BHARAT HEAVY ELECTRICALS LIMITED
CENTRALISED STAMPING UNIT
Jagdishpur

Tender for supply and installation of pre-engineered roof and wall metal cladding for Manufacturing Block at Jagdishpur

Tender Enquiry No: BHE/CSU/CVL/08

SECTION V

TECHNICAL SPECIFICATION

PART A: SPECIFIC TECHNICAL REQUIREMENTS

BHARAT HEAVY ELECTRICALS LIMITED
(A GOVERNFMENT OF INDIA UNDERTAKING)
CENTRALISED STAMPING UNIT
Industrial Area
Jagdishpur (UP) 227817

SECTION V

PART - A

SPECIFIC TECHNICAL REQUIREMENTS

1.0 GENERAL

Part-A covers specific technical requirements of contract and should be read in conjunction with BOQ, Part-B and other sections of the contract. In case of any conflict between the contents of BOQ and Part-A, BOQ will prevail over Part-A. In case of any conflict between Part-A and Part-B, Part-A will prevail over Part-B.

2.0 FREE ISSUE MATERIALS

Nothing shall be supplied as free issue material by BHEL.

3.0 DISMANTLING OF EXISTING STRUCTURES

The contractor will have to carryout dismantling of buried/ semi buried structures, if any, encountered within the battery limit and disposal of it within plant boundary as directed by BHEL at no extra cost to BHEL.

4.0 STATUTORY REQUIREMENTS

Bidder shall comply with all the applicable statutory rules pertaining to Factories Act, Fire Safety Rules of Tariff Advisory Committee, Water Act for pollution control, Explosives Act, etc.

Provisions of safety, health and welfare according to Factories Act shall be complied with. These shall include provision of continuous walkway minimum 500 wide along the crane-girder level on both sides of building, comfortable approach to EOT crane cabin, railing, fire escape, locker room for workmen, pantry, toilets, rest room, etc.

Provisions for fire proof doors number of staircases, fire separation wall, lath plastering/encasing the structural members (in the fire prone areas), type of glazing etc. shall be made according to the recommendations of Tariff Advisory Committee.

Statutory clearances and norms of State Pollution Control Board shall be followed.

Bidder shall obtain approval of Structural /Architectural drawings from concerned authorities before taking up the construction work.

5.0 LAYOUT

Before starting the work, the Contractor shall carry out the setting out of foundation and structures and provide levels, with reference to general existing grid and bench mark. If the contractor uses the grid, , bench mark and reference pillar made by other Contractors, he shall coordinate with the Contractor and shall satisfy himself of the accuracy of the reference marks. If he is required to set out the foundation afresh, he shall do so independently with reference to the one existing grid and

bench mark which has been followed by other agency at the instruction of the Engineer. In case any discrepancy be found, it shall be immediately brought to the notice of the engineer for any rectification/modification necessary. No complaint shall be entertained at a later stage. The Contractor shall accurately set out the position for holding down bolts and inserts.

If required, in the opinion of the Engineer, he shall construct and maintain pillars for Grid, references and bench marks and maintain them till the completion of the construction. He shall also help the Engineer with instruments, materials and labours for checking the detailed lay outs and levels. The Contractor shall be solely responsible for the correctness of the layout and levels, and Engineer's approval shall not be deemed to imply any warranty in carrying out the work correctly.

6.0 WORKMANSHIP

Workmanship shall be of the best possible quality and all work shall be carried out by skilled workmen except for those which normally require unskilled persons. Welding shall be done by experienced and certified welders in proper sequence using necessary jigs and fixtures. Fabrications shall be done in shops having proper equipment for accurate edge planning and milling of column shall ends, base late surfaces etc. and shaping and dimensioning of anchor bolt assembly, inserts and other misc. items. In addition to the requirement specified above, if the bye-laws of the local Govt., Municipal or other authorities require the employment of licensed or registered workmen for various traders, the contactor shall arrange to have the work done by such registered or licensed personnel. In case of manufactured materials, the Contractor shall have, with no additional cost the owner, the services of the supervisors of the manufacturers to achieve that the work is being done according to the manufacturer's specifications.

