

Indent No.:

Item: ALLOY STEEL CASTINGS

Pre-Qualification requirements for rate contract of castings, Grade G17CrMoV510/G20Mo5, BHEL specification HY19573/HY19571.

SI No	BHEL Terms	Vendors acceptance
1	Only Manufacturer's having past experience of supplying steel castings of Steam turbines to turbine OEMs will be considered for this Tender Enquiry.	
2	<p>Vendor must have experience of manufacturing and supplying Castings of material grade G17CrMoV510/G20Mo5 and must have successfully supplied at least two of castings of similar complexity and criticality within 10% weight range of castings required as per this enquiry.</p> <p>Vendor to submit documentary evidences in support of their past experience such as:</p> <ul style="list-style-type: none">a. Unpriced purchase order copies that indicates name of Customer, quantity of order, etc.b. The test certificates of the castings supplied that include the results/reports of all tests like Chemical, Mechanical & NDT etc. duly accepted by the customerc. Vendor shall also submit the detailed NDT scan plan followed for the steel castings which is submitted as their past experience for this tender enquiry.d. Copy of internal quality systems and checks followed during the various manufacturing stages like pattern making, moulding, steel melting and pouring, fettling, heat treatment, dimensional checking, internal NDT, repair welding, final NDT, destructive testing etc., followed for the manufacture of steel castings for steam turbine applications	
3	Vendor shall inform details of in-house manufacturing facilities as indicated below along with their capabilities for	
	manufacturing castings.	
	a) Steel melting facilities:	
	b) Heat treatment facilities:	
	c) Welding facilities:	
	d) Pattern making facilities:	
	e) Moulding & Casting facilities:	
	f) Machining facilities:	

	Note: In case of outsourcing of any of the above activities, vendor shall inform their sources with details of their sub supplier facilities along with their tie up letter.	
5	Vendor to furnish Weld repair procedure for approval from BHEL. Also after placement of Purchase order from BHEL, before any weld repair, based on internal NDT, defectogram report shall be submitted as prior approval.	
6	Vendor to submit “Short Term Creep Rupture Test” reports for clearance before dispatch of material to BHEL and the creep test shall be performed as per BHEL specification HY0850399. If any previous creep test been performed in line with the required specification, those test report shall be submitted (not older than 5 years) .	
7	Prior to dispatch of the material, Test Certificates (English language only) shall be sent to BHEL for review and dispatch clearance by BHEL. The photographs of the material with their traceability/ marking and condition of the material before dispatch may be provided for dispatch clearance.	
8	Vendor to confirm that they will manufacture and supply enquiry item as per BHEL enquiry specification HY19573 / HY19571.	
9	As the P.O shall be placed for firm customer orders with tight delivery schedules and associated LD penalties on BHEL, the order will be placed on vendors who are technically qualified in all aspects mentioned above in this PQC will be considered for the supplies. Accordingly, the vendors who are in receipt of the trial/ development/ first order for steam turbine components and are yet to supply the material successfully will not be eligible to participate in this tender. However, BHEL may review and take suitable decision on case to case basis in the interest of BHEL customer project delivery schedules.	
Note: Point no.6 is not applicable to BHEL PMD Vendors who have already submitted the creep reports.		