VOLUME – IA
PART I & II

TECHNICAL CONDITIONS OF CONTRACT (TCC)

BHARAT HEAVY ELECTRICALS LIMITED

CONTENTS

SL NO	DESCRIPTION	CHAPTER	NO. OF PAGES
VOL I A	**PART-I: CONTRACT SPECIFIC DETAILS**		
1	Project Information	Chapter-I	2
2	Scope of works	Chapter-II	4
3	Facilities in Scope of Contractor / BHEL (Scope Matrix)	Chapter-III	10
4	T&Ps and MMEs to be deployed by Contractor	Chapter-IV	7
5	T&Ps and MMEs to be deployed by BHEL on sharing basis	Chapter-V	2
6	Time Schedule	Chapter-VI	5
7	Terms of Payment	Chapter-VII	3
8	Taxes and Duties & BOCW	Chapter-VIII	5
9	Bill of Quantity	Chapter-IX	1
10	General	Chapter-X	7
11	Progress of work	Chapter-XI	2
12	Material Handling	Chapter-XII	2
13	Accounting of Materials	Chapter-XIII	1
14	Entry of contractor's personnel and vehicles	Chapter-XIV	3
15	Housekeeping	Chapter-XV	4
16	Safety	Chapter-XVI	6
17	Quality Assurance	Chapter-XVII	4
VOL IA	**PART-II: TECHNICAL SPECIFICATIONS**		
1	Corrections / Revisions in General Conditions of Contract and Forms & Procedures	Chapter-I	11
2	"HSE Plan for Site Operations by Subcontractor" (Document No. HSEP: 14 Rev02)	Chapter-II	131
3	Hire Charges	Chapter-III	13
4	TB GA Drawings	Chapter-IV	14
5	Technical Specifications Section - C	Chapter-V	430
6	Technical Specifications Section - D	Chapter-VI	380
7	AERB Safety guideline	Chapter - VII	132

VOLUME – IA - TECHNICAL CONDITIONS OF CONTRACT

PART I - CONTRACT SPECIFIC DETAILS

VOLUME-IA PART – I CHAPTER – I

PROJECT INFORMATION

1.1.1 INTRODUCTION

2 x 700 MWe PHWR – Kaiga-5&6 Atomic Power Project is being set up by Nuclear Power Corporation of India Ltd. (NPCIL) at Kaiga Village, Karwar Taluka, Uttara Kannada District, Karnataka, India. Kaiga Site is at about 13 km upstream of Kadra Dam and associated hydro-electric power house on the left bank of Kali River on the banks of the Kadra reservoir. It is suggested that Bidder shall necessarily acquaint himself by a visit to the site and with the conditions prevailing at site before submission of the bid. The information given here in under is for general guidance and shall not be contractually binding on BHEL/Owner. All relevant site data /information as may be necessary shall have to be obtained /collected by the Bidder.

1.1.2 PROJECT INFORMATION

1	Name of the Project	2 X 700 MWe PHWR – Kaiga-5&6 Atomic Power Project
2	Station Capacity	2 X 700 MWe
3	Owner	Nuclear Power Corporation of India Ltd. (NPCIL)
4	Site Location	Kaiga, Uttara Kannada District, Karnataka. About 53 km from Karwar (Konkan Railway) Station and NH 10 passes through Karwar
5	Nearest Railway Station	Karwar (Konkan Railway)
6	Nearest Airport	Goa – 140 kms
7	Accessibility	Kaiga site is accessible from Karwar through State Highway 06 (SH-06) by taking 3 km diversion from SH06 at Hartuga. SH-06 is interconnected with SH 34 at Kadra and NH-66 at Karwar. Hence the nearby towns like Dharward, Hubballi, Belgaum, Goa etc. is connected. The nearest Broad gauge rail connectivity exists at Karwar on Konkan Railway and Londa on Belgaum-Goa broad gauge of South Western Railway Division. Air connectivity exists with Goa, Hubballi

<table>
<tr><td></td><td></td><td>and Belagavi at 140, 150 and 175 kilometre respectively from Kaiga Site</td></tr>
<tr><td>8</td><td>Ambient Air Temperature</td><td></td></tr>
<tr><td>A</td><td>Max. Dry Bulb Temperature</td><td>+ 41.6 Deg.C</td></tr>
<tr><td>B</td><td>Min. Dry Bulb Temperature</td><td>10.9 Deg.C</td></tr>
<tr><td>C</td><td>Design temperature for electrical equipment / devices</td><td>+ 50 Deg.C</td></tr>
<tr><td>9</td><td>Relative Humidity</td><td>i. Maximum during monsoon 99.9 %
ii. Minimum(design) 3%
iii. Performance 50 %</td></tr>
<tr><td>10</td><td>Air Quality</td><td>Clean and free from chemical pollutants.</td></tr>
<tr><td>11</td><td>Rainfall</td><td>a) Annual Average: 3649.31 mm
b) Highest annual rainfall: 4695.1 mm in 1988
c) Lowest annual rainfall: 2345.3 mm in 2016
d) Period: Year 1987-2017
Average rainfall of 3900 mm during the four months of monsoon (June to September)</td></tr>
<tr><td>13</td><td>Wind Pressures</td><td><table><tr><td>Height above mean ground level, m</td><td>Design Wind Speed m/sec</td></tr><tr><td>@ 10 M</td><td>5.0</td></tr><tr><td>@ 100 M</td><td>13.8</td></tr></table>The assessment of wind loads based on the above basic wind speed shall be done as specified in IS: 875.
Wind direction: Predominantly W, SW, NE & E with respect to true North</td></tr>
<tr><td>14</td><td>Seismology</td><td>Zone III as per IS1893-2002 part I</td></tr>
</table>

VOLUME-IA PART – I CHAPTER – II

SCOPE OF WORKS

1.2.1 The scope of works covers **Civil, Structural and Architectural Works of Turbine Island Package of 2 X 700 MWe PHWR Kaiga Atomic Power Project - Unit 5 & 6**, Uttara Kannada District, Karnataka including, supply of all materials (excluding the materials supplied by BHEL free of cost), labour, equipments, tools and plants etc. complete as per specification, drawing and as directed by engineer- in-charge.

1.2.2 **The list of buildings/ structures in the package is mentioned below. However, the scope of work is indicative only, but not limited to the given below,**

1. Turbine Building
2. Turbo Generator Foundations and deck slab
3. BFP and other Pumps foundations
4. Access bridge
5. Local control room
6. Annex building
7. Workshop
8. Misc. structural steel work of Electrical building
9. Chemical Lab
10. Condenser Cooling Water (CCW) pipe/conduit
11. Tunnel and Trenches
12. Transformer Yard including oil pit
13. Pipe and Cable Bridge and Pedestals
14. Foundation of all equipments
15. Turbine oil storage tank
16. Embedded parts/Penetrations
17. Condensate Storage Tank (CST) area
18. Steam generator blowdown (SGBD) area
19. Pipe encasing
20. Peripheral drain
21. Gas cylinder room
22. Platforms in reactor building

23. Pipe & Cable (PC) Bay
24. Miscellaneous platform etc.
25. ETP sump pits
26. Plinth protection
27. Paving and underground works
28. Sewage Network, Drains
29. Storm Water Drainage System, Culverts
30. Plumbing and Sanitary works
31. Miscellaneous foundations for equipment, pumps, skids
32. Portable sheds
33. Area grading and access roads etc.
34. Civil work of fire protection system
35. PCC backfilling works

NOTE: The above provided scope of work is indicative only for the bidder's guideline. **Any other building/ structure/ foundation not mentioned above, but required for completion of the work in total, deemed to have been included in the bidder scope under this contract.** Such work will be executed under this contract by bidder as per the direction of Engineer in charge. If any item of work not available in the rate schedule of this contract, the rate will be fixed in line with Clause no. 2.15.7 of GCC.

