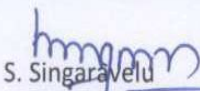
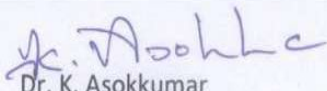

	BHARATH HEAVY ELECTRICALS LIMITED TIRUCHIRAPALLI-620 014 WELDING TECHNOLOGY CENTRE	Doc. Number: WCPI – 107
		Revision No.: 09
		Date: 06/07/2013
<u>WELDING CONSUMABLE PURCHASE INSTRUCTION FOR</u> <u>STAINLESS STEEL BARE SOLID FILLER ROD ER347</u>		
1.0 GENERAL:		
1.1 The Rod shall comply with requirements specified in the Latest Edition and Addenda (applicable on the date of Issue of Purchase Order) of ASME Sec.II.C.SFA-5.9, ER347. All tests, acceptance criteria shall be in accordance with this. Additional requirements specified in this document shall also be complied.		
1.2 The Rods shall be supplied in sizes and quantities as specified in the Purchase Order.		
1.3 The rods are intended for use as filler for radiographic quality butt welded joints in high pressure/super critical boiler tubes and pipes.		
1.4 Every batch of rods shall be inspected & test certificates countersigned by Inspecting Authority approved by IBR for country of origin (Latest).		
2.0 Chemical Composition:		
2.1 The chemical composition of the Rods shall conform to ASME SECII.C SFA5.9-ER347.		
3.0 USABILITY AND RADIOGRAPHIC SOUNDNESS:		
3.1 The rod when used as filler in GTAW with 100 % Argon shielding shall deposit weld metal that flows freely, uniformly without sputtering or other defects and shall exhibit excellent wetting characteristics. The resultant weld metal shall be smooth and uniform with no visible evidence of cracks/porosity/other defects and shall meet radiographic soundness requirements.		
4.0 FORM & SIZE:		
4.1 The Rods shall be supplied in straight lengths of 1000 mm + 15,-0 mm and as specified in the Purchase Order. The tolerance on diameter shall be as per SFA-5.02.		
5.0 FINISH & UNIFORMITY:		
5.0 The rods shall have a smooth and glossy finish that is free from slivers, depressions, scratches, scales, seams, laps and foreign matter that would adversely affect the welding characteristics or properties of weld metal.		
6.0 IDENTIFICATION:		
6.1 Each Rod shall have the Classification designation "ER347", "347", brand/trade designation marked or embossed at both the ends for positive identification.		
PREPARED:  S. Singaravelu DGM / WTC	REVIEWED & APPROVED:  Dr. K. Asokkumar AGM/WTC	

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7.0 PACKAGING:

7.1 Rods of the same size and batch/lot shall be packed in water resistant plastic tube shaped cartons. Each tube carton shall weigh not more than 10 Kg. The cartons shall be provided with watertight lid to ensure waterproof during transit & storage. Tube Cartons shall be packed in waterproof boxes with crates so as to ensure no damage during shipment and normal storage conditions. Weight of each crate shall not exceed 1000kg. The cartons shall have product information as given below legibly marked so that it is visible outside the package.

- ASME Specification & Classification Designation
- Brand Name
- Size
- Batch/Lot No.
- Net Weight

7.2 Appropriate precautionary information given in ANSI Z49.1 latest edition (as a minimum) or its equivalent shall be displayed in legible print on all packages.

8.0 TESTING & CERTIFICATION:

8.1 Each consignment of rods supplied shall be from one batch only.

8.2 Batch /Lot classification shall be Class S1 as per SFA-5.01 Filler metal procurement guidelines of ASME Sec.II.C. (Latest Edition and Addenda)

8.3 The Level of Testing shall be Schedule J as per SFA-5.01 Filler metal procurement guidelines of ASME Sec.II.C. (Latest Edition and Addenda)

8.4 Three copies of Original Test certificates in English countersigned by Inspecting Authority (Latest) approved by IBR for country of origin giving details about tests done as per above point 2.1 in compliance with this Purchase Instruction and ASME Sec.II.C, SFA-5.9, ER347 shall be sent.

8.5 The Testing Authority shall certify that supplies made against the batch conform to the requirements of the Latest Edition & Addenda (Applicable on the date of issue of Purchase Order) of ASME Sec.II.C.SFA-5.9, ER347.

Sl. No.	Pre-Qualification Criteria - ER347 STAINLESS STEEL BARE SOLID FILLER ROD	Bidder remark
1	Bidder shall be a manufacturer of the Quoted Rod/ an authorized dealer of the same. If the offer is quoted by agent, letter of authorization and agreement duly signed by the manufacturer is required to consider the offer.	
2	Bidder (Principle Supplier) shall have successful experience for supplying of ER347 ROD or GTAW Rod to any govt. Organizations/ PSUs/ Public Ltd./ Company/Reputed Industries etc. Purchase orders copies or related documents to be submitted along with offer to consider the offer.	
3	Quoted Welding Consumables brand name shall be provided along with offer.	
4	Product Catalogue shall be provided along with offer.	
5	Mill address (manufacturing address) shall be provided along with offer.	
6	Mill capacity for TIG Rod or Quoted item or GTAW Rod shall be provided along with offer.	
7	Manufacturer shall submit manufacturing process flow chart (Raw material to finished product) along with offer for Quoted Item.	
8	Manufacturer (Principle Supplier) shall submit a valid ISO 9001 certificate or Quality management system certificate or Written down procedure for Inspection or Written down procedure for Quality or ISO 140001 Certificate or ISO 45001 Certificate.	

Seal and sign of Authorized person

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Sl. No.	Pre-Qualification Criteria - ER347 STAINLESS STEEL BARE SOLID FILLER ROD	Bidder Remark.
9	Shall confirm to Technical Specifications as per as per WCPI - 107/09.	
10	Vendor should give confirmation to BHEL's Technical Specification. Any deviation from the Specification are to be mentioned in the "Bidder remark Space". If There is no deviation vendor should indicate "No Deviation".	
11	Original Test certificates in English countersigned by Inspecting Authority (Latest) approved by IBR for country of origin giving details about tests done as per point 2.1 in compliance with this Purchase Instruction and ASME Section II C, SFA-5.9, ER347 shall be sent. (OR) "A copy of valid IBR Approval Certificate for the brand being supplied to be submitted along with supply. It is mandatory that, Manufacturer should possess a valid IBR certificate (for the brand being supplied) during the manufacturing period.	
12	offered ER347 Diameter and Length	
13	Original Certified material test report in English signed by the manufacturer giving details of tests done in compliance with this WCPI - 107/09 and ASME Section II C, SFA-5.9, ER347 be sent along with supply.	

Seal and sign of Authorized person

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