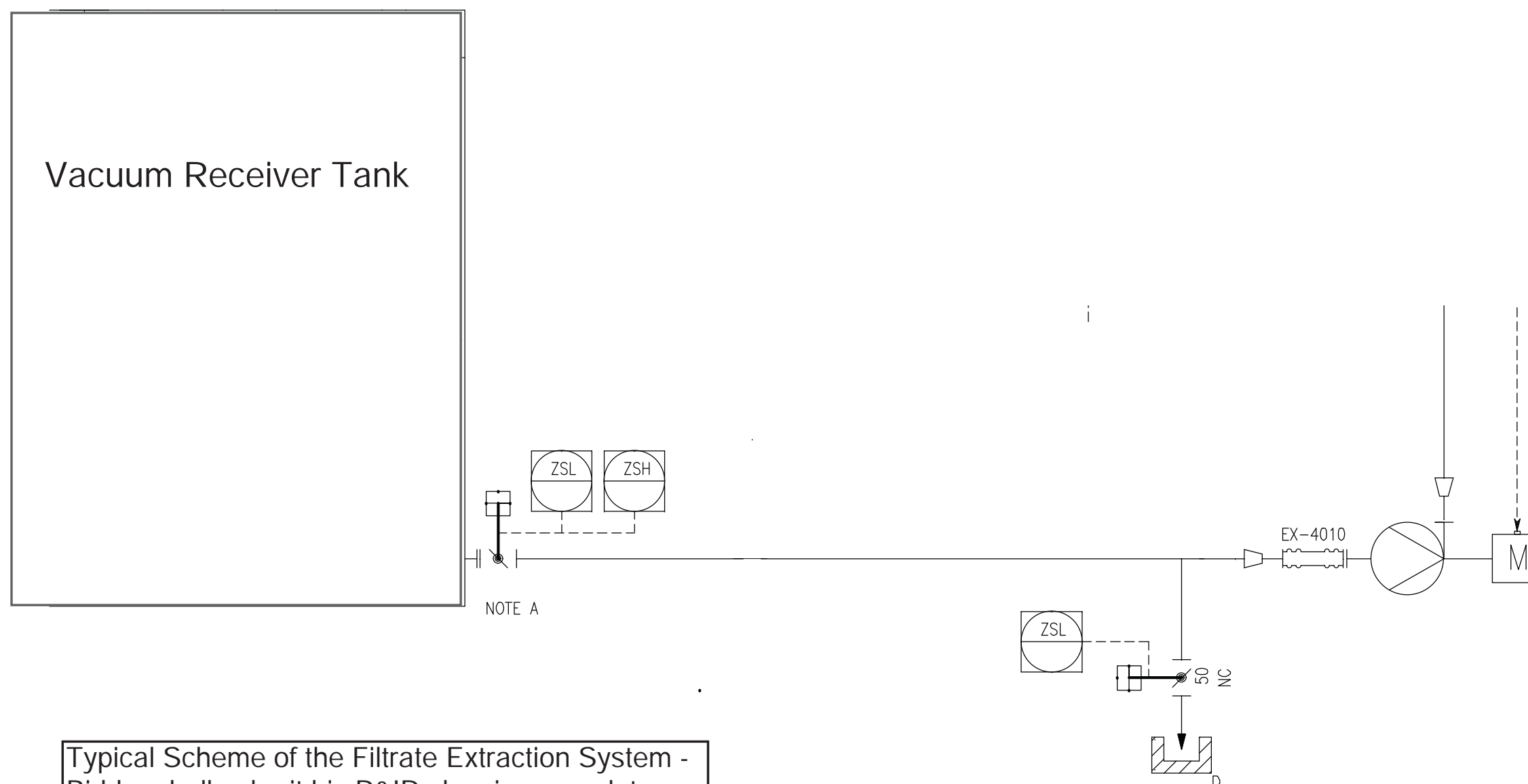
TITLE:
P & ID-GYPSUM DE WATERING SYSTEM
(FILTRATE WATER TANK)

SCALE : NTS

NTPC DRG NO: 4200-109-RPT-PVM-F-016 SH 11 of 11


BHEL DRG NO	FILE NO	REV NO
3-FW-000-04511	B240-00431	00

Bidder scope after the Pump Discharge is limited to the Engineering of the Piping up to the Filtrate Water Tank as per Clause 2.1.1.9 (ii) f of Sub-section C1, Section-I of this specification.



Typical Scheme of the Filtrate Extraction System - Bidder shall submit his P&ID showing complete arrangement for BHEL/Customer approval. Piping and Valves shall be rubber lined as per the details provided elsewhere in the specification.


Scheme No.: PE-FEP-00

	<div>KAHALGAON TPP FGD</div> <div>GYPSUM DEWATERING SYSTEM</div> <div>TECHNICAL SPECIFICATION</div> <div>MASTER DRAWING LIST WITH SCHEDULE OF SUBMISSION</div>	SPECIFICATION No: PE-TS-457-571-A001	
		ANNEXURE-V	
		REV 00	MAY 21

ANNEXURE-V


MASTER DRAWING LIST WITH SCHEDULE OF SUBMISSION

Primary Documents Marked ()**

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION MASTER DRAWING LIST WITH SCHEDULE OF SUBMISSION	SPECIFICATION No: PE-TS-457-571-A001	
		ANNUXURE-V	
		REV 00	MAY 21

Drawings/Drawings to be submitted by the bidder

Sl.No.	Document required after award of contract	No. of hard copies after award of contract	Submission time*
1.	Drawing Schedule	6	2
2.	Plot Plan & Layout	6	2
3.	Process Flow Diagram (**)	6	2
4.	Equipment List	6	2
5.	Utility Consumption	6	2
6.	Chemical List	6	2
7.	Duly filled technical datasheet (**)	6	2
8.	P & I Diagram (**)	6	2
9.	Performance Test Procedure & Report	6	8
10.	Outline Drawing of Equipments (**)	6	6
11.	Fabrication Drawing of Equipments	6	8
12.	Warranted Performance curve of Machinery	6	6
13.	Platform Drawing	6	6
14.	Line Index	6	6
15.	Piping Material Specification	6	6
16.	Piping Arrangement Drawing (**)	6	6
17.	Piping Support Arrangement Drawing	6	6
18.	Isometric Drawings	6	4
19.	Data sheet of Piping Parts	6	6
20.	Valve Drawing	6	8



KAHALGAON TPP FGD

GYPSUM DEWATERING SYSTEM

TECHNICAL SPECIFICATION

MASTER DRAWING LIST WITH SCHEDULE OF SUBMISSION


SPECIFICATION No: PE-TS-457-571-A001

ANNUXURE-V

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21.	Instrument Schedule List	6	8
22.	Instrument Function Loop Diagram	6	8
23.	Interlock and Operation Description	6	8
24.	Interlock/ Sequence Logic Diagram	6	8
25.	Instrument Power Supply Diagram	6	8
26.	Instrument Set Point List	6	8
27.	Instrument Data Sheet	6	8
28.	Valve Data Sheet, including On-Off Valve	6	8
29.	Nozzle Elevation Plan for Level Instrument	6	8
30.	Specification and Drawing of Instrument	6	8
31.	Instruction Manual for Instrument	6	12
32.	Local Control Panel Specification	6	8
33.	Local Control Panel Drawing	6	8
34.	Cable Duct/Tray Routing Plan	6	8
35.	Fabrication Drawing for Cabinet Duct/Tray	6	8
36.	Plot Plan of Field Instrument	6	8
37.	Layout of Instrument Wiring	6	8
38.	Layout of Instrument Air Supply Piping and Signal tubing	6	8
39.	Hook-up Drawing for Instrument	6	8
40.	Instrument Connection List	6	8
41.	Instrument Cable Schedule	6	8
42.	Parts Drawing for Instrument Installation Materials	6	8
43.	Calculation Sheet for Flow Instrument	6	8

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION MASTER DRAWING LIST WITH SCHEDULE OF SUBMISSION	SPECIFICATION No: PE-TS-457-571-A001	
		ANNEXURE-V	
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44.	Motor List (**)	6	8
45.	Motor Data Sheet (**)	6	8
46.	Outline drawing of Motors (**)	6	8
47.	Electrical Loading Data	6	8
48.	Drawing of Foundation of Equipment(s)	6	6
49.	Painting Specification	6	10
50.	Sub-Vendor List (**)	6	4
51.	Detail drawings indicating the dimensions of the equipments.	6	6
52.	Detail drawings indicating the piping layouts	6	6
53.	Detail drawing of Gypsum dewatering building (**)	6	6
54.	Erection drawings	6	8
55.	Operation & Maintenance (O&M) Manual	6	12
56.	Civil Loading details (**)	6	4

General Document(s) to be submitted by Bidder

Sl.No.	Document required after award of contract	No. of hard copies after award of contract	Submission time*
1.	Manufacturing Schedule	6	4
2.	Quality plan & Safety Requirement (**)	6	4
3.	Supply Item List for Package Verification at Site	6	12
4.	Packing List	6	12
5.	Transportation and Storage Specification	6	10
6.	Shop Inspection Specification	6	10
7.	Shop Inspection Report	6	12

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION MASTER DRAWING LIST WITH SCHEDULE OF SUBMISSION	SPECIFICATION No: PE-TS-457-571-A001	
		ANNEXURE-V	
		REV 00	MAY 21


8.	Site Inspection Specification	6	12
9.	Site Inspection Report	6	14
10.	Progress Report	6	4
11.	Consumable Parts List	6	6
12.	Lubricant List	6	6
13.	Special Tool List	6	6
14.	Spare Parts List for Erection	6	6
15.	Spare Parts List for Commissioning	6	8
16.	Spare Parts List for 2 years of Operation	6	8
17.	Construction Work Specification	6	10
18.	Construction Manual List	6	10


***Within No. of Weeks after the placement of LOI/PO**

**** The drawings marked (**) in the list may be considered as Primary.**

Notes:


- The above drawing list is tentative and shall be finalized with the successful bidder after placement of order. While some of the drawings indicated above may not be applicable, some additional drawings may also be required based on scope of work.
- Drawings shall be prepared in Auto-Cad latest edition. Required no. of hard and soft copies (editable) of the drawings shall be furnished as per requirement specified elsewhere in the specification.
- Only manual calculation with authentic supporting literature (e.g. extracts of hand Book/ standard/codes) shall be acceptable. All design calculations and drawings shall be in SI system only.
- All the drawings and documents including general arrangement drawing, data sheet, calculation etc. to be furnished to the customer during detailed engineering stage shall include / indicate the following details for clarity w.r.t. Inspection, construction, erection and maintenance etc.:
 - All drawings and documents shall indicate the list of all reference drawings including General Arrangement.
 - All drawings shall include / show plan, elevation, side view, cross-section, skin section, blow-up view; all major self-manufactured and bought out items shall be labeled and included in BOQ / BOM in tabular form.
 - Painting schedule shall also be made as a part of general arrangement drawing of each equipment / items indicating at least 3 trade names.

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION MASTER DRAWING LIST WITH SCHEDULE OF SUBMISSION	SPECIFICATION No: PE-TS-457-571-A001	
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<div>d) All the drawings required to be furnished to customer during detailed engineering stage shall include technical parameters, details of paints and lubrication, hardness and BOQ / BOM in tabular form indicating all major components including bought out items and their quantity, material of construction indicating its applicable code / standard, weight, make etc.</div> <div>e) Drawings/ documents to be submitted for purchaser's review/ approval shall be under Revision A, B, C... etc. while drawings /documents to be submitted thereafter for customer's approval after purchaser's approval shall be under R-0, 1, 2, 3 etc.</div> <div>f) Drawings and documents not covered above but required to check safety of machines/ system, shall be submitted during detailed engineering stage without any commercial implication.</div> <div>g) All drawings shall include "B.O.M" and indicate quantity, material of construction, make along with IS/BS No., Technical parameters, dimensions, hardness, machining symbol and tolerance, requirement of radiography and hydraulic tests, painting details, elevation, side view, plan, skin section and blow-up view for clarity.</div> <div>h) All drawings shall be prepared as per BHEL's title block and shall bear BHEL's drawing No. Documents marked for submission to BHEL's Customer shall also bear BHEL's Customer's drawing No.</div> <div>i) Schedule of drawings submissions, comment incorporations & approval shall be as stipulated in the specifications. The successful bidder shall depute his design personnel to BHEL's/ Customer's/ Consultant's office for across the table resolution of issues and to get documents approved in the stipulated time.</div> <div>j) Bidder to follow the following the drawing submission schedule:</div> <div>k) 1st submission of drawings from date of LOI as per the submission schedule.</div> <div>l) Every revised submission incorporating comments – within 7 days.</div> <div>m) Bidder to submit revised drawings complete in all respects incorporating all comments. Any incomplete drawing submitted shall be treated as non-submission with delays attributable to bidder's account. For any clarification/ discussion required to complete the drawings, the bidder shall depute his personal to BHEL for across the table discussions/ finalizations/ submissions of drawings.</div>			


	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
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ANNEXURE-VI

DOMESTIC PACKING PROCEDURE

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
		ANNEXURE-VI	
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1.0	PACKING AND FORWARDING
1.	<p>Proper packing to be ensured.</p> <p>Indigenous Supply: Gypsum Dewatering System & sub system assembly shall be wrapped in polythene bags & packed in a strong rigid wooden crate. Rain water should not enter into the pump internals during storage in the outer yard of power plant.</p> <p>Imported Supply: All imported supply should be packed as per Sea worthy packing standards Annexure-VII of this sub-section. All imported items should have Sea worthy packing. Liberal packing materials and struts shall be provided to arrest rolling and to protect from transit damages.</p>
2.	<p>Equipment and process materials shall be packed and semi-knocked down, to the extent possible, to facilitate handling and storage and to protect bearings and other machine surfaces from oxidation. Each container, box, crate or bundle shall be reinforced with steel strapping in such a manner that breaking of one strap will not cause complete failure of packaging. The packing shall be of best standard to withstand rough handling and to provide suitable protection from tropical weather while in transit and while awaiting erection at the site.</p>
3.	<p>Equipment and materials in wooden cases or crates shall be properly cushioned to withstand the abuse of handling, transportation and storage. Packing shall include preservatives suitable to tropical conditions. All machine surfaces and bearings shall be coated with oxidation preventive compounds. All parts subject to damage when in contact with water shall be coated with suitable grease and wrapped in heavy asphalt or tar impregnated paper.</p>
4.	<p>The entire system has to be supplied in containers and it should be suitable for storing in the outer yard of the plant for a minimum period of 12 months. Crates and packing material used for shipping will become the property of owner (NPGCL).</p>
5.	<p>Packaging or shipping units shall be designed within the limitations of the unloading facilities of the receiving ports and the ship will be used. It shall be the bidder’s responsibility to investigate these limitations and to provide suitable packaging and shipping to permit transportation to site.</p>
6.	<p>Packing (tare) shall be part of the equipment cost and shall not be subject to return. The packing should ensure integrity and cohesiveness of each delivery batch of equipment during transportation. In case of equipment assemblies and unit’s delivery in the packing of glass, plastics or paper the specification of packing with the material and weight characteristics are to be indicated.</p>
7.	<p>Each package should have the following inscriptions and signs stenciled with an indelible ink legibly and clearly:</p> <ul style="list-style-type: none">a. Destinationb. Package Numberc. Gross and Net Weightd. Dimensionse. Lifting placesf. Handling marks and the following delivery marking

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8.	<p>Each package or shipping units shall be clearly marked or stenciled on at least two sides with the DETAILED SHIPPING ADDRESS –TO BE PROVIDED LATER.</p> <p>In addition, each package or shipping unit shall have the symbol painted in red on at least two sides of the package, covering one fourth of the area of the side.</p>		
9.	<p>Each part of the equipment which is to be shipped as a separate piece or smaller parts packed within the same case shall be legibly marked to show the unit of which it is part, and match marked to show its relative position in the unit, to facilitate assembly in the field. Unit marks and match marks shall be made with steel stamps and with paint.</p>		
10.	<p>Each case shall contain a packing list showing the detailed contents of the package. When any technical documents are supplied together with the shipment of materials no single package shall contain more than one set of such documents. Shipping papers shall clearly indicate in which packages the technical documents are contained.</p>		
11.	<p>The case number shall be written in the form of a fraction, the numerator of which is the serial number of the case and the denominator the total number of case in which a complete unit of equipment is packed.</p>		
12.	<p>Wherever necessary besides usual inscriptions the cases shall bear special indication such as “Top”, “Do not turn over”, “Care” , “Keep Dry” etc. as well as indication of the center of gravity (with red vertical lines) and places for attaching slings (with chain marks).</p>		
13.	<p>Marking for Safe handling: To ensure safe handling, packing case shall be marked to show the following:</p> <ul style="list-style-type: none"> a. Upright position b. Sling position and center of Gravity position c. Storage category d. Fragile components (to be marked properly with a clear warning for safe handling) 		
14.	<p>Each crate or package is to contain a packing list in a waterproof envelope. All items are to be clearly marked for easy identification against the packing List. All cases, packages etc. are to be clearly marked on the outside to indicate the total weight where the weight is bearing and the correct position of the slings are to bear an identification mark relating them to the appropriate shipping documents. All stencil marks on the outside of cases are either to be made in waterproof material or protected by shellac or varnish to prevent obliteration in transit.</p>		
15.	<p>The packing slip shall contain the following information: -</p> <p>Customer name, Name of the equipment, Purchase Order number with Date, Address of the delivery site, Name and Address of the Sender, Serial Number of pump & accessories, BHEL item Code, Gross Weight and Net weight of Supplied items.</p>		
16.	<p>Prior to transport from manufacturer’s work to destination, components of the unit shall be completely cleaned to remove any foreign particles. Flange faces and other machined surfaces shall be protected by an easily removable rust preventive coating followed by suitable wrapping.</p>		
17.	<p>All necessary painting, corrosion protection & preservation measures shall be taken as specified in painting schedule. Supplier shall consider the coastal environment zone which is defined as “very severe” during final finishing/shipping.</p>		
18.	<p>Successful bidder shall furnish the detail packing /shipment box details with information like packing box size, type of packing, weight of each consignment, sequence no. of dispatch, no. of consignment for each deliverable item against each billing break up units/ billable blocks. Without these details the BBU shall not be approved during detail engineering.</p>		

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
		ANNEXURE-VI	
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	Also, complete billing break-up with above mentioned details shall be submitted to Purchaser within 10 days of placement of the LOI.
19.	All items/equipment shall be dispatched in properly packed condition (i.e. no item shall be dispatched in loose condition such that it becomes difficult to store/identify its location at site at a later stage).
20.	Cases which cannot be marked as above shall have metal tags with the necessary markings on them. The metal tags shall be securely attached to the packages with strong steel binding wire. Each piece, Skid, Case or package shipped separately shall be labelled or tagged properly.

	<h1 style="text-align: center;">CORPORATE STANDARD</h1>	AA0490010
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DOMESTIC PACKING

COMMON GUIDELINES

1 GENERAL:

This standard lays down packing instructions for domestic packing of Components/ Assemblies/ Equipment to be despatched against Customer's contracts, for which there are no special instructions issued by the Engineering Departments. For Seaworthy Packing refer standard AA0490004 wherever applicable.

The Components/Assemblies need to be packed suitably to avoid physical damage & corrosion during transit & storage. For specific applications the concerned engineering department shall issue a product standard. Reference of this product standard, must appear in the Shipping list/Packing List.

2 SCOPE:

This procedure gives minimum guidelines to be complied with for domestic packing of Components /Assemblies/ Equipment. This domestic packing shall be suitable for different handling operations and for the adverse conditions during transportation and during indoor / outdoor storage of materials.

3 WOOD SPECIFICATION

Based on availability, the wood shall conform to specification AA51401 or AA51402.

4 TYPES OF PACKING:

The following 5 types of packing have been standardized for packing of General Components/ Assemblies.

- 1) 'OP' - Open Type.
- 2) 'PP' - Partially Packed.
- 3) 'CP' – Crate/Box Packing - Components/Equipment requiring physical protection.
- 4) 'CQ' - Case Packing – Machined components-Small & Medium Components/ Assemblies/ Equipment which require corrosion & physical protection.
- 5) 'CR' - Case Packing – Electrical/Electronic Components/ Assemblies, which require special packing viz. Water Proof, Shock Proof etc...

5 DESCRIPTION OF TYPES OF PACKING:

The various types of packing, as standardized above, are described below.

5.1 'OP' - Open Type

In case, of components which are not affected by water & dust and do not require special protection, are generally not machined, shall be sent as open packages. However, these components may be sent in crates, wherever necessary.

5.2 'PP' - Partially Packed

Components which need special protection at selected portions only shall be despatched partially packed. Machined surfaces should not be allowed to come directly in contact with the wood. Such surfaces should be protected with 100GSM(Colourless) Multi Layered Cross Laminated Polyethylene

Revisions:			APPROVED: PROCEDURAL GUIDELINES COMMITTEE – PGC (Packing)		
Rev. No. 02	Amd. No.	Reaffirmed	Prepared HPBP, Trichy	Issued Corp. R&D	Dt. of 1 st Issue 31-05-2018
Dt: 28-08-2018	Dt:	Year:			

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CORPORATE STANDARD

Film to Specification No. AA51420. All sharp corners and edges shall be protected by rubber mats to prevent damage to the polyethylene film

5.3 'CP' - Crate Packing

Assemblies/Components which need only physical protection from the point of view of handling shall be despatched duly packed in crates.

5.4 'CQ' - Case Packing - Machined Components/Assemblies/Equipment

Small and medium sized components/assemblies/equipment due to size/weight and to avoid handling and pilferage problems shall be packed in Case/Containers. Wherever required adequate quantity of silica gel to AA55619 or VCI Powder/Tablets, packed in thin muslin cloth cotton bags shall be suitably placed. Small machines/components of less weight shall be provided with suitable cushioning by Rubberised coir. The components inside the case shall be entirely covered with 100GSM(Colourless) Multi Layered Cross Laminated Polyethylene Film Specification No. AA51420, wherever required. This may be prescribed for electronic parts/critical machined components/surfaces.

For mechanical product like valves where motors are separately securely wrapped in polyethylene, the requirement of individual component wrapping shall be exempted.

5.5 'CR' - Case Packing - Electrical & Electronic Components/Assemblies

Delicate components likely to be damaged e.g. Gauges, Instruments etc. are to be wrapped in waxed paper or polyethylene air bubble film and packed in cartons. Adequate quantity of Silica gel to AA55619 packed in cotton bags of 100grams each are to be suitably placed in the cartons. The cartons shall be entirely covered with 100GSM(Colourless) Multi Layered Cross Laminated Polyethylene Film Specification No. AA51420 before being packed in the cases. VCI Powder/Tablets can be used as an alternative to Silica Gel to AA55619.


Empty space in the cartons shall be filled with rubberized coir to get proper cushioning effect. The cartons shall be manufactured from corrugated Fiber Board, meeting requirements of AA51414.

6 PREPARATION OF PACKING CASES**6.1 DIMENSIONS:**

- Thickness of planks for Front, rear, top and bottom sides and binding, jointing battens shall be 25/20mm +2/-3 mm as per applicable drawings of the respective units.
- Width of all planks including the tongue shall be more than 125mm and after planing it shall be minimum 100mm.
- Minimum number of planks shall be used for a shook.
- Horizontal, vertical, diagonal planks shall be given for binding (number of such planks depend on the dimension of panel).
- Width of binding planks shall be minimum 100mm.
- Distance between any 2 binding planks shall be less than 750mm.
- diagonal planks shall be used in between vertical binding planks when distance between inner to inner of vertical planks is more than 750mm
- Distance of the outer edges of these planks from the edge of case shall be less than 250mm.
- Diagonal planks are not required for top planks and width side, if the width of pallet is less than 750mm.

6.2 JOINTING OF PLANKS

Single length planks shall be used for cubicles whose overall length is less than 2400mm. For cubicles of length more than 2400mm, jointing is permitted. The jointing shall be done with one single or maximum of 2 planks of wood same as other planks of width 250 mm (minimum) with two rows of nails on either side of the joint in zigzag manner. From the joint along height side, it shall be of lap joint with overlap of at least the width of plank.

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6.3 TONGUE AND GROOVE JOINTS

Two consecutive planks shall be joined by tongue and groove joint. Depth of tongue shall be 12+1 mm, thickness of tongue shall be 8 +1 mm. The groove dimensions shall be such that the tongue fits tightly into the groove to make a good joint. This type of joint can be done based on the product requirement wherever required.

6.4 PERMISSIBLE DEFECTS

Wood shall be free from knots, bows, visible sign of infection and any kind of decay caused by insects, fungus, etc.

End splits: Longest end splits at each end shall be measured and lengths added together. The added length shall not exceed 60mm per meter run of shook's. Wood pins shall be used to prevent further development of split.

Surface cracks: Surface cracks with a maximum depth of 3mm are permissible. A continuous crack of any depth all along the length is not allowed.

6.5 OTHER MATERIALS

6.5.1 NAILS

The dia. of the nails shall be 3.15mm. The length of the nails shall be 65mm wherever two planks of 25mm thickness are joined and 75mm wherever a 25mm planks is joined to a 50mm plank.

6.5.2 BLUE NAILS

These are used for nailing bituminized Kraft paper/hessian cloth to the planks. The length of the nails shall be 16mm.

6.5.3 HOOP IRON STRIPS

These are used for strapping the boxes. The width of the strips shall be 19+1mm and thickness 0.6+0.01mm. The material shall be free from rust.If sufficient nailing is done for bigger boxes, strapping need not be done.

6.5.4 CLIPS

These shall be used for strapping the hoop iron strips on the boxes.

6.5.5 BRACKETS

These brackets are used for nailing to the corners of cubicle boxes. The brackets shall be of mild steel of thickness min 2mm and width 25+1mm. The brackets shall be of "L" shape, the length of each side being 100+2mm. Two holes shall be provided towards the end of each side for screwing /nailing.

6.5.6 FASTENERS

Bolts, double nuts, spring washers will have to be used for packing of some special items like transformers, reactors, breakers, etc., to hold the job to the bottom plank of the box. The bolts, nuts, washers will be provided by the vendor. Drilling of holes will have to be done using contractor's tools.

6.5.7 MULTI LAYERED CROSS LAMINATED POLYTHELENE FILM

100GSM (Colourless) Multi Layered Cross Laminated Polythelene Film Specification No: AA51420 are used to make covers to the jobs individually. The cross lamination gives qualities of extra toughness, together with flexibility and lightness coupled with good weather resistance to ultra violet rays.

6.5.8 RUBBERISED COIR:

The rubberized coir is used as cushioning material. For the packing of loose items, items are to be arrested by using rubberized coir. For the packing of cubicles rubberized coir of thickness 25mm and width 75mm shall be used.

6.5.9 FOAM RUBBER / 'U' FOAM:

This is used for covering the delicate items. This material is provided by the vendor.

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CORPORATE STANDARD**6.5.10 MARKING PLATE:**

This shall be of anodized aluminium sheet. Size of the marking plate shall be maintained minimum of size as per the details specified in the Figure 4.

6.5.11 PACKING SLIP HOLDER:

This shall be of galvanized iron tinned sheet /Aluminium sheet

6.5.12 SILICA GEL:

This shall be of indicating type to conform to IS: 3401/AA55619. Silical gel shall be used for such products only where moisture needs to be avoided.

6.5.13 COTTON BAGS:

These are used for holding silica gel. The bags shall have the following matter indicated on them:

BHEL-UNIT NAME	PLACE-PINCODE
SILICA GEL	INDICATING TYPE
BLUE :	ACTIVE
ROSE :	REDUCED ACTIVITY
WHITE :	NO ACTIVITY. TO BE REPLACED WITH FRESH SILICA GEL

6.5.14 COTTON/ PLASTIC TAPE:

This is used for tying small items. And also to prevent vibrations of moving parts within the cubicles.

6.5.15 MARKING INK:

The ink used normally is black in color. In some special cases other color also will have to be used. The ink shall be non-fading/indelible and non-washable by water.

6.5.16 POLYETHYLENE BAGS:

These are to be used for keeping the Packing slips. The bag shall be of size 70mm X 100mm (minimum).


6.5.17 Hessian cloth, twine thread, paint will have to be used in packing certain items.**6.5.18 Mechanical Latching clamps:**

For CLW Railway panels and similar Panels self-locking clamps can also be used on need basis in conjunction with or apart from regular bolt and nut fixing arrangement. For reusable boxes, these clamps provide easy locking and unlocking arrangement. These clamps will be made available from BHEL in some cases.

6.5.19 STICKERS

The following stickers to be put by the vendor on cubicles/Boxes after packing.

- 1) Case No sticker: 2 nos. Size 25.Cm x 0.45Cm
- 2) BHEL Monogram sticker: 1 no. Size 1.75Cm x 2.3Cm
- 3) Address sticker: 2 nos. Size 3.8Cm x 3.0Cm
- 4) Direction sticker "Front" & "Back" - 4 nos. Size 2.0Cm x 0.75Cm
- 5) Chain Mark Sticker: 4 Nos. Size – 3.0Cm x 0.75Cm
- 6) "Fragile" sticker: 2 Nos. Size. 2.1Cm x 1.5Cm
- 7) "DO NOT STACK" sticker - 2 Nos. Size 3.0Cm x 2.2Cm

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In place of stickers, writing all the details legibly with paint shall be allowed & respective units may take decision accordingly.

7 PACKING OF CUBICLES:

7.1 The packing is to be done as per clause 5 in all respects.

7.2 The cubicles are already fixed on wooden pallets. Hence the contractor need not arrange the bottom pallets normally.

7.3 The cubicles will be of different sizes both width wise and lengthwise. The cubicles may be made up of single suite, 2 Suite, 3 Suite, 4 Suite, etc., The width of the cubicles generally varies from 400 mm to 1650mm. The length of the cubicle, generally varies from 1500 mm to 4800 mm. The height is normally 2430 mm. In some cases, the height may be less/more.

7.4 MULTI LAYER CROSS LAMINATED POLY FILM

The inner surface of 4 sides of shoo's shall be nailed with Multi-layer cross laminated poly film (as per 6.5.7) using blue nails (as per 6.5.2) wherever 2 pieces of Cross laminated poly film are used, the joint shall have an overlap of minimum 20mm.

The inner surface of top cover shall be nailed with Multi-layer cross laminated poly film (as per 6.5.7). This sheet shall project outside on 4 sides by at least 100mm and shall be nailed properly on sides. Joining of sheets should have overlap of minimum 20mm.

The cubicles shall be covered with Multi-layer cross laminated poly film (as per 6.5.7).

7.5 SILICA GEL:

Silica gel (as per 6.5.12) packed in cotton bags shall be kept at different places inside the cubicle as per BHEL-Unit directions. Each suit of cubicle shall be provided with 1 kg of Silica gel (for a 4 suit cubicle 4 kgs of Silica Gel to be used. The bag containing silica gel to be as per 6.5.13).

7.6 LOOSE PARTS:

Any loose parts in the cubicles shall be tied using cotton/ plastic tape. Wooden battens shall be provided wherever necessary.

7.7 WOODEN BATTENS:

In case of cubicle which are not rectangular in shape like control desks, sufficient number of wooden rafters/battens of proper size shall be provided to give strength to the package.

7.8 RUBBERISED COIR:

Gap between the cubicle and the case shall be filled with rubberized coir (as per 6.5.8) with distance between consecutive layers less than 500mm.

7.9 CLAMPING:

Packing shall be bound at edges by nailing M.S. Clamps / Brackets (as per 6.5.5). Each vertical edge shall have minimum 3 clamps. Top horizontal edges will have one clamp for every meter length of package. However, minimum 4 clamps shall be nailed at the top for any cubicle.

7.10 PACKING SLIP:

Packing slip kept in the polyethylene bag (As per 6.5.16) shall be placed in the box at appropriate place. In addition, one more packing slip covered in polyethylene cover and packing slip holder (as per 6.5.11) shall be nailed to front / rear of case.

7.11 MARKING PLATE:

One no. (As per 6.5.10) shall be nailed to the front side of the case.

7.12 CASE MOUNTING:

After complete packing, stencil marking of various details and marking of symbols shall be done as per BHEL instructions using indelible / non washable marking ink.

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CORPORATE STANDARD**7.13 Different types (Typical) of Cubicles with sizes for Packing**

1. Single suite cubicle - 900 x 950 x 2500
2. Two suite cubicle - 1650 x 950 x 2500
3. Three suite cubicle - 2400 x 950 x 2500
4. Four suite cubicle - 3150 x 950 x 2500
5. Regulation cub - 1300 x 1350 x 2500
6. Thy cub - 2870 x 1350 x 2500
7. VFD Cub - 3800 x 1550 x 2500

7.14 PACKING OF CUBICLES FOR EXPORT

Refer Corporate Standard AA0490009.

8 PACKING OF LOOSE ITEMS/SPARES

- 1) Shape of cases shall be square, rectangular with single gabled roof or with double gabled roof depending on the nature of the job to be packed. Construction shall be as per drawings enclosed. Only gable will be additional as required.
- 2) Wood shall conform to specification AA51401 or AA51402 with Tongue and Groove joint as per clause 6.3.
- 3) Width of planks shall be at least 100 mm. Width of binding planks (battens) shall be at least 75mm.
- 4) External surface of planks on front and rear shall be plane 100% (except bottom plank).
- 5) Inner surfaces of all 6 sides shall be lined with Multi Layered Cross Laminated Polythelene Film (as per clause 6.5.7) using blue nails.
- 6) Rubberized coir of minimum 25mm thickness and 100 mm width shall be nailed to inner surfaces of bottom and 4 sides of box.
- 7) Internal packing: Items that go into the box shall be packed using 100GSM, (Colourless) Multi Layered Cross Laminated Polyethylene Film Specification No: AA51420. Any space left between the job and the sides and the top of the box shall be filled with rubberized coir to get proper cushioning effect.
- 8) Certain items like transformers, reactors, breakers, etc., shall be bolted to the bottom of the box using bolts, nuts and washers.
- 9) Silica gel as per clause 6.5.12 held in cotton bags as per clause 6.5.13 shall be kept at proper places in the box.
- 10) Packing slip kept in polyethylene bag (clause 6.5.16) shall be placed in the box.
- 11) Marking plate as per clause 6.5.10 shall be nailed to side of the box.
- 12) Two numbers of hoop iron strips as per clause 6.5.3 shall be strapped tightly on the case using clips.
- 13) Stencil marking of various details and marking of various symbols shall be done as per BHEL instructions using indelible/non-washable marking ink.
- 14) Loose items to be kept inside the cubicle
 - The components which are removed from cubicle for shipping purpose only, such as meters shall be kept inside the cubicle individually, kept in wooden box and tied firmly in bottom of Cubicle.
 - Other items which are given loose in addition to cubicle shall be packed in separate boxes.