1.2.3 BHEL shall provide Cement, Reinforcement steel and Structural steel for civil and structural works only for incorporation in the permanent works as free supply. Embedment's /inserts required for the works in general shall be supplied by the bidder and payment shall be made as per corresponding item in BOQ. If BHEL provides Structural Steel for embedment's/inserts from scraps (if available), payment shall be made as per corresponding item in BOQ. If BHEL provides fabricated embedment's/ inserts as supplied by BHEL manufacturing units, payment for fixing of those shall be made as per corresponding item in BOQ.

1.2.4 The works to be performed under this contract consist of providing all labour, supervision, material, scaffolding, construction equipment's, tools and plants, temporary works, supplies including POL (petroleum, oil, lubricants, etc.), transportation and all incidental items not shown or specified but reasonably implied or necessary for the proper completion of work in all respects. The earthwork and all other allied works are included in the rates of items of work.

1.2.5 Testing of all materials, concrete, earthwork other allied works, preparation of bar bending schedules on the basis of construction drawings, preparation of fabrication drawings etc. are included on the rates of items of work. Works shall only be carried out with approved structural fabrication drawings.

1.2.6 The area of work shall be cleared of all vegetation, rubbish and other objectionable matter and materials removed shall be disposed of as directed by the Engineer-in-Charge. No separate payment for these operations shall be made. The cost of all these operations shall be deemed to have been included in the unit rates rendered for the different items under bill of quantities.

1.2.7 All the works areas shall be adequately flood lighted to the satisfaction of the Engineer-in-Charge when the work is in progress during the night shifts.

1.2.8 The unit rates shall include all material, equipment, fixtures, labour, tools & plant, temporary works and everything whether of permanent or temporary nature necessary for the completion of job in all respects.

1.2.9 All the BOQ Item rates shall be inclusive of customer's requirements for sampling and testing of construction material, preparation of construction methodology, working drawings and scheme, details of erection methods, safety manual, job hazard analysis and work procedure.

1.2.10 Contractor shall coordinate in preparation and submission of construction completion certificate & transfer docket containing necessary documents like test certificate, inspection reports etc. and obtaining approval from BHEL/NPCIL as per specification and as directed by engineer - in – charge.

1.2.11 It is the responsibility of the Contractor to coordinate in preparation, obtaining approval and ensure compliance with the quality assurance requirement of BHEL/NPCIL. For this purpose, Contractor shall have appropriate quality assurance organisation and have personnel with requisite qualification to carry out inspection /quality surveillance.

1.2.12 The unit rates for various items shall include all the stipulations mentioned in technical specifications for the particular BOQ item and nothing extra over BOQ rates shall be payable.

1.2.13 Drawings showing enough details for the construction as per the specification, shall be furnished by BHEL to the contractor in a phased manner.

1.2.14 Contractor shall note that BHEL is liable to its customer (NPCIL) for following all norms and guidelines regarding safety and housekeeping as specified in the tender or as provided by NPCIL during course of execution of contract. Inter-Alia, BHEL's contractor deployed at NPCIL site will also be regulated under the same norms/guidelines and has to provide all safety and housekeeping requirement as specified by customer (time-to-time). In case of contractor's failure to provide such materials/ services and consequently if any penalty/recovery is imposed by Customer (NPCIL), same will be recovered from the due payments (Bills) of the contractor.

1.2.15 The bidder should fully apprise himself of the prevailing conditions at the proposed site, climatic conditions including monsoon pattern, local conditions, soil strata and site specific parameters and shall include for all such conditions and contingent measures in the bid, including those which may have not been specifically brought out in the specifications.

1.2.16 For further detailed scope of work, refer relevant chapters in the technical specification.

VOLUME-IA PART – I CHAPTER – III

FACILITIES & CONSUMABLES IN THE SCOPE OF CONTRACTOR/ BHEL

SCOPE MATRIX

Sl.No	Description PART I	Scope to be taken care by		Remarks
		BHEL	Bidder	
1.3.1.1.0	**ESTABLISHMENT**			
1.3.1.1.1	FOR CONSTRUCTION PURPOSE:			
A	Open space for office	Yes		Free
B	Open space for storage/T&P	Yes		
C	Construction of bidder's office, canteen and storage building including supply of materials and other services		Yes	
D	Bidder's all office equipment's, office/ store/ canteen consumables		Yes	
E	Canteen facilities for the bidder's staff, supervisors and engineers etc.		Yes	
F	Firefighting equipment's like buckets, extinguishers etc.		Yes	
G	Fencing of storage area, office, canteen etc. of the bidder		Yes	
1.3.1.1.2	FOR LIVING PURPOSES OF THE SUCCESSFUL BIDDER'S PERSONNEL			
A	Open space for labour colony		Yes	
B	Living Accommodation		Yes	
1.3.1.2.0	**ELECTRICITY**			
1.3.1.2.1	Electricity for construction purposes			
1.3.1.2.1.1	Single point source (in general) For detail, refer clause no. 1.3.4	Yes		Chargeable See clause 1.3.4
1.3.1.2.1.2	Further distribution for the work to be done which include supply of materials and execution		Yes	
1.3.1.2.2	Electricity for the office, stores, canteen, labour colony, etc. of the bidder which include:		Yes	
1.3.1.2.2.1	Distribution from single point including supply of materials and service		Yes	

Sl.No	Description PART I	Scope to be taken care by		Remarks
		BHEL	Bidder	
1.3.1.2.2.2	Supply, installation and connection of material of energy meter including operation and maintenance		Yes	
1.3.1.2.2.3	Duties and deposits including statutory clearances for the above		Yes	
1.3.1.2.2.4	Demobilization of the facilities after completion of works		Yes	
1.3.1.2.3	Electricity for living accommodation of the bidder's staff, engineers, supervisors etc. on the above lines		Yes	
1.3.1.3.0	**WATER SUPPLY**			
1.3.1.3.1	For construction purposes:			
1.3.1.3.1.1	Making the water available at single point		Yes	Refer clause 1.3.5.
1.3.1.3.1.2	Further distribution as per the requirement of work including supply of materials and execution		Yes	
1.3.1.3.2	Water supply for bidder's office, stores, canteen, labour colony, etc.		Yes	
1.3.1.3.2.1	Making the water available at single point		Yes	
1.3.1.3.2.2	Further distribution as per the requirement of work including supply of materials and execution		Yes	
1.3.1.4.0	**LIGHTING**			
1.3.1.4.1	For construction work (supply of all the necessary materials) • At office storage area • At the construction site / area • At the labour hutment		Yes	
1.3.1.4.2	For construction work (Execution of the lighting work / arrangements) • At office storage area • At the construction site /area • At the labour hutment		Yes	
1.3.1.5.0	**COMMUNICATION FACILITIES for site operations of the bidder**			
1.3.1.5.1	Telephone, Fax, internet, intranet, email etc.		Yes	
1.3.1.6.0	**TRANSPORTATION**			
1.3.1.6.1	For site personnel of the bidder		Yes	