7.0 TEMPORARY WORK

All scaffoldings, staging, temporary bracing and other necessary temporary work required for proper execution of the Contract shall be provided by the Contractor at his own cost and inclusive of all materials, labour, supervision and other facilities.

The layout and details of such Temporary work shall have the prior approval of the Engineer as agreed, but the Contractor shall be responsible for proper strength and safety of the same. All Temporary work shall be so constructed as not to interfere with any permanent work or with the work by other agencies. If it is necessary to remove any of the temporary work at any time to facilitate execution of the work or with the work of other agencies, such removal and re-erection, if required, shall be carried out by the Contactor at the discretion of the Engineer without any delay and any extra cost on this account shall be borne by the Contractor.

8.0 INTERFACE WITH STRUCTURES UNDER OTHER'S SCOPE

a) In cases of interface e.g. structures under other's scope of supply being supported on structures under scope of this contractor, the same will be discussed and suitably addressed.

b) Modification in layout of foundation/structure during detail engineering stage may be necessary to avoid fouling with those under other's scope. Necessary changes on this account will be made without any extra cost to Owner.

c) Necessary engineering is to be done and provisions are to be kept accordingly by the Contractor to construct foundations/underground structures, etc. without disturbing/ endangering the constructions done under the scope of other contracts.

9.0 INSPECTION, TESTING AND QUALITY CONTROL FOR CIVIL WORKS

Sampling and testing for major items of civil works viz earthwork, concreting, structural steel work (including welding) etc. shall be carried out in accordance with the requirements of this specification and field quality plan (FQP).

The bidder shall submit for BHEL's approval a detailed field quality assurance programme for metal cladding works before starting of the fabrication work. This shall include frequency of sampling and testing nature/type of test, method of test, setting of a testing laboratory, arrangement of testing apparatus/equipment, deployment of qualified/experienced manpower, preparation of format for record, Field Quality Plan, etc. Tests shall be done in the field and/or at a laboratory approved by the Engineer and the Bidder shall submit to the Engineer, the test results in triplicate. In addition, the bidder shall furnish the original test certificate from the manufacturer's of various materials to be used in the construction.

If any work found to be of inferior quality or sub-standard, the same shall be dismantled and shall be redone as per approved quality or relevant standard. BHEL reserve the rights to reject the work of inferior quality. All expenses on account of dismantling and rework shall be born by contractor.

10.0 CONSTRUCTION / ERECTION METHODOLOGY

- All fabrication and erection activities of structural steel shall be carried out using automatic submerged arc welding machines, cutting machine, gantry cranes, crawler / wheel mounted heavy cranes and other equipments like heavy plate bending machines, shearing machines, lathe, milling machines etc. Use of derricks shall not be permitted.
- All handling of materials shall be with cranes. Heavy tailors shall be used for transportation.
- Mechanized modular units of scaffolding shall be used.
- Grouting shall be carried out using hydraulically controlled grouting equipment.
- All finishing items shall be installed using appropriate modern mechanical tools.
- Manual punching etc. shall not be permitted.
- Heavy duty hoist for lifting of construction materials shall be deployed.
- Compressors for cleaning of foundations and other surfaces shall be used.
- Field laboratory shall be provided for testing of steel works, ultra sonic testing machines, radiographic testing machines, dye penetration test equipment, destruction testing equipment, etc shall be deployed.
- All persons working at site shall be provided with necessary safety equipment and all safety aspects shall be duly considered for each construction/erection activity. Moreover, only the persons who are trained in the respective trade shall be employed for executing that particular work.
- Fabrication and Erection of all fabricated columns shall be done in single piece unless otherwise provided for in the approved drawings. Main columns of the power house building can have maximum of one number of the erection splice. All shop and site splice shall suitably staggered. The erection splice shall be provided with full strength splice cover plate over the butt weld. Contractor shall

submit the erection scheme for the erection of all type of structures and carryout the erection work only after approval of the scheme by the owner.