9 BOX SIZES**9.1 BOX SIZES**

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Table 1 – SPARES WOODEN BOX DETAILS

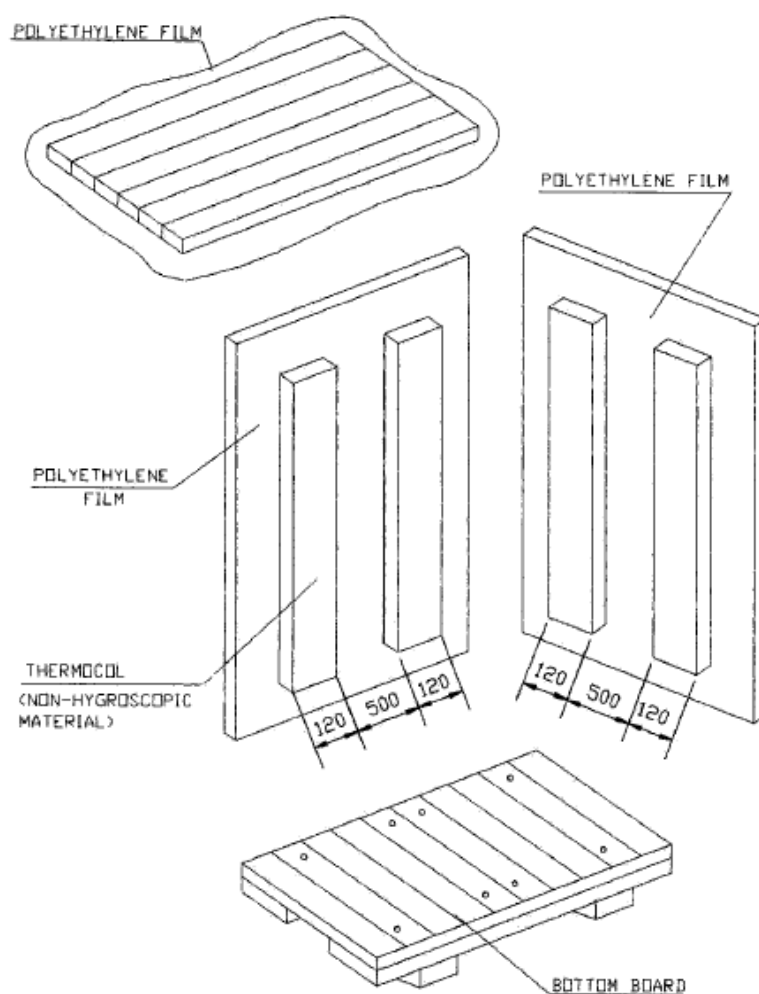
SNO	BOX TYPE	BOX SIZE (in mm)	BOX Wt (in KG)	Carrying Capacity
1	A	800 X 200 X 200	15	
2	B	1500 X 200 X 200	22	
3	C	2000 X 200 X 200	27	
4	D	1100 X 200 X 200	15	
5	E	200 X 200 X 200	5	
6	F	320 X 250 X 260	13	
7	G	320 X 250 X 430	16	
8	H	430 X 370 X 430	23	
9	I	1100 X 400 X 400	45	
10	J	1500 X 500 X 400	65	
11	K	2000 X 500 X 400	93	
12	L	2500 X 500 X 400	88	
13	M	900 X 600 X 600	100	
14	N	3000 X 400 X 400	60	
15	P	600 X 500 X 400	35	
16	Q	710 X 630 X 600	90	
17	R	850 X 630 X 670	102	
18	S	1000 X 770 X 670	140	
19	T	2500 X 850 X 800	180	
20	U	1500 X 700 X 700	120	
21	W	1200X900X600	120	
22	Y	450 X 200 X 200	10	

Table 2 – WOODEN BOX DETAILS

BOX TYPE	BOX SIZE (in MM)	BOX Wt (in KG)	Carrying Capacity
1	320X250X260	10	
2	320X250X430	15	
3	430X370X430	25	
4	670X670X470	65	
5	720X630X600	75	
6	1000X770X660	100	
7	1100X430X670	80	
8	1200X1200X900	80	
9	1300X770X1050	155	
10	2500X850X800	225	
11	2000X1500X1200	305	
12	1850X1050X1250	260	
13	2000X800X800	180	
14	2600X1500X1600	470	
15	250X250X600	20	
16	250X250X880	30	
17	300X300X700	25	
18	380X380X880	45	
19	510X510X1400	60	
20	570X570X1400	80	
21	575X575X1875	105	
22	3600X1100X1100	390	
23	900X500X800	110	
24	2000X950X740	225	
25	1600X1120X700	220	
26	2500X2000X1200	490	
27	2900X1900X1400	525	
28	3000X1000X900	370	
29	3200X2200X950	450	
30	2150X1100X750	325	
31	2000X2000X700	130	
32	700X1200X1325	130	

CORPORATE STANDARD**Table 3 – STEEL BOXES**

SL NO	TYPE	DIMENSION IN MM			WEIGHT	CARRYING CAPACITY (KGS)
		LENGTH	BREADTH	HEIGHT		
1	I	2480	1680	1500	339	4500
2	II	1200	900	600	061	2000
3	IIB	1800	850	950	115	2500
4	III	900	600	600	029	1000
5	IV	600	450	500	019	750
6	V	400	350	300	011	500

TYPICAL PATTERN OF WOODEN BOX**Figure 1**

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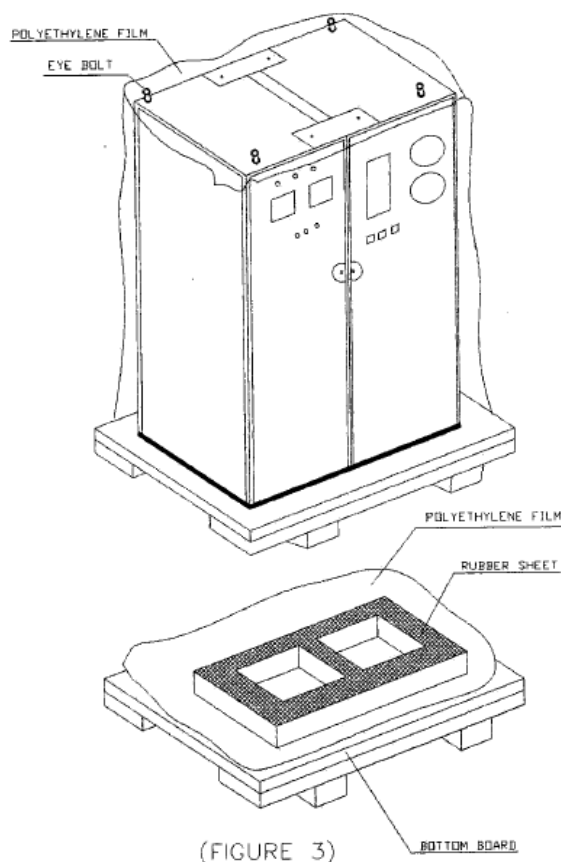


Figure 2

9.2 STEEL CONTAINERS:

Steel containers for packing can be used in case of repeated supplies of the same equipment. Empty steel containers are to be returned back from customer's end and to be reused for the next supplies. The containers are to be made of structural steel as per AA10108 with proper reinforcement with I, C and T Sections. Depends on the availability of resources & requirements units may be allowed to use standard cargo containers also instead of fabricated steel boxes.

- a) Following precautions are to be taken during packing: -
- b) Put the machine in the steel container properly,
- c) Cover the machine with polythene.
- d) To arrest the movement in the steel container necessary wooden Blocks/Battons may be put.
- e) Put cover on steel, container and Bolt Properly

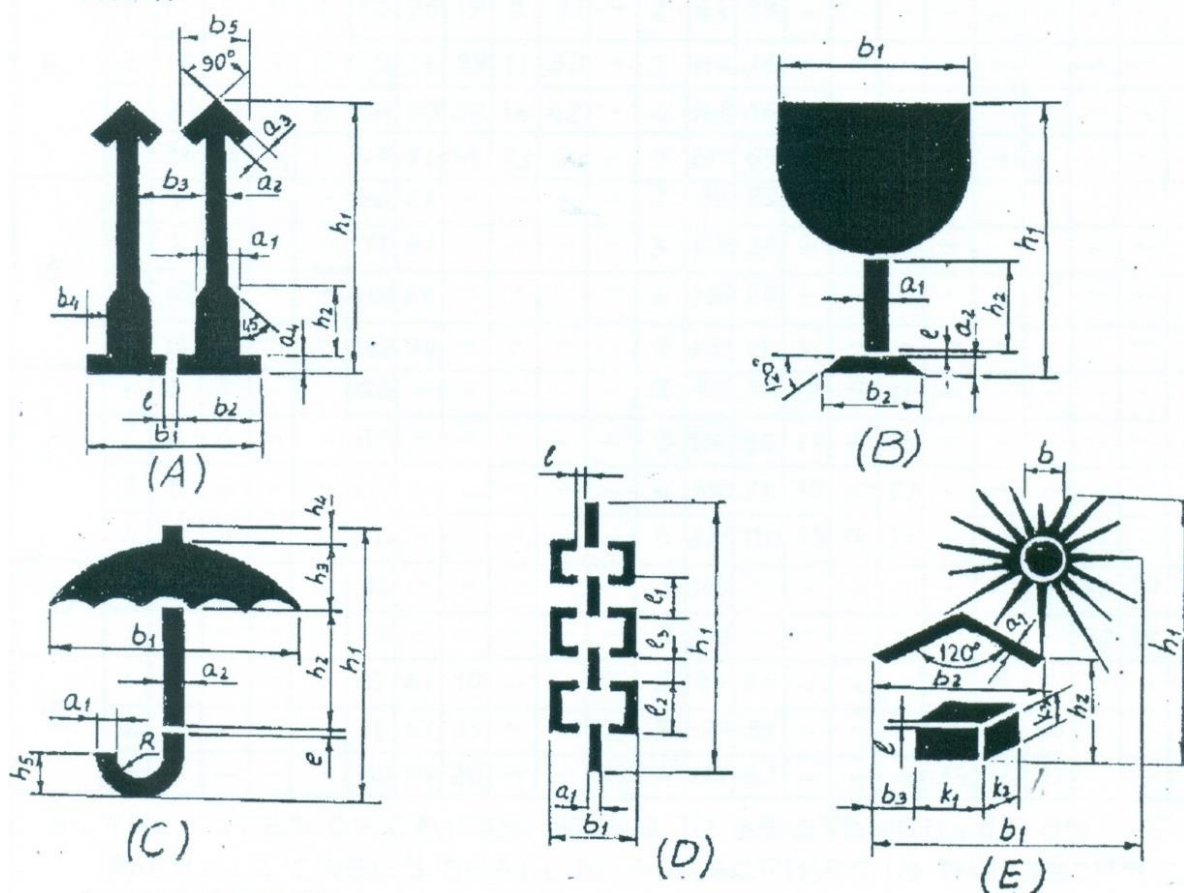
9.3 SEALED PACKING:

Components sub-assemblies and assemblies sensitive to climatic conditions shall be packed seal tight. All the openings of the sensitive components, sub-assemblies and assemblies shall be blanketed to prevent the ingress of dust and moisture. The components sub-assemblies and assemblies are completely covered with 2 layers of polyethylene sheet. All sharp corners and edges are to be protected by rubber mats to prevent the polyethylene sheet from damage. Top surface of the case shall be free from dents to prevent rain water pockets.

10 MARKINGS/STENCILINGS

MARKINGS ON PACKING CASES

1. THIS PLANT STANDARD PRESCRIBES THE VARIOUS CAUTION SIGNS AND OTHER MARKINGS ON PACKING CASES.
2. DIMENSIONS IN THE TABLE 1 SHALL BE USED FOR MAKING STENCILS ONLY.



- A. UPRIGHT
- B. FRAGILE
- C. PROTECTION FROM FALLING OR CONDENSING MOISTURE.
- D. SLINGING POSITION
- E. PROTECTION FROM DIRECT RADIATIONS.



Figure 3

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Table 4

Black and Red Marking Ink to IS:1234 "Ink, Stencil, Oil Base, For Marking Porous Surfaces" or duplicating ink stencilling, oil base for marking porous surfaces.

All cases containing fragile items are to be stencilled with red marking and stencilling paint/ink

"HANDLE WITH CARE", "FRAGILE DO NOT TURN OVER".

Besides the caution signs the product information's shall be stencilled of letters with 13mm to 50mm height.

In case of consignment consists of more than one package, each package shall carry its package no as given in shipping list. All caution signs shall be stencilled in high quality full glossy out door finishing paint red in colour (AA56126). All other markings shall be carried out in black enamel(AA56126).

Caution signs & other markings shall be stencilled on both the end shooks & the side shooks.

Caution sign (for slinging) shall be stencilled only on side shooks at the appropriate place.

Note: Incase the size of package is small for using the stencils, then hand written letters/figures shall be allowed.

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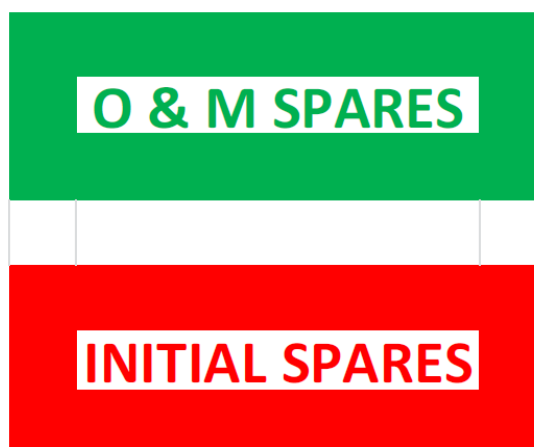
	BHEL – <unit> - <location> - <pin>				
CONSIGNEE					
MATERIAL					
CUSTOMER REF.				MO. NO.	
DESPATCH ADVICE NOTE NO				CASE NO	
DIMENSIONS(MM) L x B x H				NET WT –KGS	GROSS WT –KGS
SPECIAL INSTRUCTIONS	HANDLE WITH CARE - KEEP DRY DO NOT DROP - DO NOT TILT				

Figure 4 – TYPICAL MARKING PLATE (225 X 170)**Figure 5**

Easy spares [Initial and O&M] Traceability and Identification at units and as well as at sites:

11 RECYCLING OF INCOMING WOODEN PACKING CASES**OBJECTIVES**

- To utilize useable wood of incoming packing cases, for manufacturing of new packing boxes.
- To recycle incoming wooden packing cases, as such, wherever possible.

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- 1) All incoming wooden packing cases received from suppliers /customers will be opened carefully, with the intention of reusing them, by Shop.
- 2) After carefully taking out the contents, the empty wooden packing cases will be shifted by Shop to the specified locations i.e. bin / nearly spaces, already earmarked in stores.
- 3) Material shifting contractor engaged by store, will collect all such wooden packing cases and scrap wood from specified points, on a regular basis.
- 4) After collecting / loading the empty packing cases/ scrap wood, contractor will take the carrier first to Weighment Bridge for weighment, thereafter; he will go to Carpentry, where Carpentry representative will identify the packing cases which can be used by Carpentry for manufacturing of New Packing Boxes. All such identified packing boxes will be unloaded and handed over to Carpentry by contractor.
- 5) These packing boxes will be made re-useable after necessary rectification and additional work.
- 6) Contractor will again take the carrier for weighment and this second reading will also be recorded on the same "Weighment Slip".
- 7) Weight of empty packing cases / scrap wood taken will be calculated on the basis of 1st and 2nd weighment readings recorded on the "Weighment Slip". A copy of "Weighment Slip" (where both the weighment readings are recorded) will be given by the contractor to the carpentry representative. Based on this "Weighment Slip", carpentry will maintain a register in which details of quantity received will be recorded.
- 8) All "Weighment Slips" will invariably be signed by carpentry representative (even when no boxes have been unloaded by carpentry). Store will accept the scrap wood only if "Weighment Slips" are signed by carpentry representative.
- 9) Balance empty packing cases / scrap wood will be handed over by contractor to Store, for storing in scrap yard.
- 10) A separate area in Scrap yard will be provided, for executing the work of denailing of wooden packing cases, under supervision of carpentry.
- 11) Carpentry contractor will identify packing cases / scrap wood for denailing, which will be handed over to him by Store, at Scrap yard, for denailing and further operation.
- 12) Quality and Carpentry will jointly inspect the wood generated by de-nailing process and will prepare "INSPECTION CUM RECEIPT REPORT OF USEABLE WOOD RECEIVED FROM TPS – STORE BY CARPENTRY".
- 13) After acceptance of the wood by Quality and Carpentry, the same will be shifted to carpentry for receipt and its record will be maintained by carpentry.
- 14) This will be a Permanent Productivity Project executed by carpentry. "Productivity Savings" duly verified at the current Purchase Order rate of wood, will be sent every month to Resource Management Department, for highlighting it in their monthly progress report.

12 STANDARD METHOD OF PACKING

Table 5 - Standard Method of Packing

DESCRIPTION	CASE	CRATE	SKID	BUNDLE	BARE	DRUM	METAL DRUM	FIBRE DRUM
PRESSURE VESSELS								
TOWERS					O			
TANKS					O			
VESSELS					O			
GASKETS	O							
FASTENERS	O							
COVERS		O						
EXCHANGERS								

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DESCRIPTION	CASE	CRATE	SKID	BUNDLE	BARE	DRUM	METAL DRUM	FIBRE DRUM
HEAT EXCHANGERS					O			
TUBE BUNDLE	O							
SHELL					O			
AIR FIN COOLERS					O			
COLOUMNS, MOTOR SUSPENSIONS, PLENUM CHAMBERS, SCREEN GUARDS, ETC					O			
BEARING BLOCKS	O							
FANS	O	O						
MOTORS	O							
GASKETS	O							
FASTENERS	O							
TEST FLANGES			O					
TEST RINGS			O					
COVERS			O					
CRYOGENIC VESSELS								
COLD CONVERTERS					O			
HORIZONTAL STORAGE TANKS					O			
TRANSPORTATION TANK					O			
COLD BOX					O			
DRYING UNIT					O			
DRYING BOTTLES					O			
MOISTURE SEPARATORS					O			
SILENCERS					O			
ONGC SKIDS					O			
VAPORISER		O						
SPECIAL PRODUCTS								
SI/VI PIPING		O						
CRO BIO CONTAINERS	O							
AIR BOTTLES	O							
TITANIUM BOTTLE	O							
WAR HEAD CONTAINER	O							
MISSILE CONTAINER	O							
FUEL CONTAINER	O							
AIR LOCK ASSEMBLY	O							
BOILER DRUMS					O			
BOILER ITEMS								
COILS			O					
PANELS					O			
HEADERS			O		O			
FEEDERS								
MACHINED ITEMS								
SHELL SEGMENTS					O			

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DESCRIPTION	CASE	CRATE	SKID	BUNDLE	BARE	DRUM	METAL DRUM	FIBRE DRUM	
SHELL SEGMENTS IN STACKS					O				
SPHERE PETALS									
COLOUMNS, BASE PLATES, TIERCOS, PIPES, NOZZLE E1, F1, INTERNAL PIPES, PADS ETC.					O				
ROLLERS	O								
VALVE TRAYS									
VALVE TRAY COMPONENTS	O								
LATTICE GIRDERS		O							
FASTENERS	O								
GASKETS	O								
SUB CONTRACTS									
FAB STRUCTURALS					O				
SUPPORTING STRUCTURALS					O				
STRUCTURE SUB ASSEMBLY					O				
FAB PIPES					O				
GRATINGS					O				
STAIR CASES					O				
HANDRAILS/ PLATFORMS					O				
BOUGHT OUT COMPONENTS									
IRON & STEEL (LIKE PLATES, BEAMS, ANGLES, CHANNELS ETC.)					O				
PIPE FITTINGS									
CS PIPES, TUBES					O				
SS PIPES, TUBES					O				
FIN TUBES	O								
ELBOWS		O			O				
FLANGES	O	O							
VALVES	O								
GAUGES	O								
DEMISTERS		O							
ABSCRBANTS (LIKE MOLECULAR SIEVES, ACTIVATED ALUMINA, MOBILE SORBID)						O			
PAINT TINS		O							
PAINT DRUMS						O			
IGNITORS	O								
SPRAY NOZZLES	O								
ELECTRICAL INSTRUMENTATION									
MOTORS, PUMPS, COMPRESSORS, TURBINES	O								
SWITCH BOARDS, DISTRIBUTION BOARDS, STARTERS, JUNCTION BOXES		O							
INDICATORS, VIBRATOR SWITCHES	O								

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DESCRIPTION	CASE	CRATE	SKID	BUNDLE	BARE	DRUM	METAL DRUM	FIBRE DRUM
CABLE BUNDLES, CABLE DRUMS					O			
CABLE TRAYS, CABLE RACKS, EARTHING MATERIAL		O						
OPERATIONAL SPARES	O							

13 PROCEDURE FOR HANDLING OF COMPONENTS

The purpose of this procedure is to protect the quality of the components/equipment while handling in various stages of manufacturing packing & despatching.

- 13.1** Adequate care shall be taken in handling the material, and components to avoid damage during receipts, storage issue manufacture & despatch operations.
- 13.2** Appropriate material handling equipment like fork lifters, cranes etc. shall be used where needed.
- 13.3** Lifting by crane and transportation by trolley of critical items and large components like rotors castings etc. shall be done carefully.
- 13.4** For critical items, where specified, special handling fixtures shall be used for lifting.
- 13.5** Slings and shackles used for lifting the components/equipment shall be checked for fitness and suitability before use.
- 13.6** Slings used on machined surfaces shall be suitably padded. No slings shall be used on journal surfaces.
- 13.7** Precision machined components like blades, catches, rollers etc. shall be lifted using suitable wooden pallets.

13.8 HANDLING OF COMPONENTS ON RECEIPT/DESPATCH

Before loading/unloading a packing case from the carrier look for the following shipping instructions painted on the packing case.

- a) The markings showing the upright position.
 - b) The markings showing the sling position
 - c) Markings showing the fragile contents.
 - d) Other required markings as per clause no.10
- 13.8.1** Appropriate cranes and slings should be used for different components/ cases. Slings should normally make an angle as minimum as possible (width wise) but in no case more than 15°.
 - 13.8.2** Handling and lifting should be done without jerks or impacts.
 - 13.8.3** Immediately after receipt of the goods, the packing should be examined all-round for any sign of damage. If necessary, lift the cover or a number of boards of the case so as to make the contents visible. In the event of sealed packing being used the plastic sheeting should not be damaged. It is imperative that the packing material is restored in original condition after the inspection.
 - 13.8.4** On receipt of the equipment it should be checked with the shipping list and missing or damage if any should be reported immediately. It is important to arrange for immediate examination to determine the extent of the damage, the cause of the damage and where applicable the person or persons responsible for the damage. According to general practice when transporting by railway or by road vehicle the carrier concerned should be immediately called upon (within specified periods) for jointly establishing a statement of the damage. This is essential as a basis for a subsequent claim and possible damage report to the insurance company.
 - 13.8.5** Protective coating applied on machined surfaces should not be disturbed. The plastic covering should be put back carefully so that it prevents ingress of dust and moisture. Some packing may have vapour phase inhibitor (VPI) paper enclosed inside the packing cases. This should be restored to its original place as far as possible.

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13.8.6 Silica gel and such other chemicals kept in the box as desiccants and indicators should also be left in the box itself.

14 GENERAL GUIDELINES FOR ODC TRANSPORTATION/DESPATCH

Based on the Dimensions/Weight indicated in the Transportation Sketch, the type of Trailer is decided and indicated in the Tender Enquiry.

14.1 TRANSPORTATION:

1. LOW BED TRAILERS (LB 8):

Well Bed Length	: 10000mm
Over Gooseneck	: 13000mm
Width	: 3000mm
Carrying Capacity	: 40MT

2. LOW BED TRAILERS (LB 16):

Well Bed Length	: 12000mm
Over Gooseneck	: 16000mm
Width	: 3000mm
Carrying Capacity	: 75MT

3. TOW TYPE TRAILERS (WITH FRONT DOLLEY 16 TYRES): 12000MM length (for Exceptional equipment length: 30000mm and above)

Bigger Dia equipment are loaded in the Well with overhanging.

Smaller Dia equipment with excess length are loaded over Gooseneck with rear hanging.
The Vehicle Dimensions are defined above are only guidelines for selection based on actual Dimensions/ Weight of the Consignment

14.2 PACKING:

For all ODCs, Wooden Saddles are cut to the diameter of equipment as per the Transportation Sketch.

Wooden Saddles	For Diameter up to 4000mm	For Diameter above 4000mm
Length:	1836/2743mm (6'0"/9'0")	3353mm (11'0")
Width:	300mm (1'0")	300mm (1'0")
Height:	Saddle + one/two wedges a top	Saddle + three/four wedges a top

Number of Saddles:	
Minimum	3 in case of Loading inside Well +1 when loaded on Gooseneck
Maximum:	4 in case of Loading inside Well +2 when loaded on Gooseneck

For Securing the equipment firmly on the Trailer, 19mm (3/4"), wire rope with 25mm (1") Heavy Duty Turn Buckles / BD Clamps are used as Lashing for the equipment.

14.3 NUMBER OF LASHINGS:

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	CONSIGNMENT LOADED INSIDE WELL BED	CONSIGNMENT LOADED OVER GOOSENECK
a) up to 40MT	4 (2 Single Line lashing 2 Double Line Lashing)	5 (3 Single Line Lashing 2 Double Line Lashing)
b) 40MT to 60MT	5 (3 Single Line Lashing 2 Double Line Lashing)	5 (Single Line Lashing 3 Double Line Lashing)
c) 60MT and above	5 (2 Single Line Lashing 3 Double Line Lashing)	6 (3 Single Line Lashing 3 Double Line Lashing)

15 GUIDELINES FOR HANDLING/LOADING/LASHING**15.1 HANDLING****Figure 6**

Before unloading the jobs Completely painted and neatly stencilled will be checked.

Pipes with split type end cover will be checked



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Figure 7

All Coil Tubes to be provided with End Caps.



Figure 8

Neatly stacked Coil Assemblies.

CORPORATE STANDARD**Figure 9**

Columns to be lifted with Nylon belts. This protect painting, edges and attachments.

**Figure 10****15.2 LOADING**

All the components to be transported by putting inside the properly fabricated Crating

	<p style="text-align: center;">CORPORATE STANDARD</p>	AA0490010
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Figure 11

Small components may fall down while transporting without closed crating and there are chances of missing of small parts. Hence, it is always better to transport small components in closed containers/crating. Loose to be being shipped in a closed crating.



Figure 12

CORPORATE STANDARD

No component loaded over the crating.



Figure 13

Headers supported with wooden V blocks at 3 meters interval.



Figure 14

Spacers in between each coil assembly.



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Figure 15

Goose pipe to be provided with rubber pad protects removal of painting and damage to the job.



Figure 16

15.3 LASHING

Use Nylon belts only for lashing of all components. It prevents removal off painting and cut in the materials.

CORPORATE STANDARD**Figure 17**


Nylon Belts used for lashing the beams.

**Figure 18****16 PRODUCT WISE SPECIAL INSTRUCTION**

Additional instructions of packing not included in this standard shall be covered by individual product standard.


17 REFERRED STANDARDS (Latest publications including amendments):

- | | | | | |
|------------|------------|------------|------------|------------|
| 1) AA51420 | 2) AA55619 | 3) AA51414 | 4) IS:3401 | 5) AA10108 |
| 6) AA56126 | 7) AA51402 | 8) AA51401 | 9) IS:1234 | |


	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
		ANNEXURE-VII	
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ANNEXURE-VII

SEA WORTHY PACKING PROCEDURE

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
		ANNEXURE-VII	
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1.0	PACKING AND FORWARDING
1.	<p>Proper packing to be ensured.</p> <p>Indigenous Supply: Gypsum Dewatering System & sub system assembly shall be wrapped in polythene bags & packed in a strong rigid wooden crate. Rain water should not enter into the pump internals during storage in the outer yard of power plant.</p> <p>Imported Supply: All imported supply should be packed as per Sea worthy packing standards Annexure-VII of this sub-section. All imported items should have Sea worthy packing. Liberal packing materials and struts shall be provided to arrest rolling and to protect from transit damages.</p>
2.	<p>Equipment and process materials shall be packed and semi-knocked down, to the extent possible, to facilitate handling and storage and to protect bearings and other machine surfaces from oxidation. Each container, box, crate or bundle shall be reinforced with steel strapping in such a manner that breaking of one strap will not cause complete failure of packaging. The packing shall be of best standard to withstand rough handling and to provide suitable protection from tropical weather while in transit and while awaiting erection at the site.</p>
3.	<p>Equipment and materials in wooden cases or crates shall be properly cushioned to withstand the abuse of handling, transportation and storage. Packing shall include preservatives suitable to tropical conditions. All machine surfaces and bearings shall be coated with oxidation preventive compounds. All parts subject to damage when in contact with water shall be coated with suitable grease and wrapped in heavy asphalt or tar impregnated paper.</p>
4.	<p>The entire system has to be supplied in containers and it should be suitable for storing in the outer yard of the plant for a minimum period of 12 months. Crates and packing material used for shipping will become the property of owner (NPGCL).</p>
5.	<p>Packaging or shipping units shall be designed within the limitations of the unloading facilities of the receiving ports and the ship will be used. It shall be the bidder’s responsibility to investigate these limitations and to provide suitable packaging and shipping to permit transportation to site.</p>
6.	<p>Packing (tare) shall be part of the equipment cost and shall not be subject to return. The packing should ensure integrity and cohesiveness of each delivery batch of equipment during transportation. In case of equipment assemblies and unit’s delivery in the packing of glass, plastics or paper the specification of packing with the material and weight characteristics are to be indicated.</p>
7.	<p>Each package should have the following inscriptions and signs stenciled with an indelible ink legibly and clearly:</p> <ul style="list-style-type: none">a. Destinationb. Package Numberc. Gross and Net Weightd. Dimensionse. Lifting placesf. Handling marks and the following delivery marking

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8.	<p>Each package or shipping units shall be clearly marked or stenciled on at least two sides with the DETAILED SHIPPING ADDRESS –TO BE PROVIDED LATER.</p> <p>In addition, each package or shipping unit shall have the symbol painted in red on at least two sides of the package, covering one fourth of the area of the side.</p>		
9.	<p>Each part of the equipment which is to be shipped as a separate piece or smaller parts packed within the same case shall be legibly marked to show the unit of which it is part, and match marked to show its relative position in the unit, to facilitate assembly in the field. Unit marks and match marks shall be made with steel stamps and with paint.</p>		
10.	<p>Each case shall contain a packing list showing the detailed contents of the package. When any technical documents are supplied together with the shipment of materials no single package shall contain more than one set of such documents. Shipping papers shall clearly indicate in which packages the technical documents are contained.</p>		
11.	<p>The case number shall be written in the form of a fraction, the numerator of which is the serial number of the case and the denominator the total number of case in which a complete unit of equipment is packed.</p>		
12.	<p>Wherever necessary besides usual inscriptions the cases shall bear special indication such as “Top”, “Do not turn over”, “Care” , “Keep Dry” etc. as well as indication of the center of gravity (with red vertical lines) and places for attaching slings (with chain marks).</p>		
13.	<p>Marking for Safe handling: To ensure safe handling, packing case shall be marked to show the following:</p> <ol style="list-style-type: none"> Upright position Sling position and center of Gravity position Storage category Fragile components (to be marked properly with a clear warning for safe handling) 		
14.	<p>Each crate or package is to contain a packing list in a waterproof envelope. All items are to be clearly marked for easy identification against the packing List. All cases, packages etc. are to be clearly marked on the outside to indicate the total weight where the weight is bearing and the correct position of the slings are to bear an identification mark relating them to the appropriate shipping documents. All stencil marks on the outside of cases are either to be made in waterproof material or protected by shellac or varnish to prevent obliteration in transit.</p>		
15.	<p>The packing slip shall contain the following information: -</p> <p>Customer name, Name of the equipment, Purchase Order number with Date, Address of the delivery site, Name and Address of the Sender, Serial Number of pump & accessories, BHEL item Code, Gross Weight and Net weight of Supplied items.</p>		
16.	<p>Prior to transport from manufacturer’s work to destination, components of the unit shall be completely cleaned to remove any foreign particles. Flange faces and other machined surfaces shall be protected by an easily removable rust preventive coating followed by suitable wrapping.</p>		
17.	<p>All necessary painting, corrosion protection & preservation measures shall be taken as specified in painting schedule. Supplier shall consider the coastal environment zone which is defined as “very severe” during final finishing/shipping.</p>		
18.	<p>Successful bidder shall furnish the detail packing /shipment box details with information like packing box size, type of packing, weight of each consignment, sequence no. of dispatch, no. of consignment for each deliverable item against each billing break up units/ billable blocks. Without these details the BBU shall not be approved during detail engineering.</p>		

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	Also, complete billing break-up with above mentioned details shall be submitted to Purchaser within 10 days of placement of the LOI.
19.	All items/equipment shall be dispatched in properly packed condition (i.e. no item shall be dispatched in loose condition such that it becomes difficult to store/identify its location at site at a later stage).
20.	Cases which cannot be marked as above shall have metal tags with the necessary markings on them. The metal tags shall be securely attached to the packages with strong steel binding wire. Each piece, Skid, Case or package shipped separately shall be labelled or tagged properly.