Sl.No	Description PART I	Scope to be taken care by		Remarks
		BHEL	Bidder	
1.3.1.6.2	For bidder's equipments and consumables (T&P, Consumables etc.)		Yes	
1.3.1.7.0	**DEMOBILIZATION OF ALL THE ABOVE FACILITIES**		Yes	
1.3.1.8.0	**Arranging of gate pass for workers from M/s NPCIL which requires Police verification certificate, Medical certificate and copy of Aadhaar card as per NPCIL procedure**		**YES**	

Sl.No	Description PART II	Scope to be taken care by		Remarks
		BHEL	Bidder	
	CONSTRUCTION FACILITIES			
1.3.2.1.0	**Engineering works for construction**			
1.3.2.1.1	Providing the construction drawings for all the equipment covered under this scope	Yes		
1.3.2.1.2	Drawings for construction methods		Yes	In consultation with BHEL
1.3.2.1.3	As-built drawings – wherever deviations observed and executed and also based on the decisions taken at site- example – routing of small bore pipes	Yes	Yes	"
1.3.2.1.4	Shipping lists etc for reference and planning the activities	Yes	Yes	"
1.3.2.1.5	Preparation of site construction schedules and other input requirements		Yes	In consultation with BHEL as per requirement of BHEL targets
1.3.2.1.6	Review of performance (Form-14) and revision of site construction schedules in order to achieve the end dates and other commitments			
1.3.2.1.7	Weekly construction schedules based on Sl No 1.3.2.1.5			
1.3.2.1.8	Daily construction / work plan based on Sl No 1.3.2.1.7			For daily monitoring meeting at site
1.3.2.1.9	Periodic visit of the senior official of the bidder to site to review the progress so that works are completed as per schedule. It is suggested this review by the senior official of the bidder should be done once in every two months.		Yes	

Sl.No	Description	Scope to be taken care by		Remarks
	PART II	BHEL	Bidder	
1.3.2.1.10	Preparation of Fabrication shop and preassembly bay as per NPCIL requirement		Yes	

1.3.3. OPEN SPACE

1.3.3.1. To establish a temporary site office and storage area at the job site, minimum open space will be provided as made available by customer.

1.3.3.2. Location and area requirement for office / storage sheds shall be discussed and mutually agreed to after award of work at site. Construction of necessary stores and storage of materials shall be in contractor's scope. Security of stores & work place shall be in Contractor's scope.

1.3.3.3. It is the responsibility of the contractor to construct fabrication shop for reinforcement and structural steel, Grit blasting and painting shops, provide all utilities and dismantle and clear the site after completion of work or as and when required, as a part of his scope of work.

1.3.3.4. Availability of land is very limited and the contractor has to plan and use the existing land considering the use of land by other contractors and the storage of plant machineries and materials. Land will be allocated with certain time frame and to the extent available/ considered necessary, and will be reviewed by BHEL depending upon the area availability. The contractor will be responsible for handing back all lands, as handed over to him by BHEL.

1.3.3.5. BHEL shall not provide to the contractor any residential accommodation to any of his staff and labourer and the contractor has to make his own arrangements at his cost.

1.3.3.6. Also, contractor shall establish workers canteen at site for the use of labourers engaged by him.

1.3.4. ELECTRICITY

1.3.4.1. In general, Construction power will be provided to the contractor at prevailing rates of NPCIL on chargeable basis at one single point by BHEL. The contractor has to provide necessary meter for measuring the power consumption. The contractor shall make his own arrangement for further distribution with necessary isolator/LCB etc. However, based on request of Contractor and requirement of project, BHEL Site in charge, at his discretion, may provide construction power at multiple point (as close to work area as possible), on chargeable basis, for smooth execution of the work at site. If, BHEL provides electricity at more than one point (as

close to work area as possible), it will be responsibility of the contractor to provide all the support necessary for enabling BHEL for extending such provision to contractor. The contractor has to provide necessary meter for measuring the power consumption. The contractor shall make his own arrangement for further distribution with necessary isolator/LCB etc.

Prevailing rate of NPCIL for Construction Power Supply is Rs. 5.00 per kWh.

1.3.4.2. Necessary "Capacitor Banks" to improve the Power factor to a minimum of 0.9 shall be provided by the contractor at his cost. On account of the contractor's failure in maintaining the power factor at 0.9, penalty if any, levied by customer will be recovered from contractor's bills. Currently, this penalty will be surcharge @ 1% of energy charges for every 0.01 fall in average power factor.

1.3.4.3. The contractors/ consumers shall install suitable power factor improving device and a trivectometer for calculation of Power Factor with Maximum Demand. In case contractor fails to provide trivectometer. NPCIL/BHEL will consider P.F. at their connection as 0.6.

1.3.4.4. The bidder irrespective of connected load must have following minimum Electrical protection for Over current, Earth fault and Short circuit on their panel. Bidders have to provide soft starters for motor loads 100 KW and above.

1.3.4.5. Provision of distribution of electrical power from the given points to the required places with proper distribution boards, approved cables and cable laying including supply of all materials like cables, switch boards, pipes etc., observing the safety rules laid down by electrical authority of the State/ BHEL / their customer with appropriate statutory requirements shall be the responsibility of the tenderer / contractor.

1.3.4.6. The bidders shall follow AERB safety guide /site procedures of NPCIL.

1.3.4.7. BHEL is not responsible for any loss or damage to the contractor's equipment as a result of variations in voltage / frequency or interruptions in power supply.

1.3.4.8. In case of non-availability of construction power, the contractor shall make their own arrangements for their construction power/electricity requirements to have uninterrupted work. Also, as there are bound to be interruptions in regular power supply, power cut/load shedding as in any construction sites, contractor should make his own arrangement for alternative source of power supply through deployment of adequate number of DG sets at their cost during the power breakdown /failure to get urgent and important work to go on without interruptions. No

separate payment shall be made for any contingency arrangement made by contractor, due to delay / failure in providing electricity.

1.3.4.9. It shall be the responsibility of the contractor to provide and maintain their complete electrical installation with due regard to safety requirements at site. All cabling and installations shall be subject to the approval of the Engineer/ Safety Engineer and shall comply in all respects to the appropriate statutory requirements.

For this purpose, the contractor shall provide full specifications of the equipment and the layout drawings. Approval of the Engineer does not absolve the contractor from complying with any or all other conditions laid down herein.

1.3.4.10. The power supply shall be subject to all such restrictions and regulations currently in existence and as may be enforced by the NPCIL/ Government/ State Electricity Board/ or by any other competent authority from time to time for which the contractor will not have any claim whatsoever.

1.3.4.11. Electricity for labour colony shall be arranged by the contractor at his cost.

1.3.5. WATER

1.3.5.1. Boreholes for drawal of water shall not be permitted in the plant area for KAIGA-5&6.

1.3.5.2. Water source for Construction Water (Raw Water) is available within 2Km from project site. Contractor shall make his own arrangement for drawing water from this source.