11.0 FIELD / WORKS LABORATORY FACILITIES AT SITE FOR MATERIAL TESTING:

Contractor shall provide field/ works testing facilities at accredited laboratory.

12.0 MAKE OF BOUGHT OUT MATERIAL:

Contractor shall supply bought out items as per the list attached at annexure-A-1 of this section.

13.0 SPECIFIC STRUCTURAL REQUIREMENTS FOR MANUFACTURING PLANT

13.1 Superstructure

- R.C.C. columns in M-25 concrete up to Gantry level or (9.20m) and steel portal as per design above 9.20m.
- R.C.C. beams in M-20 concrete at Intermediate and Top level.
- Walls 230mm thick in brick masonry with class-250 bricks laid in 1:4 cement & fine sand (F.M.=1.25) mortar.
- Plastering inside in 1:4 cement and fine sand (F.M.=1.25) mortar
- Plastering outside in 1:4 cement and fine sand (F.M.=1.25) mortar.
- Cladding sheets shall be laid over steel structural portal frame . The steel structural portal frame is fixed above +9.2m from FFL on top of RCC columns.

13.2 Roofing and wall cladding:

- Galvalume metal sheets as per ASTM Spec A792/A792M-97a Hi-rib steel sheeting in approved profile 1000mm wide, hot dip metallic coating of zinc and aluminum – placed over A Z-section Purlin, fixed by galvanized hex head self – drilling fasteners [maximum length up to 12mm long]. Sheeting thickness shall be 0.5mm colour coated galvalume along with a sandwitched insulation of density not less than 32 Kg/Cu.m.or as per BOQ thus making a composite panel thickness of 50mm comprising of an inner sheet, an outer sheet and a sandwitched insulation.with approved colour
- Walls shall be with single sheet metal cladding (Galvalume) as described in BOQ.

ANNEXURE-"A-1"

INDICATIVE LIST OF APPROVED MAKE OF BOUGHT OUT MATERIAL TO BE ARRANGED BY THE CONTRACTOR AT HIS OWN COST

The following list may be read in conjunction with the relevant make/ makes of materials mentioned in the BOQ or elsewhere in this tender document.

S.NO.	MATERIAL NAME	MAKE
1	ROOF AND WALL METAL CLADDING	Any manufactury using Galvalume metal sheets as raw material.

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SECTION V

PART B:STANDARD TECHNICAL SPECIFICATION FOR METAL CLADING WORKS

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SECTION V
PART - B

STANDARD TECHNICAL SPECIFICATION FOR CLADDING WORKS

Following sections of technical specifications shall be followed for all works at site in addition to standard CPWD/ BIS specifications.

1.00.00 SCOPE

This section covers design, supply, cutting & fabrication and erection of corrugated/plain asbestos, corrugated galvanized iron, aluminum, permanently colour coated troughed zinc-aluminium alloy coated M.S. sheet or other sheet for covering to roof and sides at various elevations as specified.

2.01.00 Storage of Materials

All materials shall be stored by the Contractor in proper way to prevent all damage.

2.02.00 Workmanship

The workmanship shall be according to best construction practice to give a watertight finish to the satisfaction of the Engineer. Fixing of gutters and down pipes shall be according to IS: 2527

2.02.01 Fibre Glass Reinforced Plastic Sheeting

This shall be of thickness and profile as specified. Colour and light transmittance shall be as mentioned. Where used in conjunction with C.G.I. or asbestos sheeting, the end and side laps and fixing device shall be same as used for general sheeting. Where used in lieu of glass, the fixing shall be by means of timber or metal glazing beads. In all cases, the installation shall be completely watertight and able to withstand the designed wind-pressure.

