



**Bharat Heavy Electricals Limited**  
**High Pressure Boiler Plant**  
**Quality Control Department**  
**Tiruchirapalli 620 014 , India**

Phone : 0431-2575187  
Fax : 91-(0431)-2520730  
e-mail : [myselfvan@bheltry.co.in](mailto:myselfvan@bheltry.co.in)

**AN ISO 9001 COMPANY**

Enquiry No. BHE:QC:SHOP:OS:209

Date: 08.12.2010

**SUB: Enquiry for outsourcing of Shop Quality Control back-end activities by physical supervisory support.**

Quality Control Department BHEL Tiruchirappalli is interested in utilizing services for physical supervisory support for Shop Quality Control back-end activities under the close supervision of BHEL Quality Control from experienced and reputed Inspection agencies meeting the following eligibility criteria.

- i) The Inspection Agency should have a minimum of 5 years experience in Industrial Inspection related activities in Fabrication of Boiler components or Boiler construction site.
- ii) Inspection Agency should possess PAN Card.
- iii) Inspection Agency should possess Service Tax, PF & ESI Registration Certificates.

The Inspection agencies who fulfil the above eligibility criteria may download the Enquiry Document and submit the offer as detailed below.

Kindly offer your Quotation in Two Parts in separate sealed covers. **Part A** – Technical Bid and **Part B** – Price Bid. Earnest Money Deposit (EMD) amount of Rs.2,00,000/- (Rupees Two Lakhs only) in the form of crossed Demand Draft drawn in favour of Bharat Heavy Electricals Limited payable at Tiruchirapalli shall be sent along with your offer.

Inspection agencies shall quote a SINGLE RATE for each category of work valid uniformly for the entire contract period. No escalation of rate is admissible during the contract period. The inspection agency shall quote the rate exclusive of service tax and education cess as applicable. No other taxes or duties will be paid by BHEL other than the above. However, additional financial implications on account of statutory changes and new levies subsequently introduced will be reimbursed by BHEL on production of documentary evidence.

We request you to furnish your quotation IN TWO PARTS viz.,

**Part A** – Technical Bid shall contain with document evidence of 1) Organisation Chart and details of technical persons with qualification and experience on roll, 2) Previous experience in Industrial Inspection related activities in Fabrication of Boiler components or Boiler

construction site, 3) Copies of PAN card, Service Tax, Provident Fund and ESI Registration certificates, 4) Technical Bid Criteria as given in Annexure-III duly signed by authorized signatory and 5) Annual Turnover, Audited Profit and Loss account & Balance Sheet for the last 3 years and 6) EMD of Rs2,00,000/- as mentioned above.

**Part B – Price Bid as per the enclosed Annexure – IV**

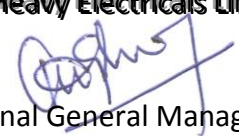
Technical Bid (A) and Price Bid (B) shall be in separate sealed covers. Both the sealed covers should be sent together in one sealed cover clearly indicating the Enquiry Reference addressed to “Additional General Manager / QC / Boiler shops, New Quality Building, Bharat Heavy Electricals Limited, Tiruchirapalli-620014” on or before **Wednesday, the 29<sup>th</sup> of December 2010 at 14.00 Hours.**

Part A – Technical Bid will be opened on **Wednesday the 29<sup>th</sup> of December 2010 at 14.30 hours** at Conference Hall of New Quality Building, BHEL Tiruchirapalli-14 in the presence of Inspection Agencies / Authorised Representatives who have Quoted. Only the Technical bid meeting all the requirements shall be considered Technically Suitable. The Price Bid will be opened and Reverse action will be conducted only to those who are technically suitable after scrutiny by BHEL on a suitable date with due intimation.

BHEL reserves the right to reject any offer without assigning any reason and also enter into contract with more than one Inspection Agency by sharing each work centre depending upon the quantum of work.

