

Pre-Qualification Requirements for Diffuser

Clause 1-4 are mandatory requirements. Offer of vendors not meeting these requirements will not be considered.

1. Experience Requirement:

- 1.1. The Vendor must have experience of hard facing of Inconel 625 or Stellite 21/ Stellite 6 using arc welding (SMAW/GMAW/SAW/GTAW/PTAW) on any one of the following base material:
GX10CrMoVNB9-1, GX12CrMoWVNB10-1-1, X22CrMoV12-1, X10CrMoVNB9-1,
X12CrMoWVNB10-1-1, X19CrMoVNB11-1, X13CrMoCoVNB9-2-1,
- 1.2. In support of this, vendor to furnish following experience details. The vendor to submit at least 3 purchase order executed in the last 7 years as on enquiry issue date. Vendor to submit experience details preferably in format given below:

| Sl. No. | Material Grade | Qty. | PO No. | Name & Address of customer | Date of supply | Customer Phone No & Email |
|---------|----------------|------|--------|----------------------------|----------------|---------------------------|
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Vendor to furnish Following documents for any one of the PO from above experience list:

- 1.2.1. Unpriced PO, Test certificates, dispatch note/ Invoice etc.
- 1.2.2. The test certificates (TC's) shall be certified by customer / third party Inspection Agency and must contain following details:
- Base material complete test certificates as per casting specification
 - filler material and welding process
 - Hardness after hard facing.
 - Hard facing DP test result.
 - Dimensions Report.
 - Thickness of hard facing
 - Copy of WPS/PQR/WPQ for above experience

2. Technical Requirement:

- i) Vendor to submit all the relevant WPS, PQR & WPQ for hardfacing as per drawing (For BHEL enquiry item), duly approved by third party for BHEL review in case of PO placement before start of work. Vendor to confirm.
- ii) Vendor to confirm that they will manufacture and supply enquiry items as per enquiry specification and drawing with all cross referred standards therein.

3. Manufacturing Facilities:

- i) Following in-house manufacturing facility availability is mandatory for consideration for this enquiry:
- Hard Facing (Arc welding: SMAW/GMAW/SAW/GTAW/PTAW)
 - Heat Treatment
 - Handling Facility

Details of above in-house facility to be submitted.

- ii) Vendor to provide list of in house machines (with brief specification, achievable accuracies and surface finish) that will be used for machining the component. In case, vendor is offloading any machining operation then vendor to provide machining operation details and required machining facility details in the sub vendor works.

4. Testing Facilities:

Vendor to submit details of in house available testing facility as per the requirement of enquiry drawing and specification. In case of outsourcing of any test, vendor to agree to carry out testing at NABL / Government accredited labs only.

Note: Against vendor's replies, BHEL reserves the right to ask for more information/documents/clarifications. Vendor's offer shall not be considered if vendor fails to furnish the document/information/clarifications as mentioned above or vendor doesn't meet the above acceptance criteria.

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1.2.2, 3(i)
(For point 1.2, 1.3.2, 3 & 4)