1.3.5.3. Water (Raw water) required for construction purposes will have to be drawn by the contractor and contractor has to make their own arrangement for further distribution by arranging required pipes, valves, pumps, etc. The Contractor shall make adequate arrangement for storage of sufficient quantity of water required for construction work.

1.3.5.4. No charges shall be levied by BHEL/NPCIL for the water drawn and consumed. Any new Royalty or other statutory taxes if any imposed by statutory Authority during the currency of contract shall be reimbursed by BHEL on submission of documentary proof of same.

1.3.5.5. In case of non-availability of water, the contractor shall make their own arrangements of water suitable for construction purpose to have uninterrupted work. No separate payment shall be made for any contingency arrangement made by contractor, due to delay / failure for providing water supply.

1.3.5.6. Contractor has to make his own arrangements for all water requirement for his labour accommodation at his cost. The Contractor shall make his own arrangement for further necessary distribution of the above at his cost.

1.3.5.7. Contractor has to make his own arrangement for drinking water at his cost.

1.3.6. MATERIAL SUPPLY

Supply / providing aggregate and all other materials as per the technical specification required for the work are in the scope of the contractor. BHEL shall provide Cement, Reinforcement steel and structural steel for civil and structural works only for incorporation in the permanent work as FREE SUPPLY.

1.3.6.1. **Fine aggregate**

Fine aggregate shall conform to requirements of IS 383 and Customer technical specification as applicable. Fine aggregate shall consist of natural sand, manufactured sand, or a combination thereof. Fine aggregate having a specific gravity of less than 2.55 (saturated surface dry condition) shall not be used. Fine aggregate shall be graded within the limits specified in NPCIL's technical specifications. The sand shall be of siliceous material, sharp, hard, strong and durable and shall be free from adherent coating, clay, dust, alkali, organic material, deleterious matter, lumps, etc. Sampling of fine aggregate shall be in accordance with IS: 2430. Fine aggregate shall be so graded that concrete of required workability, density and strength could be produced using the specified water binder ratio. The method of determination of gradation shall be as per IS: 2386. For more details, bidder to refer Technical Specification Section-C.

USE OF CRUSHED SAND

If the contractor desires to replace sand partially or completely, with crushed sand, he may do so only if the quality of final product meets all the requirements of NPCIL's technical specifications. It shall be noted that crushed sand shall be manufactured by specially crushing it from the aggregate by deploying proper machinery for the same. Crusher dust obtained while producing aggregate shall not be directly used for replacing sand unless it meets the technical specifications/ grading limits specified in the technical specification.

1.3.6.2. **Coarse aggregate**

Coarse aggregate for normal concrete shall consist of hard, strong, durable particles of crushed stone and shall be free from thin elongated soft pieces, vegetation or other

deleterious matter. It shall have no adherent coating. Coarse aggregate shall have an average specific gravity (saturated surface dry condition) 2.6 or more and no individual value shall be less than 2.55. For more details, bidder to refer Technical specification Section-C.

1.3.6.3. **Cement**

Regarding supply of cement, the cement shall be provided normally in bulkers and shall be unloaded in the silos (2 Nos minimum each of 100MT capacity per batching plant) to be installed by the bidder nearer to their batching plants. This is only minimum requirement and the numbers of cement silos shall be increased based on the site requirement. Carrying out design mix required for the scope of work providing all materials except cement is in the scope of bidder. Only cement for the design mix shall be provided by BHEL free of cost. On advance request of the bidder, the cement shall be supplied in Bags for other than RCC works like masonry, flooring works etc. Advance request for supply of cement in bags shall be minimum two months.

1.3.6.4. **QUALIFICATIONS AND APPROVAL OF SOURCES**

All materials required for the manufacture of concrete and used for curing of concrete shall be procured only from NPCIL approved sources. The contractor shall also ensure that at least two sources of each material are pre-qualified for ensuring uninterrupted supply of material. Bulk procurement of the ingredients of the concrete shall be made only after the contractor has completed the process of pre-qualification and the Engineer has duly approved the sources/ products.

1.3.6.5. **Reinforcement / Structural Steel**

1.3.6.5.1. The reinforcement steel and structural steel material will be issued from BHEL stores, within the plant premises. Collection and transporting to the place of work is in contractor's scope without any extra cost to BHEL.

1.3.6.5.2. The steel will be issued to the agency in standard lengths. In some instances, for 8mm,10mm &12mm dia reinforcement steel will be supplied in coil form. No extra claims will be entertained against issue of Non-standard lengths of steel and de coiling of 8mm, 10mm &12mm dia Steel.

1.3.6.5.3. Areas of work requiring cut to length steel in order to minimize scrap generation and wastage, has to be identified in consultation with BHEL site engineer and contractor shall furnish the requirement to BHEL well in advance of such requirement.

1.3.6.5.4. If any matching sections of steel are not available with BHEL, contractor may arrange these sections from Customer approved sources and the landing cost of sections to site will be reimbursed based on the prevailing rate at SAIL at the time of procurement at the nearest SAIL outlet with the freight charges against supporting document.

1.3.6.5.5. Bidder to note that steel materials required for Embedment's, inserts, MS Grating, Galvanized Grating, GI Handrail, Stainless Steel Handrail, fasteners like MS/HT/HSFG bolts/nuts, lock nuts, washers and foundation bolts other than those supplied by BHEL, shall be supplied by the bidder. However, Bidder shall use the scrap materials available with BHEL or with the respective bidders, for their use in the permanent works as embedment/inserts etc. after necessary store issue formalities, if taken from BHEL and shall be accounted for monthly reconciliation, if it belongs to the bidder's scrap materials. However, Bidder shall use the scrap materials available with BHEL or with the respective bidders, for their use in the permanent works as embedment/inserts etc. after necessary store issue formalities, if taken from BHEL and shall be accounted for monthly reconciliation, if it belongs to the bidder's scrap materials.

1.3.7. CONSUMABLES

All consumables, like gas, electrodes, chemicals, lubricants etc. required for the scope of work, shall be arranged by the contractor at his cost unless otherwise specifically mentioned in the contract. All consumables to be used for the job shall have to be approved by NPCIL / BHEL prior to use.

In the event of failure of contractor to bring necessary and sufficient consumables, BHEL may arrange for the same at the risk and cost of the contractor. The entire cost towards this along-with overhead shall be paid by the contractor or deducted from the contractor's bills.

1.3.8 LIGHTING FACILITY:

1.3.8.1 Adequate lighting facilities such as flood lamps, hand lamps and area lighting shall be arranged by the contractor at the site of construction, and contractor's material storage area etc. at his cost.

1.3.8.2 Lighting: - Adequate lighting facility in line of Rule- 11 of Atomic Energy (Factories) Rules 1996 for building and outside area such as flood light, hand lights and area fightings shall be provided by the Contractor at his own cost at the site of construction, at the storage of his materials and equipment and at temporary access roads within the working area. The Contractor shall obtain the approval of BHEL Engineer/NPCIL for the lighting arrangement prior to installation.