Thanking you,

Yours faithfully,  
**For Bharat Heavy Electricals Limited**



Additional General Manager  
Quality Control / Boiler Shops



## **Bharat Heavy Electricals Limited**

**High Pressure Boiler Plant  
Quality Control Department  
Tiruchirapalli 620 014, India**

Phone : 0431-2575187  
Fax : 91-(0431)-2520730  
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**AN ISO 9001 COMPANY**

Enquiry No.: BHE:QC:SHOP:OS:209  
Date: 08.12.2010

**ENQUIRY FOR OUTSOURCING OF SHOP QUALITY CONTROL BACK-END  
ACTIVITIES BY PHYSICAL SUPERVISORY SUPPORT**

**TENDER SUBMISSION LAST DATE:**

***29.12.2010 (WEDNESDAY) AT 14.00 HOURS***

**TENDER OPENING DATE:**

***29.12.2010 (WEDNESDAY) AT 14.30 HOURS***

**ADDRESS FOR COMMUNICATION:**

**AGM / QC / Boiler Shops  
New Quality Building  
Bharat Heavy Electricals Limited  
Tiruchirapalli – 620 014  
Tamilnadu**

**CONTACT PHONE NUMBER: 0431 – 2575187 & 2575290**

**e-Mail ADDRESS: [mvselvan@bheltry.co.in](mailto:mvselvan@bheltry.co.in)**

**ENQUIRY REF. NO. BHE:QC:SHOP:OS:209**

**Date: 08.12.2010**

**1.0 GENERAL:**

- 1.1 BHEL units are ISO 9000 accredited companies and our system and procedures comply with ISO requirements. Hence the Inspection Agency shall preferably be an ISO accredited company or be familiar with ISO standards and make sure that they fulfill all their obligations towards meeting the ISO requirements.
- 1.2 The Inspection Agency should have a minimum of 5 years experience in Industrial Inspection related activities in Fabrication of Boiler components or Boiler construction site.
- 1.3 The Inspectors deployed by the Inspection Agency shall have minimum Diploma in Mechanical Engineering as qualification with a minimum of one year experience in Inspection related activities in a Fabrication Industry. They shall be conversant with the use of measuring Instruments and possess working knowledge on computers.
- 1.4 The Inspectors deployed by the Inspection Agency shall ensure that calibrated instruments & gauges are being used which will be provided at each Bay by BHEL shop.
- 1.5 All the Inspectors to be posted will have to undergo an extensive Training programme being arranged by us on the products to be inspected and use of SAP systems relevant to the identified work by BHEL, followed by written test / Viva-voce / Practical test and only those deemed qualified through this Training programme shall be engaged for this work.
- 1.6 The inspectors posted for Inspection shall be available in the neatly dressed in the Inspection Agency's Uniform (for easy identification in Shops) and with safety shoes, all to be furnished by the Inspection Agency.
- 1.7 The Inspectors posted by the Inspection agency have to work for a minimum of 8 Hours in 2 shift on rotation basis ie., 1) 8.00 AM – 4.30 PM and 2) 4.30 PM – 1.00 AM shifts. As and when required they may be required to work beyond normal working hours without any extra compensation and no increase in Rate for contract will be entertained on this account.
- 1.8 Vehicle for the movement from residence to work place and back to residence for the Inspectors posted has to be arranged by the respective Inspection agency to perform Inspection services at BHEL shops.
- 1.9 The Inspection Agency shall have adequate experienced Inspection personnel to maintain the required strength of Inspectors by suitable immediate substitute for the Inspectors who resign / on long leave and the Inspection agency has to take all

necessary steps to ensure the Inspection services without any obstruction or interruptions.

- 1.10 It is estimated that approximately a minimum of 80 Inspectors (ie., 40 Inspectors for work centre no:1, 24 Inspectors for work centre no:2, 16 Inspectors for work centre no: 3&4 will be required to work in the 4 major work centres located within BHEL Trichy complex for the Inspection activities to be positioned catering to the various types of products and taking into account the Working in minimum 2 shifts per day. When the planned Tonnage is increased, the Inspection Agency shall deploy additional man-power proportionate to the increased tonnage / work load.