Annexure-VII-Seaworthy packing Specification


VOLUME IIB

**TECHNICAL SPECIFICATION
FOR
SEAWORTHY PACKING FOR EXPORT JOBS**

SPECIFICATION NO. PE-TS-888-100-A001



**BHARAT HEAVY ELECTRICALS LIMITED
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NEW DELHI, INDIA**

	TITLE TECHNICAL SPECIFICATION FOR SEAWORTHY PACKING FOR EXPORT JOBS	SPECIFICATION NO. PE-TS-888-100-A001	
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1.0 Purpose

The purpose of this specification is to describe minimum packing requirements for the different items/equipment for all export Project and also to define marking and shipping requirements during transportation by ship, road and air for all export jobs.

2.0 SCOPE

For export jobs, sea worthy packing capable of performing all necessary functions like prevention of damage to the contents, sufficient to support frequent handling and lengthy period of outdoor storage in adverse weather conditions are required. Workmanship and materials used shall be of high standard meeting the technical requirements and in accordance with best commercial export packing practices. Vendor shall be responsible for sea worthy export packing, however it shall meet the minimum requirements specified herein. Equivalent or better packing methods may be deployed subject to approval of the BHEL/Purchaser. Vendor shall submit the packing procedure for its equivalent for purchaser's approval during detailed engineering.

The scope this specification is to define VENDOR's responsibilities in terms of:

- Preservation of the GOODS/items/equipments before packing.
- Packing of the GOODS for road, rail, sea and/or air transportation to desired destination i.e. project site
- Making cases/crates
- Chemical Treatment/Fumigation before packing to prevent fungus, damage due to termite, borer, rats, etc.
- Marking of cases/crates.
- Other Services required.


3.0 Application

This specification is applicable to all the goods to be transported to project site and requires to be in transit for longer duration. *However, for "Misc cable erection items", "Fire sealing system" & "Exothermic welding material", the packing requirements shall be as per the procurement specification.*

4.0 Definitions

- "BHEL" : Main EPC vendor
- "OWNER" : Customer for a particular export project.
- "VENDOR" : Company(ies)/VENDOR(s) to whom the BHEL has placed Purchase Order for GOODS/ items/system/package.
- "GOODS": means all or part of the articles, material, equipment supplies including technical documentation, as described in the Purchase Order, to be supplied by VENDOR.
- "PACKER": Packaging Company to whom VENDOR intends to sub-contract the packing in case they do not have own packing capability/facilities .
- "FREIGHT FORWARDER" : Means the Company responsible for performing freight forwarding activities.

5. General Information

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The following requirements are intended as minimum requirements, and compliance to these requirements in no way absolves or relieves VENDOR of any responsibility or obligation outlined in the Purchase Order. In all circumstances, the packing will be designed and constructed in order to support GOODS during transportation as well as to prevent the Goods from damage due to impact, extreme climatic conditions, sun and rain. It must be ensured that the delivery of the GOODS to the jobsite by sea, road or air, in good condition.

GOODS shall be export packed in compliance with the best-established practices for international projects, in accordance with the following instructions. In the event of any conflict between these specified requirement and the established practices, specification requirement shall govern.

Due to climatic conditions and the complex transport operation(s), it is essential that protection and packing is of the highest standard. Packing means to efficiently protect the GOODS during the total transport operation; from the moment they leave the factory until they are delivered to the jobsite, including handling operations (loading/unloading) and storage.

When VENDOR do not have packing capabilities/facilities of their own and therefore intends to sub-contract, VENDOR have to inform BHEL/Purchaser of the name and address of proposed PACKER(s) for approval.

6.0 Criteria for Selection of Packaging

Packages are to be made according to categories, described in articles 8.1 to 8.5, depending on the type of materials, their fragility and size.

These categories have been established for the protection of equipment and material during multi-mode transports, i.e.: combination of overland and sea transport; containerization, air transportation.

In a general manner, the GOODS have to be packed in such a way that crates, bundles, pallets can be stored into General Purpose containers, wherever possible.

If VENDOR has any doubt about the correct method of protection or packing, he should contact BHEL/Purchaser in order to mutually agree on the adequate type of packing to be used.

Materials can be classified in following categories

- Hazardous Material
- Non-Hazardous Material
-


Further to above categorisation, non-hazardous materials can be sub- categorised for selection of packing.

6.1 Hazardous Materials

Though handling of hazardous material may is not applicable in the scope of this specification. All hazardous material must be packed in adherence to the detailed requirement relating to packing, marking and labelling set out in the most recent report of the Board's Standard Advisory Committee on the Carriage of Dangerous Goods in Ships for sea freight, and the Restricted Articles Regulations, laid down by the International Air Transport Association for airfreight.

6.2 Non-Hazardous GOODS

The scope of this specification is to provide necessary guidelines for packing for power plant equipment, components, Pipings & Valves, Fittings, other structural items, electrical items, spare parts and erection materials. The procedure is defined in subsequent paragraphs in details in clause no. 8.0.

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7.0 Marking Instructions & Despatch details, Storage Code

7.1 Marking Instructions & despatch details

Packages and crates will be marked with indelible black paint, resistant to seawater. Marking must be perfectly legible.

The shipping marks, which will be as per fig-13, shall be stencilled on two sides and one end in clear characters at least 5 centimetres high (where crate size permits, otherwise use optimum size for each package dimension).

When the GOODS are to be shipped in containers then marking may be stencilled on one end only. However, packages must be stowed in a manner that shows these marks.

Crates containing fragile articles must be packed with special precaution against risk of breakage and must be stencilled on all sides "FRAGILE - HANDLE WITH CARE". Where crates are not to be overturned, VENDOR must show on the crates, clear and readily visible identification as per fig-12, to ensure they are kept in the correct position.

Packages/equipment of 2,000 kg or more must be marked with slinging points on all sides, in addition to the centre of gravity marks.

Number packages consecutively i.e. 1 of 10, 2 of 10, etc. Do not duplicate package numbers. VENDOR is responsible for any loss or damage caused by incorrect marking.

All cases/crates shall also be marked with the appropriate international standard graphic symbols for handling as shown in Fig 12.

As a minimum, all cases/crates are to be marked clearly on all four sides with:

- "HANDLE WITH CARE"
- "RIGHT SIDE UP"
- "KEEP DRY"

In the case of packages with a single gross weight totalling 2,000 kg and/or a height of more than 1m, the centre of gravity shall be clearly marked with the symbol on two adjoining sides. For all items of equipment with an eccentric centre of gravity this symbol shall be marked at the bottom, side and top of the package.


The slinging and lashing points shall be marked with a chain symbol.

When packing in cases/crates, these packages shall also have metal corners at the slinging points. (Fig-11)

External front and rear sides of the boxes to be planed for writing instructions.

Dispatch details such as consigner/consignee address, contract and case details, country of origin, port of delivery, stacking instructions shall be written on one side of the boxes. An anodized aluminum plate as per details and specifications given in fig-13 shall be provided on one side of the boxes.

One copy of packing slip wrapped in polyethylene bag covered with aluminum packing slip holder to be nailed on the external surface of the box. One more copy of the packing slip wrapped in polyethylene bag is to be kept inside the box at the pertinent place.

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7.2 Storage Code

The type of storage required is required to be specified, it will be shown on each packaging in **RED colour**.

- X Crates or packages to be stored outdoor without covers
- XX Crates or packages to be stored under tarpaulin
- XXX Crates or packages to be stored in covered or enclosed premises
- XXXX Crates or packages which must be stored in air-conditioned premises

8.0 GUIDELINES FOR PACKING GOODS

8.1 In the subsequent paragraphs details of different types of packings for different types of GOODS are defined. Vendor shall make packing details/procedure based on the guidelines and submit for approval.

8.1.1 Packing for Pipe, Fittings, Flanges and Valves, Structural Steel

Particular attention should be brought to pipe, fittings, flanges, valves and structural steel. Packing categories for piping and fittings will differ according to the diameter and wall thickness of these products. VENDOR shall comply with the following established practice.

IMPORTANT NOTE:

Depending on the project schedule and availability of ocean vessels, the piping and structural steel may be shipped in containers. In this event, VENDOR has to arrange the packages in such a way it allows the stuffing into Open Top in gauge containers.

8.1.2 Pipe

Where practicable, pipe lengths shall be limited to 11.8 meters.

All pipes 2" included and below shall be packed in crates. All pipes to be capped and ends sealed with waterproof tape.

Pipes over 2" up to 6", shall be bundled and banded in bundles of uniform length. Bundling is carried out with U-IRON or traversal planks, joined with threaded connecting rods with locknuts. Quantities and strapping positions depend on the lengths, with a 120 cm spacing to prevent distortion. Bundle weight shall not exceed 2,000 kg. All pipes are to be capped and ends sealed with waterproof tape (tape is not necessary if end caps are of the pre-shrunk or self-sealing type).

Pipes larger than 6" shall be shipped as single lengths with the ends capped. End caps are to be of the recessed type to enable the use of soft faced hooks, but still completely sealing the end and also protecting the weld.


All stainless steel piping must be packed separately in wooden crates. Any banding of bundles is to be with the same material.

8.1.3 Pipe Fittings, Flanges and Valves

All pipe fittings, flanges and valves up to 6", are to be packed in cases/crates. For items over 6", these may be fixed securely to a pallet base and enclosed in a crate, for protection. Where valves have actuators attached, rigidity must be ensured for the valve and actuator. The vulnerable parts of the actuator are to be completely protected within a wooden crate.

All stainless steel fittings, flanges and valves of all sizes, must be packed separately in wooden crates. Any strapping is to be with the same material.

8.1.4 Structural Steel

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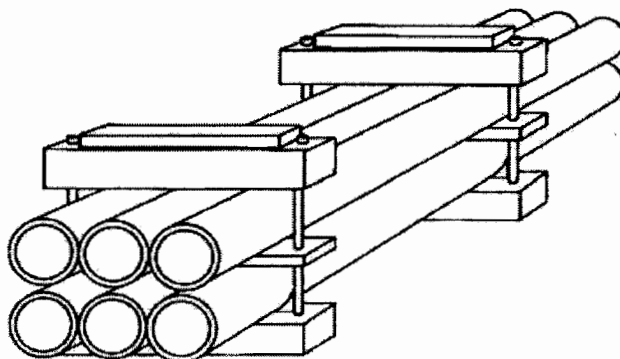
Structural Steel, reinforcing rods, bars, etc., should be packed in bundles of uniform length. Refer to articles 8.1.2, for strapping requirements. Bundle weight not normally to exceed 2,000 kg. Fabricated structures and structural steelwork, etc, should be bundled and packed using wooden beams and long bolting to secure the load.

8.2 Bundling – Packing Category I

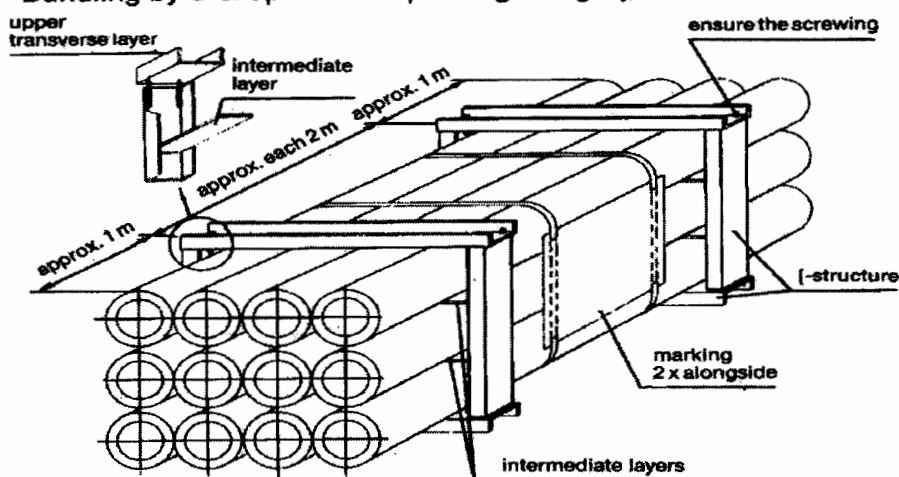
8.2.1 Type of Equipment

Equipment which is not subject to damage by corrosion or mechanical effect, i.e. pipes, piping, structural steel.


Packing category I



Bundling by U-shaped iron – packing category I A



8.2.2 Type of Construction

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- Bundling has to be effected
- By squared timber and threaded rods.
- With an intermediate layer (threaded on tightening bolts) according to the weight of the package.
- Wedge-shaped timbers must be added at the outer points of lower layer.
- Between the bolts a spacer must be nailed.
- The bolts must be secured (e.g. by locking nut).
- If single parts could protrude, an appropriate protection must be installed (flat iron or plates).
- Bundling with steel straps or PVC straps is not accepted.

8.3 Skids, Square Timber Constructions, Casings – Packing (Category II)

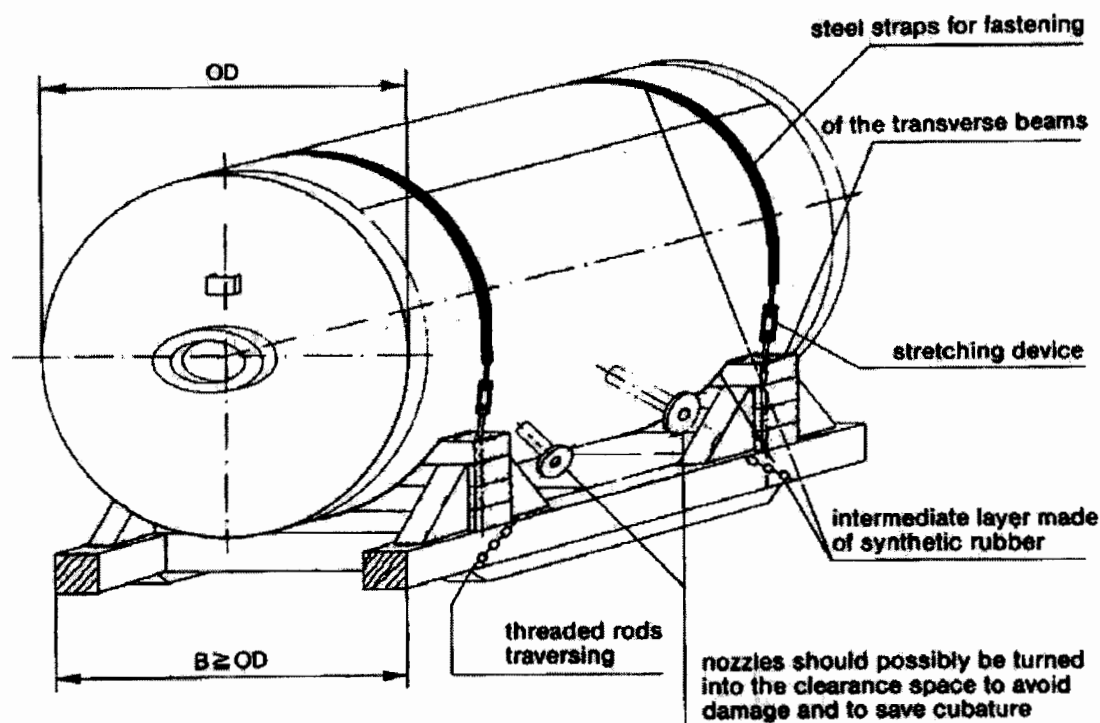
8.3.1 Type of Equipment


Voluminous apparatus, tanks and/or heavy pieces those are not vulnerable to mechanical or corrosive effects.

8.3.2 Type of Construction

- The construction skid can be made of wood or of metal.
- The fastening of the packages on the skid will be made by steel straps (flat iron) which have to be elastically lined, non-slip and securely bolted onto the skids.
- Flange openings have to be closed with gaskets and blind flanges or, if necessary, provided with cover.
- Skid constructions may not be less than the dimensions of the package in length or in width.
- Tanks and apparatus with their own support cradles must be supplied with an anti-slip lining.

PACKING CATEGORY-II



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8.4 Packing of GOODS in Wooden Crates/Cases/Boxes

The construction of wooden crate/cases/boxes shall be as per the details indicated in clause 9.0 & Fig 1 to 11. Details indicated in the sketches for different categories Packing crates/boxes are only for a typical equipment considered for illustration.

8.4.1 Packing Category III

8.4.1.1 Type of Equipment

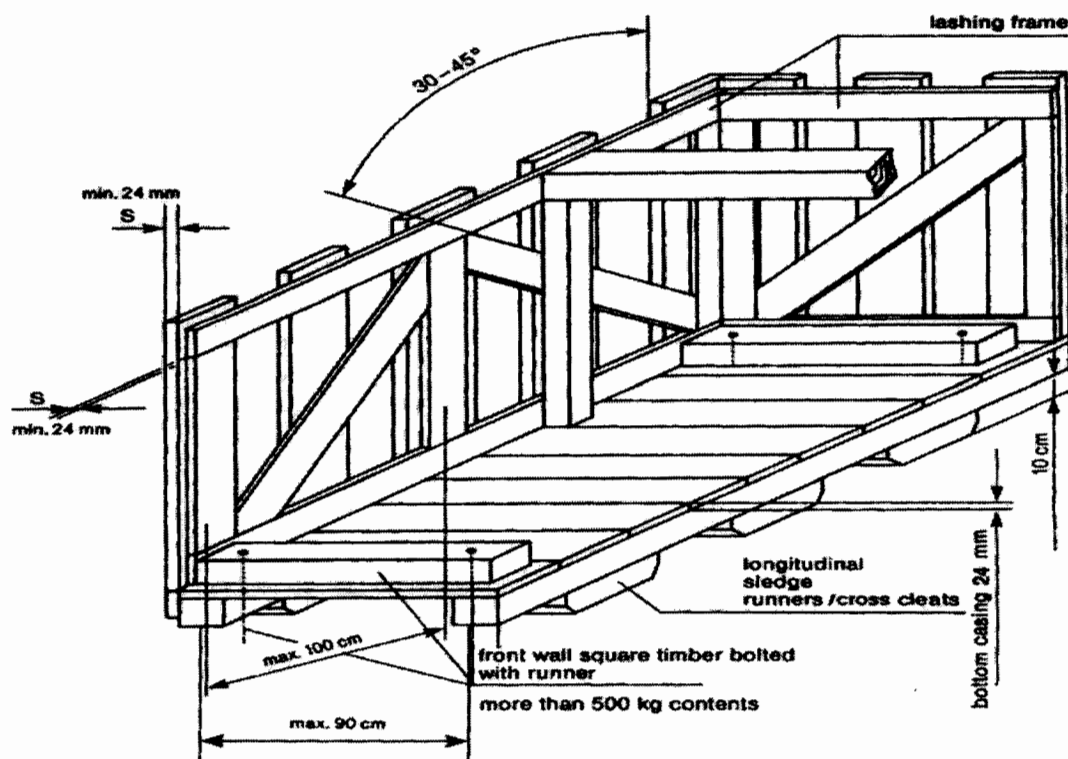
Fabricated equipment, which cannot be transported on cradles; frame-works, prefabricated piping and fittings, mechanical and electrical assemblies. *This type of packing is recommended where many parts of the equipment/component/assembly are not protruding out.*

8.4.1.2 Type of Construction

The equipment must be safely fastened to the bottom with bolts, possibly by the runners or to be spread in such a manner that no protruding parts are possible. For parts, sensitive to rainwater and/or debris, a protection has to be made by a foil cap.

If it is possible that single part could protrude through the front/back side wall, they shall be closed completely. The marking of the package shall be done on plywood plates at the prescribed sides.

Packing Category III



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8.4.2 Cases with Lining – Packing Category IV

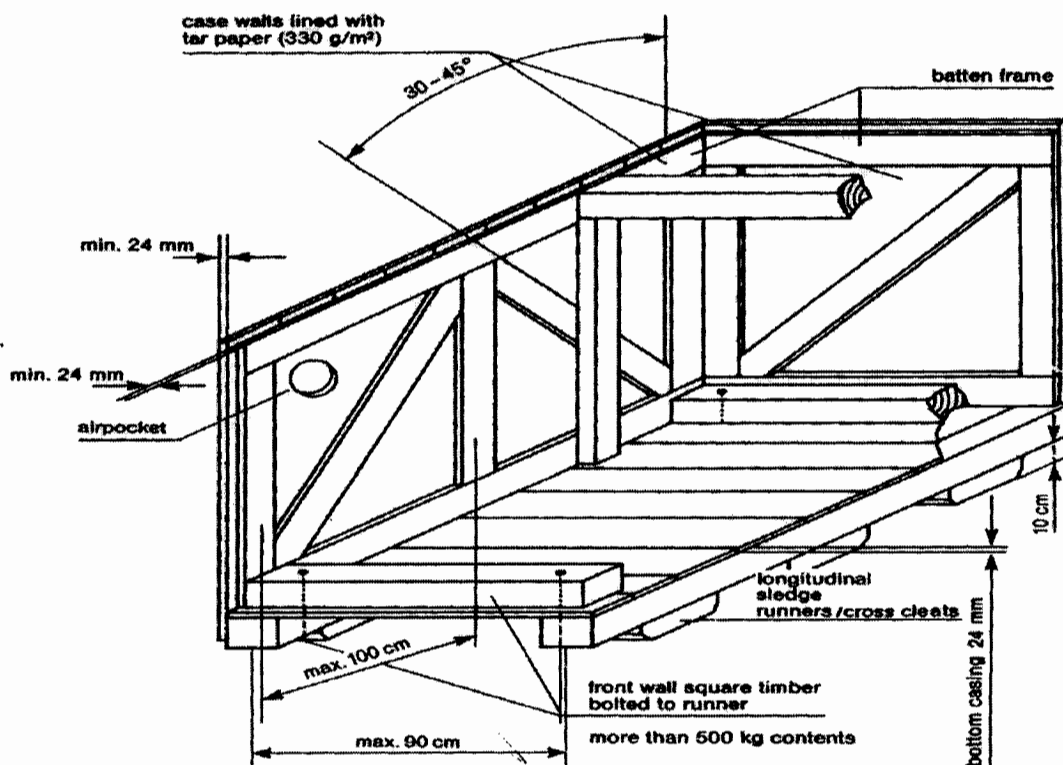
8.4.2.1 Type of Equipment

Recommended for equipment and mechanical parts Equipment sensitive to mechanical damage or parts and components that are particularly at risk of theft or loss; pumps, elbows, flanges, fittings, tools, erection materials, etc.

8.4.2.2 Type of Construction


The same type of construction as article 8.4.1.2, but with all sides completely boarded without space between the boards. Sides to be provided with waterproof lining; fabric-reinforced waterproof tar paper or polyethylene-foils resistant to ultraviolet rays can be used. Polyethylene-foil shall be fixed under the lid cover to avoid penetration of water. At weights of more than 500 kg the longitudinal runner must be bolted to the front all square timber. For ventilation inside the case, an opening in the waterproof lining must be placed between the diagonal battens and diagonal joists.

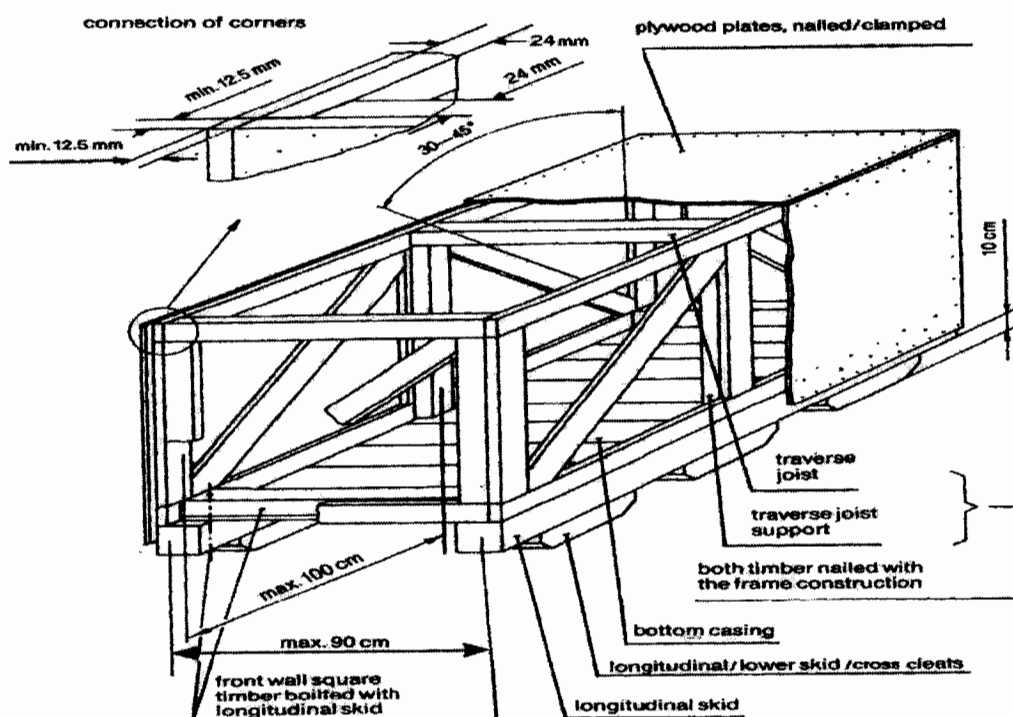
Packing Category IV



8.4.3 Cases with Alternative Surface Materials

8.4.3.1 Plywood Box – Packing Category IV A

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Case constructed of 5 layers of watertight, glued plywood with a total thickness of 12.5 mm. The frame must be constructed from minimum 24 mm timber or as per guide lines given above against clause 8.0, Fig 1 to 11 and must be suitable for the weight and nature of the parts to be packed. Planed square timber must be bolted with longitudinal skid and covered with diagonal joists. If applicable, construction of the cover and sides is to include diagonal bracing. Covers consisting of several layers of plywood are to be sealed with durable elastic putty or additional water-resistant sheets to be fixed.

8.4.4 Case with Barrier Material – Polyethylene Foil – Packing Category V

8.4.4.1 Type of Equipment

Sensitive equipment, simple electrical equipment, insulation materials, fire-resistant materials, with non-corrosion- guarantee for a period up to twelve (12) months.

8.4.4.2 Type of Construction


Preservation by welding in polyethylene-foil with addition of desiccants and if necessary, application of non-corrosive contact agents, otherwise, type of construction as indicated in article 8.4.2.2.

Additional marking:

- Case with desiccants.

8.4.5 Case with Barrier Material – Aluminium Compound Foil – Packing Category VI

8.4.5.1 Type of Equipment

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Electrical equipment such as, switchboards, electric motors, sensitive equipment, with non-corrosion guarantee, for a period up to twelve (12) months.

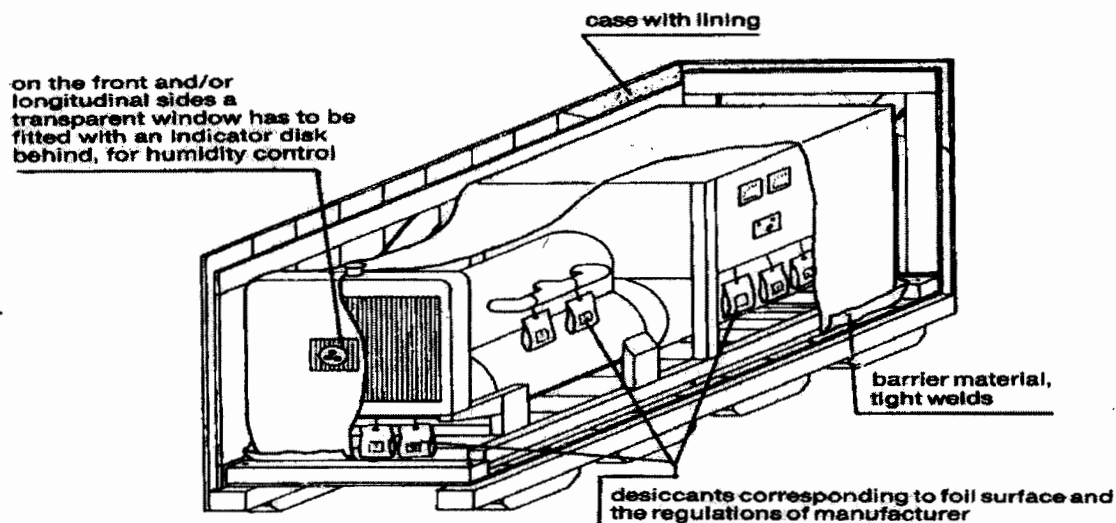
8.4.5.2 Type of Construction

Type of construction as indicated in article 8.4.2.2. Preservation by sealing an aluminium compound foil, with the addition of desiccants. Humidity indicators, if required and installed in the barrier wrapping, shall allow easy control from the outside.

Additional marking:

- Case with desiccants.

Packing Category V/VI




8.4.6 Double Case – Packing Category VII

8.4.6.1 Type of Equipment

GOODS which are of high sensitivity to shock, impact and vibration, for instance, special electrical equipment like computers, switchboards, laboratory instruments

8.4.6.2 Type of Construction

Case construction as indicated in article 8.4.2.2, with additional floating inner packing (case-in-case principle), padding corresponding to weight and sensitiveness. Preservation by sealing in aluminium compound foil with the addition of desiccants. The inner case has to be made of plywood or equivalent material with a thickness of 8-12 mm, depending on the weight of the GOODS to be packed. The inner buckles and/or frame borders have to be dimensioned so that the full stability of the inside case will be reached and no twisting is possible. The inner sides of the inside case will be lined with bituminous kraft paper on all sides (except bottom).

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8.4.7 Cable Drum – Packing Category VIII

8.4.7.1 Type of Equipment

All type of cables, wires, ropes, hoses.

8.4.7.2 Type of Construction

For all type of cables refer clause no. 11.1. For other items (wires, ropes, hoses) new or practically new drums are to be used. Planking of the e drums by use of boards, thickness minimum 20 mm, with additional double steel strapping, nailed, and carefully preserved/protected cable ends prior to packing.

8.4.8 Hazardous Materials – Packing Category IX

8.4.8.1 Type of Equipment

Hazardous materials according to the law are explosives, compressed gases, liquefied gases dissolved under pressure or deeply refrigerated, flammable liquids, flammable solids: substances liable to spontaneous combustion; substances which, on contact with water, emit flammable gases, oxidizing substances, organic peroxides, poisonous (toxic) and infectious substances; radioactive materials, corrosives, miscellaneous dangerous goods.

8.4.8.2 Type of Construction

Hazardous materials shall always be packed and documented separately from any other material. Selection of packaging materials, execution of packing and marking as well as documentation shall always be in compliance with the applicable laws and regulations. Any certificates required for transportation or for authorities to be supplied before shipment of the GOODS.

8.4.9 Wooden Floor as a Transport Support – Packing Category X

8.4.9.1 Type of Equipment

Any materials to be stuffed in containers or on flat racks and that are not stowed on standard pallets or otherwise suitably packed

8.4.9.2 Type of Construction


- Longitudinal internal square timbers bolted to the front wall runners, longitudinal skid.
- Maximum distance between longitudinal runners 90 cm (middle to middle of the runner).
- Full boarding of the floor.
- Attaching of lifting lugs and/or iron ropes for lifting/pulling the units off the transport equipment.
- If applicable, preservation of the equipment by sealing in polyethylene-foil or aluminium compound foil and the addition of desiccants.

8.5 Air Transport Packing

8.5.1 General

Certain types of material may have to be shipped by air from their country of origin. This means of transport will be exceptional, and will be used only:

- For GOODS, which are highly sensitive to shock or vibrations, such as computers, electronic instruments, or those of small dimensions and weight.
- For GOODS urgently required at the module yard(s) and/or jobsite.

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8.5.2 Type of Packing

Depending on the goods to be packed, VENDOR may use one of the following types:

- A triple-corrugated cardboard container made with waterproofed glue and a barrier layer of polyethylene on the outsides to keep out humidity.
- Wooden/cardboard packing cases: the wood being used for the framework and base of the cases, waterproofed triple-corrugated cardboard being used for the sides and top. These cases are of the "Bell" type, and used for material of small or medium dimensions.
- For larger dimensions, plywood cases are acceptable. The timber characteristics, cross-sections and thickness will be systematically determined by the nature of the loads to be packed.

8.5.3 Dimensions

In order to optimize the existing transport facilities (passenger or cargo aircraft), the dimensions of:

- Triple-corrugated containers.
 - Wooden/cardboard packing cases.
 - Plywood cases.
- Are to be adapted to pallets used for air transportation.

9.0 Detailed specification for Wooden Crates/Boxes/Cases and other packing materials

9.1 Technical specification for wood

The wood shall be Fir, Chir, Silver Oak (Gravillea Robusta), chemically treated mango and Pinewood with moisture content not exceeding 50%. The wood shall have flexural and compressive strength, stiffness, shock absorption and nail retention properties. The wood shall be free from common defects such as warp, bone, twist, knot, crakes, splits, end splits, bend, visible sign of infection and any kind of decay caused by insects or fungus, etc. Surface cracks with maximum depth of 3mm are permissible. A continuous crack of any depth all along the length is not allowed.

9.2 Chemical Treatment of Wood:


The wood shall be chemically treated to provide protection against deterioration due to fungi and attack by termites, borers, marine organism and any other kind of infection. It shall be treated only after final processing like cutting, planning, joint grooving, etc.

9.3 TYPE, DESIGN & DIMENSION OF WOODEN PACKING CASES:

9.3.1 PACKING OF EQUIPMENTS

Various mechanical, electrical and C&I equipment e.g. Pumps, motors, equipment skids, heat exchangers, control panels, switch gears, transformers, etc. shall be wrapped in weather proof packing and then secured in wooden packing cases. The construction of wooden packing cases/crates shall be as per details given below and also given in figure 1 to 11.

9.3.1.1 Bottom Frame

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The construction of bottom frame shall be as per Fig-2. The No. of slides/runners for bottom frames shall be selected depending upon the weight and overall dimensions of the load to be carried. The equipment shall be secured by fixing their base frame/plate with the help of bolt and nuts etc. to bottom frame of the wooden packing cases/crates. The equipment not provided with base frame/plate like cylindrical vessels, etc to be secured to the bottom frame of the wooden cases with "C" clamps fabricated from steel channels/ angle iron.

9.3.1.2 TOP FRAME

The construction of top frame shall be as per fig-3.

9.3.1.3 END PANELS

The dimension of the end and lateral panels shall be calculated according to overall dimensions of the items to be packed. Diagonal braces shall be used for packing cases having height exceeding 500mm. Details of bracings shall be as per fig 5 to 9.