1.3.9 CONTRACTOR'S OBLIGATION ON COMPLETION:

On completion of work, all the temporary buildings, structures, pipe lines, cables etc. shall be dismantled and leveled and debris shall be removed as per instructions of BHEL by the contractor at his cost. In the event of his failure to do so, the expenditure towards clearance of the same will be recovered from the contractor. The decision of BHEL Engineer in this regard is final.

1.3.10 BLASTING

A valid blasting license shall be obtained by the Contractor from authorities concerned for starting any blasting work. The Contractor shall employ a competent and experienced supervisor (called Man-in-Charge) preferably having experience in mining operation and licensed blaster. They shall be held personally responsible to ensure that all safety regulations are followed.

1.3.11 DEWATERING

Contractor shall ensure at all times that his fabrication yard/ batching plant area & approach/ access roads are free from accumulation of water, so that the materials are safe and the erection/ progress schedule are not affected. No separate claim in this regard shall be admitted by BHEL.

1.3.12. CONTRACTOR'S OBLIGATION ON COMPLETION

On completion of work, all the temporary buildings, structures, pipe lines, cables etc. shall be dismantled and leveled and debris shall be removed as per instructions of BHEL by the contractor at his cost. In the event of his failure to do so, the expenditure towards clearance of the same will be recovered from the contractor. The decision of BHEL Engineer in this regard is final.

1.3.13. BID DRAWINGS

Drawings enclosed are only tentative & for information purpose and this may get revised during execution.

VOLUME-IA PART – I CHAPTER – IV

T&Ps TO BE DEPLOYED BY CONTRACTOR

1.4.1 All the tools and plants required for satisfactory completion of the work have to be arranged by the contractor.

1.4.2 The contractor is required to arrange all the major T&Ps and other T&Ps for the satisfactory completion of the work. Below mentioned is a tentative list of T&Ps required and not exhaustive.

A. STRUCTURAL WORKS

Sr No	Major T&Ps	Mobilizing time from the date of start of work
1.	1 Nos. 75 T capacity crawler crane for erection.	As per work requirement at site
2.	1 Nos. 75 T capacity crawler crane for Fabrication	As per work requirement at site
3.	1 Nos. 40 T capacity Tyre mounted crane	As per work requirement at site
	Other T&Ps	**Mobilizing time from the date of start of work**
4.	2 nos. Pick and Carry cranes of minimum capacity 14 T each	As per work requirement at site
5.	2 Nos. Radial drill machine	As per work requirement at site
6.	2 nos. magnetic base drill machine	As per work requirement at site
7.	6 nos. submerged arch welding machine	As per work requirement at site
8.	6 nos. MIG machine	As per work requirement at site
9.	25 nos. welding rectifier	As per work requirement at site
10.	1 no. trailor – 15T	As per work requirement at site
11.	3 no. power driven HSFG bolt tightening m/c	As per work requirement at site
12.	2 no's Power winch – 3T for structural erection	As per work requirement at site

13.	2 no's Power winch – 5T for structural erection	As per work requirement at site
14.	2 nos ultra-sonography machine with recording device for structural work	As per work requirement at site
15.	1 nos. Painting equipment sets complete with compressor, hopper, screen, blasting hose pipe, nozzle airless/conventional spray (within CGI temporary cover shed)	As per work requirement at site

B. CIVIL WORKS

Sr No	Major T&Ps	Mobilizing time from the date of start of work
1.	3 Nos. Tower Cranes of adequate capacity and appropriate height & radius to cover the TG building area along with operator and necessary spares	As per work requirement at site
2.	1 no. automatic concrete batching plant with printing facility (60 Cum/Hr) – and DG backup with minimum 2 Nos of silo (100MT each) per batching plant AND 1 no. automatic concrete batching plant with printing facility (30 Cum/Hr) – and DG backup with minimum 2 Nos of silo (100MT each) per batching plant (Concrete Mixing Plant shall be as per clause 6.6 of Technical specification Section-C)	1 no 60 Cum/Hr Batching plant to be mobilized within 30 days 1 no 30 Cum/Hr Batching plant to be mobilized within 60 days
3.	2 nos. Truck mounted concrete mixer cum pump along with placing boom minimum 36 m high	1 no within 30 days. Balance as per work requirement at site
4.	2 nos. concrete pump (60 cum/ hr min capacity & lift 90M) N.B. – Concrete pump can be replaced by providing additional concrete boom placer of adequate capacity with prior approval of Engineer In-Charge.	1 no within 30 days. Balance as per work requirement at site
5.	Ice Plant for production of ice for temperature control concrete	As per work requirement at site
6.	10 nos. transit mixer (5 or 6 M3 capacity) including standby 2 nos.	5 no within 30 days. Balance as per work requirement at site
7.	1 set of Reinforcement Forging and Threading Machine for Coupler Connections. (Reinforcement Cutting, Forging and Threading Machine should be	As per site requirement

	from the approved supplier/manufacturer of reinforcement coupler by BHEL/NPCIL)	
8.	1 nos. excavator equivalent to capacity of Pocklain CK90	As per work requirement at site
9.	1 no. Vibromax (earth compactor)	As per work requirement at site
	Other T&Ps	**Mobilizing time from the date of start of work**
10.	MS scaffolding pipe / ACROW PIPE	As per work requirement at site
11.	MS scaffolding pipe cup lock system /Doka D3 load bearing tower system.	As per BHEL requirement at site for TG deck
12.	Plywood shuttering board to achieve F-3/U-3 finish in concrete with adequate supporting structure from Doka/Arcow or equivalent	As per work requirement at site
13.	10 nos. Reinforcement cutting machine	As per work requirement at site
14.	20 nos. Reinforcement bending machine	As per work requirement at site
15.	3 nos. Back hoe loader like JCB	As per work requirement at site
16.	5 nos. Vacuum dewatered flooring machine	As per work requirement at site
17.	4 Nos. Dozer	As per work requirement at site
18.	2 nos. power driven earth rammer (Roller Type 1/2 T)	As per work requirement at site
19.	1 no. compression testing machine (200 T cap)	As per work requirement at site
20.	15 nos. Dumpers / Tippers (15 MT/ 20 MT) capacity	4 nos. within 20 days from commencement of work.
21.	Dewatering pumps capacity ranging from minimum 1 HP to 100 HP pumps	As per work requirement at site
22.	1 nos. Wagon Drill	As per work requirement at site
23.	3 nos. Jack Hammer	As per work requirement at site
24.	Air compressor	As per work requirement at site
25.	Concrete vibrator with adequate needle (Minimum 10 nos diesel/power nos.)	As per work requirement at site
26.	Grouting Pump with all accessories and fittings	As per work requirement at site
27.	10 nos. curing pump – 1.5 /2 HP (pump for curing at heights)	As per work requirement at site
28.	1 no. Concrete Paver machine	As per work requirement at site

29.	1 nos. Motorized External Platforms (sky climber)	As per work requirement at site
30.	2 no total station with adequate arrangement for Surveyors.	As per work requirement at site
31.	1 no theodolite 1 second accuracy	As per work requirement at site
32.	6 no's auto level & staff	As per work requirement at site
33.	300 no's concrete cube moulds	As per work requirement at site
34.	Adequate no. of small trucks 2T/5T for shifting of shuttering etc. within site	As per work requirement at site
35.	Water Tanker with Sprinkler	As per work requirement at site
36.	Civil laboratory equipment's as per list in Sl 1.4.7 with temporary building one AC lab room of size 4.5mtr x 6mtr and 1 non AC lab room of size 4.5 mtr x 4.5 mtr. (Laboratory should as per clause 6.14 of Technical specification Section-C)	As per work requirement at site
37.	5 no. drinking water tank – 2000 lit.	As per work requirement at site
38.	10 nos. mobile toilet blocks for labour use.	As per work requirement at site
39.	2 nos. truck mounted 125 KVA DG set	As per work requirement at site
40.	Construction power cable	As per work requirement at site
41.	Construction water Pipeline	As per work requirement at site
42.	Portable fire extinguishers as below: Soda acid – 20 sets. Dry chemical powder – 20 sets CO2 – 20 sets. Water & sand bucket (4 buckets in one stand) – 15 sets. Fire hose with nozzle (50 M length) – 10 sets.	25% within 30 days and balance progressively within 90 days.