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2.02.02 PERMANENT COLOUR COATED SANDWICHED (INSULATED) METAL CLADDING SYSTEM

i. Troughed high ribbed profiled zinc-aluminium alloy coated (both sides) M.S. sheet (Galvalume) having 0.6mm minimum thickness (or high tensile steel sheet having minimum yield strength of 550 Mpa of 0.5mm

minimum thickness) shall be used on external face (outer face) of cladding system. Weight of coating shall not be less than 150 gm/sq.m. The outer side (exposed face) shall be permanently colour coated with Polyfluro Vinyl Coating (PVF_2) of Dry Film Thickness (DFT) 20 microns (minimum) over primer. Inner side of external sheet shall be provided with suitable pre-coating of minimum 7 microns.

ii. Galvanised M.S. sheets of minimum 0.6mm thickness shall be used as inner liner (internal face) of cladding system. The exposed face shall be permanently colour coated with silicon modified polyester paint of DFT 20 microns (minimum) over primer. Inner face of external sheet shall be provided with suitable pre-coating of minimum 7 microns. The rate of galvanization shall not be less than 275 gm/sqm.

iii. The permanent colour coated sheet shall meet the general requirements of IS:14246 and shall conform to class 3 for the durability.

iv. Inner sheet shall be fixed directly to side runners and Z spacers made out of at least 2 mm thick galvanized steel sheet of grade 375 as per IS:277. Inner sheet shall be fixed at the rate not more than 1.50M centre to centre to hold the insulation and external sheeting. The fasteners shall be of high quality corrosion resistant grade of self tapping / self drilling type provided with suitable cap.

v. The insulation shall be of bonded mineral wool of minimum thickness 50mm conforming to IS:8183, having a density of 32 Kg/cu.m. for glass wool & 48 Kg/cu.m. for rock wool.

2.02.05 PERMANENT COLOUR COATED (NON-INSULATED) METAL CLADDING SYSTEM

i. Troughed high ribbed profiled zinc-aluminium alloy coated (Galvalume) not less than 150 gm/sq.m M.S. sheets having 0.6 mm minimum thickness (or High tensile steel sheet having minimum yield strength of 550 Mpa of 0.5mm minimum thickness) shall be used for the cladding system. The outer side (exposed face) shall be permanently colour coated with PVF_2 paint of minimum DFT 20 microns over primer and the inner side (internal face) shall be coated with same paint of minimum DFT 12 microns over primer. These shall be fixed directly to runners. The sheets shall meet the general requirement of IS:14246 and shall conform to class 3 for the durability.

ii) **FLASHING, CAPS, TRIM CLOSURES ETC.**

All flashings, trim closures caps etc. required for the metal cladding system shall be made out of plain sheets having same material and coating specification as mentioned above for the outer face of the sandwiched metal cladding.

3.00.00 ACCEPTANCE CRITERIA

The installations shall present a neat appearance and shall be checked for water tightness. The following shall be checked:

a) Side and end laps

b) Absence of cracks, holes or damages in sheet

c) Spacing of bolts

d) Provision of double washers (G.I. and asbestos or bituminous washers)

e) Proper installation of flashing.

4.00.00 I.S. CODE

All work shall be carried out as per this specification and shall conform to the latest revision and/or replacements of the following or any other Indian Standard (IS) Codes, unless specified otherwise. In case any particular aspect of work is not specifically covered by Indian Standard Codes, any other standard practice, as may be specified by the Engineer, shall be followed.

IS: 3007 sheets.	:	Code of practice for laying of asbestos cement
IS: 2527 down	:	Code of practice for fixing rainwater gutters and pipes for roof drainage.
IS: 1626 gutters	:	Specification for asbestos cement building pipes, and fittings.
IS: 277	:	Specification for galvanized steel sheets (plain and corrugated).

5.00.00 RATES AND MEASUREMENT

5.01.00 Rates

Rates shall be unit rate for complete item described in “Schedule of Items” and shall include all wastage.

5.02.00 Measurement

Sheeting work in roof & sides shall be measured in Sq.M. for net area of the work done. Profiled sheeting shall be measured flat and not girthed. Opening less than 0.40 Sqm shall not be deducted. No extra shall be paid for extra labour in cutting and for wastage etc. No payment shall be made for laps in sheeting works.