9.3.1.4 Sling Plate


To facilitate lifting of cases, longitudinal under slide boards shall be fixed. To avoid damage to the box while lifting sling plates shall be provided. Refer fig-11.

9.3.1.5 Angle Iron Cleats

Angle iron cleats shall be used for strengthening the joints as indicated in fig-10


9.3.1.6 Other Requirements

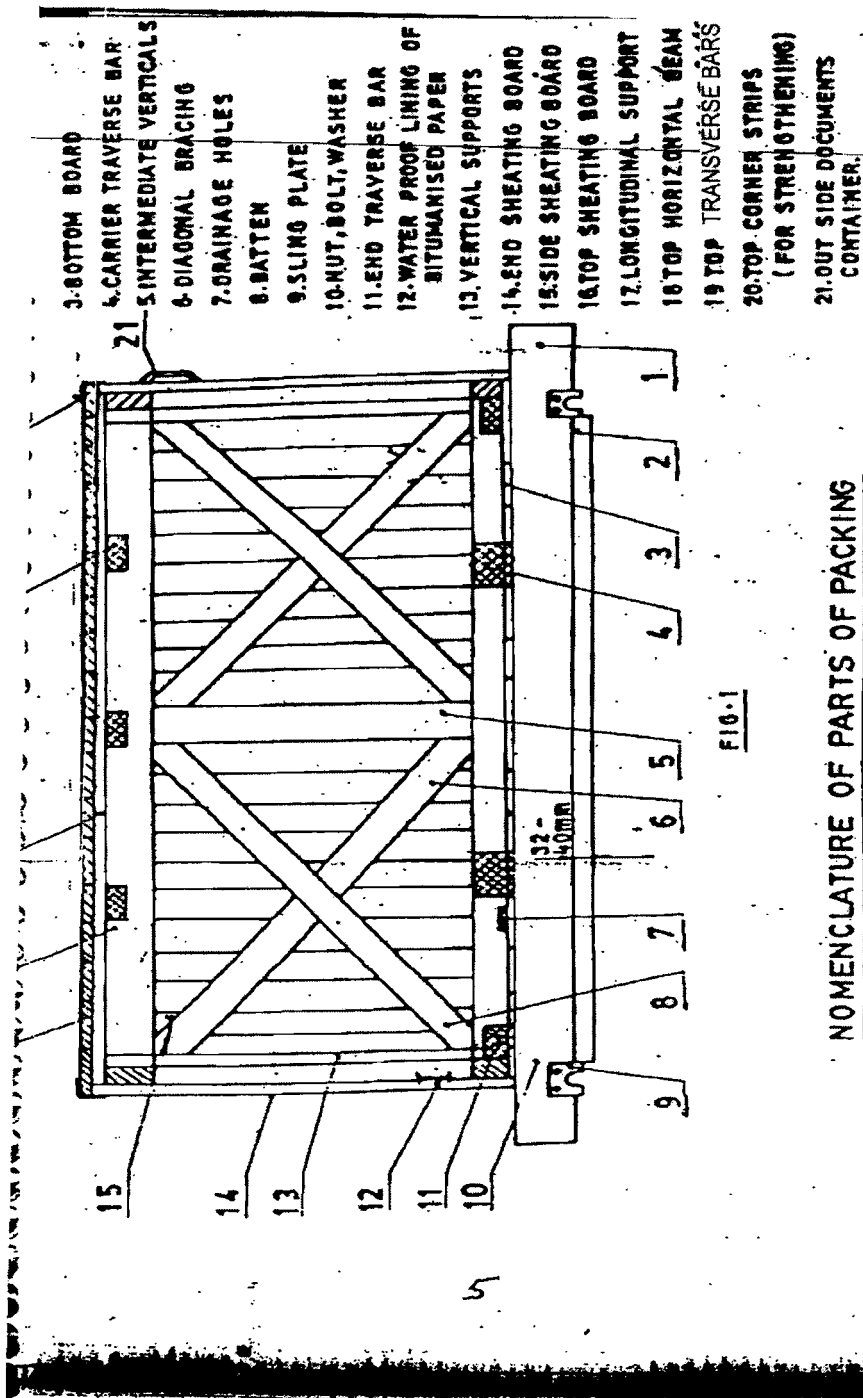
- The thickness of planks for top, bottom, side and end panels shall be at least 25mm. Planks used for this purpose shall be joined with each other by tongue and groove joint. The groove dimension shall be such that tongue fits tightly into groove to make the joint.
- Runners/slides, traverse bars, etc shall be of single length i.e. without any joint. Planks for sheathing, diagonal bracing etc shall also be of single length up to 2400mm, proper jointing is permitted for planks for sheathing and diagonal bracings.
- Each equipment to be individually covered with double polyethylene petticoat. Sheet thickness of polythene sheet shall not be less than 0.175 mm (175 microns). The sealing shall be such so as not to allow moisture inside.
- The inner surface of 4 sides of shooks shall be nailed with bituminized water proof craft paper. Wherever 2 pieces of kraft paper are used, joint shall have an overlap of minimum 20 mm.
- All the inner sides of the box shall be nailed with bitumen coated HESSIAN POLYTHYLENE KRAFT PAPER. For top frame it shall project on all sides by 100mm and shall be nailed on sides. Wherever 2 pieces of kraft paper are used, joint shall have an overlap of minimum 20 mm.
- For delicate equipment like control panels and switchgears, lighting panels and lighting transformers, suitable cushioning material like rubberised coir (min. 50 mm thick and 100 mm wide) shall be provided on their bottom support and the gap between the panel and casing

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shall be filled with rubberized coir with distance between consecutive supports less than 500 mm (ref fig15). For other equipment suitable support from sides of the casing shall be provided.

- Switchgear cubicles, control panels and control desks shall be packed and shipped in separate convenient sections. The components e.g. circuit breakers relays and instruments etc. which are removed from panels for shipping purpose and shall be separately packed and shipped as per packing instructions in clause 10.4.
- Packing case for control panels and switchgear panels shall be finally covered with GI sheet of minimum thickness of 0.4mm.
- Packing cases shall be bound at edges by nailing MS clamps/brackets at sufficient intervals. Further heavier boxes shall be strapped with C clamps (ref fig-4) fabricated from steel channels/angles and lighter boxes shall be strapped with hoop iron strips.
- Silica gel is used for this purpose to protect contents over sufficiently long time from corrosion. Silica gel shall be indicating type confirming to IS-304 (1979) packed in cotton bags placed at different positions inside the packing for absorbing moisture and shall not come into directly contact with equipment/material inside the package. The quantity of silica gel shall be adequate for storage period of one year, however it shall not be less than 4 gm. per ltr. Volume of case subject to minimum 400 gm. Per case.

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BOTTOM FRAME ARRANGEMENTS

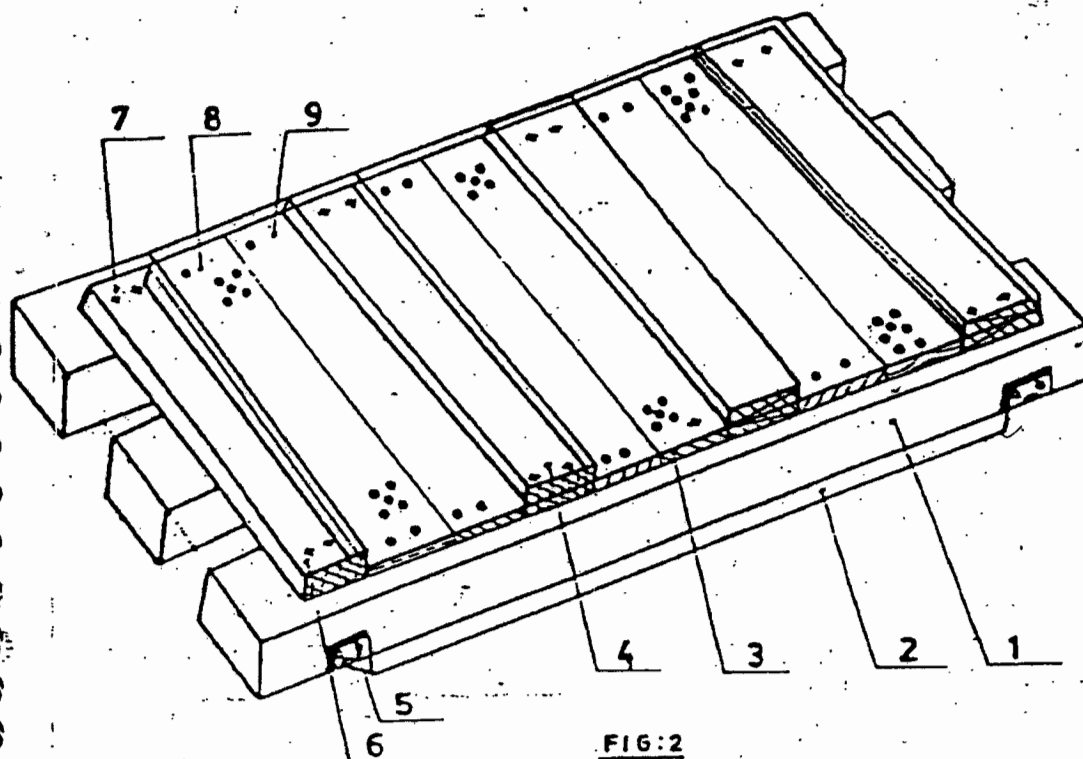



FIG:2

Nos. of slides: Minimum 2 Nos.
 For length more than 1800 mm or
 load more than 1000kg, Nos. of
 slides shall be minimum 3 Nos.
 For dimensions of slides, refer Table 1
 Cross section of end traverse bar; 100 x 100 mm.
 (minimum)

1. SLIDE
2. UNDER SLIDE BOARD
3. BOTTOM BOARD
4. CARRIER TRAVERSE BAR
5. SLING PLATE
6. TRAVERSE BAR
7. BOLT, NUT & WASHER
8. DRAINAGE HOLES
9. NAILS

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TOP FRAME ARRANGEMENT

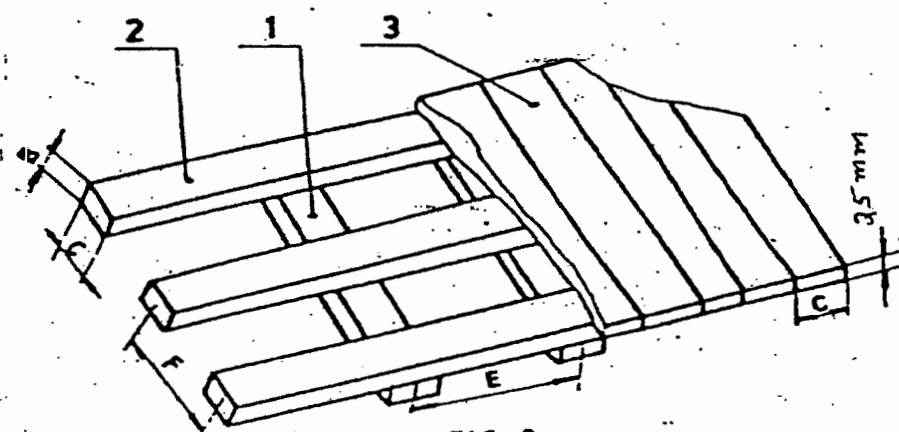
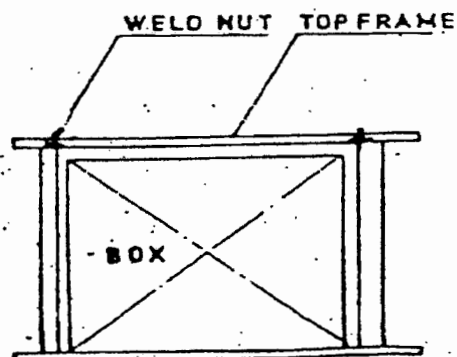
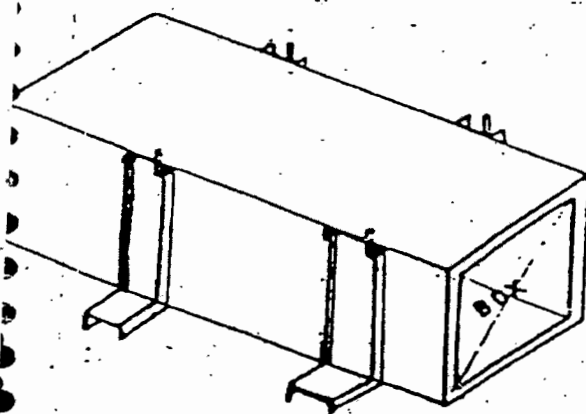


FIG-3


F : 700 to 1000 mm
E : 500 to 900 mm
30x100 mm.

- 1 - Traverse Bars
- 2 - Horizontal Soans
- 3 - Top Board

ARRANGEMENT OF C-CLAMPS AROUND CASES



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ARRANGEMENT OF DIAGONAL BRACING AND HORIZONTAL SUPPORT

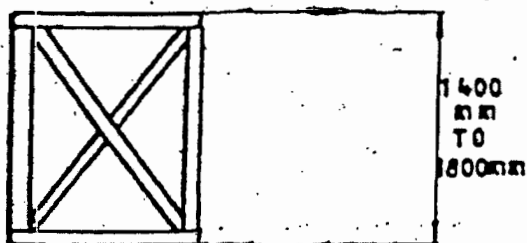


FIG: 6

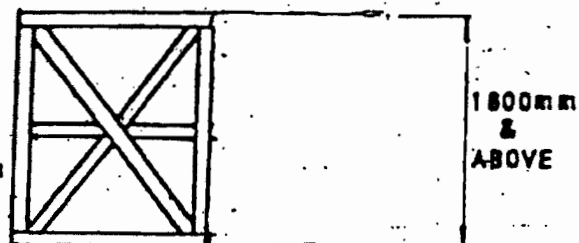


FIG: 8

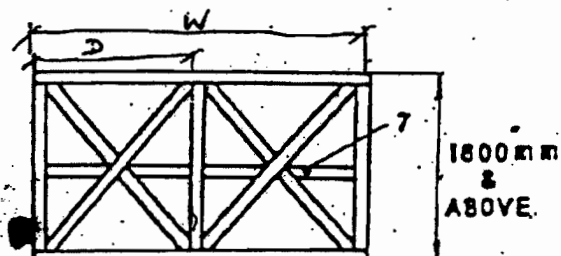


FIG: 7

7- Middle Horizontal Support

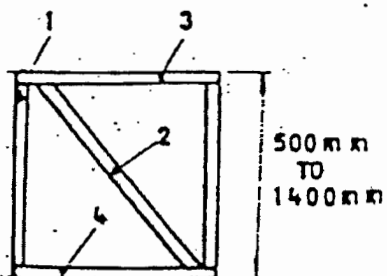


FIG: 5

1- Vertical Support

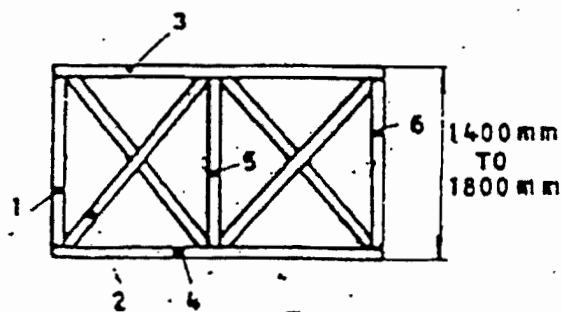



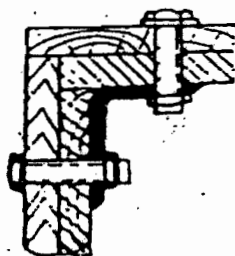
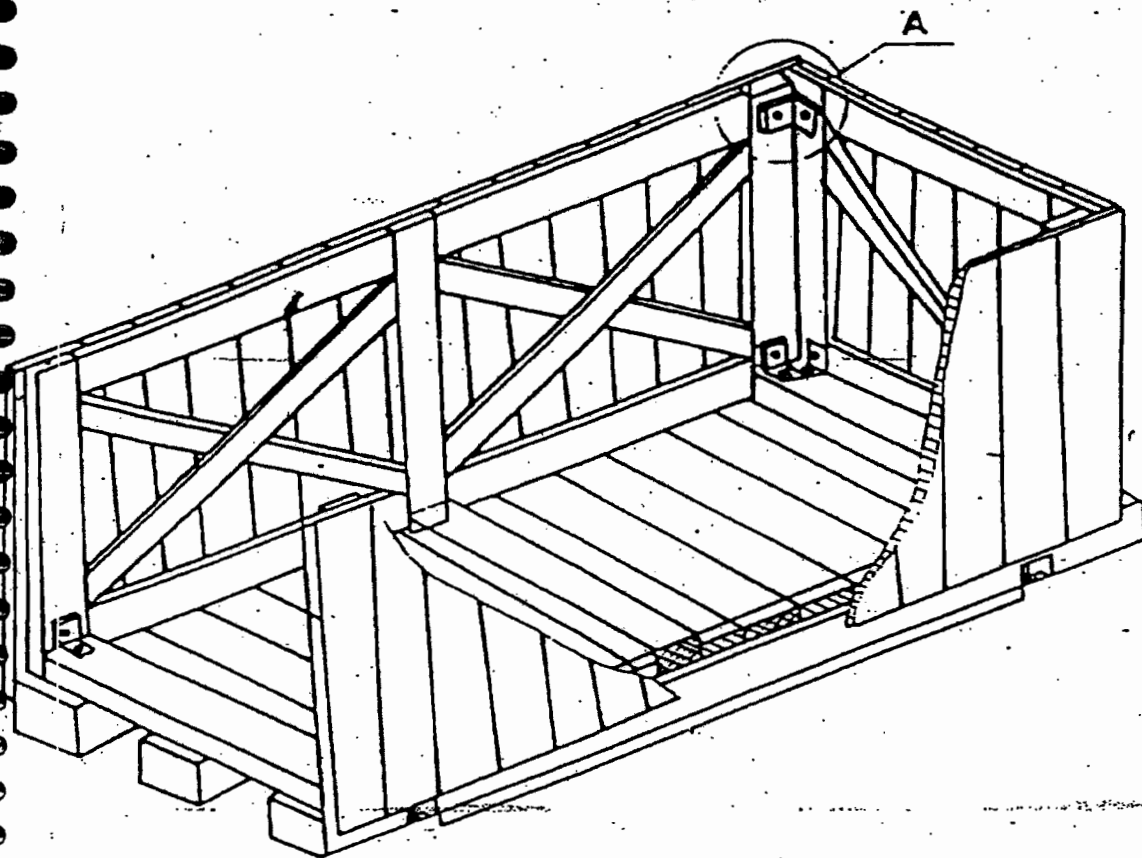
FIG: 7

1, 5, 6 - Vertical Support

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ARRANGEMENT OF PACKING CASE



DETAIL-A

HOLE DIAMETER
MUST CONFORM
TO BOLT DIA

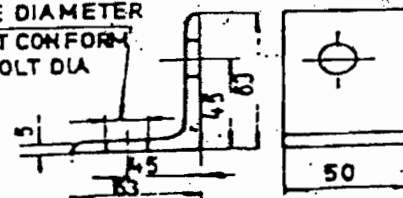

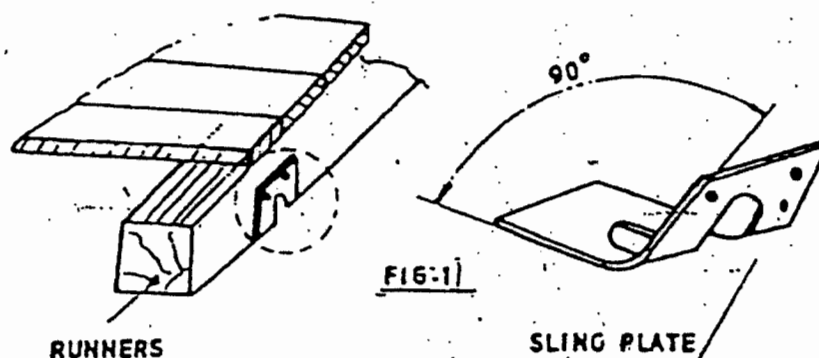


FIG:10

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ARRANGEMENT OF SLING & PLATE ON CASES



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TABLE-1

LOADS	LENGTHS OF SLIDES						
	600	800	1000	1200	1300	1500	2000
	Cross section b x c				<div style="border: 1px solid black; display: inline-block; width: 80px; height: 15px; vertical-align: middle;"></div> c b		
500	50 X 100	50 X 100	50 X 100	50 X 100	75 X 100	75 X 100	100 X 100
800	50 X 100	50 X 100	75 X 100	75 X 100	75 X 100	75 X 100	100 X 100
1000	75 X 100	75 X 100	75 X 100	100 X 100	100 X 100	100 X 110	100 X 150
1500	75 X 100	75 X 100	100 X 100	100 X 100	100 X 100	100 X 150	100 X 150
2000	75 X 100	100 X 100	100 X 100	100 X 150	100 X 150	100 X 150	150 X 150
2500	75 X 100	100 X 100	100 X 150	100 X 150	100 X 150	150 X 150	150 X 150
3000	100 X 100	100 X 150	150 X 150	150 X 150	150 X 150	150 X 150	150 X 150





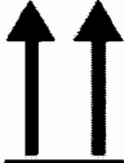




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Table-2








End and side panels	Width of the panel "W"	Distance between longitudinal support (Dimension "D")						
		600	800	1000	1200	1400	1600	1800
		Cross section b x c				Item 1 to 7		
Fig- 5 to Fig-9	600 to 1200	30	30	30	30	30	30	30
		X	X	X	X	X	X	X
	1201 to 1600	100	100	100	130	130	130	130
		X	X	X	X	X	X	X
	1601 to 2000	130	130	130	130	130	130	130
		X	X	X	X	X	X	X
	2001 to 3000	130	130	130	130	130	130	130
		X	X	X	X	X	X	X
	3001 to 4000	130	130	130	130	130	130	150
		X	X	X	X	X	X	X
		150	150	150	150	150	150	150


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INDICATION MARKS ON CASES/BOXES/CRATES

Designation	Symbol	Explanation
Fragile, Handle with care		The symbol should be applied to easily broken cargoes. Cargoes marked with this symbol should be handled carefully and should never be tipped over or slung.
Use no hooks		Any other kind of point load should also be avoided with cargoes marked with this symbol. The symbol does not automatically prohibit the use of the plate hooks used for handling bagged cargo.
Top		The package must always be transported, handled and stored in such a way that the arrows always point upwards. Rolling, swinging, severe tipping or tumbling or other such handling must be avoided.
Keep away from heat (solar radiation)		Compliance with the symbol is best achieved if the cargo is kept under the coolest possible conditions. In any event, it must be kept away from additional sources of heat. It may be appropriate to enquire whether prevailing or anticipated temperatures may be harmful.
Protect from heat and radioactive sources		Stowage as for the preceding symbol. The cargo must additionally be protected from radioactivity.
Sling here		The symbol indicates merely where the cargo should be slung, but not the method of lifting. If the symbols are applied equidistant from the middle or center of gravity, the package will hang level if the slings are of identical length. If this is not the case, the slinging equipment must be shortened on one side.
Keep dry		Cargo bearing this symbol must be protected from excessive humidity and must accordingly be stored under cover. If particularly large or bulky packages cannot be stored in warehouses or sheds, they must be carefully covered with tarpaulins.

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Center of gravity		This symbol is intended to provide a clear indication of the position of the center of gravity. To be meaningful, this symbol should only be used where the center of gravity is not central. The meaning is unambiguous if the symbol is applied onto two upright surfaces at right angles to each other.
No hand truck here		The absence of this symbol on packages amounts to permission to use a hand truck on them.
Stacking limitation		The maximum stacking load must be stated as "... kg max.". Since such marking is sensible only on packages with little loading capacity, cargo bearing this symbol should be stowed in the uppermost layer.
Clamp here		Stating that the package may be clamped at the indicated point is logically equivalent to a prohibition of clamping anywhere else.
Temperature limitations		According to regulations, the symbol should either be provided with the suffix "...°C" for a specific temperature or, in the case of a temperature range, with an upper ("...°C max.") and lower ("...°C min.") temperature limit. The corresponding temperatures or temperature limits should also be noted on the consignment note.
Do not use forklift truck here		This symbol should only be applied to the sides where the forklift truck cannot be used. Absence of the symbol on other sides of the package amounts to permission to use forklift trucks on these sides.
Electrostatic sensitive device		Contact with packages bearing this symbol should be avoided at low levels of relative humidity, especially if insulating footwear is being worn or the ground/floor is nonconductive. Low levels of relative humidity must in particular be expected on hot, dry summer days and very cold winter days.

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Do not destroy barrier		A barrier layer which is (virtually) impermeable to water vapor and contains desiccants for corrosion protection is located beneath the outer packaging. This protection will be ineffective if the barrier layer is damaged. Since the symbol has not yet been approved by the ISO, puncturing of the outer shell must in particular be avoided for any packages bearing the words "Packed with desiccants".
Tear off here		This symbol is intended only for the receiver.


FIG-12

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BHEL-PEM-DELHI-INDIA	
CONSIGNEE	
MATERIAL	
CUSTOMER REF.	MO. NO.
DESPATCH ADVICE NOTE NO.	CASE NO.
DIMENSIONS(MM) LXBXH	NET WT -KGS
	GROSS WT -KGS
SPECIAL INSTRUCTIONS	HANDLE WITH CARE -- KEEP DRY DO NOT DROP -- DO NOT TILT

FIG-13: MARKING PLATE

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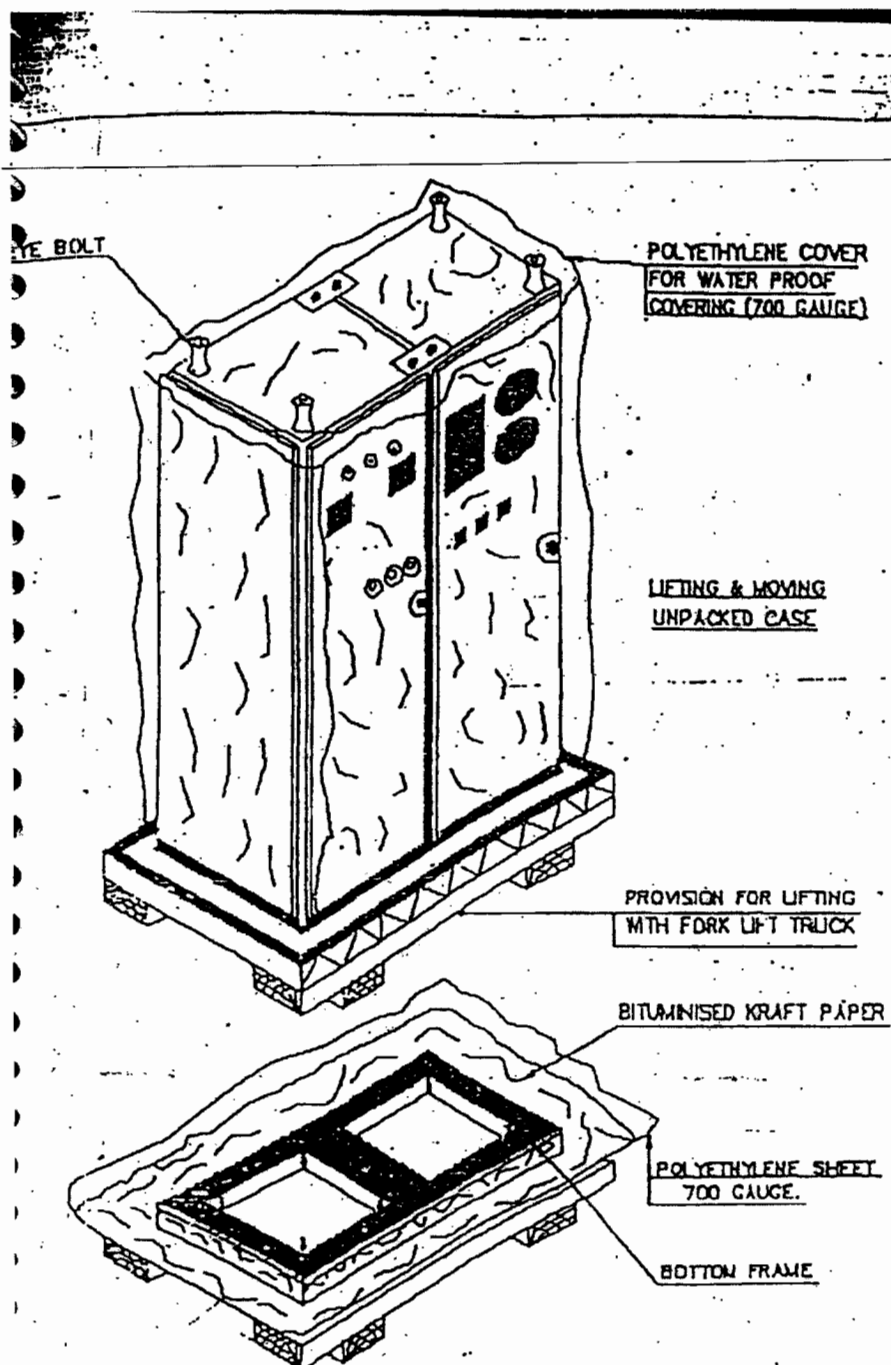



FIGURE-14

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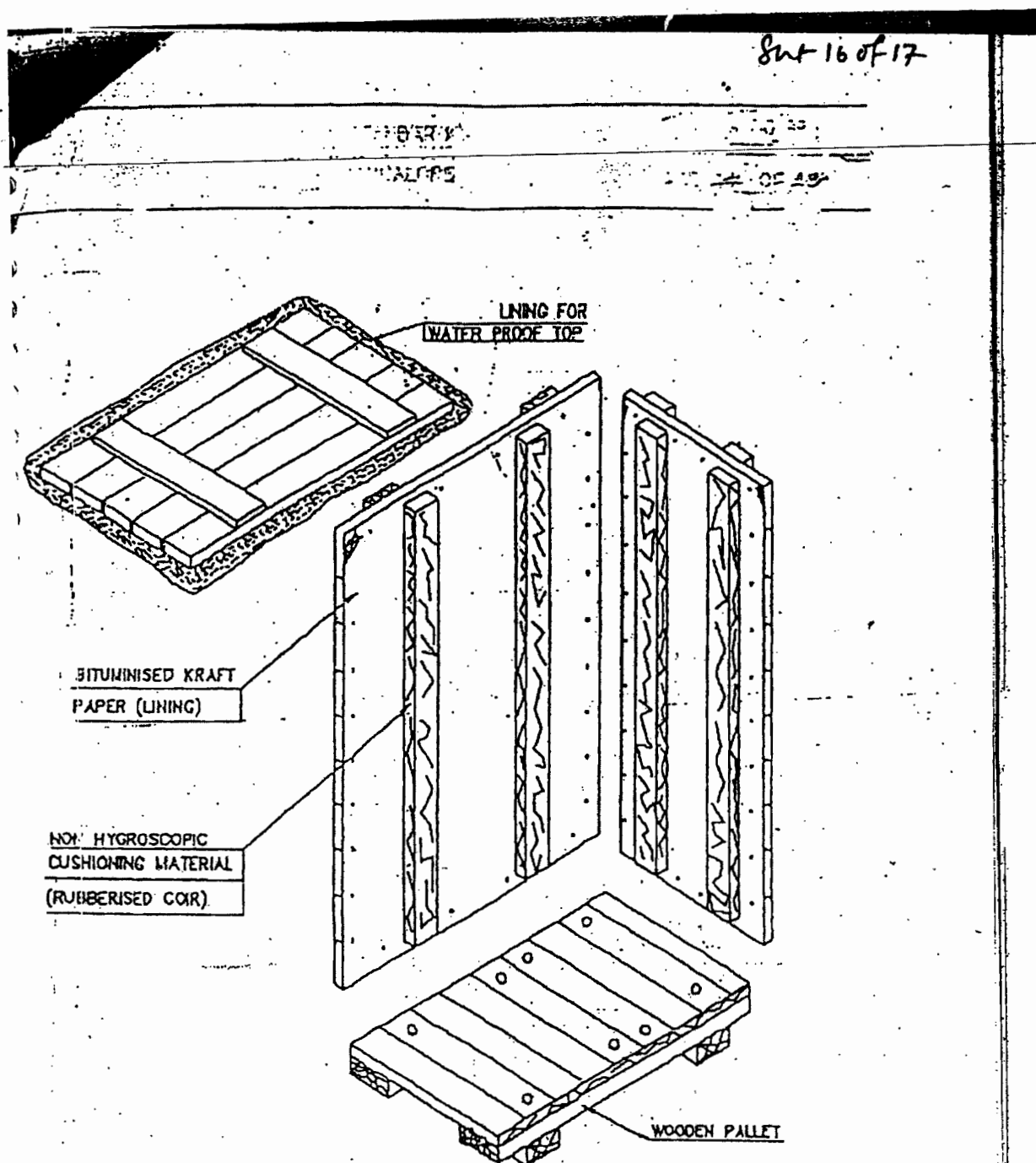

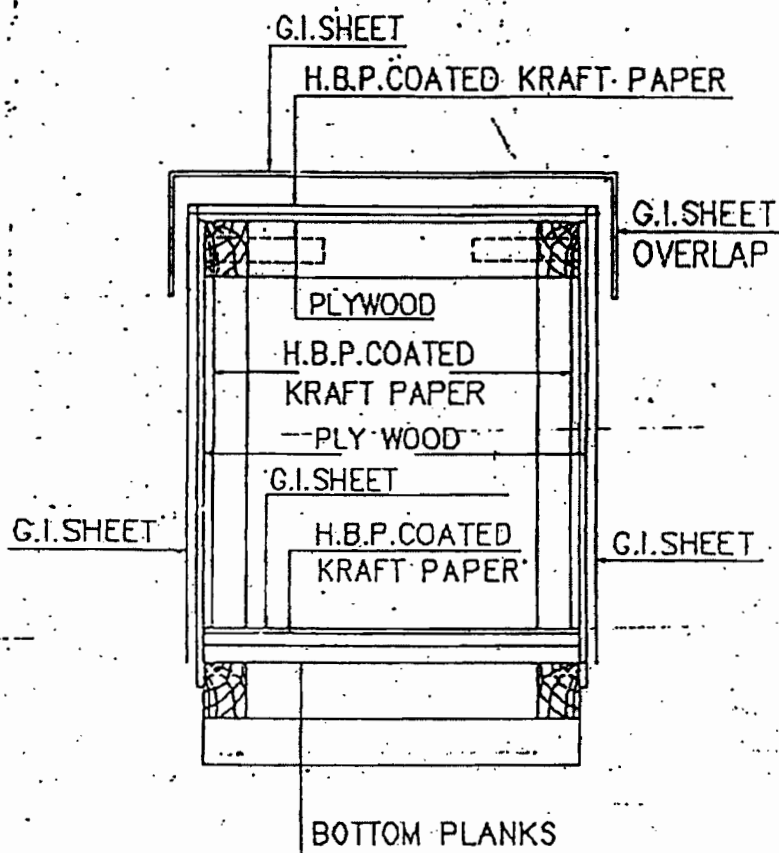



FIGURE-15

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**FIG-16 : CLOSED PACKING CASE WITH G.I.SHEET
SHOWING LAYERS OF PACKING MATERIALS.**

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10.0 TYPICAL PACKING DETAILS/PROCEDURE FOR MECHANICAL ITEMS

10.1 INSULATION MATERIAL (MINERAL WOOL MATTRESSES)

This specification covers the requirements of seaworthy packing and marking for bonded mineral (rock) wool mattresses having metallic hexagonal wire netting as facing on one or both sides.