Note:

1. T&P shown in the above mentioned list and the mobilization schedule is tentative requirement considering parallel working. However, mobilization schedule modification as well as no. of T&Ps as mutually agreed at site for major T&Ps, have to be adhered to. Numbers/ time of requirement will be reviewed time to time at site and contractor will provide required T&P/ equipment's to ensure completion of entire work within schedule/target date of completion without any additional financial implication to BHEL. Vendor shall give advance intimation & certification regarding capacity etc. prior to dispatch of heavy equipment's. Also on completion of the respective activity, demobilization of T&P in total or in part can be done with the due approval of engineer in charge. Retaining of the T&P's during the contract period will be mutually agreed in line with construction requirement.

2. All T&P and all IMTEs, which are required for successful and timely execution of the work covered within the scope of this tender, shall be arranged and provided by the contractor at his own cost in working condition.
3. In the event of contractor failing to arrange the required tools, plants, machineries, equipment, material or non-availability of the same owing to breakdown, BHEL will make alternative arrangement at the risk and cost of the contractor.

   Case 1: BHEL provides its own Capital T&P.

   In case the BHEL provides any T&P which is owned by BHEL, hire charges (as per BHEL norms) will be recovered from the contractor as per the prevailing BHEL corporate hire charges. In case, the T&P is specifically listed in "T&Ps to be deployed by Contractor", "Hire charges applicable to outside agencies other than contractors working for BHEL" will apply. If not listed, "hire charges applicable to contractor working for BHEL" will apply. The hire charges of Capital tools & plants are exclusive of operating expenses e.g. operator, fuel & consumables and the same shall be arranged by the contractor at his cost.

   Case 2: In all cases other than that specified in case 1 above, actual expenses incurred by BHEL along with applicable overheads will be back-charges to the contractor

4. In the event of need of change of type of any of major T&Ps, approval shall be taken from BHEL Engineer in-charge prior to mobilization. The decision of Number of T&P required due to replacing the enlisted T&P as per above table, shall be taken after analyzing the production capacity and suitability of both the T&Ps.
5. Clause no. 1.6.1.1 of this specification may please be referred for date of start of work.

1.4.3 In addition to the above, any other tools and plants required for execution of the above work are in contractor's scope.

1.4.4 Contractor shall submit the T&P mobilization schedule indicating the quantity and duration of deployment on monthly basis for the entire contract period in mutual concurrence with BHEL Engineer at the time of commencement of work.

1.4.5 The Bidder shall establish and maintain a field laboratory on the site and this laboratory shall be available at all time for testing.

1.4.6 The contractor shall establish a state of the art material-testing laboratory at site for testing of all the concrete ingredients, fresh concrete and hardened concrete. Fully automatic cube testing machines of adequate capacity and numbers shall be installed in the laboratory. Facilities for water permeability test as per DIN 1048 and Rapid Chloride Permeability Test (RCPT) as per ASTM-C-1202 shall also be available in the laboratory. Laboratory pan type mixer shall be available with the Contractor.

1.4.7 The laboratory must have qualified technicians to carry out all tests and must be adequately equipped to ensure that all necessary testing work can carried out in compliance with the standards.

1.4.8 Field and laboratory testing procedures for materials follow Indian Standard Specifications with necessary equipment's like as given in table below:

SL NO	NAME OF TEST	NAME OF EQUIPMENT	SIZE OF EQUIPMENT	IS REF.
CONCRETE TESTING EQUIPMENT				
1	Initial & final setting time, Consistency of cement	Vicat Apparatus with desk pot	Standard	IS 5513
2	Shrinkage of cement, Auto Clave Test	Le Chatelier's apparatus Auto Clave Equipment	Standard	IS 5514
3	Abrasion value test	Los Angles Abrasion testing machine	Standard	IS 2386
4	Aggregate Impact value test	Aggregate Impact value testing machine with blow counter	Standard	IS 9377
5	Aggregate crushing value test	Crushing value apparatus	Standard	IS 2386
6	Flakiness index	Thickness gauge for measuring flakiness index	Standard	IS 2386
7	Elongation Index	Elongation gauge	Standard	IS 2386
8	Bulk density, voids and bulking apparatus	Measuring cylinders	3, 5,10 & 15 litres cylinders	
9	Workability of concrete	Slump cone	Standard, at least 04 no's	IS 456
10	Specific gravity of aggregates	Pycnometer	Standard, at least 02 no's	IS 383
11	Cement mortar cube vibrating	Motorised vibration machine for cement testing	Standard	IS 4031
12	Course aggregate Sieve analysis (Concrete & Road Works)	Sieve set	450mm dia. GI Frames Size: 125 mm, 90 mm, 75 mm, 63 mm, 53 mm, 40 mm, 20 mm, 16 mm, 12.5 mm, 10 mm, 4.75 mm, Pan and cover	IS 383
13	Fine aggregate sieve analysis	Sieve set	200 mm dia. Brass sieves; Size 4.75 mm, 2.36 mm, 1.18 mm 600 micron, 300 micron, 150 micron, 75 micron, 75 micron, Pan and cover	IS 383
14	Sieve Shaker	Motorized Sieve shaker	Mfg. Catalogue	
15	Silt content check	Sand silt content beaker	Standard	
SL NO	**NAME OF TEST**	**NAME OF EQUIPMENT**	**SIZE OF EQIPMENT**	**IS REF.**

SOIL TESTING EQUIPMENT				
1	Liquid limit test	Liquid limit apparatus	Standard	IS 2720
2	Core Cutter test	core cutter apparatus	Rammer, 6 no's of std. core cutter mould, dolly	IS 2720
3	Proctor density test	Std proctor Compaction apparatus	Standard	IS 2720
4	Moisture Content	Rapid moisture meter	Standard, at least 04 no's	IS 2720

1.4.9 Contractor shall have at all times experienced operators and technicians for routine and breakdown maintenance of the equipment. Any delay in rectification of defects will warrant BHEL rectifying the defect and charging the cost to the contractor.

1.4.10 Crane operators deployed by the contractor shall be tested by BHEL before they are allowed to operate the cranes.

1.4.11 The age of contractor deployed cranes upto 150T should be within 15 years as on date of deployment. Contractor has to provide documentary proof for the age of the crane at the time of deployment to BHEL Engineer.

