Pre-Qualification Criteria		
Sl. No.	DESCRIPTION	Bidder reply.
1	Bidder shall be a manufacturer of Welding Consumables / an authorized dealer of Welding Consumables. If the offer is quoted by agent, letter of authorization and agreement duly signed by the manufacturer is required to consider the offer.	
2	Quoted Welding Consumables brand name shall be provided.	
3	Quoted Welding Consumables catalogue shall be provided.	
4	Mill (Manufacturing Plant)address.	
5	Shall confirm to Technical Annexure -1 .	
6	Test certificates shall contain all the relevant results as per Technical Annexure -1.	
7	Bidder shall have successfully supplied EM12K SAW consumables as per ASME Sec. IIC to any govt. Organizations/ PSUs/ Public ltd./ Company/Reputed Industries. Purchase orders copies to be submitted along with offer to consider the offer. Note: Successfully supplied means – supplied and accepted	

Sign and Seal of authorized person

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Technical Annexure2

1. SCOPE

Low Alloy Steel Bare Solid Wire diameter 4.0 mm for Submerged Arc Welding that conforms to ASME, SEC II.C, SFA- 5.17 Class EM-12K.

2. GENERAL

The wire shall comply with the requirements called for in the Latest Edition and addenda (applicable on the date of issue of purchase order) of ASME Sec II.C, SFA- 5.17,EM12K. All tests, acceptance criteria etc. referred in this document shall be in accordance with this. Additional requirements specified in this document are also to be complied.

3. CHEMICAL COMPOSITION - As per ASME Sec II.C, SFA- 5.17, EM12K.

4. SIZE

The Wire shall be supplied in Diameter 4.0 mm as specified in the Purchase Order. The tolerance on diameter shall be as per ASME Sec IIC SFA- 5.02.Net weight of each coil shall be 25 kg.

5. FORM

The Wire shall be appropriately layer wound in coils with hardboard liner support of dimensions and weight as given below.

a) Inner Diameter of Liner : 305 + 10/-0 mm

b) Width of Coil (maximum) : 100.00 mm

c) Net Weight of Coil : 25 Kg.

The wire in coil form along with liner shall be so designed & constructed to prevent distortion of the wire coil / unwinding of the wire/ contamination of the wire during transportation, storage and use under normal conditions.

6. FINISH AND UNIFORMITY:

The wire shall be copper coated by an appropriate process that results in uniform coating thickness without any flaking providing a bright and glossy finish that ensures prevention from rusting in long duration storage.

The Wire surface shall be entirely free from slivers, depressions, scratches, scales, seams, laps, drawing compounds or any other foreign matter that would adversely affect the welding characteristics or properties of Weld metal.

The wire shall be of a single continuous length made from a single heat/melt without any splices.

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7. WINDING, TEMPER, CAST, & HELIX:

The Wire shall be layer wound in coils so that kinks, waves, sharp bends, overlapping or wedging are not encountered leaving it free to unwind without any restriction. The outside end of the wire (The end with which welding is to begin) shall be identified and securely fixed so that it can be readily located and admitted into the wire feed system. This end shall be fastened to avoid unwinding. The inner end of the wire shall be fixed to the hardboard liner so as to ensure unrestricted layer by layer unwinding of the wire in the wire feed sprocket.

The temper, cast and helix of wire on coils shall ensure unrestricted layer by layer unwinding and easy straightening in the wire feed system and shall render itself to accurate tracking to the Weld groove as it issues out of the current contact tube.

8. IDENTIFICATION:

Adhesive labels containing following product information shall be securely affixed in a prominent location on the hardboard liner of the coil. The Label shall be so affixed that it stays in place during usage of the coil under normal conditions.

a) Specification & Classification Designation.
b) Brand Name.
c) Batch/Lot Number.
d) Size & Net Weight

9. PACKAGING:

The Wire Coils completely devoid of moisture or any other foreign material st adequately sealed in suitable cartons to ensure against any deterioration in 'Wire quality during transportation by sea or long duration storage

10. TESTING AND CERTIFICATION

a) The testing authority shall certify that supplies made against the batch conforms to the requirements of the latest Edition and addenda (Applicable on the date of issue of Purchase order) of ASME Sec.II.C, SFA-5.17, EM-12K.

b) Batch/Lot classification shall be Class S1 as per section 5.2.1 of SFA 5.01 filler Metal Procurement Guidelines of ASME Sec.II.C.

c)The level of testing shall be Schedule "J" of Section 6.6 of SFA 5.01 Filter Metal Procurement Guidelines of ASME Sec II.C.

d)Three copies of Original Test certificates in English giving details of tests done for compliance to this Purchase Instruction and ASME Sec.II.C, SFA-5.17, EM-12K shall be sent.

02-11-2021
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