10.1.1 TYPE OF CONSTRUCTION

Mattress shall be packed in Polythene (of 0.2 mm thickness) all around and sealed to prevent moisture absorption during transit and storage. Further it shall be wrapped with Bitumen coated Polythene bonded/lined Hessian and stitched and then packed in 5 ply DFC carton box.

Silica gel is used for this purpose to protect contents over sufficiently long time from corrosion. Silica gel shall be of indicating type conforming to IS:304-1979 packed in cotton bags placed at different positions inside the packing for absorbing moisture and shall not come into direct contact with the material inside the package. The quantity of silica gel shall be enough for storage period of one year. However, it shall not be less than 4 gms per litre volume of case subject to minimum of 400 gms per case.

Each mattress as well as the packages shall be serial numbered. Also, printed sheets indicating the nominal thickness, density and wire netting details (i.e. material and size) shall be placed below the wire netting.

Following details shall be legibly written on the packages. The details shall also be typed on a sheet of paper & kept in a sealed Polythene cover, inside the packages


- a) Project Name
- b) Purchase Order No.
- c) Sl. No. of package
- d) Size of mattress (Thickness x Length x Width)
- e) Density
- f) Wire netting material and size
- g) Weight of the package

10.2 INSULATION MATERIAL (ALUMINIUM COIL)

Heavy Gauge Aluminium Coil Packaging are done by Eye-to-Sky packaging or by Eye to eye packaging as per the proven practice being followed by manufacturer of Aluminium sheets.

10.2.1 Type of construction for Eye to Sky packaging

- a. Strapping of coil with polyester strap around circumference at one place.
- b. Putting paper I. D. Edge protector.
- c. Wrapping the coil with VCI stretch film after putting silica gel bags (4 nos.) Inside the coil.
- d. Wrapping the coil with HDPE film.
- e. Covering the coil including its build up & bore with masonite / particle board.
- f. Putting metallic I. D on coil.
- g. Putting O.D edge protector (paper) on coil.

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- h. Putting circumferential polyester strap (3 nos.) & eye polyester strap (4 nos.).
- i. After placing the coil on coil tilter ply wood (10mm thick) of suitable size along with wooden pallet is to be put at the bottom side of the coil.
- j. Coil is to be tilted to eye-to-sky position.
- k. Final strapping with metallic strap to unit coil and skid at 2 places with top cover of plywood.
- l. Fixing the coil with wooden blocks at 4 corners.
- m. Labeling 2 nos.(one metallic & one adhesivetype) For specification, net wt. & gross wt.

10.2.2 Type of construction for Eye to Eye packaging


- a. Strapping of coil with polyester strap around circumference at one place.
 - b. Putting paper I. D. Edge protector.
 - c. Wrapping the coil with VCI stretch film after putting silica gel bags (4 nos.) Inside the coil.
 - d. Wrapping the coil with HDPE film.
 - e. Covering the coil including its build up & bore with masonite / particle board.
 - f. Putting metallic I. D on coil.
 - g. Putting O.D edge protector (paper) on coil.
 - h. Putting circumferential polyester strap (3 nos.) & eye polyester strap (4 nos.).
 - i. Placing of coil on wooden skid Coil is to be tilted to eye-to-sky position.
 - j. Final strapping of coil and skid at 2 places with steel strap. Fixing the coil with wooden blocks at 4 corners.
- Labeling 2 nos.(one metallic & one adhesive type) For specification net wt. & gross wt.

10.3 Packing Procedure for Online Tube Cleaning System and accessories


This procedure is applicable for the shipment of Onload Tube Cleaning System and accessories by sea.

10.3.1 Packing details:

- The Packing case shall be made of treated rubber wood. The design of the case shall be as per Annexure IIIA & IIIB.
- The Equipments shall be placed on the wooden base of the Packing case and fastened if required to arrest the movement of the same.
- Equipment shall be covered by Polythene sheet and inside wall surfaces of the wooden cases also shall be covered by polythene sheet.
- All Nozzles shall be closed with plywood dummies.
- All electrical components assembled or loose shall be covered with polythene sheets along with silica gel pack.
- Silica gel desiccants shall be kept inside each case in sufficient quantities in order to absorb the moisture.

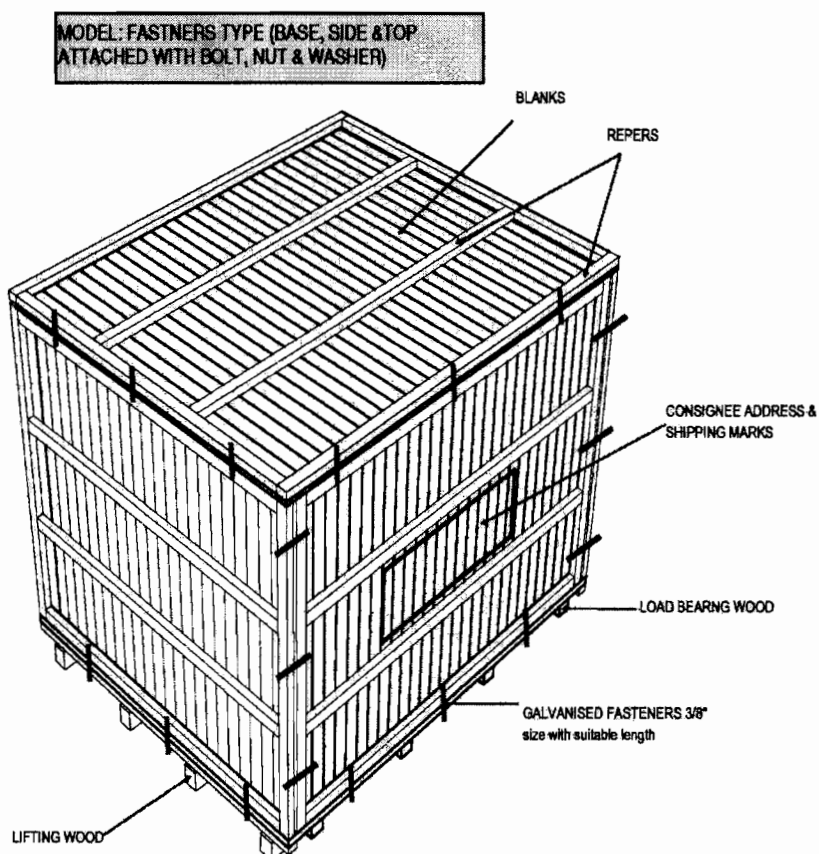
	TITLE TECHNICAL SPECIFICATION FOR SEAWORTHY PACKING FOR EXPORT JOBS	SPECIFICATION NO. PE-TS-888-100-A001	
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- Thermocol packing shall be made for glass items like Ball vessel sight glass, Vpiece
- sight glass & pressure gauge.
- Silica gel desiccants shall be kept inside of each case to absorb the moisture.
- A Packing list covered in a polythene envelope shall be fixed inside and outside of each packing case.
- Shipping marks and consignee address shall be painted on the outer surface of the case.
- All handling instruction required for the case like top, sling, rain, handle with care etc, shall be marked on the case as per the symbol attached.
- Machined surface will be applied with Anti rust oil and covered by polyurethane sheet to protect from external oxidation.
- All valves will be closed with dummies to protect the internals and placed in the wooden case which will covered by polyurethane sheet.


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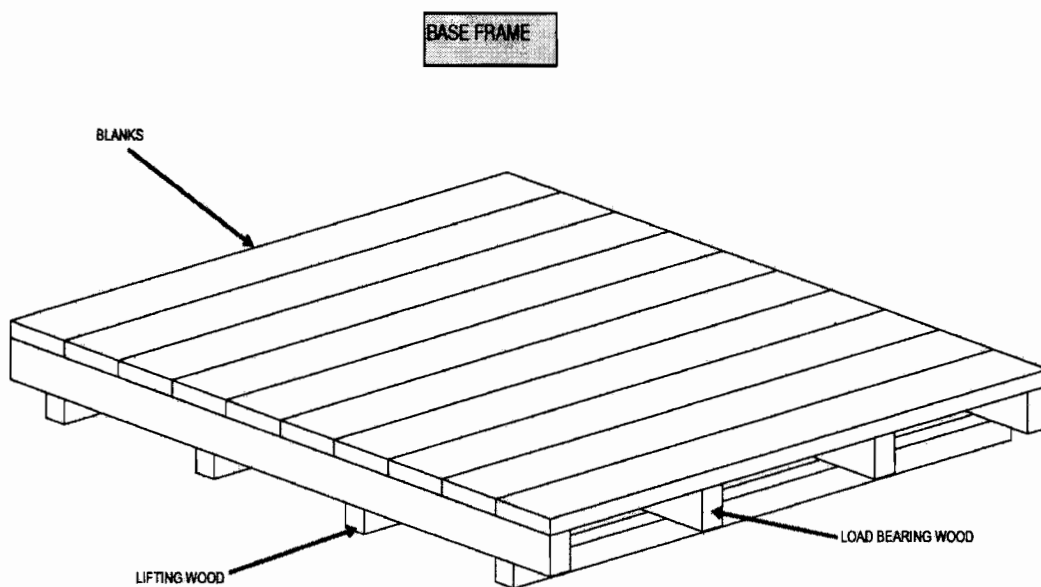
This Type of case to be used for following items:

1. BALL SEPERATOR
2. BALL COLECTOR SKID




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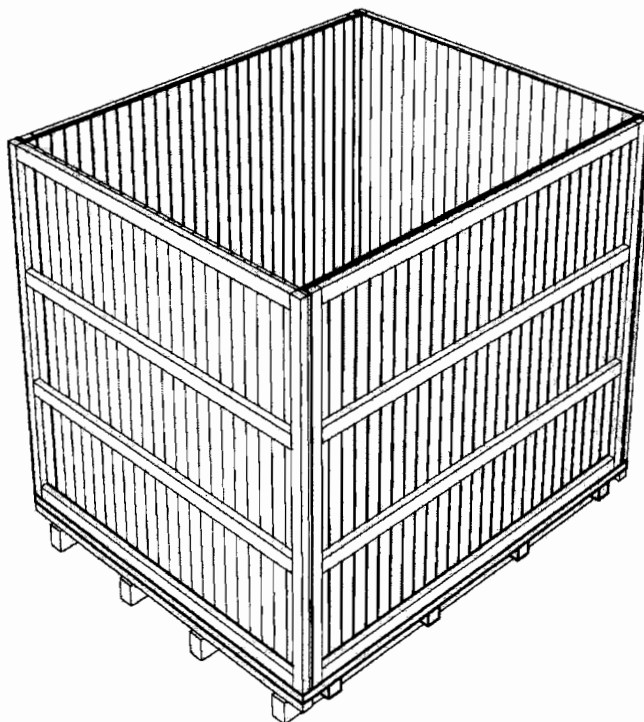
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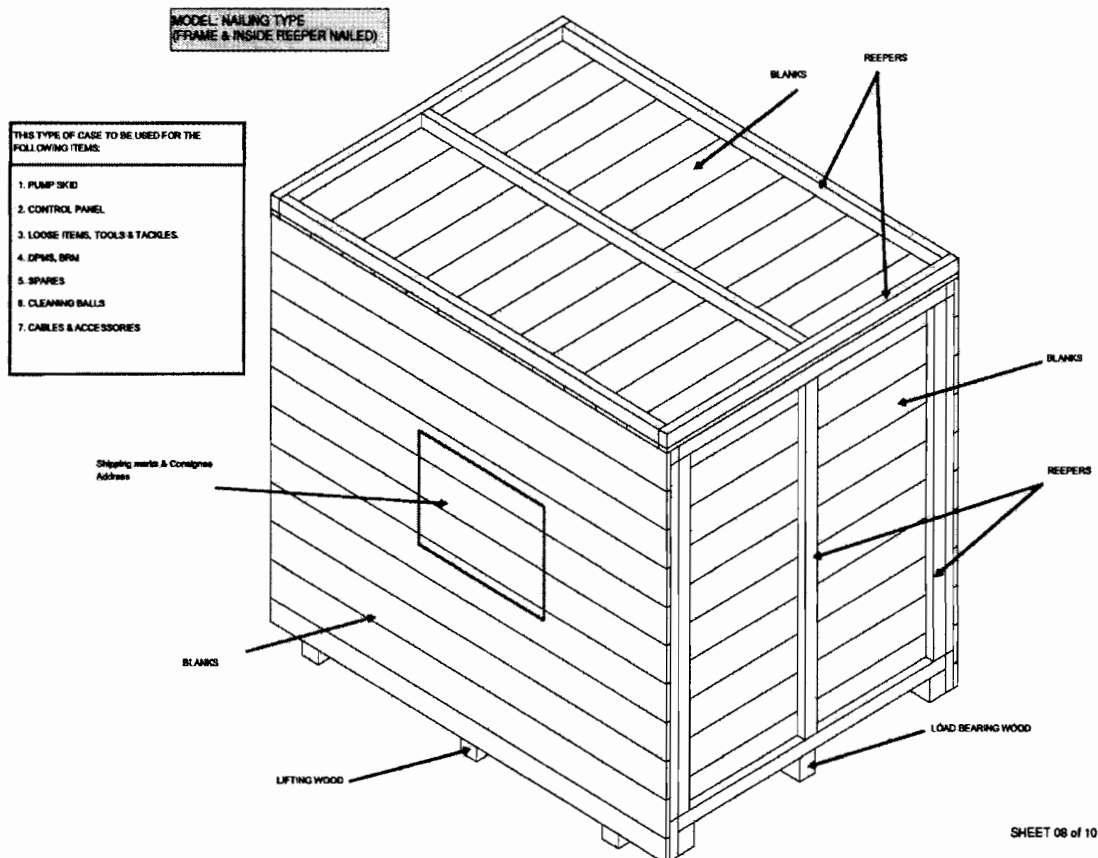
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MODEL: FASTNERS TYPE - WITHOUT TOP




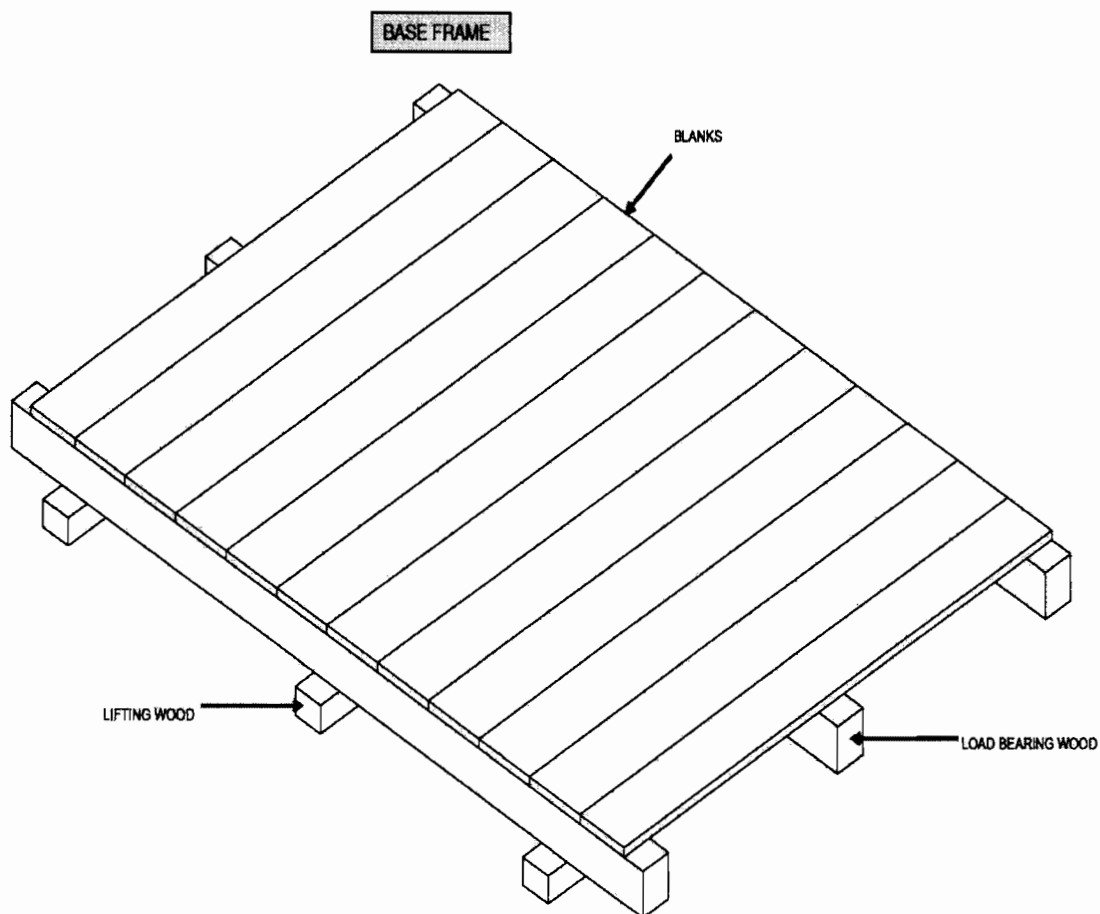
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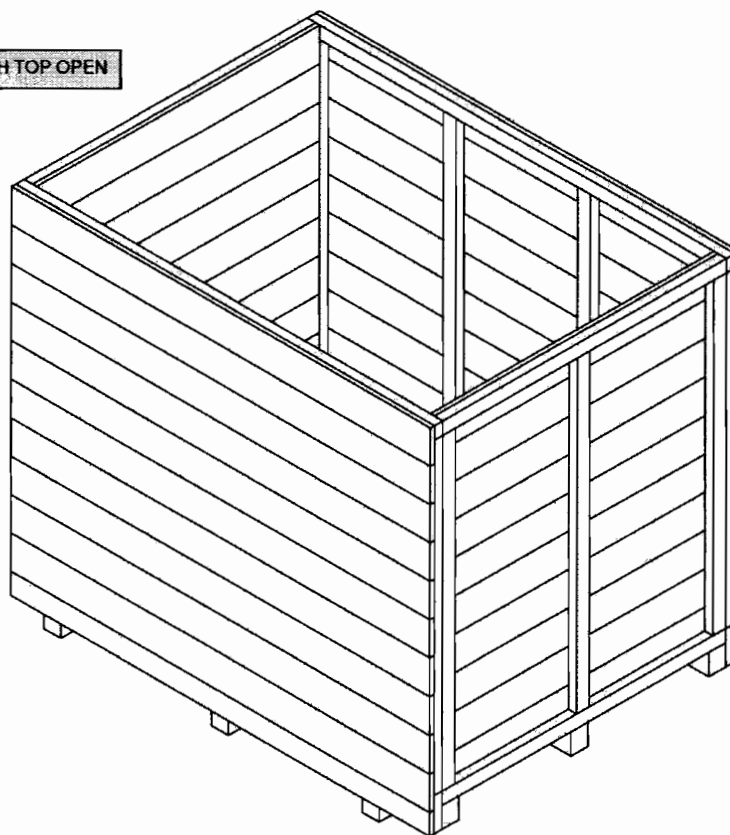
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NAILING TYPE MODEL WITH TOP OPEN



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10.4 PACKING OF LOOSE ITEMS

Loose mechanical, electrical and C&I items e.g. valves, fittings, pressure/temperature gauges/switches, circuit breakers, relays etc shall be individually wrapped using polyethylene sheets/U foam/ thermocol sheets/air bubble sheets depending upon the items and then packed in wooden boxes. The left out spaces and top of the boxes shall be filled with rubberized coir to get proper cushioning effect, Special attention shall be paid to relays, instruments etc for arresting the movements of their operating mechanism during transportation.

The construction of wooden packing cases shall be as per clause 9.3.1 retaining its all features concerning strength of the box. The construction of wooden packing case for electrical and C&I items shall be as per fig-16.

Inner surface of 6 sides of the box shall be lined with bitumen coated hessian polyethylene kraft paper. Rubberized coir of min. 25mm thickness and 100 mm width shall be nailed to inner surfaces of bottom and 4 sides of the boxes.


11.0 PACKING OF ELECTRICAL ITEMS

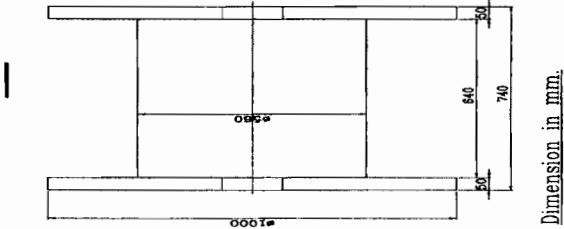
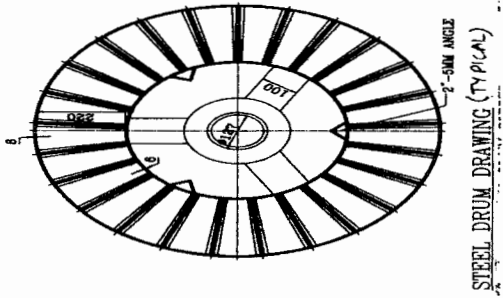
11.1 CABLES


11.1.1 **Type of Equipment** All type of cables..

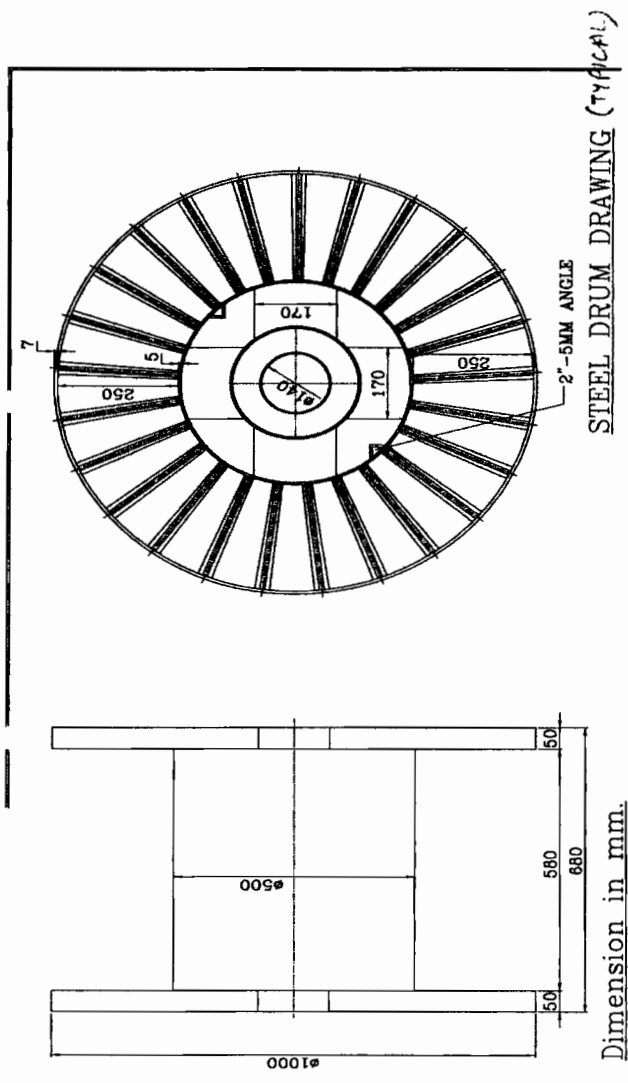
11.1.2 **Type of Construction**

New or practically new cable drums made of steel and painted with epoxy resin paint are to be used. Cable ends are carefully protected before packing. Over the cables polyethylene sheet shall be wrapped and then sealed properly. Cable drum can be put in wooden crates for ease in transportation and handling. (Wooden cable drum is also acceptable, however vendor to furnish constructional details for approval).

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11.2 PACKING OF CABLE TRAYS & ACCESSORIES AND CABLE TRAY SUPPORT MATERIAL

11.2.1 Cable trays can be packed in wooden boxes as per fig 1 to 11 or in steel boxes. Details of steel box construction is as indicated below.

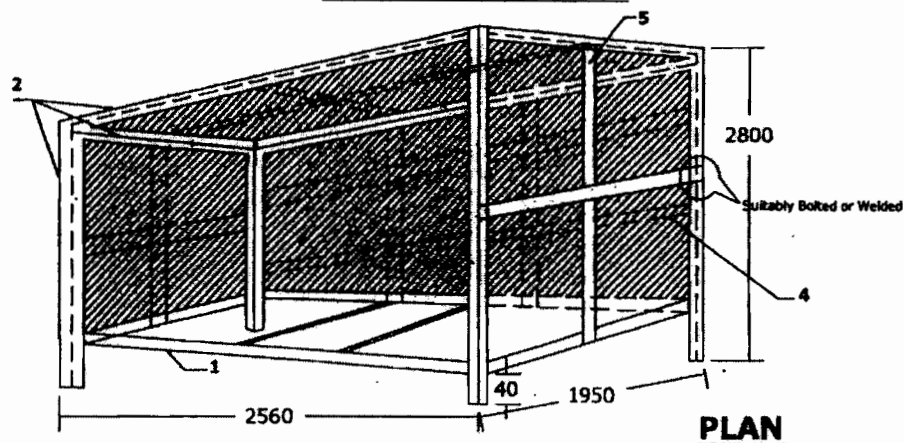
- 1) All Dimensions are in "mm" unless otherwise stated.
- 2) Packing Box shall be fabricated using 50x50x6mm MS Angle, 50x3mm Flat, 2.5 mm thick C Channel, 1mm & 1.6mm Thick sheet.
- 3) Finish of Packing Box Shall be Galvanized.
- 4) Angle & Channel Section forming part of the Main frame shall be welded thoroughly with each other to give a rigid structure.
- 5) Sheet Section and Flat section shall be bolted/ Riveted/ Welded suitably to the Main frame stated in '4' above.

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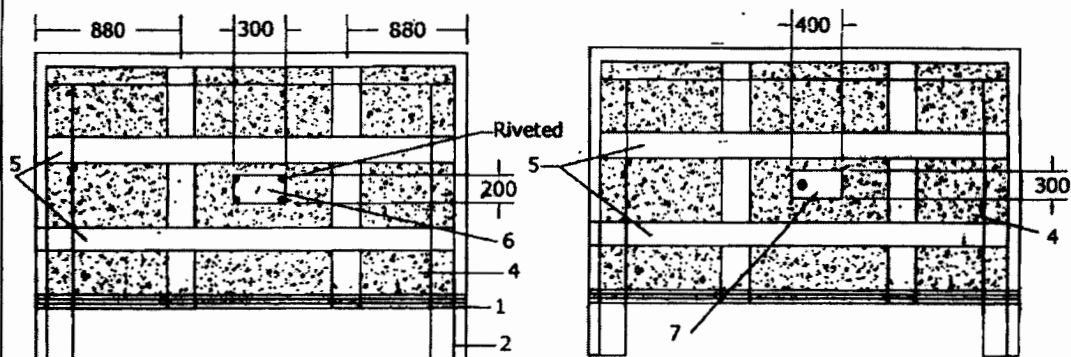
- 6) Welding Portion on galvanized surfaces shall be painted with Zinc Rich Paint.
- 7) Dispatch details such as consignor/consignee address, contract and case details, 'country of origin, port of delivery, stacking instructions shall be written on one of the side of boxes. An anodized aluminium plate as per details and specifications given in page 3 of 5 shall be provided on the boxes
- 8) One copy of packing slip wrapped in polythylene bag covered with suitable aluminium .packing slip holder to be nailed on the external surface of the box. One more copy 9f the packing Slip wrapped in polythylene bag to be kept inside the box at the prominent place.
- 9) **INDICATION MARKS ON THE BOXES:** Markings shall be provided on the boxes indicating position of Boxes for handling, storage and nature of consignment. For guidelines referred page 4 of 5. The ink issued for this purpose as well as for marking dispatch instruction shall be indelible/non-washable marking ink.
- 10) Each item as mentioned in BOQ shall be packed & supplied as a set comprising of required numbers of associated fasteners & hardware etc

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STEEL PACKING (TYPICAL DETAILS)

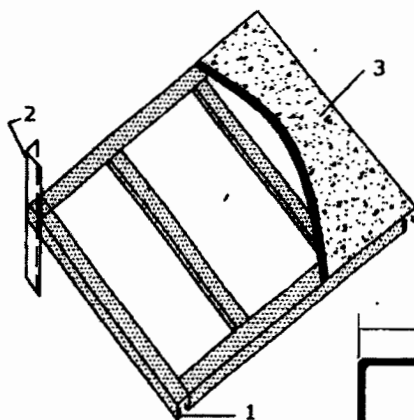


PLAN



FRONT SIDE OF BOX

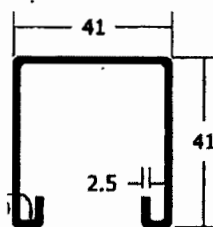
BACK SIDE OF BOX




BOTTOM FRAME ARRANGEMENT

Note:

1. "C" Channel to be used on Bottom Frame.
2. 50x50x6 Angle to be used Vertically on four sides of the Box and Horizontally on four sides on the top Frame.
3. 1.6mm thick sheet (plain) on Bottom Plate.
4. 1.0mm thick sheet to cover top & four sides of BOX.
5. 50x3 Flat as additional cross members to be used Horizontally & Vertically on top & Four Sides of Box.
6. Anodised Aluminium Plate for Marking.
7. Hinged Inspection Window.



DETAILS OF "C" CHANNEL

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11.3 PACKING FOR STATION LIGHTING SYSTEM

Aspects of packing specific to equipments / items of station lighting system are given here. All other instructions / aspects as per the main specification of export packing which are not covered here shall also be applicable.

11.3.1 For LIGHTING TRANSFORMER, DISTRIBUTION BOARDS, LIGHTING PANELS,

- Construction of packing case for LIGHTING DISTRIBUTION BOARDS, LIGHTING PANELS, TRANSFORMER . shall be EITHER as per FIGURE 1,2,3,5,6,7,8,9,10,11 OR FIGURE 14,15,16.
- Each Panel/Transformer shall be individually covered with double polythene sheet of thickness 175 microns minimum.
- All the 6 inner surfaces of packing shall be nailed with bitumen coated hessian polythene craft paper. Wherever 2 pieces of craft paper are used, the joint shall have minimum overlap of 20mm.

For the top frame it shall be project on all sides by 100mm and shall be nailed on sides .

- The gap between the panels and packing case shall be filled with rubberized coir of thickness 50mm minimum and width 100mm. The distance between two consecutive supports of rubberized coir shall be less than 500mm.
- Silica get packed in cotton bags shall be placed at different positions inside the packing.
- Packing case shall be finally covered with GI sheet of thickness 0.4mm minimum.

11.3.2 For LUMINARIES, RECEPTACLES. EMERGENCY LIGHT, 240/24V TRANSFORMER, CEILING FAN, SWITCH BOARDS, FLEXIBLE CONDUIT, WIRES, EARTH WIRE. JUNCTION BOXES, ERECTION COMMISSIONING SPARES, RECOMMENDED SPARES , ERECTION MATERIAL AND CONSUMABLES

- Construction of packing case for THE ABOVE MATERIAL shall be as per FIGURE 1to11.
- Items placed inside the case shall be covered with double polythene sheet of thickness 175 microns minimum.
- All the 6 inner surfaces of packing shall be nailed with bitumen coated hessian craft paper. wherever 2 pieces of craft paper are used, the joint shall have minimum overlap of 20mm. For the top frame it shall be project on all sides by 100mm and shall be nailed on sides.
- Silica get packed in cotton bags shall be placed at different positions inside the packing.

11.3.3 For CONDUIT PIPE


As per international practice pipes are shipped in open bundles with metal strapping. Packing as per attached figure A shall be provided which is described as following:

- Each bundle shall be wrapped with 2 layers of 175 microns thick polythene sheet.
- Then bundle will be wrapped with bitumen coated hessian craft paper.
- Bundle shall be strapped with steel straps.
- An anodized aluminium packing description plate as per Figure No. 13 shall be provided.

11.3.4 For POLES


Poles will be wrapped with 2 layers of minimum 175 microns thick polythene sheet and then with bitumen coated hessian craft paper, packed as per Figure – C i.e. bundling.

11.3.5 For STRUCTURAL STEEL

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Structural steel will be different sizes and shapes. Hence it will be packed as per Figure No. B and described as following :

- a) Each bundle shall be wrapped with 2 layers of 175 microns thick polythene sheet.
- b) Then bundle will be wrapped with bitumen coated hessian craft paper.
- c) Bundle shall be strapped with steel straps.
- d) An anodized aluminium packing description plate as per Figure No. 13 shall be provided.