1.4.12 **CRANE OPERATOR FOR CRANES PROVIDED BY CONTRACTOR**

1.4.12.1 Must be capable of independently operating hydraulic/ mechanical crawler/ tyre mounted cranes of respective categories.

1.4.12.2 Must have minimum 2 years' experience in operation of hydraulic/ mechanical crawler/ tyre mounted cranes in respective categories & hold valid HMV/TRANS license. Should be able to read and interpret the operation and maintenance manual, boom load chart, boom angle and other indicating devices.

1.4.12.3 Operator shall have latest physician's certification for their physical fitness in vision with/ without lenses & adequate hearing with or without hearing aid.

1.4.13 In construction projects of this magnitude all the areas/ approaches might not be ready. In such cases consolidation of ground and arrangement of sleepers/ sand bag filling, construction of Temporary approach road for all their working area etc. for safe operation/ movement of T&P, etc. shall be the responsibility of the contractor at his cost. No compensation on this account shall be payable.

VOLUME-IA PART – I CHAPTER – V

T&PS PROVIDED BY BHEL ON SHARING BASIS

1.5.1 BHEL will provide suitable higher capacity cranes above 150T capacity to the contractors as per the requirement at the discretion of BHEL on free of hire charges on shareable basis. The cranes of 150MT and below 150MT is in the scope of bidder. Before requesting BHEL for higher capacity crane, agency has to ensure that all cranes of their scope 150MT and below should be available at site.

1.5.1 Besides the T & P mentioned above, which is being made available to the contractor on free of hire charges, any additional crane and other T & P which may be required for successful and timely execution of the work covered within the scope of this tender shall be arranged and provided at site by the contractor at his cost. n case if the contractor fails to provide such equipment's, BHEL will arrange for the same and the cost will be recovered from the contractor's bill with BHEL overheads, as applicable from time to time which may vary even during contract period.

1.5.2 BHEL's Crane is only for erection purpose and shall not be available for material handling or transportation purpose. Contractor shall make their own arrangements for material transportation to erection site.

1.5.3 BHEL may provide either BHEL owned cranes or hired cranes at the discretion of BHEL.

1.5.3.1 In the event of providing BHEL Cranes:

1.5.3.1.1 For all BHEL's own cranes of capacity greater than 150T, BHEL shall provide operators, free of charges.

1.5.3.1.2 Fuel, lubricants and consumables for BHEL's own cranes of capacity greater than 150T, are to be arranged by the contractor within the quoted rates.

1.5.3.1.3 Tentative List of consumables required to be provided by contractor is as below:

i. Engine Oil 15 W 40
ii. Fuel Filters
iii. Air Filters
iv. Hydraulic Filters
v. Hydraulic Oil –Servo 68
vi. Gear Oil- Servo 90
vii. Engine oil Filter

viii. Oil Separator Filter

ix. Rope- CRG 100 Grease

x. Grease- Servo Multi-Purpose Grease

1.5.3.1.4 Maintenance for the BHEL crane shall be carried out by BHEL. Bidder shall extend support (if required) for routine maintenance works.

1.5.3.2 In the event of providing hired Cranes:

1.5.3.2.1 Crane operators for hired cranes will be provided by BHEL, on free of charges.

1.5.3.2.2 The fuel for the crane is to be arranged by the contractor.

VOLUME-IA PART – I CHAPTER-VI

TIME SCHEDULE

1.6.1 **TIME SCHEDULE**

1.6.1.1 The commencement of work at site shall be mutually agreed date between bidder and BHEL to start the work.

1.6.1.2 The entire scope of work shall be completed within **32 (Thirty-two) months** from the date of commencement of work at site with intermediate milestones as mentioned in clause no. 1.6.7.4.

1.6.1.3 During the total period of contract, the contractor has to carry out the activities in a phased manner as required by BHEL and the program of milestone events.

1.6.1.4 The contractor is required to refer Form 15 in Volume 1- BOOK 2 for all the instructions to be taken immediately after receipt of LOI.

1.6.2 **MOBILISATION**

1.6.2.1 The Contractor has to subsequently augment his resources in such a manner to achieve the COMPLETION SCHEDULE.

1.6.2.2 The above time allowed for completion of work including Sundays and Holidays is from the date of commencement of work. Detailed program to be prepared by the tenderer taking in to consideration of the COMPLETION SCHEDULES /site decision on drawings flow (latest) and submitted for BHEL's approval.

1.6.3 In order to meet above schedule in general, and any other intermediate targets set, to meet customer/ project schedule requirements, contractor shall arrange & augment all necessary resources from time to time on the instructions of BHEL.

1.6.4 In case the project is to be advanced, the civil works in the scope of the contractor is to be advanced to meet the project requirement. No extra payment whatsoever shall be paid on this account.

1.6.5 **GUARANTEE PERIOD**

Guarantee period of 12 months shall commence from the date of completion of the whole work certified by the BHEL Engineer.

1.6.6 **SUBMISSION OF L3 SCHEDULE**

The contractor shall submit a detailed L3 schedule within 15 days in consultation with BHEL based on the tentative schedule provided as per the clause 1.6.7. The schedule shall be approved by BHEL and the same shall be implemented. Bidder shall submit the detailed schedule in MS Projects to meet the agreed project schedule covering various mile stone activities. This schedule shall also clearly indicate the interface facilities/inputs to be provided by BHEL/Customer and the dates by which such facilities/inputs are required. The schedule shall be acceptable to BHEL for meeting their mile stone targets/schedule.

1.6.7 **CONSTRUCTION SCHEDULE**

1.6.7.1 The tentative construction schedule for the scope of works for both Units is as mentioned below:

Sl. No.	Area	Description	Completion Month from the date of commencement of civil work (Tentative)	
			Unit#5	Unit#6
1	Commencement	Commencement of Civil Works	1	4
2	TG Foundation	Construction of Raft	4	7
3		TG Columns (Including condenser pedestal)	14	17
4		TG Deck	19	22
5		Finishing Works (Including Aux Columns)	22	25
6	Turbine Building	Construction of Raft (Inc CEP, BFP, Vacuum Pumps)	3	6
7		Tunnels & Trenches	8	11
8		Construction of floor at EL 100.0 m	14	17
9		Construction of floor at EL 111.0 m	17	20
10		Construction of floor at EL 118.0 m	20	23
11		Finishing works	24	27
12	Electrical Building	Construction upto EL 100 m	11	14
13		Construction above 100 m	18	21
14		backfilling & Finishing works	23	26
15	Pipe & Cable bridge (PCB)	Construction of foundation	8	11
16		Construction upto EL 100 m	14	17

Sl. No.	Area	Description	Completion Month from the date of commencement of civil work (Tentative)	
			Unit#5	Unit#6
17		Construction above 100 m	19	22
18	Access Bridge (AB) between Turbine Building & Control Building	Construction upto EL 100 m	15	18
19		Construction above 100 m	20	23
20	Transformer Yard	Construction of Transformer Yard & other equipment foundations including bus duct, rail foundation, BOP	11	14
21		Construction of GT foundation	16	19
22		Construction of UT foundation	17	20
23		Construction of SUT foundation	17	20
24		Finishing works	19	22
25	Annex Building	Construction upto EL 100 m	15	18
26		Construction above 100 m	20	23
27		Backfilling & Finishing works	22	25
28	Erection of O&M Platforms	Erection of O&M Platforms	26	29
29	Final Bill & Completion			32

1.6.7.2 The above schedule is tentative and the above completion schedule against each structure/ building is for entire completion and handing over the structure/ Building to BHEL. The foundations, pedestals, floors, and any structure, required for the start of structural erection work/ civil work/ mechanical equipment erection work, shall be handed over to BHEL progressively within the scheduled period given in the above table, as per the BHEL site requirement.