## **2.0 SCOPE OF WORK:**

- 2.1 The location of work centre is within the campus of BHEL, Trichy. There are 4 Major work centres situated in different location within BHEL, Trichy complex where different types of Boiler components and Valves are being manufactured.
- 2.2 The approximate planned tonnage for one year is as stated below:
- i) 60,000 Metric Tons of Boiler components in 1<sup>st</sup> work centre.
  - ii) 58,000 Metric Tons of Boiler components in 2<sup>nd</sup> work centre.  
(The weight of one single Boiler component manufactured in Work centres 1&2 generally varies from less than 1 Metric Ton to maximum of 7 Metric Tons) &
  - iii) Rs.710 crore Values of Valve Components (Total number of Valves will be approximately 95,000 nos.) in both 3<sup>rd</sup> and 4<sup>th</sup> work centres put together.
- 2.3 The typical Shop Quality Control back-end activities as given in ANNEXURE-II are common to all the 4 major work centres.
- 2.4 The unit of measurement for the Quantum of work done is in Metric Tons against each finished products for the products manufactured in Work centres 1&2 and Value of each finished Valve is in Rupees for the valves manufactured in work centres 3&4.
- 2.5 BHEL reserves the right to enter into contract with more than one Inspection Agency by sharing the work centre depending upon the capability of mobilizing manpower by the Inspection agency and total quantum of work load.

## **3.0 CONTRACT PERIOD:**

- 3.1 The period of contract will be for one year from the date of execution of Inspection contract.
- 3.2 The contract can be extended for further period based on mutual agreement between BHEL and inspection agency.

#### **4.0 PROCEDURE FOR SHOP QC BACK-END ACTIVITIES:**

- 4.1 The Inspectors posted for Inspection have to carry out all shop QC back-end activities under close supervision of BHEL QC personnel. Engineering drawings which are available in the work centre provides intricate details of the products and inspection requirements, Quality Work Instructions (QWI) like Quality Control Procedures (QCP), Standard Quality Plans (SQP), Standard Inspection Procedures (SIP), Contract Quality Plan (CQP) as applicable for each product are available in Soft form in the PC's which will be provided by BHEL at the respective Work centers or Bays. Most of the products require various stage inspections including verifying documents, raw material inspection, fit up, FOT (First Off Trial), welding, NDE, machining, dimensional checking, Post weld Heat treatment, Hydro testing, Painting and verification of various process parameters at each and every stages of Inspection which have to be ensured and documented to obtain final Inspection clearance from customers and statutory authorities.
- 4.2 The Inspectors posted by the Inspection agency are expected to maintain punctuality to attend the shop QC activities and they have to attend the calls immediately at the time of shop call intimation.
- 4.3 In emergencies / exceptional cases, Inspectors posted by the Inspection agency have to provide the services at short notice, in extended working hours, Sundays, Holidays and in odd hours to the requirement of BHEL without any extra payment.
- 4.4 The Inspectors posted by the Inspection agency are expected to execute and provide quality services in a professional manner.
- 4.5 The components, which are inspected and cleared by the Inspectors posted by Inspection Agency, may be subjected to re-inspection by BHEL Quality Control personnel or Customer Inspector. Wherever any extra expenditure incurred either by BHEL or by its customers, either during fabrication or erection at site, towards rectification of defects in the components cleared by your inspectors and if the cause of this rectification is due to faulty inspection clearance, the rework and inspection charges incurred will be recovered from your bills and decision of BHEL Quality will be final in this regard.
- 4.6 The components inspected and cleared by statutory authority shall be cleared for dispatch by raising Usage Decision (UD) and generate Inspection reports (IR) in SAP system. The Inspector shall ensure that IBR stamping is done on components before dispatch, as required.
- 4.7 Workload fluctuation is cyclic from month to month depending upon the availability of raw materials and related documents. It is therefore requested that this cyclic nature of work load should be kept in mind while organizing the shop QC activities.