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PACKING PROCEDURE FOR CONDUIT PIPE

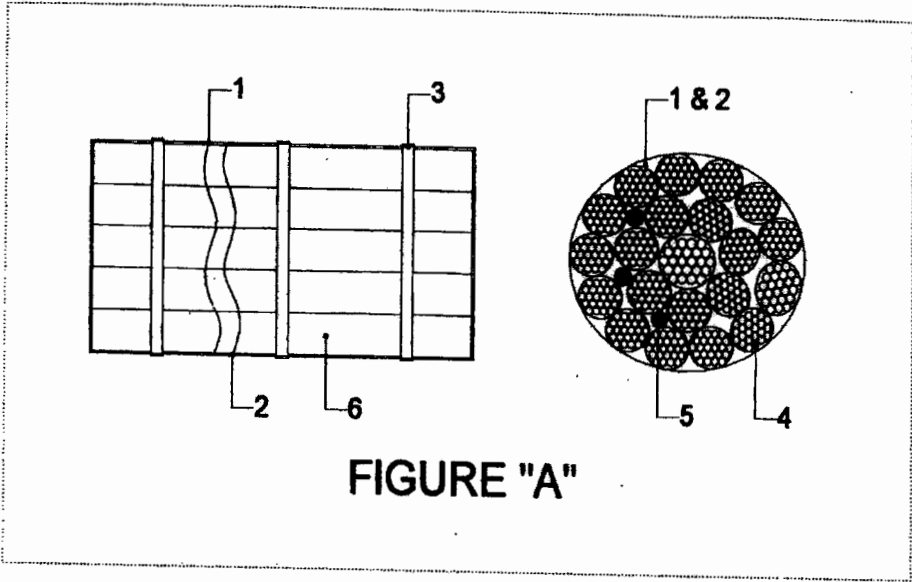



FIGURE "A"

- 1) LAYER OF BITUMEN COATED HESSIAN KRAFT PAPER.
- 2) LAYER OF POLYTHENE SHEET.
- 3) METAL STRAPPING.
- 4) CONDUIT PIPES.
- 5) SILICA GEL POUCHES.
- 6) BUNDLES OF CONDUIT PIPES.

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PACKING PROCEDURE FOR STRUCTURAL STEEL

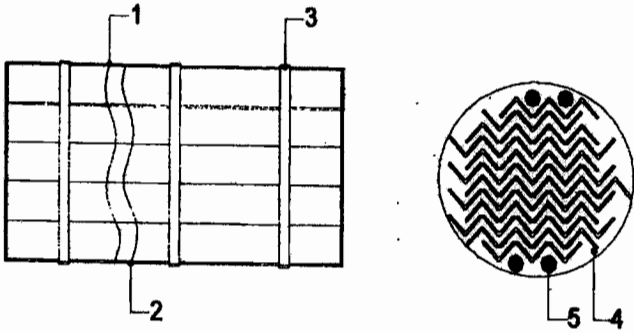

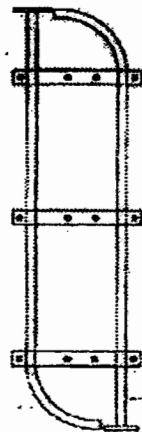


FIGURE "B"

- 1) LAYER OF BITUMEN COATED HESSIAN KRAFT PAPER.
- 2) LAYER OF POLYTHENE SHEET.
- 3) METAL STRAPPING.
- 4) STRUCTURAL STEEL.
- 5) SILICA GEL POUCHES.

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packing procedure for poles



POLES WRAPPED WITH POLYTHENE SHEET &
EXTENDING COATED HESSIAN CLOTH



TOP WOODEN BATTEN TO BE
FIXED WITH L50x80x8 MM ON TOP
OF IT FOR TIEING THE ROPE
25 MM DIA



BOTTOM WOODEN BATTEN TO BE
FIXED ON L50x80x8 MM ANGLE

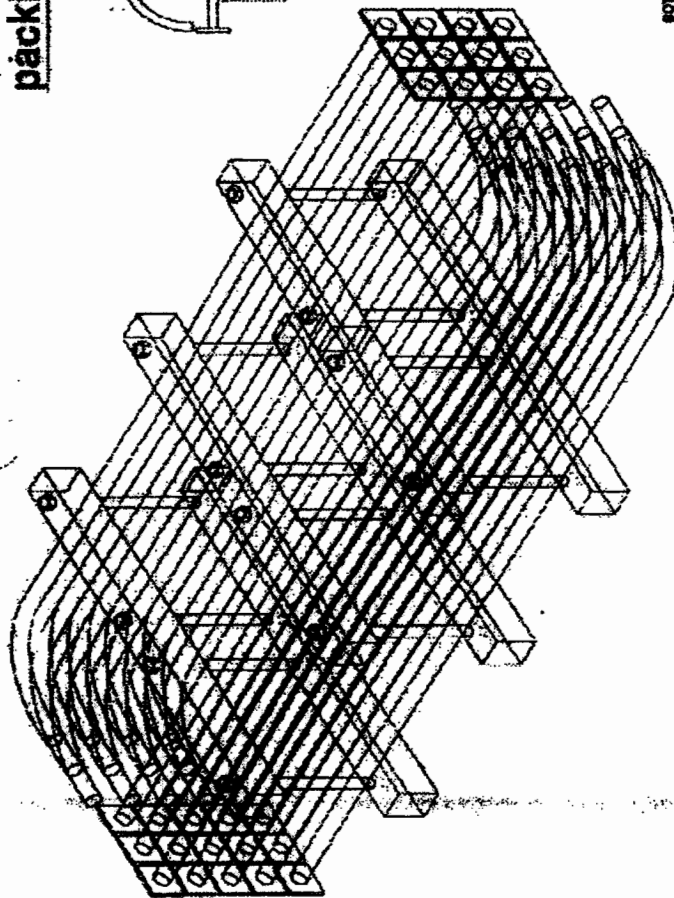



FIGURE "C"

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11.4 PACKING FOR DC BATTERY

The packing procedure for seaworthy packing of DC Battery is defined below, which is capable of withstanding impacts, compression, vibration, toppling, sea water spray, prevention against rust, temperature and extreme atmospheric conditions. Aspects of packing specific to equipments / items of DC Battery are given here. All other instructions / aspects as per the main specification of export packing which are not covered here shall also be applicable.

The packing procedure consists of various stages namely primary packing, cushioning, securing, desiccant, outside packing box, Runners/ sliders/ transverse bars of plywood, etc., provided for each movement.


- a) The packing boxes shall be made up of plywood boxes (thickness 9mm min.) with blocks at the bottom of the box for provision for handling the boxes using the forklift. The packing boxes sizes are generally standardized to half-euro size (capable of handling equipment's weight).
- b) Rubberized coir of 25mm thickness shall be provided as cushioning material at the bottom and thermocole of 20mm shall be provided inside on all four sides. Other than this polyethylene film wrap or cover also will be provided. Left out spaces to be filled with rubberized coir/ thermocol to get cushioning effect.
- c) Silica gel in dust free air permeable cotton/paper bag shall be placed in the packing boxes for storage period of 1 year as per IS 304 (1979)
- d) While packing the cells, transit caps (polypropylene) of red and blue shall be used for big size cells for ensuring that cells does not get damaged during the transport due to vibrations etc.
- e) The battery accessories shall be packed with suitable precautions as follows:
 - i) Copper connectors shall be packed after making bunches with lead wire seals to avoid misplacement.
 - ii) Hardware items shall be packed in polyethylene bags (Thickness $\geq 0.175\text{mm}$) with item slip
 - iii) Battery rack shall be packed in dismantled condition, wrapped with polyethylene sheet
 - iv) For Ni-Cd type battery, electrolyte in solid form for dry cells shall be packed in cans with KOH, LiOH being packed separately.
 - f) Galvanized Steel straps are provided for binding the packing box sides.
 - g) The handling instructions shall be marked in indelible/ non-washable ink, indicating the upright position.

11.5 PACKING OF SERVICE TRANSFORMERS(OIL FILLED) & ACCESSORIES

This instruction is applicable for packing of transformers (oil filled), its accessories and components so as to ensure safe delivery to end user. Aspects of packing specific to equipments / items of transformers(oil filled) are given here. All other instructions / aspects as per the main specification of export packing which are not covered here shall also be applicable.

11.5.01 PACKING DETAILS :

- a) Items shall be packed in case / crates as per the shipping list.
- b) All fragile items and small items shall be packed in cases and to be marked as "Fragile, handle with care Fragile items".
- c) Fragile accessories are to be first packed in their original boxes (VENDOR's packing). Very

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- d small / delicate items such as glass thermometer, door keys shall be packed in separate box.
- d In case original box is found damaged, suitable alternate box or packing method using felt or foam sheet and polythene wrap to be used.
- e These boxes are then placed in identified wooden boxes. Inside of such boxes are lined with a layer of polythene sheet, packing wool / grass and another layer of polythene sheet before placing the boxes. All boxes are then wrapped with this polythene sheet before closing the box. Fragile items shall not be placed loose, one above the other inside the case.
- f All wiring cables, connection flats of non-ferrous materials, CTs, valves bellows shall also be packed.
- g Items like CTs, Oil communicating bushings, insulators, wired equipments and housings such as RTCC Panel, M. Box, Drive Mechanism, thermometers, gauges shall be wrapped in polythene from all around.
- h Buchholz relay and OSR relay openings will be blanked using covers, before putting them in the box
- i Items shall be carefully lowered and arranged inside the crate / case and each item shall be locked from all sides in such a way to avoid its movement in any way. Wooden stoppers and separators shall be provided for this and nailed to the crate / case wood.
- j Wooden planks and batons in contact with fragile items shall be provided with kit foam at the locations of contact.
- k Oil communication bushings shall be packed in separate case on V or U shape wooden felted supports, as in case of condenser bushings.
- l While placing and arranging the items inside the crates / cases, these shall be verified for correctness and then the packing note shall be signed. The cover top of the crate / case shall then be closed.
- m The main equipment like transformer tank shall be packed suitably to prevent any damage during transit / storage. Support structures like frame, header supports etc. shall be crated. Conservator headers shall also be crated. Radiators pipe work and other instruments & components shall be packed in cases. All the cases shall be lined with polythene from inside.

11.6 ALTERNATIVE PACKING CASES FOR CONTROL PANELS AND SWITCH GEARS

For Control and switch gear panels, construction of wooden packing cases may be provided as per fig 14 & 15 and as detailed below.

Thickness of planks for all sides, binding and jointing battens shall be at least 25 mm. Width of the plank shall be at least 125mm and that of binding and jointing planks shall be at least 100mm.


Top frame shall be suitable so that it does not collapse due to sandwiching between slings while lifting. Longitudinal and traverse bars for the bottom wooden pallet to be suitably selected.

Diagonal bracings shall be as per cl 9.3.1.3 and all other requirements shall be as per clauses 9.3.1.4 to 9.3.1.6.

12.0 Containerization

As required by BHEL, the VENDOR shall stuff the GOODS into 20 or 40 foot containers (dry, open top, flat racks, etc.).

The maximum inside dimensions of containers are to be considered:

	TITLE TECHNICAL SPECIFICATION FOR SEAWORTHY PACKING FOR EXPORT JOBS	SPECIFICATION NO. PE-TS-888-100-A001			
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- 40 foot containers: 11.80 m x 2.20 m x 2.05 m
- 20 foot containers: 5.80 m x 2.20 m x 2.05m
-

The present definition of containerization is valid for sea containers only. Vendor to check the size of containers before start of packing of equipment.

12.1 Protection of Cases/Crates

Since shipping containers are in general not water tight, packing in contact with the floor of the container shall be raised in order to prevent it from being damaged by the accumulation of water.

12.2 Mechanical Constraints

The mechanical constraints for "general use" closed containers are of a different nature (height of "stacking" being limited inside the containers), the packing for the GOODS may be of a lighter structure. However, it is necessary that the packing be appropriate so as to protect the GOODS on site during the storage period, as required after discharging of the GOOD'S from the containers.

Note:

It is the responsibility of the VENDOR to ensure that the cases/crates are stowed, secured and fastened inside the container. The VENDOR will take all necessary precautions to conform to the maximum weight allowed and the centre of gravity of the container. The securing and fastening of the cases/ crates can be carried out by nailing timbers on the bottom or on the vertical sides of the container.

13.0 Other Services to be provided by Vendor

In addition to the packing and shipping documents, VENDOR must also carry out the following services, which shall be included in his quotation:

Carriage of VENDOR's sub-contracted equipment and material, which must be re-grouped in VENDOR's or PACKER's workshops, whilst waiting for packaging.

BHEL reserves the right to postpone the shipping of the GOODS. In this event, any storage and insurance costs during the first ninety (90) days shall be borne by the VENDOR.

Loading, including lifting, securing, lashing, and stowing, of all cases, crates, or packages onto means of transportation such as, but not limited to, trailers, containers, etc.

14.0 Responsibilities and Guarantees


VENDOR is responsible for the choice of category for packing according to the transport facilities used, and on the basis of the present document. In case of doubt or disagreement regarding the choice, VENDOR must inform BHEL prior to packing and await BHEL's approval. All phases of packaging, marking, loading, etc. will be subject to BHEL inspection.

BHEL reserves the right to reject the packing when the packing does not conform to these instructions and/or when the packing does not ensure perfect protection of the GOODS. VENDOR is responsible for the weights and dimensions declared, and the marking of the packages.


The documents must be in strict conformity with the packing contents.

The packing specified in these "Packing, Marking and Shipping Instructions" is guaranteed for a twelve (12) months storage period after delivery on site.

VENDOR is responsible for providing storage recommendation adapted to the GOODS. According to this guarantee, VENDOR is held responsible in the event of goods becoming

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useless, damaged or broken, as a result of poor packing and/or stowing, or due to corrosion, subsequent to insufficient or inadequate protection. All direct or indirect costs resulting thereof, will be back-charged to VENDOR.

	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
		ANNEXURE-VIII	
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ANNEXURE-VIII

PIPE & VALVE MATERIAL SPECIFICATION

1. General

This specification covers the basic requirements for the design and materials of process and utility piping for the Flue Gas Desulfurization Plant.

2. Material Selection

- 1) Basically, rubber lined pipes are selected to prevent the corrosion and erosion for process service, namely slurry line and other line possible to contact with raw gas.
- 2) Class AA60 is applied according to process line conditions.
- 3) For utility services, other classes are applied.
- 4) In principle, piping material will conform to ASTM, but ASTM equivalent material specified by other authorized code may be applied.
- 5) Non-asbestos type shall be used for Packing and Gasket.

3. Design of Piping Component

- 1) In principle, each component of all piping will be selected from ANSI ASME or international standard in the dimensions and other requirements.
- 2) Metric series are applied to the bolt thread.
- 3) Nozzle weld tees or extruded tees are used as branch connection in lined piping, in general.
- 4) Short radius elbow may be used for 550mm or larger size piping.
- 5) Fittings for 50 and smaller galvanized piping shall be of screwed type.

4. Piping Material

1) Symbols of Piping Service Class

Piping service class name is composed of the following symbols.

Example: A A 60

Suffix Number

Second Pipe Material Symbol

First Pipe Material Symbol

Note:

First Pipe Material Symbol	
A: Lining	AA: Rubber Lining
B : Stainless Steel	BA: 304 Stainless steel
C: Carbon Steel	CA: A53 Gr.B Welded
	CC: A53 Gr.B or A106 Gr.B/C
	CG: Galvanized

2) Class No. and Fluid Designation

CLASS NO.	FLUID NAME	SYMBOL	
AA60	Gypsum Slurry	GS	
	Filtrate Slurry	FS	
	Waste Water	WW	
	Duct Drain	DD	
	Beltfilter Vent Gas	VBG	
BA01	Instrument Air	AI	
	Lube Oil (Low Pressure)	LOL	
CC01	Process Water	WP	Note 1
	Raw Water	WR	
	Cooling Water Supply	WCS	
	Cooling Water Return	WCR	
	Vacuum Pump Vent	VG	
	Antifoam Agent	AA	

Note I

Class AA60 shall be applied for process water service line in contact with corrosive and abrasive media.

3) Abbreviations

Abbreviations used throughout this specification are as follows:

BB	:	Bolted Bonnet
BC	:	Bolted Cover
BE	:	Bevel End
BW	:	Butt Weld
CAL	:	Calculation
CR	:	Chloroprene Rubber
E	:	Electric Resistance Weld
EPDM	:	Ethylene Propylene Diene Methylene Rubber
Eq	:	Equal
FE	:	Flange End
FF	:	Flat Face
G. OP	:	Gear Operation
Gal.	:	Galvanized
HEX.	:	Hexagon
IIR	:	Isobutylene Isoprene Rubber

ISRS	:	Inside Screw Rising Stem
La	:	Larger
L.OP	:	Lever Operation
NB	:	Nominal Bore
NW	:	Nozzle Weld
OS&Y	:	Outside Screw & York
PE	:	Plane End
PP	:	Poly Propylene
PTFE	:	Poly Tetra Fluoro Ethylene
RF	:	Raised Face
R/L	:	Rubber lined or rubber seated
S	:	Seamless
SB	:	Screw Bonnet
SC	:	Screw Cover
SCH	:	Schedule No.
SCR'D	:	Screwed
Sm	:	Smaller
SO	:	Slip On
St.	:	Stelliting
SW	:	Socket Weld
W	:	Weld
WN	:	Welding Neck
W/LINING	:	With Lining
V#	:	Valve No.
13 CR	:	13% CHROMIUM

CLASS	Max. Press. (MPaG)		1.1		C. A. mm	CLASS
AA60 (1/1)	Max. Temp. (degC)		65			AA60 (1/1)
FLUID	GYPSUM SLURRY					
ITEM	Size	Thickness	Specification			ITEM No.
PIPING	DN25 – DN50	SCH40	A53-B SML PE (I:R/L) ASME			
	DN65 – DN150	SCH40	A53-B E. R. W BE (I:R/L) ASME			
	DN200 – DN300	SCH20	A53-B E. R. W BE (I:R/L) ASME			
	DN350 – DN400	SCH10	A53-B E. R. W BE (I:R/L) ASME			
	DN450 – DN500	SCH10	A53-B E. R. W BE (I:R/L) ASME			
	DN550 – DN1000	7.9T	A134 (A283-C) EFW BE (I:R/L) ASME			
	DN1100– DN1200	9.5T	A134 (A283-C) EFW BE (I:R/L) ASME			
FITTING	DN25 – DN50	Suit to PIPE	BW A234-WPB (I:R/L) ASME-B16.9			
	DN65 – DN150	Suit to PIPE	BW A234-WPBW (I:R/L) ASME-B16.9			
	DN200 – DN300	Suit to PIPE	BW A234-WPBW (I:R/L) ASME-B16.9			
	DN350 – DN500	Suit to PIPE	BW A234-WPBW (I:R/L) ASME-B16.9			
	DN550 – DN1000	Suit to PIPE	BW A134 (A283-C) EFW (I:R/L) ASME-B16.9			
	DN1100– DN1200	Suit to PIPE	BW A134 (A283-C) EFW (I:R/L) ASME-B16.9			
SMOOTH BEND	DN25 – DN80	Suit to PIPE	BW A53-B (I:R/L)			
FLANGE	DN25 – DN600		SO A105 ASME150 SO FF (I:R/L) ASME-B16.5			
	DN650 – DN1800		SO A105 AWWA CL.B SO FF (I:R/L) AWWA-C207			
PINCH VALVE	DN25 – DN150		PN 16 A126-B TRIM-13CR SLEEVE-CR LINING-IIR FF HAND WHEEL			
GASKET	DN25 – DN600		V-2000 RUBBER RUBBER OR EQ. ASME150 2.0T FLAT RING			
	DN650 – DN1800		V-2000 RUBBER RUBBER OR EQ. AWWA CL.B 2.0T FLAT RING			
BOLT & NUT	ALL SIZE		STUD U HEAVY NUT A307-GR.B/A563-GR.A FINISHED			
Note: I: R/L - Replaceable Wear Resistant Natural Rubber Lining of minimum 6mm thickness. Additional thickness of 2 mm rubber lining shall be provided in bends.						

CLASS	Max. Press. (MPaG)	1		C. A. mm
BA01 (1/1)	Max. Temp. (degC)	45		
FLUID	INSTRUMENT AIR, LUBE OIL			
ITEM	Size	Thicknes s	Specification	
PIPING	DN6- DN50	SCH40S	A312-TP304 SML PE ASME	
	DN65-DN250	SCH20S	A312-TP304 E. R. W BE ASME	
FITTING	DN6 - DN50	Suit to PIPE	3000LB SW A182-F304 ASME-B16.11	
	DN65 - DN250		BW A403-WP304 ASME-B16.9	
FLANGE	DN6 - DN50	Suit to PIPE	SW GR. 304 GR. 304 ASME150 SW RF ASME-B16.5	
	DN65 - DN250		LOOSE A105 ASME150 LOOSE ASME-B16.5	
GATE VALVE	DN6 - DN50		API-602 PN 16 A182-F304 AISI304 SW BB, OS&Y HAND WHEEL	
	DN65 - DN250		ASME-B16.34 PN 16 A351-CF8 AISI304 RF BB, OS&Y HAND WHEEL	
GASKET	DN6 - DN150		V-6500 NON-ASBESTOS OR EQ. ASME150 1.5T FLAT RING	
	DN200- DN250		V-6500 NON-ASBESTOS OR EQ. ASME150 3.0T FLAT RING	
BOLT & NUT	ALL SIZE		STUD U HEAVY NUT A307-GR. B/A563-GR. A FINISHED	

CLASS	Max. Press. (MPaG)	0.11	0.85		C. A. mm
CC01 (1/1)	Max. Temp. (degC)	155	45		
FLUID	WATER, VENT GAS				
ITEM	Size	Thickness	Specification		
PIPING	DN6 - DN50	SCH80	A53-B SML PE ASME		
	DN65 - DN150	SCH40	A53-B E. R. W BE ASME		
	DN200 - DN300	SCH20	A53-B E. R. W BE ASME		
FITTING	DN6 - DN50		3000LB SW A105 ASME-B16.11		
	DN65 - DN150	Suit to PIPE	BW A234-WPB ASME-B16.9		
	DN200 - DN300		BW A234-WPB ASME-B16.9		
FLANGE	DN6 - DN150	Suit to PIPE	SO A105 ASME150 SO RF ASME-B16.5		
	DN200 - DN300		SO A105 ASME150 SO RF ASME-B16.5		
GATE VALVE	DN6 - DN50		API-602 PN16 A105 13CR SEAT STL SW BB, OS&Y HAND WHEEL		
	DN65 - DN300		ASME-B16.34 PN16 A395 13CR RF BB, OS&Y HAND WHEEL		
GLOBE VALVE	DN6 - DN50		API-602 PN16 A105 13CR SEAT STL SW BB, OS&Y HAND WHEEL		
	DN65 - DN300		ASME-B16.34 PN16 A395 13CR RF BB, OS&Y HAND WHEEL		
CHECK VALVE	DN6 - DN50		API-602 PN16 A105 13CR SEAT STL SW BC, LIFT		
	DN65 - DN300		ASME-B16.34 PN16 A395 13CR RF BC, SWING		
BALL VALVE	DN6 - DN100		ASME-B16.34 PN16 A105 AISI304 RF BALL LEVER. FULL BORE		
BUTTERFLY VALVE	DN50 - DN150		ASME-B16.34 PN16 A216-WCB 13CR EPDM RF WAFER WAFER LEVER.		
	DN50 - DN150		ASME-B16.34 PN16 A216-WCB 13CR EPDM RF WAFER WAFER AIR CYLINDER W/L. SWITCH		
	DN50 - DN150		ASME-B16.34 PN16 A216-WCB 13CR EPDM RF WAFER WAFER ELECTRIC MOTOR W/L. SWITCH		
	DN200 - DN300		ASME-B16.34 PN16 A216-WCB 13CR EPDM RF WAFER WAFER WHEEL WITH GEAR		
	DN200 - DN300		ASME-B16.34 PN16 A216-WCB 13CR EPDM RF WAFER WAFER AIR CYLINDER W/L. SWITCH		
	DN200 - DN300		ASME-B16.34 PN16 A216-WCB 13CR EPDM RF WAFER WAFER ELECTRIC MOTOR W/L. SWITCH		
GASKET	DN6 - DN150		V-6500 NON-ASBESTOS OR EQ. ASME150 1.5T FLAT RING		
	DN200 - DN300		V-6500 NON-ASBESTOS OR EQ. ASME150 3.0T FLAT RING		
BOLT & NUT	ALL SIZE		STUD U HEAVY NUT A307-GR. B/A563-GR. A FINISHED		



SUB-SECTION-I-M7

PIPING

LOT-4 PROJECTS
FLUE GAS DESULPHURISATION (FGD) SYSTEM PACKAGE

TECHNICAL SPECIFICATION
SECTION-VI
BID DOCUMENT NO.: CS-0011-109(4)-9

7/2021/PS-PEM-MAX

CLAUSE NO.	TECHNICAL REQUIREMENTS	<div>एनडीपीसी NTPC</div>																																					
	<p><u>LOW PRESSURE PIPING</u></p> <p>EQUIPMENT SIZING CRITERIA</p> <p>1.00.00</p> <p>1.01.00 All the piping systems and equipment supplied under this package shall be designed to operate without replacement and with normal maintenance for a plant service life of 30 years, and shall withstand the operating parameter fluctuations and cycling which can be normally expected during this period.</p> <p>1.02.00 For all Low Pressure piping systems covered under this specification, sizing and system design shall be to the requirements of relevant codes and standard indicated. In addition to this, requirements of any statutory code as applicable shall also be taken into consideration.</p> <p>1.03.00 Inside diameters of piping shall be calculated for the flow requirements of various systems. The velocities for calculating the inside diameters shall be limited to the following:</p> <p>a) Water Application</p> <table><tr><th colspan="2"></th><th colspan="3">Water Velocity in m/sec</th></tr><tr><th></th><th>Pipe Size</th><th>Below 50 mm</th><th>50-150 mm</th><th>200 mm & above</th></tr><tr><td>(a)</td><td>Pump suction</td><td>-----</td><td>1.2-1.5</td><td>1.2-1.8</td></tr><tr><td>(b)</td><td>Pump discharge and recirculation</td><td>1.2-1.8</td><td>1.8-2.4</td><td>2.1-2.5</td></tr><tr><td>(c)</td><td>Header</td><td>-----</td><td>1.5-2.4</td><td>2.1-2.4</td></tr></table> <p>Pipe line under gravity flow shall be restricted to a flow velocity of 1 m/sec generally. Channels under gravity flow shall be sized for a maximum flow velocity of 0.6 m/sec.</p> <p>WILLIAM & HAZEN formula shall be used for calculating the friction loss in piping systems with the following "C" value:</p> <table><tr><td>(i)</td><td>Carbon steel pipe</td><td>100</td></tr><tr><td>(ii)</td><td>Ductile Iron.</td><td>140</td></tr><tr><td>(iii)</td><td>Rubber lined steel pipe</td><td>120</td></tr><tr><td>(iv)</td><td>Stainless steel pipe</td><td>100</td></tr></table> <p>For calculating the required pump head for pump selection, at least 10% margin shall be taken over the pipe friction losses and static head shall be calculated from the minimum water level of the tank/ sump/ reservoir from which the pumps draw water.</p> <p>(b) Compressed Air Application</p> <p>Compressed air 15.0 m/sec.(under Average Pressure & Temp. conditions)</p>			Water Velocity in m/sec				Pipe Size	Below 50 mm	50-150 mm	200 mm & above	(a)	Pump suction	-----	1.2-1.5	1.2-1.8	(b)	Pump discharge and recirculation	1.2-1.8	1.8-2.4	2.1-2.5	(c)	Header	-----	1.5-2.4	2.1-2.4	(i)	Carbon steel pipe	100	(ii)	Ductile Iron.	140	(iii)	Rubber lined steel pipe	120	(iv)	Stainless steel pipe	100	
		Water Velocity in m/sec																																					
	Pipe Size	Below 50 mm	50-150 mm	200 mm & above																																			
(a)	Pump suction	-----	1.2-1.5	1.2-1.8																																			
(b)	Pump discharge and recirculation	1.2-1.8	1.8-2.4	2.1-2.5																																			
(c)	Header	-----	1.5-2.4	2.1-2.4																																			
(i)	Carbon steel pipe	100																																					
(ii)	Ductile Iron.	140																																					
(iii)	Rubber lined steel pipe	120																																					
(iv)	Stainless steel pipe	100																																					
LOT-4 PROJECTS FLUEGAS DESULPHURISATION(FGD) SYSTEM PACKAGE	TECHNICAL SPECIFICATION SECTION-VI, PART-B BID DOC NO.: CS-0011-109(4)-9	SUB-SECTION-I-M7 (LOW PRESSURE PIPING)	PAGE 1 OF 16																																				

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CLAUSE NO.	TECHNICAL REQUIREMENTS	एनडीपीसी NTPC					
1.04.00	The pipes shall be sized for the worst (i.e. maximum flow, temp. and pressure values) operating conditions.						
1.05.00	Based on the inside dia. so established, thickness calculation shall be made as per ANSI B 31.1 OD and thickness of pipes shall than be selected as per ANSI B 36.10/IS-1239 Heavy grade/IS-3589/ASTM-A-53/API-5L/ANSI B 36.19 as the case may be.						
1.06.00	Corrosion allowance of 1.6 mm will be added to the calculated thickness being considered (except stainless steel piping).						
1.07.00	Bend thinning allowance/manufacturing allowance etc. shall be as per the requirement of the design code provision.						
1.08.00	High points in piping system shall be provided with vents along with valves as per the system requirement. Low points shall be provided with drains along with drain valves as per the system requirement. Drain lines shall be adequately sized so as to clear condensate in the lines. Material for drain and vent lines shall be compatible with that of the parent pipe material.						
1.09.00	Material of construction for pipes carrying various fluids shall be as specified elsewhere.						
1.10.00	Compressed air pipe work shall be adequately drained to prevent internal moisture accumulation and moisture traps shall be provided at strategic locations in the piping systems.						
1.11.00	Depending upon the size and system pressure, joints in compressed air pipe work shall be screwed or flanged. The flange shall be welded with the parent pipe at shop and shall be hot dip galvanized before dispatch to site. Alternatively, the flanges on GI pipes may be screwed-on flanges also.						
1.12.00	Threaded joints shall be provided with Teflon sealant tapes.						
1.13.00	Following types of valves shall be used for the system/service indicated.						
	SYSTEM	TYPES OF VALVES					
		Butterfly	Gate	Globe	Check	Ball	Plug
	Water	x	x	x	x	x	
	Air		x	x	x	x	
	Drains & vents		x	x	x		
	Fuel oil (if any)		x	x	x	x	x
1.14.0	Recirculation pipes along with valves, breakdown orifices etc. shall be provided for important pumping systems as indicated in respective process and instrumentation diagrams (P&IDs). The recirculation pipe shall be sized for minimum 30%design flow of single pump operation or the recommended flow of the pump manufacturer whichever is higher.						
LOT-4 PROJECTS FLUEGAS DESULPHURISATION(FGD) SYSTEM PACKAGE		TECHNICAL SPECIFICATION SECTION-VI, PART-B BID DOC NO.: CS-0011-109(4)-9		SUB-SECTION-I-M7 (LOW PRESSURE PIPING)		PAGE 2 OF 16	


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CLAUSE NO.	TECHNICAL REQUIREMENTS	<div>एनटीपीसी NTPC</div>	
2.00.00	TECHNICAL SPECIFICATION		
2.01.00	GENERAL		
	Specific technical requirements of low-pressure piping, fittings, supports, valves, specialties and tanks etc. have been covered under this Sub-section. It includes details pertaining to design and material of construction for piping, fittings, valves, equipment, etc. cleaning/surface preparation application of primer and painting on over ground piping. It also includes detailed technical requirement of laying underground/buried piping including water proofing/anti corrosive protection. It also covers design, engineering, manufacturing, fabrication, technical details of piping, valves, specialties, piping hangers / supports, tanks etc.		
2.02.00	Pipes and fittings		
2.02.01	All low pressure piping systems shall be capable of withstanding the maximum pressure in the corresponding lines at the relevant temperatures. However, the minimum thickness as specified in the following clauses and or respective codes for pipes and fittings shall be adhered to. The bidder shall furnish the pipe sizing/ thickness calculation as per the criteria mentioned above under LP piping equipment sizing criteria of this Technical Specification.		
2.02.02	Piping and fittings coming under the purview of IBR shall be designed satisfying the requirements of IBR as a minimum.		
2.02.03	Supporting arrangement of piping systems shall be properly designed for systems where hydraulic shocks and pressure surges may arise in the system during operation. Bidder should provide necessary protective arrangement like anchor blocks/anchor bolt etc. for the safeguard of the piping systems under above mentioned conditions. The requirement will be, however, worked out by the contractor and he will submit the detailed drawings for thrust/anchor block to the Employer. External, and internal, attachments to piping shall be designed so as not to cause flattening of pipes and excessive localized bending stresses.		
2.02.04	Bends, loops, off sets, expansion or flexible joints shall be used as required in order to prevent overstressing the piping system and to provide adequate flexibility. Flexibility analysis (using software packages such as Caesar-II etc.) shall be carried out for sufficiently long piping (straight run more than 300M).		
2.02.05	Wherever Bidder's piping coming under this specification, terminates at an equipments or terminal point not included in this specification, the reaction and the thermal movement imposed by bidder's piping on equipment terminal point shall be within limits to be approved by the Employer.		
2.02.06	The hot lines shall be supported with flexible connections to permit axial and lateral movements. Flexibility analysis shall be carried out for pipelines which have considerable straight run as indicated above and necessary loops/ expansion joint etc. shall be provided as may be necessary depending on layout.		
2.02.07	Piping and fittings shall be manufactured by an approved manufacturer of repute. They should be truly cylindrical of clear internal diameter, of uniform thickness, smooth and strong, free from dents, cracks and holes and other defects.		
2.02.08	For rubber lined ERW pipes, beads shall be removed for pipe size 80 NB and above.		
2.02.09	Inspection holes shall be provided at suitable locations for pipes 800 Nb and above as required for periodic observations and inspection purposes.		
LOT-4 PROJECTS FLUEGAS DESULPHURISATION(FGD) SYSTEM PACKAGE		TECHNICAL SPECIFICATION SECTION-VI, PART-B BID DOC NO.: CS-0011-109(4)-9	SUB-SECTION-I-M7 (LOW PRESSURE PIPING)
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CLAUSE NO.	TECHNICAL REQUIREMENTS												
2.02.10	At all intersection joints, it is Contractor's responsibility to design and provide suitable reinforcements as per the applicable codes and standards.												
2.02.11	For large size pipes/ducts, at high point and bends/change of direction of flow, air release valves shall be provided as dictated by the system requirement and operation philosophy & tripping conditions of pumping system. Sizing criteria for air release valves shall be generally on the basis of valve size to pipe diameter ratio of 1:8. Requirement shall be decided as per relevant code. Transient analysis /surge analysis where ever specified and required shall be conducted in order to determine the location , number and size of the Air-Release valve on certain long distance/high volume piping systems, if applicable within the scope of work of the package.												
2.03.00	Material												
2.03.01	Alternate materials offered by Bidder against those specified. shall either be equal to or superior to those specified, The responsibility for establishing equality or superiority of the alternate materials offered rests entirely with the Bidder and any standard code required for establishing the same shall be in English language.												
2.03.02	No extra credit would be given to offers containing materials superior to those specified. Likewise no extra credit would be given to offers containing pipe thickness more than specified.												
2.03.03	All materials shall be new and procured directly from the manufacturers. Materials procured from traders or stockists are not acceptable.												
2.03.04	All materials shall be certified by proper material test certificates. All material test certificates shall carry proper heat number or other acceptable references to enable identification of the certificate that certifies the material.												
2.03.05	Material of construction for pipes carrying various fluids shall be as follows: <table><tr><th>SI N</th><th>Type of Fluid</th><th>Material</th></tr><tr><td>1.</td><td>i) Ordinary Water (Raw Water, Clarified Water, etc.) ii) Equipment cooling water including Both primary & secondary circuit (DMCW pH-corrected & ACW drain water)</td><td>IS-2062 Gr.-E-250B/ASTM A-36/ASTM A-53 type 'E'Gr.B/IS-3589 Gr. 410 /IS-1239 Heavy.</td></tr><tr><td>2.</td><td>i) Demineralised water, ii)Alkaline solution (ECW system chemical dosing)</td><td>Stainless Steel to ASTM A312, Gr. 304 welded for sizes 65 mm NB and above. Stainless steel to ASTM A312, Gr. 304 sch.40s seamless for sizes 50mm and below</td></tr><tr><td>3.</td><td>i) Drinking (potable) water ii)Compressed air (Instrument & service air)</td><td>ASTM A-53 type E Gr. B galvanized/ IS 1239 Gr heavy galvanized/IS 3589 Gr 410 galvanized. Galvanized shall be to IS- 4736 or equivalent.</td></tr></table>	SI N	Type of Fluid	Material	1.	i) Ordinary Water (Raw Water, Clarified Water, etc.) ii) Equipment cooling water including Both primary & secondary circuit (DMCW pH-corrected & ACW drain water)	IS-2062 Gr.-E-250B/ASTM A-36/ASTM A-53 type 'E'Gr.B/IS-3589 Gr. 410 /IS-1239 Heavy.	2.	i) Demineralised water, ii)Alkaline solution (ECW system chemical dosing)	Stainless Steel to ASTM A312, Gr. 304 welded for sizes 65 mm NB and above. Stainless steel to ASTM A312, Gr. 304 sch.40s seamless for sizes 50mm and below	3.	i) Drinking (potable) water ii)Compressed air (Instrument & service air)	ASTM A-53 type E Gr. B galvanized/ IS 1239 Gr heavy galvanized/IS 3589 Gr 410 galvanized. Galvanized shall be to IS- 4736 or equivalent.
SI N	Type of Fluid	Material											
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3.	i) Drinking (potable) water ii)Compressed air (Instrument & service air)	ASTM A-53 type E Gr. B galvanized/ IS 1239 Gr heavy galvanized/IS 3589 Gr 410 galvanized. Galvanized shall be to IS- 4736 or equivalent.											
2.03.06	In water lines, pipes upto 150mm Nb shall conform to ANSI B36.10/ASTM-A-53, Type-E Gr.B /IS:1239 Gr. Heavy and minimum selected thickness shall not be less than IS:1239 Grade Heavy except for demineralized water, drinking water .												

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2.03.07	Pipes of above 150mm Nb shall be to AWWA-C200/ANSI B 36.10/ASTM A-53/IS 3589 Gr.410. Pipe to be fabricated by the bidder shall be rolled and butt welded from plates conforming to ASTM A-53 type 'E' Gr. B/IS 2062 Gr.E-250B/ASTM-A-36. However, larger pipes, i.e. 1000mm Nb and above shall be made from plates conforming to ASTM A 36/IS 2062 Gr.E-250B and shall meet the requirements of AWWA-M-11 (for deflection & buckling criteria considering water filled pipe as well as vacuum condition that may prevail during transient/surge conditions, truck-load, rail-load and weight density for compacted soil or any other load as the case may be).				
2.03.08	<p>In demineralised water service, the pipes upto 50 Nb shall be of stainless steel ASTM A 312, Gr. 304 sch. 40 Seamless. The size for these pipes shall be to ANSI B 36.19. These shall be socket welded. The material for pipe from 65mm NB upto and including 400 NB shall be to ASTM A 312, Gr. 304 (welded). In no case the thickness of fittings shall be less than parent pipe thickness.</p> <p>Bidder/Contractor shall note that pipes offered as per a particular code shall conform to that code in all respects i.e. Dimension, tolerances, manufacturing methods, material, heat treatment, testing requirements, etc. unless otherwise mentioned elsewhere in the specification.</p>				
2.03.09	Instrument air, Plant (service) air lines and Drinking water lines shall be to ASTM A 53 type E grade B/ANSI B 36. 10/IS 3589, Gr. 410 / IS: 1239 Heavy (in case thickness calculated is more than gr. Heavy, ANSI B 36.10 Schedule numbers shall be followed) and galvanized to IS 4736 or any equivalent internationally reputed standard. The material of the pipes shall be to ASTM A 53 type 'E' Gr. B / IS: 3589, Gr. 410 / IS: 1239 Gr. Heavy. The fittings shall be of either same as parent material or malleable iron to IS-1879 (galvanized).				
2.03.10	Spiral welded pipes as per API-5L/IS-3589 are also acceptable for pipe of size above 150 NB. However minimum thickness of the pipes shall be as elaborated in above clauses.				
2.03.11	Condensate lines shall be to ASTM A 106 Gr. B and dimension to ANSI B 36.10 schedule "standard" as minimum to be maintained.				
2.03.12	If carbon steel plates of thickness more than 12 mm are used for manufacture of pipes, fittings and other appurtenances, then the same shall be control-cooled or normalized as the case may be following the guidelines of the governing code.				
2.04.00	Field routed pipes:				
2.04.01	Pipe lines of NB 50 size and below are regarded as field run piping. It is Bidder's responsibility to plan suitable layouts for these system insitu. Bidder shall prepare drawings indicating the layout of field run pipe work. These drawings shall be approved by Project Manager to the installation of the field run pipe work. Based on these approved layouts the Bidder shall prepare the BOQ of field run-pipes and submit to Employer for approval.				
2.05.00	Slope/Drains and Vents				
2.05.01	Suitable slope shall be provided for all pipelines towards drain points. It is Bidder responsibility to identify the requirements of drains and vents, and supply the necessary pipe work, valves, fittings, hangers and supports etc. As per the system requirement low points in the pipelines shall be provided with suitable draining arrangement and high points shall be provided with vent connections where air or gas pockets may occur. Vent for use during hydrostatic test shall be plugged after the completion of the test. Vent shall not be less than 15mm size. Drains shall be provided at low points and at pockets in piping such that complete drainage of all systems is possible. Drain shall not be less than 15mm for line size up to 150mm, not less than 20mm up to 300mm and not less than 25mm for 350mm to 600mm pipes and not less than 50mm for 600mm and above pipes.				
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2.05.02	Air piping shall be sloped so that any part of the system can be drained through the shut-off drain valve or drain plugs.			
2.06.00	Pipe Joints In general all water lines 65mm NB and above, are to be joined generally by butt welding except the locations where valves/fittings are to be installed with flanged connections and 50mm and below by socket welding unless mentioned otherwise specifically. All air lines shall be of screwed connection and rubber lined pipes of flanged connections.			
2.06.01	Screwed Joints (a) Threading of pipes shall be carried out after bending, heat treatment etc. If not possible, threading may be done prior to these operations but proper care should be taken to protect them from damage. Threads shall be to ANSI B 2.1 (taper) NPT/ ANSI B1.20.1 (taper) NPT IS: 554 unless specified otherwise. (b) Galvanized pipe shall generally be joined by screwing into sockets. The exposed threaded portion on the outside of the pipes shall be given a zinc silicate coating. Galvanized pipes shall not be field joined by welding for protection of Galvanising Zinc layer. Screwed ends of GI pipes shall be thoroughly cleaned and painted with a mixture of red and white lead before jointing. For galvanized pipe sizes above 150 mm NB, screw & socket jointing as per ASTM-A-865 shall be employed for both pipe-to-pipe and pipe-to-fitting jointing. For pipe to fitting connection since no direct threading can be done on the fittings (supplied as per ASTM-A-234 Gr. WPB and ANSI B-16.9) necessary straight pipe lengths acting as match pieces shall be welded to the fitting at both ends and subsequently the free ends of the straight lengths shall be threaded as per ASTM A-865 for jointing with main pipe. Once welding of fittings with match pieces and threading of free ends of match pieces are over, the entire fabricated piece shall be galvanized, or in case match pipes and fittings are already galvanized before the above mentioned fabrication then suitable application of Zinc-Silicate paste adequately at the welded surface (both in side & out side) after welding with zinc rich electrode, along with the nascent threaded metal portions at both free ends given the same application of Zinc Silicate paste. Alternatively flanged jointing may be employed for pipe sizes 100 NB and above. However, the bidder shall ensure the galvanized pipe joints do not fail during hydro test. (c) Teflon tapes shall be used to seal out screwed joints and shall be applied to the male threads only. Threaded parts shall be wiped clean of oil or grease with appropriate solvent if necessary and allowing proper time for drying before applying the sealant. Pipe ends shall be reamed and all chips shall be removed. Screwed flanges shall be attached by screwing the pipe through the flange and the pipe and flange shall be refaced accurately. (d) For pipe sizes from 350 mm NB to 550 mm NB (including 350 NB & 550 NB) the GI pipes shall be of flanged connection. However, the pipes after welding of flanges shall be completely galvanized. Any site welding done on galvanized pipes shall be done with zinc-rich special electrodes and the welded surfaces whether inside or outside shall be coated with zinc-silicate paste. Seal welding of flanges with zinc-rich electrode will be permitted only when any flange is leak-prone during hydro testing. (e) For pipe sizes 600 mm NB and above, the GI pipes shall be of welded connection (with zinc-rich special electrodes) followed by application of zinc silicate coating at welded surfaces both inside and outside the pipe, except for the last blank/blind flange, or, equipment connection where application of zinc-silicate paste after welding cannot be done due to inaccessibility of the inside welded surface and where galvanic protection has been impaired due to welding of pipe-to-pipe joint. Thus the last erection joint shall be flanged joint.			
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2.06.02	<p>Welded Joints</p> <p>(a) For making up welded joints (butt weld or socket weld) the welding shall be performed by manual shielded metal arc process in accordance with the requirements specified elsewhere in the spec. Any welder employed for carrying butt welding shall be qualified as per ASME section IX for the type of joints he is going to weld. Jointing by butt weld, or socket weld shall depend upon the respective piping material specifications.</p>
2.06.03	<p>Flanged Joints</p> <p>(a) Flanged connections for pipes are to be kept to the minimum and used only for connections to vessel, equipments, flanged valves and other fittings like strainer/traps/orifices etc. for ease of connection and maintenance etc. Rubber lined pipes shall be flange joined only.</p> <p>(b) All flanged valves intended for installation on steel piping system, shall have their flanges drilled to ANSI B 16.5 (or equivalent) and according to the pressure class stated in their respective piping material specification.</p> <p>(c) Drilling on flanges of flanged valves must correspond to the drilling of flanges on the piping system on which the valves are installed.</p>
2.07.00	<p>Bends/elbows/mitre bends/ Tees/ Reducers & other fittings</p>
2.07.01	<p>For pipe fittings such as elbows (long radius), reducers, tees, etc. the material shall be to ASTM-A-234 Gr. WPB/ASTM-105 up to 300 NB. For pipe fittings above 300 NB, the fittings may be fabricated conforming to parent pipe material. Provision of compensation pads shall be kept as per ANSI B 31.1. The fitting shall conform to the dimensional standard of ANSI B-16.9/ 16.11. Further branching in pipes for sizes 65nb and above is also acceptable (ANSI B 31.1).</p> <p>However, for pipes up to 150 NB, pipe fittings may be supplied with material and dimension conforming to IS 1239 in case parent pipes also conform to IS 1239.</p>
2.07.02	<p>For pipe size 350Nb and above mitre bends may be used for all pipes except rubber lined pipes. However, mitre bends are also acceptable for rubber lined pipes above 1200 NB. The bend radius shall be 1½ times the nominal pipe diameter. 90 deg. bends (mitre) shall be in 4 pieces (3 cuts) and 45 deg. mitre bends shall be in 3 pieces 22½ deg. Fabrication of mitre bends shall be as detailed in BS 2633/BS534.</p>
2.07.03	<p>For pipes, above 1200 NB, reducer and tees shall be to dimensional standard of AWWA-C-208.</p>
2.07.04	<p>Stainless steel fittings shall conform to either ASTM-A-182 Gr. 304 or ASTM-A-403 Grade WP. 304 Class-S, for sizes upto and including 50 mm NB, i.e. the fittings shall be of seamless construction. However, for stainless fittings above 50 mm NB, the same shall conform to ASTM-A-403 Gr. WP 304 Class W i.e. the fittings shall be of welded construction strictly in accordance with ASTM-A-403.</p>
2.07.07	<p>In no case, the thickness of fittings shall be less than the thickness of parent pipe, irrespective of material of construction.</p>
2.08.00	<p>Flanges</p>
2.08.01	<p>Flanges shall be slip on type or weld neck type. Welding of flanges in tension is not permitted.</p>
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2.08.02	All flanges and-flanged drilling shall be to ANSI B 16.5 / BS EN-1092 / AWWA C - 207 of relevant pressure/temperature class. Flanges shall be fabricated from steel plates conforming to ASTM A 105/IS 2062 Gr. E-250B. However stainless steel flanges shall be fabricated from SS plates to ASTM-A-240, Gr. 304 or equivalent.			
2.09.00	Specific technical requirement of laying buried pipe with anti-corrosive treatment The pipe in general shall be laid with the top of the pipe minimum 1.0 (one) meter below finished general ground level.			
2.09.01	Trenching (a) The trench shall be cut true to the line and level and shall follow the gradient of the pipeline. The width of the trench shall be sufficient to give free working space on each side of the pipe. Trenches shall conform to IS 5822 or any international standard.			
2.09.02	Preparation and cleaning of piping (a) The pipeline shall be thoroughly cleaned of all rust, grease, dirt, weld scales and weld burrs etc. moisture or other foreign matter by power cleaning method such as sand or grit blasting, power tool cleaning, etc. Grease or heavy oil shall be removed by washing with a volatile solvent such as gasoline. Certain inaccessible portions of the pipeline (which otherwise not possible to be cleaned by power cleaning methods) may be scrubbed manually with a stiff wire brush and scrapped where necessary with specific permission of the Project Manager. (b) On the internal surface for pipes 1000 Nb and above, a coat of primer followed by a hot coal-tar enamel or coal tar epoxy painting (cold) shall be applied.			
2.09.03	Coating and wrapping/ Anti corrosive Protection Coal tar tape a. Buried piping shall be coated and wrapped, as per specification, after completion of welded and/or flanged connections, and after completion and approval of Hydro testing. Materials to be used for coating and wrapping of underground pipelines are: (1) Coating primer (coal tar primer) (2) Coating enamel (coal tar enamel) (3) Wrapping materials. All primer/coating/wrapping materials and methods of application shall conform to IS: 10221 except asphalt/bitumen material. Materials (primer/coating/wrapping) as per AWWA-C-203 are also acceptable. Protective coating shall consist of coal tar primer, coal tar enamel coating, glass fiber, tissue inner wrap followed by glass fiber or coal tar impregnated Kraft outer wrap or finish coat. Number of coats and wraps, minimum thickness for each layer of application shall be as per IS-10221. Number of. Coats and wraps shall be decided based on soil corrosivity/resistivity as indicated in IS-10221. Soil data-for this purpose shall be made available. Total thickness of completed coating and wrapping shall not be less than 4.0 mm. b. Alternatively, the anti-corrosive protection for buried pipes can consist of anti-corrosive protection Coal-tar tapes. Material and application of tapes shall conform to IS 15337 or equivalent. These-tapes shall be applied hot over the cold coal tar			
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		primer in steps of 2mm thickness so as to cover the spiral edges of the first tape by the application of second tape. The total thickness of the finished protective coating shall be 4.0 mm minimum.			
2.09.04		Trench bed preparation and back filling			
		Prior to lowering and laying pipe in any excavated trench, the bottom of the trench may require to be back filled and compacted (or as the case may be) to provide an acceptable bed for placing the pipe. Bed preparation in general shall be as per IS: 5822.			
2.09.05		Laying of galvanized steel (GI) pipes			
		All the joints shall be screwed with socket or flanged. Screwed ends of GI pipes shall be thoroughly cleaned and painted with a mixture of red and white lead before jointing Threaded portion on either side of the socket joint shall be applied with Zinc silicate paste.			
		All the provisions for trenching' bed preparation' laying the pipe application of primer' coating' wrapping with tapes and back filling etc. as indicated for "laying of buried piping" and " anti corrosive protection for buried piping" are applicable for buried galvanized steel (GI) pipes also.			
2.10.00		Cleaning and flushing			
2.10.01		All piping shall be cleaned by the Bidder before and after erection to remove grease, dirt, dust, scale and welding slag.			
2.10.02		Before erection all pipe work, assemblies, sub-assemblies, fittings, and components, etc. shall be thoroughly cleaned internally and externally by blast cleaning or by power driven wire brushes and followed by air-blowing . However for pipe sizes below 100nb the pipes may be cleaned internally by compressed air blowing as an alternative to internal blast cleaning. The brushes shall be of the same or similar material as the metal being cleaned. Cleaning of Galvanized pipes shall be done by air blowing only.			
2.10.03		After erection, all water lines shall be mass flushed with water. The cleaning velocities in water lines shall be 1.2-1.5 times the operating velocities in the pipelines.			
2.10.04		All compressed air pipe work shall be cleaned by blowing compressed air.			
2.11.00		Specification for hangers and supports			
2.11.01		All supports and parts shall conform to the requirement of power piping code ANSI B 31.1 or approved equivalent.			
2.11.02		The maximum spans of the supports of straight length shall not exceed the recommended values indicated in ANSI B 31.1.			
2.11.03		At all sliding surfaces of supports suitable arrangement is to be provided to minimize sliding friction.			
2.12.00		Design/Construction/Material Particulars of Gate/ Globe /Check /Butterfly / Ball / Air release /Float valves / Moisture Traps.			
2.12.01		GENERAL			
		(a) All valves shall have indicators or direction clearly marked on the hand-wheel so that the valves opening/closing can be readily determined.			
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	<p>(b) Special attention shall be given to operating mechanism for large size valves with a view to obtaining quick and easy operation ensuring that a minimum of maintenance is required.</p> <p>(c) The valves coming in vacuum lines shall be of extended gland type and/or water sealed.</p> <p>(d) The actuator-operated valves shall be designed on the basis of the following:</p> <ol style="list-style-type: none"> (1) The internal parts shall be suitable to support the pressure caused by the actuators; (2) The valve-actuator unit shall be suitably stiff so as not to cause vibrations, misalignments, etc. (3) All actuator-operated valves shall be provided with hand operated gearing mechanism also. (4) All actuators operated valves shall open/ close fully within time required by the process. <p>(e) Valves coming under the purview of IBR shall meet IBR requirements.</p> <p>(f) All valves shall be provided with embossed name plate giving details such as tag number, type, size etc.</p> <p>(g) Wherever required valves shall be provided with chain operator, extension spindles and floor stands or any other arrangement approved by employer so that they can be operated with ease from the nearest operating floor. Wherever necessary for safety purpose locking device shall be provided. Further, necessary small platforms for facilitating easy valve operation shall be provided by the contractor wherever necessary in consultation with project manager within the bid price at no extra cost to employer</p>
2.12.02	<p>VALVE BODY MATERIAL</p> <p>Valve body material for various services shall be as follows:</p> <p>Valve body material for water application like Secondary circuit auxiliary cooling water of ECW system, clarified water, DM cooling water (pH corrected) , drinking water etc. shall be cast iron for sizes 65NB and above; gun-metal for sizes 50 Nb and below.</p> <p>For compressed air application, valve body material shall be cast carbon steel or forged carbon steel for sizes 65 mm NB & above and Gun metal for sizes 50 NB and below.</p> <p>DM water: SS body and disc along with SS internals. However for butterfly valves, Cast Iron /Ductile Iron/SG iron/carbon steel body and disc with elastomer lining are also acceptable.</p>
2.12.03	<p>The design, material, construction, manufacture, inspection, testing and performance of valves shall comply with all currently applicable statutes, regulations and safety codes in the locality where the valves will be installed. The valves shall conform to the latest editions of applicable codes and standards as mentioned elsewhere. Nothing in this specification shall be construed to relieve the Bidder of his responsibility. Valves in general shall conform to the requirements of the following standards.</p>
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2.12.04		Standards and Codes					
		AWWA-C-504		Rubber seated butterfly valves.			
		BS-5155/EN-593		Cast iron and steel body butterfly valves for general purpose.			
		IS-778		Gun-metal gate, globe and check valves for general purpose.			
		BS-5154		Copper alloy globe/globe stop and check and gate valves for general purpose.			
		IS-780		Sluice valves for water works purpose (50-300 mm size)			
		IS-2906		Sluice valves for water works purpose (350-1200 mm size)			
		IS-5150		Cast iron wedge and double disc gate for general purpose.			
		BS-5152		Specification for cast iron globe valves.			
		BS-5153		Cast iron check valves for general purpose.			
		IS-5312		Swing check type reflux (non-return) valves.			
		ANSI B 16.34		Standard for valves.			
		API-594		Standard for Dual-check valves.			
		API-600		Steel gate valves.			
		ANSI-B-16.10		Valves face to face and other relevant dimension.			
		API-598		Valves inspection test.			
		2.13.00		End Connections			
				The end connections, shall comply with the following:			
				Socket welding (SW) - ANSI B 16.11			
				Butt Welding (BW) - ANSI B 16.25.			
Threaded (SC) - ANSI B 2.1							
		Flanged (FL) - ANSI B 16.5& AWWA-C-207 (steel flanges), ANSI B 16.1 (Cast Iron flanges).					
		Gate/Globe/Check Valves					
		(a) All cast iron body valves (gate, globe and non-return) shall have flanged end connections; (screwed ends for Ductile D.2NI body valves are not acceptable).					
		(b) All steel and stainless steel body valves of sizes 65 mm and above shall have flanged or butt welding ends. Valves of sizes below 65mm shall have flanged or socket welded ends. Compatibility of welding between valve body material and connecting pipe material is a pre-requisite in case of butt-welded joints.					
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		<p>(c) All gun metal body valves shall have screwed ends.</p> <p>(d) All flanged end valves/specialties. shall be furnished along with matching counter flanges, fasteners, gaskets etc. as required to complete the joints.</p> <p>(e) Gate/sluice valves shall be used for isolation of flow. All gate valves shall be of the full-way type, and when in the full open position the bore of the valve shall not be constricted by any part of the gate.</p> <p>Gate valves shall be of the solid/elastic or articulated wedge disc. Gate valves shall be provided with the following accessories in addition to other standard items:</p> <p>(1) Hand wheel</p> <p>(2) Position indicator (for above 50 mm NB valve size)</p> <p>(3) Draining arrangement wherever required.</p> <p>(f) Globe valves shall be used for regulation purposes. They shall be provided with hand wheel, position indicator, draining arrangement (wherever required) and arrow indicating flow direction. Preferably, the valves shall be of the vertical stem type. Globe valves shall preferably have radiused or spherical seating and discs shall be free to revolve on the spindle.</p> <p>The pressure shall preferably be under the disc of the valve. However, globe valves, with pressure over the disc shall also be accepted provided (i) no possibility exists that flow from above the disc can remove either the disc from stem or component from disc (ii) manual globe valves can easily be operated by hand. If the fluid load on the top of the disc is higher than 40-60 KN, bypass valve shall be provided which permits the downstream system to be pressurized before the globe valve is opened.</p> <p>(g) Check valves shall be used for non-return service. They shall be swing. check type or double door (Dual plate)check type with a permanent arrow inscription on the valve body indicating the fluid flow direction. In long distance pipes lines with possibility of surge-occurrence, dual plate check valves are preferable for its spring controlled opening /closing of flaps/doors against flow reversals. However, dual plate check valves shall not be used for sizes more than 600mm NB.</p> <p>(h) For bore greater than 2" the valves must be swing check type or dual plate check type suitable for installation in all positions (vertical and horizontal);</p> <p>(i) For bore smaller than or equal to 2" the valves must be of the piston type to be installed, in horizontal position.</p> <p>(j) All gate and globe valves shall be provided with back seating arrangement to enable on line changing of gland packing. The valves shall be preferably outside screw & yoke type.</p> <p>(k) All gate and globe valves shall be rising stem type and shall have limit switches for full OPEN and full CLOSED indication wherever required. This will include motor-operated valves also wherever required. In such cases the limit switches shall form an integral part of the valve. Stop-gap arrangement in this respect is not acceptable.</p> <p>(l) All valves except those with rising stems shall be provided with continuous mechanical position indicators; rising stem valves shall have only visual indication through plastic/metallic stem cover for sizes above 50 mm nominal bore.</p> <p>(m) For CI gate, globe and check valves wherever thickness of body/bonnet is not mentioned in the valves standards, thickness mentioned in IS- 1538 for fitting shall be applicable.</p>			
LOT-4 PROJECTS FLUEGAS DESULPHURISATION(FGD) SYSTEM PACKAGE		TECHNICAL SPECIFICATION SECTION-VI, PART-B BID DOC NO.: CS-0011-109(4)-9		SUB-SECTION-I-M7 (LOW PRESSURE PIPING)	
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CLAUSE NO.	TECHNICAL REQUIREMENTS																												
2.13.01	<p>MATERIAL OF CONSTRUCTION (GATE/GLOBE/CHECK VALVE)</p> <p>(a) The materials shall generally comply with the following:</p> <p>(1) Cast Steel Valves</p> <table><tr><td>Body & bonnet</td><td>ASTM A 216 Gr. WCB/ ASTM A 105</td></tr><tr><td>Disc for non-return Valves</td><td>ASTM A 216 Gr. WCB/ ASTM A 105</td></tr><tr><td>Trim.</td><td>ASTM A 182 Gr. F6 or Equivalent</td></tr></table> <p>(2) Stainless steel valves</p> <table><tr><td>Body & Bonnet</td><td>SS 304</td></tr><tr><td>Disc</td><td>-do-</td></tr><tr><td>Trim.</td><td>SS 316</td></tr></table> <p>(3) Cast iron valves</p> <table><tr><td>Body & bonnet</td><td>BS 1452 Gr. 14/ IS-210 Gr. FG 260</td></tr><tr><td>Seating surfaces and rings</td><td>13% chromium steel/ 13% Chrome overlay</td></tr><tr><td>Disc for non-return valves</td><td>BS 1452 Gr. 14/IS-210 Gr FG 260</td></tr><tr><td>Hinge pin for non-return valves</td><td>AISI 316</td></tr><tr><td>Stem for gate globe valves</td><td>13% chromium steel or Equivalent</td></tr><tr><td>Back seat</td><td>13 % chromium steel / 13% Chrome overlay</td></tr></table> <p>(4) Gun Metal valves</p> <table><tr><td>Body and bonnet</td><td>IS 318 Gr. 2/ Equivalent Standard</td></tr><tr><td>Trim.</td><td>-do-</td></tr></table> <p>(b) Cast iron body valves shall have high alloy steel stem and seat.</p> <p>(c) Material for counter flanges shall be the same as for the piping.</p> <p>(d) Forged carbon steel valves are also acceptable in place of Gun metal valves.</p>	Body & bonnet	ASTM A 216 Gr. WCB/ ASTM A 105	Disc for non-return Valves	ASTM A 216 Gr. WCB/ ASTM A 105	Trim.	ASTM A 182 Gr. F6 or Equivalent	Body & Bonnet	SS 304	Disc	-do-	Trim.	SS 316	Body & bonnet	BS 1452 Gr. 14/ IS-210 Gr. FG 260	Seating surfaces and rings	13% chromium steel/ 13% Chrome overlay	Disc for non-return valves	BS 1452 Gr. 14/IS-210 Gr FG 260	Hinge pin for non-return valves	AISI 316	Stem for gate globe valves	13% chromium steel or Equivalent	Back seat	13 % chromium steel / 13% Chrome overlay	Body and bonnet	IS 318 Gr. 2/ Equivalent Standard	Trim.	-do-
Body & bonnet	ASTM A 216 Gr. WCB/ ASTM A 105																												
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Body and bonnet	IS 318 Gr. 2/ Equivalent Standard																												
Trim.	-do-																												
2.14.00	<p>Air Release Valve</p> <p>(a) The air release valves shall be of automatic double air valve with two orifices and two floats. The float shall not close the valve at higher air velocities. The orifice contact joint with the float shall be leak tight joint.</p>																												


LOT-4 PROJECTS FLUEGAS DESULPHURISATION(FGD) SYSTEM PACKAGE	TECHNICAL SPECIFICATION SECTION-VI, PART-B BID DOC NO.: CS-0011-109(4)-9	SUB-SECTION-I-M7 (LOW PRESSURE PIPING)	PAGE 13 OF 16
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17/2021/PS-PEM-MAX		TECHNICAL REQUIREMENTS		<div>एनटीपीसी NTPC</div>	
CLAUSE NO.					
		<div>(b) The valve shall efficiently discharge the displaced air automatically from ducts/pipes while filling them and admit air automatically into the ducts/pipes while they are being emptied. The valve shall also automatically release trapped air from ducts/pipes during operation at the normal working pressure.</div> <div>(c) Body material of automatic air release valves shall comply generally with BS 1452 Gr. 14/IS: 210 Gr. FG 260. and spindle shall conform to high tensile brass.</div> <div>(d) Air release valves shall not have any integral isolation device within them. Each Air release valve shall be mounted, preceded by a separate isolation gate/ butterfly valve.</div>			
2.15.00		Butterfly valves			
2.15.01		Design/Construction			
		<div>(a) The valves shall be designed for the design pressure/temperature of the system on which it is installed and in accordance with AWWA-C-504, EN-593 or any other approved equivalent standard latest edition. Fabricated steel (IS: 2062 GR. E-250B) butterfly valves instead of cast iron body valves are also acceptable for size above 300 mm nb diameter.</div> <div>(b) The valves shall be suitable for installation in any position (horizontal/vertical etc.) and shall be generally of double-flanged construction. However for sizes 600 NB and below the valves of Wafer construction are also acceptable</div> <div>(c) Valves-350Nb and above shall have pressure equalizing bypass valves, wherever system parameters warrant the same.</div> <div>(d) Valves-200Nb and above shall also be provided with gear operator arrangement as a standard practice suitable for manual operation. Manual operation of valve shall be through gear arrangement having totally enclosed gearing with hand wheel diameter and gear ratio designed to meet the required operating torque It shall be designed to hold the valve disc in intermediate position between full open and full closed position without creeping or fluttering. Adjustable stops shall be provided to prevent over travel in either direction.</div> <div>Limit and torque switches (if applicable) shall be enclosed in water tight enclosures along with suitable space heaters for motor actuated valves, which may be either for On-Off operation or inching operation with position transmitter.</div>			
2.15.02		Material of Construction (Butterfly Valves)			
		Materials and other design details shall be as indicated below :			
		(a) Cast Iron Butterfly Valves			
		<div>Body & Disc<div>ASTM A48, Gr. 40 with 2% Ni / IS: 210. Gr. FG-260, with 2% Ni / SG iron BSEN 1563, Gr EN GJS-400-15 with 2%Ni and epoxy coated</div></div> <div>Shaft<div>BS 970 431 S: 291 / EN 57, or AISI-410 or AWWA-permitted shaft material equivalent to EN-57/AISI-410 or better.</div></div> <div>Seat ring<div>18-8 Stainless steel</div></div>			
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CLAUSE NO.					
2.15.03	Seal	Nitrile Rubber			
	(b)	Stainless Steel Butterfly Valves			
	Body & Disc	SS 304			
	Shaft	SS 316			
	Seat Rings	EPT/BUNA-N/Neoprene			
	(c)	Carbon steel Butterfly Valves			
	Body & Disc	ASTM A 216, Gr. WCB			
	Shaft	SS 304			
	Disc & Seat Rings	EPT/BUNA-N/Neoprene			
	(d)	Elastomer lined Butterfly Valves			
	Body & Disc	ASTM A48, Gr. 40 / IS: 210. Gr. FG-260 / SG Iron (ductile iron) IS 1865 Gr 400-15 or BSEN 1563, Gr EN GJS-400-15 / ASTM A 216, Gr. WCB with elastomer lining.			
	Shaft	SS 316			
	Proof of Design Test (Type Test) for Butterfly Valves				
	Proof of Design (P.O.D.) test certificates shall be furnished by the bidder for all applicable size-ranges and classes of Butterfly valves supplied by him, in the absence of which actual P.O.D. test shall be conducted by the bidder.				
	All valves that are designed and manufactured as per AWWA-C-504 / AWWA-C-516 shall be governed by the relevant clauses of P.O.D test in AWWA-C-504/AWWA-C-516. For Butterfly valves, designed and manufactured to EN-593 or equivalent, the P.O.D. test methods and procedures shall generally follow the guidelines of AWWA-C-504 in all respect except that Body & seat hydro test and disc-strength test shall be conducted at the pressures specified in EN-593 or the applicable code. Actuators shall also meet requirements of P.O.D. test of AWWA-C-504/AWWA-C-516.				
2.16.00	Float operated valves				
(a)	Valve shall automatically control the rate of filling and will shut off when a predetermined level is reached and close to prevent over flow on pre-set maximum water level. Valve shall also open and close in direct proportion to rise or fall of water level.				
(b)	DESIGN AND CONSTRUCTION FEATURES				
	The following design and construction feature of the valve shall be the minimum acceptable.				
(c)	Valves shall be right-angled or globe pattern.				
(d)	Valves shall be balance piston type with float ball.				
(e)	Leather liner shall not be provided.				
LOT-4 PROJECTS FLUEGAS DESULPHURISATION(FGD) SYSTEM PACKAGE		TECHNICAL SPECIFICATION SECTION-VI, PART-B BID DOC NO.: CS-0011-109(4)-9		SUB-SECTION-I-M7 (LOW PRESSURE PIPING)	
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		<div>(f) The body and cover material shall be cast iron conforming to ASTM-A 126 Grade 'B' or IS: 210 Grade 200 or equivalent, and Float shall be of copper with epoxy painting of two (2) coats.</div> <div>(g) Valves shall be suitable for flow velocities of 2 to 2.5 m/sec.</div> <div>(h) The valves shall have flanged connections.</div>			
2.17.00		<div>Surface preparation and Painting for external piping surfaces (non-coastal projects)</div> <div>a) Surface preparation - Power tool cleaning / Shot blasting/ abrasive blasting</div> <div>b) Type of Primer - Red Oxide Zinc Phosphate primer (Alkyd base) to IS 12744 (2 X 25 microns)</div> <div>c) Intermediate Coat – Synthetic Enamel (long oil alkyd) to IS2932 (1 X 30 microns)</div> <div>d) Final Coat - Synthetic Enamel (long oil alkyd) to IS2932 (2 X 35 microns)</div> <div>Min. Total DFT (Microns) to be maintained – 150 (Min) and Color shall be as per NTPC Color Coding Scheme</div> <div>Note: No painting is required on Galvanized, Stainless Steel, Gun Metal surfaces</div>			
2.18.00		<div>Surface preparation and Painting for external piping surfaces (coastal projects)</div> <div>a) Surface preparation - Near white metal blast cleaning with surface profile 35-50 microns as per surface preparation specification SSPC.SP10 of Society of Protective coatings , USA</div> <div>b) Type of Primer – Inorganic zinc (ethyl) silicate primer coat(1 X 70 microns): Self-curing Inorganic Zinc (ethyl) Silicate Primer Coat (having minimum 80% of metallic Zinc content in dry film , Solid by Volume Minimum 60% ±2%) to be applied over blast cleaned surface.</div> <div>c) Intermediate Coat (2 X 90 microns)– Polyamide Cured pigmented Micaceous Iron Oxide Epoxy based Paint (containing lamellar MIO minimum 30% on pigment, Solid by Volume Minimum 80% ±2%) Polyamide Cured pigmented Micaceous Iron Oxide Epoxy based Paint (containing lamellar MIO minimum 30% on pigment, Solid by Volume Minimum 80% ±2%).</div> <div>d) Final Coat (1 X 70 microns) - Acrylic Aliphatic Polyurethane, two pack, isocyanate based color pigmented Paint (Solid by Volume Minimum 55% ±2%)</div> <div>Min. Total DFT (Microns) to be maintained – 320 (Min) and Color shall be as per NTPC Color Coding Scheme</div> <div>Note: 1.) For external surfaces (galvanized steel), proper surface preparation with power tool cleaning up to grade ST2, ISO:8501-01 followed by zinc phosphate primer with 50 microns DFT, again followed by Acrylic Aliphatic Polyurethane coat of 40 microns DFT. 2.) If final shade of 9002 (off white) is required then Micaceous Iron Oxide (MIO) color shall be grey. 3.) No painting is required on Stainless Steel, Gun Metal surfaces.</div>			
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SECTION II