- 4.8 The performance of inspectors will be monitored continuously by BHEL Quality Control and the performance rating will be communicated to Head of Inspection Agency separately. In case of unsatisfactory performance, you are expected to take appropriate time bound corrective actions to improve the quality of service and feed- back shall be given to BHEL on the corrective actions taken.

**5.0 INVOICE AND PAYMENT:**

- 5.1 The Inspection Agency shall submit the detailed work completion report every month based on UD generated in SAP system to respective work centre QC Section In-charge for verification of item wise Quantity and weight.
- 5.2 Your invoices together with the work completion Report shall be submitted once in a month for the period from 25<sup>th</sup> to 24<sup>th</sup> of every month and your payment shall be made as per BHEL rules.
- 5.3 The Invoices shall be submitted to BHEL within 15 days but not exceeding one month from the last date of inspection of the item of every month to avoid missing of invoices and making payment in time.

**6.0 PERSONNEL WELFARE:**

- 6.1 All Labour regulation laws like Provident Fund, ESI etc., applicable to you either existing or enacted in future shall be strictly complied by you.
- 6.2 Safety, Provident fund, ESI, Insurance and all statutory requirements and BHEL safety rules and regulations are to be taken care of by you. BHEL is not responsible for any injury or damage that is caused to your staff during the course of inspection or otherwise.
- 6.3 Separate PF code and ESI code are to be obtained and a copy of the same are to be furnished along with the offer.

**7.0 INCOME TAX:**

- 7.1 Income tax, as applicable, will be deducted at source at the rate applicable in accordance with statutory guidelines. PAN Number to be furnished along with the offer.

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**TYPICAL SHOP QC BACK-END ACTIVITIES**

- Collection and verification of attestation cards against allocated materials.
- Preparation of History cards and ensuring completion of all activities as per checklist.
- Recording the QC inspection data in the history cards.
- Generating NDT calls in SAP.
- Collection and compilation of NDT Reports.
- Preparation and compilation of heat treatment movement sheets.
- Preparation of heat treatment extract for NTPC clearance and distribution to respective bays.
- Assisting QC personnel by making available of all relevant QWI, Drawings, measuring instruments / testing equipments at the time of QC Inspection.
- Generating Inspection calls for Customer Inspection as per CQPs.
- Consolidation of Customer / Statutory Authority Inspection clearance reports.
- Ensuring completion of Inspection and verification of Inspection and testing records as per SQP/CQPs.
- Ensuring completion of surface preparation before NDE and final painting.
- Handing over of IBR documents to document section.
- Assisting QC personnel for keying in data for statistical / root cause analysis.
- Assisting QC personnel during inspection by physical supervisory support.
- Preserving calibration / FOT records & maintaining AMC records for testing equipments.
- Up-keeping the spectro machines with proper charging of batteries and routine calibration as per testing instructions.
- Other shop QC back-end activities if any in line with QWI, CQPs, drawings and customer / statutory body requirements.