STANDARD TECHNICAL SPECIFICATION


	KAHALGAON TPP FGD GYPSUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
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1.0 STANDARD TECHNICAL REQUIREMENTS – EQUIPMENTS/ COMPONENTS OF GDS

I	DESIGN CONSTRUCTION –VACUUM BELT FILTERS
1.	The vacuum belt filter shall be proven design in operation for similar capacities. The filter cloth shall be polyester or polypropylene as per the proven design of the supplier and shall be guaranteed for a minimum life of not less than 7000 hrs.
2.	The complete frame of the filter and all parts in contact with gypsum shall be made of corrosion resistant material.
3.	In case, the contractor offers a design with an underlying belt for carrying the filter cloth, the same shall be endless, factory vulcanized rubber belts. The belt shrouds and the sealing belts shall provide a leak tight arrangement to prevent overflow of gypsum slurry. The sealing belt shall have minimum life of not less than 7000 hrs.
4.	The vacuum box shall ensure tight sealing with the belt/cloth and shall be of proven design.
5.	The belt filter shall have an automatic cloth tracking mechanism and shall be provided with all required instrumentation as per the supplier's proven practice. The belt filter shall have an automatic cloth tensioning mechanism.
6.	The filter shall be provided with minimum 2 stages of cake washing for removing impurities in the gypsum. One stage of cloth washing arrangement shall also be provided.
7.	The service factor of the gear unit (if any) shall be minimum 1.5.
8.	Piping and wiring within the skid should be in the vendor's scope.
9.	Nozzles and connections The suction and discharge pipes will be flanged and will have the same nominal test procedure as the body of the pump. Threaded connections are not admitted in these pipes.
10.	The flanges shall comply with the following standards: - Steel flanges as per ANSI B16.5 (raised face type, at least class 150) - Cast iron flanges as per ANSI 16.1 (flat face type, at least class 125) The pipe shall be designed according to API676 with regards to the force.
11.	MOC (material of construction) of vent fan and its ducting shall be as per proven practice meeting the system requirement.
II	DESIGN AND CONSTRUCTION OF VACUUM PUMPS
	Design and construction of various components of the pumps shall conform to the following general specifications. For material of construction of the components, data sheets shall be referred to.
a)	Pump Casing
	Pumps shall be radial split casing, close/semi-open, over-hang, end suction type back pull-out design, vertical discharge type for horizontal centrifugal pump. The casing shall be designed to withstand the maximum shut-off pressure developed by the pump at the pumping temperature. Pump casing shall be provided with a vent connection and piping with fittings & valves. Casing drain as required shall be provided complete with drain valves, piping and plugs. It shall be provided with a connection for suction and discharge pressure gauge as standard feature. It shall be structurally sound to provide housing for the pump assembly and shall be designed hydraulically to minimum radial load at part load operation.
b)	Impeller

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	Impeller shall be closed, semi-closed or open type as specified elsewhere and designed in conformance with the detailed analysis of the liquid being handled. The impeller shall be secured to the shaft, and shall be retained against circumferential movement by keying, pinning or lock rings. On pumps with overhung shaft, impellers shall be secured to the shaft by a lockout or cap screw which tightness in the direction of normal rotation.		
c)	Impeller/Casing Wearing Rings		
	Replaceable type wearing rings shall be provided at suitable locations of pumps. Suitable method of locking the wearing ring shall be used. Wearing rings shall be provided in pump casing and/or impeller as per manufacturer's standard practice.		
d)	Shaft		
	The critical speed shall be well away from the operating speed and in no case less than 130% of the rated speed. The shaft shall be ground and polished to final dimensions and shall be adequately sized to withstand all stresses from rotor weight, hydraulic loads, vibration and torques coming in during operation.		
e)	Shaft Sleeves		
	Renewable type fine finished shaft sleeves shall be provided at mechanical seals. Shaft sleeves shall be fastened to the shaft to prevent any leakage or loosening. Shaft and shaft sleeve assembly should ensure concentric rotation.		
f)	Bearings		
	Heavy duty bearings, adequately designed for the type of service specified in the enclosed pump data sheet and for long, trouble free operation shall be furnished. The bearings offered shall be capable of taking both the radial and axial thrust coming into play during operation. In case, sleeve bearings are offered additional thrust bearings shall be provided. Antifriction bearings of standard type, if provided, shall be selected for a minimum life 20,000 hrs. of continuous operation at maximum axial and radial loads and rated speed. Proper lubricating arrangement for the bearings shall be provided. The design shall be such that the bearing lubricating element does not contaminate the liquid pumped. Where there is a possibility of liquid entering the bearings suitable arrangement in the form of deflectors or any other suitable arrangement must be provided ahead of bearings assembly. Bearings shall be easily accessible without disturbing the pump assembly. A drain plug shall be provided at the bottom of each bearings housing.		
g)	Mechanical Seals		
	Mechanical seals shall be of single type with either sliding gasket or bellows between the axially moving face and shaft sleeves or any other suitable type. The sealing faces should be highly lapped surfaces of materials known for their low frictional coefficient and resistance to corrosion against the liquid being pumped.		
	The pump supplier shall coordinate with the seal maker in establishing the seal chamber of circulation rate for maintaining a stable film at the seal face. The seal piping system shall form an integral part of the pump assembly. For the seals under vacuum service, the seal design must ensure sealing against atmospheric pressure even when the pumps are not operating. Necessary provision for seal water supply along with complete piping fittings and valves as required shall form integral part of pump supply.		
h)	Pump Shaft Motor Shaft Coupling		
	The pump and motor shafts shall be connected with an adequately sized flexible coupling of proven design with a spacer / v-belt connection to facilitate dismantling of the pump without disturbing the motor. Necessary coupling guards shall also be provided.		
i)	Base Plate		

<div>KAHALGAON TPP FGD</div> <div>GYPHUM DEWATERING SYSTEM TECHNICAL SPECIFICATION</div>		<div>SPECIFICATION No: PE-TS-481-571-A101</div> <div>SECTION: II</div> <div>SUB-SECTION: IIA</div> <div>REV. 00MAY 21</div>	
	A common base plate mounting both for the pump and motor shall be furnished. The base plate shall be fabricated steel and of rigid construction, suitably ribbed and reinforced. Base plate and pump supports shall be so constructed and the piping unit so mounted as to minimize misalignment caused by mechanical forces such as normal piping strain, internal differential thermal expansion and hydraulic piping thrust. Suitable drain troughs and drip lip shall be provided.		
j)	Drive Motor (Prime Mover)		
	The kW rating of the drive shall be based on continuously driving the connected equipment for the conditions specified.		
III	PIPING		
a)	The slurry pipes shall be sized to minimize erosion and avoid settling of the gypsum at all load operation. Slurry pipes shall be designed to keep the velocity above the settling velocity under all operating conditions. The bidder may provide a recirculation line with motorized isolation valve for the above purpose. All the pipes handling slurry shall be provided with replaceable rubber lining of proven quality. The slurry pipes shall be lined with replaceable wear resistant natural rubber lining of minimum 6 mm thickness. Additional thickness of 2 mm in rubber lining shall be provided at bends. The bidder can provide slurry pipes of size lower than 300 NB made up of FRP material (silicon carbide coating on slurry exposed surface) if it has previous experience of providing the same. Outer surface of the pipes should be fire retardant. All the rubber-lined pipes shall be of flanged connection.		
b)	Valves shall be of proven type and type contractor shall submit details valve schedule for employer's approval. Reference list for previous installations for similar application shall also be furnished to the employer.		
c)	The isolation valves provided in all the slurry lines shall be of knife gate type/butterfly type unless specifically mentioned. Motorized/ Pneumatic actuators shall be provided for valves requiring frequent operation as indicated in the relevant scheme.		
d)	Necessary arrangements for purging & flushing of all the process pipelines, equipments etc. shall be required.		
e)	Belt filter washing pumps shall have a minimum flow line to tank with a restriction orifice.		
f)	All Lube oil , Instrument Air piping shall be made up of Gr.304 Stainless Steel material.		
g)	All process water & Cooling water piping shall be made up of Carbon Steel Pressure Piping.		
IV	PROCESS/CLARIFIED WATER PUMPS		
a)	The cake/cloth wash pumps shall be horizontal centrifugal type designed for continuous operation with semi-open or closed impeller. Casing, Gland and Stuffing Box shall be of 2.5 Ni Cast Iron to IS:210 Grade FG 260 or equivalent. Impeller, Wearing rings (as applicable) shall be of Stainless Steel -316 grade and Shaft & Shaft sleeves shall be of SS-410 grade. Pump re-circulation line shall be provided for pumping system. Pumps shall be provided with accessories such as Y-type suction strainers, Coupling guard, drain plugs, vent valves etc.		
V	FILTRATE EXTRACTION PUMP		
	Typical MOC of Filtrate Extraction Pumps as follows: a) Casing: 1. Ductile Iron (65-45-12, ASTM A536) with replaceable rubber liner- 14000 hours to be guaranteed. OR 2. Ductile Iron with Hi Chrome liner – 14000 hours to be guaranteed. OR 3.Hi Chrome (ASTM 532 Grade IIIA) - 24000 hours to be guaranteed.		

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	<p>b) Impeller: Hi Chrome or superior material with 14000 hours guarantee.</p> <p>c) Solid Shaft: Duplex 2205 /EN8D /EN9</p> <p>d) Shaft sleeve at mechanical seal: CD4MCU ASTM A 743/ Duplex 2205</p> <p>e) Base Plate: Carbon steel with Epoxy Coating</p> <p>Bidder shall provide MOC of proven design to be approved during detailed engineering as per system/process requirement. The material and thickness of the liners shall ensure a minimum service life of 2 years before replacement</p>
V	GENERAL
a)	Cake/Cloth Wash pump shall be 1500/3000 RPM. The Vacuum Pump is a low speed machine and the RPM shall be selected by the bidder meeting the system requirement. Bidder to note that above shall be subject to BHEL/BHEL's Customer approval during contract stage.
b)	For gypsum, the bulk density shall be taken as 900 kg/m ³ for volumetric computation and 1250 kg/m ³ for torque and drive requirements. Refer respective P&IDs for Slurry details.
c)	The slurry pumps shall be provided with motorized suction and discharge valves. In addition, flushing water lines with motorized valves shall be provided for each pump for automatic flushing of the pump after each shut down. The flushing water for the pumps shall be taken from the process water supply.
d)	The slurry pump casing should be radially split to allow easy removal of impeller.



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GYPSUM DEWATERING SYSTEM
TECHNICAL SPECIFICATION

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SECTION-III

Annexure-1	LIST OF DOCUMENTS TO BE SUBMITTED WITH BID
Annexure-2	COMPLIANCE CUM CONFIRMATION CERTIFICATE
Annexure-3	PRE BID CLARIFICATION SCHEDULE
Annexure-4	DEVIATION SHEET (COST OF WITHDRAWAL)
Annexure-5	SCHEDULE OF GUARANTEES
Annexure-6	LIST OF MAKES OF SUB VENDOR ITEMS
Annexure-7	LIST OF TOOLS & TACKLES
Annexure-8	EQUIPMENT DATA SHEET/ SCHEDULE (TO BE FILLED BY BIDDER)
Annexure-9	LIST OF COMMISSIONING SPARES

	KAHALGAON TPP FGD GYPHUM DEWATERING SYSTEM TECHNICAL SPECIFICATION	SPECIFICATION No: PE-TS-481-571-A101	
		SECTION : III	
		ANNEXURE : 1	
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ANNEXURE - 1**DRAWINGS / DOCUMENTS TO BE SUBMITTED WITH THE BID**

Bidder should submit the filled up (wherever applicable), signed and stamped copy of the following documents along with the offer/ bid for technical evaluation:

Sl. No.	Reference	Description
1.	Annexure-2	COMPLIANCE CUM CONFIRMATION CERTIFICATE
2.	Annexure-3	PRE BID CLARIFICATION SCHEDULE
3.	Annexure-4	DEVIATION SHEET (COST OF WITHDRAWAL)
4.	Annexure-5	SCHEDULE OF GUARANTEES
5.	Annexure-6	LIST OF MAKES OF SUB VENDOR ITEMS
6.	Annexure-7	LIST OF TOOLS & TACKLES
7.	Annexure-8	EQUIPMENT DATA SHEET/ SCHEDULE (TO BE FILLED BY BIDDER)
8.	Annexure-9	LIST OF COMMISSIONING SPARES
9.		UNPRICED SCHEDULE IN THE PRICE FORMAT ISSUED ALONG WITH TENDER

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COMPLIANCE-CUM-CONFIRMATION CERTIFICATE

The bidder shall confirm compliance with following by signing / stamping this compliance certificate (every sheet) and furnish same with the offer.

- a) The scope of supply, technical details, construction features, design parameters etc. shall be as per technical specification & there are no exclusions, other than those mentioned under "exclusion and those resolved as per 'Schedule of Deviations', with regard to same.
- b) There are no other deviations w.r.t. specifications other than those furnished in the 'Schedule of Deviations'. Any other deviation, stated or implied, taken elsewhere in the offer stands withdrawn unless specifically brought out in the 'Schedule of Deviations'.
- c) Bidder shall submit QP in the event of order based on the guidelines given in the specification & QP enclosed therein. QP will be subject to BHEL / CUSTOMER approval & customer hold points for inspection / testing shall be marked in the QP at the contract stage. Inspection / testing shall be witnessed as per same apart from review of various test certificates/ Inspection records etc. This is within the contracted price without any extra implications to BHEL after award of the contract.
- d) All drawings/ data-sheets / calculations etc. submitted along with the offer, if not sought/required for bid evaluation shall not be taken cognizance off.
- e) The offered materials shall be either equivalent or superior to those specified in the specification & shall meet the specified / intended duty requirements. In case the material specified in the specifications is not compatible for intended duty requirements, the same shall be resolved by the bidder during the pre-bid discussions, otherwise BHEL/Customer's decision shall be binding on the bidder, whenever the deficiency is pointed out.

For components where materials are not specified, the same shall be suitable for intended duty, all materials shall be subject to approval in the event of order.

- f) The commissioning spares shall be supplied on 'As Required Basis' & prices for same are deemed to be included in the base price.
- g) All sub-vendors shall be subject to BHEL / CUSTOMER approval in the event of order.
- h) Guarantee/Warranty for plant/equipment shall be as per relevant clause of GCC / SCC / other Commercial Terms & Conditions.
- i) In the event of order, all the material required for completing the job at site shall be supplied by the bidder within the ordered price even if the same are additional to approved billing break-up, approved drawing or approved Bill of quantities within the scope of work as tender specification. This clause will apply in case during site commissioning, additional requirements emerges due to customer and / or consultant's comments. No extra claims shall be put on this account.

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j) Schedule of drawings/documents/quality plans submission, comment incorporation & approval shall be as stipulated elsewhere in the specification. The successful bidder shall depute his design personnel to BHEL's / Customer's / Consultant's office for across the table resolution of issues and to get documents approved in the stipulated time.

k) As-built drawings shall be submitted as and when required during the project execution.

l) The bidder has not tampered with this compliance-cum-confirmation certificate and if at any stage any tampering in the signed copy of this document is noticed then same shall be treated as breach of contract and suitable actions shall be taken against the bidder.

m) Successful bidder shall furnish detailed erection/installation manual for each of the equipment supplied under this contract as per the schedule of submission of documents and well before the scheduled erection of the equipment / component concerned.

n) Document approval by customer under Approval category or information category shall not absolve the vendor of their contractual obligations of completing the work as per specification requirement. Any deviation from specified requirement shall be reported by the vendor in writing and shall require written approval. Unless any change in specified requirement has been brought out by the vendor during detail engineering in writing while submitting the document to customer for approval, approved document (with implicit deviation) will not be cited as a reason for not following the specification requirement.

o) In case vendor submits revised drawing after approval of the corresponding drawing, any delay in approval of revised drawing shall be to vendor's account and shall not be used as a reason for extension in contract completion.



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ANNEXURE-3
PRE-BID CLARIFICATION SCHEDULE

S. NO.	SECTION/CLAUSE/PAGE NO.	STATEMENT OF THE REFERRED CLAUSE	CLARIFICATION REQUIRED

The bidder hereby clarifies that above mentioned are the only clarifications required on the technical specification for the subject package.

Signature: _____


Name: _____

Designation: _____

Company: _____


Date: _____

Company Seal


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DEVIATION SHEET (COST OF WITHDRAWAL)

(TO BE FILLED UP BY BIDDER IN THE FORMAT ATTACHED AS ANNEXURE –II OF GENERAL CONDITIONS OF CONTRACT ISSUED ALONG WITH TENDER. ANY DEVIATION QUOTED ELSEWHERE/ IN OTHER FORMAT SHALL NOT BE CONSIDERED)

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SCHEDULE OF GUARANTEES

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1.0 PERFORMANCE GUARANTEE


- All performance tests for GDS shall be carried out in accordance with the relevant latest international codes/standards.
- 1) Bidder shall furnish Performance guarantee for the design, manufacture, material, safe and trouble-free operation of the Gypsum Dewatering System (GDS) and its accessories.
 - 2) Bidder shall furnish guaranteed power consumption for the gypsum dewatering system. Guaranteed Power Consumption in the applicable format shall be submitted in sealed envelope along with price bid as part of techno-commercial offer. However along with unpriced format, bidder shall furnish guaranteed power consumption format indicating "Quoted" in the table provided in Annexure-IV of the price schedule.
 - 3) Vendor shall Guarantee and demonstrate each Vacuum Belt Filter capacity of minimum **49.84 TPH wet gypsum cake** with an inlet solid concentration of 45% by weight.
 - 4) The contractor shall guarantee and demonstrate that gypsum cake moisture content shall be less than **10%** and chloride content shall be less than **100 ppm**.
 - 5) The filter cloth shall be guaranteed for a minimum life of not less than 7000 hrs.
 - 6) The liners in hydro-cyclone shall have a minimum wear life of not less than 7000 hrs.
 - 7) Noise level ≤ 85 dB (A) at 1 m horizontal distance from equipment/enclosures & 1.5 m above operating floor is to be guaranteed.
 - 8) Vibration levels measured on the non-rotating parts shall not exceed the zone limit "B" as defined in ISO 10816 at steady conditions and shall not exceed the zone limit "C" as defined in ISO 10816 at transient conditions.
 - 9) Acceptance tests to be carried out as per the procedure defined by the bidder which shall be submitted for BHEL/ CUSTOMER approval.
 - 10) In the event that the performance test is unsuccessful, bidder shall take necessary remedial action at his cost and the performance test shall be repeated.

Bidder shall submit signed & stamped copy of this document.

	KAHALGAON TPP FGD GYPHUM DEWATERING SYSTEM TECHNICAL SPECIFICATION SUB-VENDOR LIST	SPECIFICATION NO. PE-TS-481-571-A101	
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LIST OF MAKES OF ITEMS

S.N.	ITEM NAME	MANUFACTURER	LOCATION

	3x660 MW NABINAGAR STPP TECHNICAL SPECIFICATION GYP SUM DEWATERING SYSTEM	SPECIFICATION No: PE-TS-481-571-A101	
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LIST OF TOOLS & TACKLES

S.N.	ITEMS	QUANTITY



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EQUIPMENT DATA SHEET/SCHEDULE

S.No.	Description	Data
1.0	GENERAL	
	a. Client	: BHEL-PEM, Noida
	b. Project	: KAHALGAON TPP FGD
	c. End Customer	: NTPC
	d. Service	: Continuous
	e. Installation	: Inside the Building
	f. Quantity for all FGD units	: 2 sets (1W+1S)
2.0	MANUFACTURER DETAILS	
	a. Model	: Bidder to Provide
	b. Type	: Bidder to Provide
3.0	OPERATING CONDITION	
	Medium to be handled	: Gypsum Slurry
4.0	Technical Data	
4.1	PRIMARY HYDRO-CYCLONE	
	i. Stage	Bidder to Provide
	ii. Manufacturer	Bidder to Provide
	iii. Number of Hydro cyclone	Bidder to Provide
	iv. Diameter of Hydro cyclone	Bidder to Provide
	v. Diameter of Vortex Finder	Bidder to Provide
	vi. Diameter of Apex Valve	Bidder to Provide
	vii. Diameter of Feed Inlet	Bidder to Provide
	viii. Design Pressure	Bidder to Provide
	ix. Working Pressure	Bidder to Provide
	x. Feed Flow rate	Bidder to Provide
	xi. Overflow Rate	Bidder to Provide
	xii. Underflow Rate	Bidder to Provide
	xiii. Mesh of separation (50% Removed)	Bidder to Provide
	xiv. Solid content of feed slurry	Bidder to Provide



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	xv.	Solid content in underflow of Hydrocyclone	Bidder to Provide	
	xvi.	Solid content in Overflow of Hydrocyclone	Bidder to Provide	
	xvii.	Type of cyclone	Bidder to Provide	
	a)	Cyclone Dia/Height (mm)	Bidder to Provide	
	b)	Required Liquid Feed Pressure	Bidder to Provide	
	c)	Cyclone Connection Number/Dia. (mm)	Bidder to Provide	
	d)	Feed	Bidder to Provide	
	e)	Overflow	Bidder to Provide	
	f)	Underflow	Bidder to Provide	
	g)	Rf Value (Underflow Slurry (m3/hr/Feed	Bidder to Provide	
	h)	Material	Bidder to Provide	
	i)	Shell	Bidder to Provide	
	j)	Internal Structure Part	Bidder to Provide	
	k)	Lining	Bidder to Provide	
	l)	Particle Size Distribution	Bidder to Provide	
	m)	Weight	Bidder to Provide	
4.2	VACUUM BELT FILTERS (VBF)			
	a.	Manufacturer	:	Bidder to Provide
	b.	Model No.	:	Bidder to Provide
	c.	Dimensions (W x L x H) (m x m x m)	:	Bidder to Provide
	d.	Cloth Width m	:	Bidder to Provide
	e.	Cloth Length m	:	Bidder to Provide
	f.	No. Working / Stand-by	:	Bidder to Provide
	g.	Capacity (Guaranteed) Gypsum (Dry) Kg/hr	:	Bidder to Provide
	h.	Inlet Flow Volume m3/h	:	Bidder to Provide
	i.	Gypsum Flow (Dry) Kg/hr	:	Bidder to Provide
	j.	Moisture Removed %	:	Bidder to Provide
	k.	No. of stages of cake washing / water flow m3/h	:	Bidder to Provide


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	l. No. of stages of cloth washing / water flow	m ³ /h	:	Bidder to Provide
	m. Design Pressure of Vacuum Chamber		:	Bidder to Provide
	n. Operating Pressure of Vacuum Chamber		:	Bidder to Provide
	o. Material / Thickness	mm	:	Bidder to Provide
	i. Casing		:	Bidder to Provide
	ii. Cloth		:	Bidder to Provide
	iii. Gypsum Discharge Hopper		:	Bidder to Provide
	iv. Vacuum Box		:	Bidder to Provide
	p. Life of Cloth	hrs	:	Bidder to Provide
	q. Type /Material of Carrying Belt		:	Bidder to Provide
	r. Type / Material of Sealing Belt		:	Bidder to Provide
	s. Life of Carrying Belt	hrs	:	Bidder to Provide
	t. Life of Sealing Belt	hrs	:	Bidder to Provide
	u. Automatic Cloth Tensioning Mechanism Provided		:	Yes / No - Bidder to confirm
4.3	VACUUM RECEIVER TANK			
a.	No. of Tank for each VBF		:	Bidder to Provide
b.	Capacity (m ³)		:	Bidder to Provide
c.	Dimensions (Dia x Height) (mm x mm)		:	Bidder to Provide
d.	Material / Thickness (mm)		:	Bidder to Provide
e.	Lining Material / Thickness mm		:	Bidder to Provide
4.4	Vacuum Pumps			
a.	Manufacturer		:	Bidder to Provide
b.	Make/Model		:	
c.	Type		:	Bidder to Provide
d.	No. of Pumps for each Vacuum Belt Filter		:	Bidder to Provide
e.	Rated Capacity Flow (m ³ /hr)		:	Bidder to Provide
	Rated Capacity Head (mWCI)		:	Bidder to Provide
	Rated Capacity Power (KW)		:	Bidder to Provide
f.	Power consumption (KW)		:	Bidder to Provide

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g.	Pump Speed (rpm)	:	Bidder to Provide
h.	Motor Rating (KW)	:	Bidder to Provide
i.	Motor Speed (rpm)	:	Bidder to Provide
j.	Margins (Flow/Head) (%/%)	:	Bidder to Provide
k.	Operation Pressure	:	Bidder to Provide
l.	Design Pressure	:	Bidder to Provide
m.	Material/Thickness (mm) of	:	Bidder to Provide
	Base/Lining	:	Bidder to Provide
	Casing	:	Bidder to Provide
	Shaft	:	Bidder to Provide
	Impeller	:	Bidder to Provide
n.	Type of seal	:	Bidder to Provide
o.	Sealing Water Flow (m3/hr)	:	Bidder to Provide
p.	Bearing	:	Bidder to Provide
	No. of Bearings	:	Bidder to Provide
	Type Of Bearings	:	Bidder to Provide
q.	Type of coupling	:	Bidder to Provide
r.	Whether silencer provided at outlet	:	Yes/No
4.5	SLURRY PIPES	:	
a.	Pipe size (mm)	:	Bidder to Provide
b.	Type of Joints	:	Bidder to Provide
	Pipe to Pipe/Pipe to Fittings	:	Bidder to Provide
	Fittings	:	Bidder to Provide
c.	Material / Thickness (mm)of Pipe	:	Bidder to Provide
d.	Material Thickness of lining	:	Bidder to Provide
e.	Estimated Life of liners (hrs.)	:	Bidder to Provide
f.	Slurry Solid concentration (w/w %)	:	Bidder to Provide
g.	Slurry Settling Velocity (m/s)	:	Bidder to Provide
h.	Pipe Velocity (m/s)	:	Bidder to Provide
4.6	BELT FILTER WASH PUMPS	:	
a.	No. for each VBF	:	

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b.	No. of stand-by pumps for each VBF			
c.	Make / Model			
d.	Impeller Type			
e.	Material / Thickness (mm) of Impeller and lining			
f.	Casing Type			
g.	Material/Thickness of Casing/Lining			
h.	Rated Flow/Head (m3/hr./mWCI)			
4.7	CAKE WASH PUMPS			
i.	No. for each VBF			
j.	No. of stand-by pumps for each VBF			
k.	Make / Model			
l.	Impeller Type			
m.	Material / Thickness (mm) of Impeller and lining			
n.	Casing Type			
o.	Material/Thickness of Casing/Lining			
p.	Rated Flow/Head (m3/hr./mWCI)			
4.8	BELT ACCESSORIES			
4.8.1	Bearing			
a.	Carrying	:	Bidder to Provide	
b.	Return	:	Bidder to Provide	
4.8.2	Material			
a.	Roller	:	Bidder to Provide	
b.	Spindle	:	Bidder to Provide	
4.8.3	Pulleys			
i)	General (for all types of Pulleys)	:	Bidder to Provide	
a.	Pulley Shaft Diameter	:	Bidder to Provide	
ii)	Drive Pulleys			
a.	Lagging	:	Bidder to Provide	
b.	Lagging thickness	:	Bidder to Provide	
c.	Minimum angle of wrap	:	Bidder to Provide	
d.	Maximum out of roundness	:	Bidder to Provide	

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iii)	Other Pulleys			
a.	Lagging	:	Bidder to Provide	
b.	Lagging thickness	:	Bidder to Provide	
iv)	Rubber for lagging			
a.	Type	:	Bidder to Provide	
b.	Hardness	:	Bidder to Provide	
c.	Elongation	:	Bidder to Provide	
d.	Strength	:	Bidder to Provide	
e.	Abrasion Loss	:	Bidder to Provide	
f.	Specific Gravity	:	Bidder to Provide	
g.	Adhesion Strength	:	Bidder to Provide	
v)	Bearings for Pulleys			
a.	Type	:	Bidder to Provide	
b.	Casing	:	Bidder to Provide	
c.	Sealing	:	Bidder to Provide	
d.	Lubrication	:	Bidder to Provide	
e.	Pulley Material	:	Bidder to Provide	
f.	Shaft Material	:	Bidder to Provide	
4.9	Secondary (Waste Water) Hydrocyclone	:	Bidder to Provide	
	i) Stage	:	Bidder to Provide	
	ii) Manufacturer	:	Bidder to Provide	
	iii) Number of Hydrocyclone	:	Bidder to Provide	
	iv) Diameter of Hydrocyclone	:	Bidder to Provide	
	v) Diameter of Vortex Finder	:	Bidder to Provide	
	vi) Diameter of Apex Valve	:	Bidder to Provide	
	vii) Diameter of Feed Inlet	:	Bidder to Provide	
	viii) Design Pressure	:	Bidder to Provide	
	ix) Working Pressure	:	Bidder to Provide	
	x) Feed Flow rate	:	Bidder to Provide	
	xi) Overflow Rate	:	Bidder to Provide	
	xii) Underflow Rate	:	Bidder to Provide	

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	xiii) Mesh of separation (50% Removed)	:	Bidder to Provide
	xiv) Solid content of feed slurry	:	Bidder to Provide
	xv) Solid content in underflow of Hydro-cyclones	:	Bidder to Provide
	xvi) Solid content in Overflow of Hydro-cyclones	:	Bidder to Provide
	xvii) Type of cyclone	:	Bidder to Provide
	a. Cyclone Dia/Height (mm)	:	Bidder to Provide
	b. Required Liquid Feed Pressure	:	Bidder to Provide
	c. Cyclone Connection Number/Dia. (mm)	:	Bidder to Provide
	d. Feed	:	Bidder to Provide
	e. Overflow	:	Bidder to Provide
	f. Underflow	:	Bidder to Provide
	g. Rf Value (Underflow Slurry (m ³ /hr/Feed Slurry (m ³ /hr)	:	Bidder to Provide
	h. Material	:	Bidder to Provide
	i. Shell	:	Bidder to Provide
	j. Internal Structure Part	:	Bidder to Provide
	k. Lining	:	Bidder to Provide
	l. Particle Size Distribution	:	Bidder to Provide
	m. Weight	:	Bidder to Provide



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LIST OF COMMISSIONING SPARES

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