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**TECHNICAL BID CRITERIA**

Enquiry No.: BHE:QC:SHOP:OS:209

Date: 08.12.2010

<b>S. N</b>	<b>TECHNICAL BID CRITERIA</b>
1	Quotation to be submitted in Two Parts in separate sealed covers. Part A – Technical Bid and Part B – Price Bid.
2	An Earnest Money Deposit (EMD) amount of Rs.2,00,000/- (Rupees Two lakhs only) to be sent along with your Technical Bid offer.
3	ONLY SINGLE RATE for each category of work is valid uniformly for the entire contract period. No escalation of rate is admissible during the contract period. The rate quoted should be exclusive of service tax.
4	The Inspection Agency should have a minimum of 5 years experience in Industries in Inspection related activities in Fabrication of Boiler components or Boiler construction site.
5	The Inspectors deployed by the Inspection Agency shall have minimum Diploma in Mechanical Engineering as qualification with a minimum of one year experience in Inspection related activities in a Fabrication Industry. They shall be conversant with the use of measuring Instruments and possess working knowledge on computers.
6	The Inspectors to be posted will have to undergo an extensive Training program being arranged by us on the products to be inspected and use of SAP systems relevant to the identified work by BHEL, followed by written test / Viva-voce/ Practical test and only those deemed qualified through this Training program shall be engaged for this work.
7	The inspectors posted for Inspection shall be available in the neatly dressed in the Inspection Agency's Uniform (for easy identification in Shops) and with safety shoes, all to be furnished by the Inspection Agency.
8	The Inspectors posted by the Inspection agency have to work for a minimum of 8 Hours in 2 shift on rotation basis ie., 1) 8.00 AM – 4.30 PM and 2) 4.30 PM – 1.00 AM shifts. As and when required they may be required to work beyond normal working hours without any extra compensation and no increase in Rate for contract will be entertained on this account.
9	Specified number of Inspectors have to be posted in each work centre on permanent basis for entire contract period to meet the inspection requirement of BHEL. When the planned Tonnage is increased, the Inspection Agency shall provide adequate increase in man-power proportionate to the increased tonnage / work load.
10	BHEL reserves the right to enter into contract with more than one Inspection Agency by sharing the work centre depending upon the capability of mobilizing manpower by the Inspection agency and total quantum of work load
11	In emergencies / exceptional cases, Inspectors posted by the Inspection agency have to provide the services at short notice, in extended working hours, Sundays, Holidays and in odd hours to the requirement of BHEL without any extra payment.

12	The period of contract will be one year from the date of execution of Inspection contract. The contract can be extended for further period based on mutual agreement between BHEL and inspection agency.
13	Safety, Provident fund, ESI, Insurance and all statutory requirements and BHEL safety rules and regulations are to be taken care by you. BHEL is not responsible for any injury or damage that is caused to your staff during the course of inspection or otherwise
14	Payment for the accepted Invoices towards Inspection services will be paid within 45 days from the date of submission of the relevant accepted invoices.
15	The Inspection Agency shall have adequate experienced Inspection personnel to maintain the required strength of Inspectors by suitable immediate substitute for the Inspectors who resign / on long leave and the Inspection agency has to take all necessary steps to ensure the Inspection services without any obstruction or interruptions.
16	The Inspection Agency shall submit the Technical Bid with document evidence of 1)Organisation Chart and details of technical persons with qualification and experience on roll, 2)Previous experience in Industrial Inspection related activities in Fabrication of Boiler components or Boiler construction site, 3) Copies of PAN card, Service Tax, Provident Fund and ESI Registration certificate, 4)Technical Bid Criteria as given in ANNEXURE-III duly signed by authorized signatory and 5) Annual Turnover, Audited Profit and Loss account & Balance Sheet for the last 3 years.
17	No other pre conditions along with this offer will be entertained by BHEL.

All the above Technical Bid Criteria are acceptable.

**Signature with Seal of  
Authorized signatory**

Enquiry No.: BHE:QC:SHOP:OS:209  
Date: 08.12.2010

## PART – B: PRICE BID

S.N	Activity / Description	Basis for Rate to be Quoted	Quoted Rate
1	Physical supervisory support for Boiler Shop Quality Control backend activities in work centre 1&2	Rate in Rupees PER METRIC TON of finished goods	
2	Physical supervisory support for Valves Shop Quality Control backend activities in work centre 3&4	Rate in Percentage of Value of finished goods	

The Quoted rates are exclusive of service taxes and duties. For Service Tax, Service Tax Registration Number is required.

**Signature with Seal of  
Authorized signatory**

- **Note:** The above details shall be submitted in Letter Head by Quoting the Rate