1.6.7.3 The major activities as mentioned against the work schedule given in Clause No.1.6.7.1 are to be indicated in detailed schedule which will be prepared by the bidder.

1.6.7.4 **INTERMEDIATE MILESTONES**

Intermediate milestones are as below.

S No	Description	Completion month from the date of commencement of civil work (Tentative)	Intermediate Milestone
1	Completion of Construction of Turbine Building floor at EL 100.0 m Unit # 5	14th Month	M1
2	Completion of TG Deck Unit # 6	22nd month	M2

1.6.7.5 Penalty for Intermediate Milestones

1.6.7.5.1 M1 and M2 shall be intermediate Milestones for this work.

1.6.7.5.2 In case of slippage of these identified Intermediate Milestones, Delay Analysis shall be carried out on achievement of each of these two Intermediate Milestones in reference to Form 14.

1.6.7.5.3 In case delay in achieving M1 milestone is solely attributable to the contractor,0.5% per week of executable contract value* limited to Maximum 2% of executable contract value will be withheld.

1.6.7.5.4 In case delay in achieving M2 milestone is solely attributable to the contractor,0.5% per week of executable contract value* limited to maximum 3% of executable contract value will be withheld.

1.6.7.5.5 Amount already withheld, if any, against slippage of M1 milestone, shall be released only if there is no delay attributable to contractor in achievement of M2 milestone.

1.6.7.5.6 Amount required to be withheld on account of slippage of identified intermediate milestone(s) shall be withheld out of respective milestone payment and balance amount (if any) shall be withheld @10% of RA Bill amount from subsequent RA bills.

1.6.7.5.7 Final deduction towards LD (if applicable), on account of delay attributable to contractor shall be based on final delay analysis on completion / closure of contract. Withheld amount, if any due to slippage of intermediate milestones shall be adjusted against LD or released as the case may be.

1.6.7.5.8 In case of termination of contract due to any reason attributable to contractor before completion of work, the amount already withheld against slippage of intermediate milestones shall not be released and be converted in to recovery.

1.6.7.5.9 Note: *Executable contract value-value of work for which inputs/fronts were made available to contractor and were scheduled for execution till the date of achievement of that milestone.

1.6.7.6 The above time allowed for completion of work including Sundays and Holidays is from the date of commencement of work. Detailed program to be prepared by the bidder taking in to consideration of the COMPLETION SCHEDULES / site decision on drawings flow (latest) and submitted for BHEL's approval.

1.6.7.7 In order to meet the above schedule in general, and any other intermediate targets set, to meet customer/ project schedule requirements, Contractor shall arrange & augment all necessary resources from time to time on the instructions of BHEL Engineer.

1.6.8 **RECORDS TO BE MAINTAINED AT SITE:**

The under mentioned Records/ Log-books/ Registers applicable to be maintained.

I. Hindrance Register.

II. Site Order Book.

III. Test Check of measurements.

IV. Cement Supply and Consumption Daily Register

V. Records of Test reports of Field tests.

VI. Records of manufacturer's test certificates

VII. Records of disposal of soil/ rock generated during and after the work completion.

VIII. Records of disposal of scraps generated during and after the work completion.

IX. List of T&Ps and MMEs

VOLUME-IA PART – I CHAPTER-VII

TERMS OF PAYMENT

1.7.0 TERMS OF PAYMENT

1.7.1 ADVANCE FOR MOBILIZATION

1.7.1.1 Following will be the breakup for payment of Interest Free Mobilization advance, limited to maximum of 5 % of the contract value, as per GCC clause 2.13.1

T&Ps to be mobilised	% split-up
Back hoe loader like JCB– 2 Nos	0.25
Batching Plant – 60 cum/hr. capacity– 1 No. with 2 Nos of silo (100MT each)	0.75
Transit mixer– 4 Nos	0.2
Concrete boom placer– 1 No	0.25
Tower cane – 1 No	0.75
Batching Plant – 30 cum/hr. capacity – 1 No. with 2 Nos of silo (100MT each)	0.75
Concrete boom placer– 1 No	0.25
Concrete pumps – 1 No. (Deployment of concrete boom placer is allowed in lieu of concrete pump)	0.25
Transit mixer – 2 Nos	0.1
Civil Laboratory with AC – 1 No	0.25
75 T capacity crawler crane for Fabrication – 1 Nos	0.15
Tower cane – 1 No	0.75
Reinforcement cutting machine- 10 nos.	0.1
Reinforcement bending machine - 20 nos.	0.1

1.7.1.2 Payment of advance shall be as mentioned above and recovery of the advance will be as per clause 2.13 of GCC.

1.7.2 INTERIM PAYMENT

1.7.2.1 Interim bills in the form of monthly running bills prepared by the contractor in soft as well as Hard copies shall be based on the quantities executed and measured.

1.7.2.2 95% item rate shall be released after completion of works certification by Engineer in charge.

1.7.2.3 5% of the item rate shall be released after submission of the quality check formats as per the quality plan for the quantum of work billed and duly certified by engineer.

1.7.2.4 Retention amount shall be as per Clause no. 2.22 of General Conditions of Contract (GCC) which is revised in TCC Part-2 Chapter-1: Corrections.

1.7.2.5 BHEL Site Engineer, at discretion, may operate the part rate of the items where supply and installation are involved, on receipt of the materials at site.

1.7.3 ROYALTY / SEIGNIORAGE CHARGES

Royalty/ seigniorage charges for excavation outside the plant boundary, as applicable as per Govt. of Karnataka for earth work shall be payable by the bidder at bidder's cost and proof of payment shall be submitted to BHEL along with each RAB. The above royalty/ seigniorage charges shall be inclusive within the quoted rate. No extra payment shall be applicable to the vendor.

1.7.4 METHOD OF MEASUREMENT

Mode of measurement shall be as per relevant IS 1200 in conjunction of IS code 3385. In case the same is not available, the standard procedure adopted in CPWD shall be adopted. In case the same is also not available, the standard procedure adopted in CPWD shall be adopted. In case the same is also not available in CPWD, the measurement of the work done will be based on the mutual agreement between BHEL and contractor. In all the above cases, the interpretation of BHEL will be final and binding to the contractor.

1.7.5 PERFORMANCE BOND TOWARDS WATERPROOFING OF UNDERGROUND STRUCTURES

1.7.5.1 Contractor shall make periodical inspection and repair the waterproofing for any apparent defects to ensure complete waterproofing during the guarantee period of 10 years. The Contractor shall submit a Bank Guarantee from a scheduled commercial bank (other than co-operative bank) for an amount of 10% of the cost of water proofing works carried out. The bank Guarantee shall be valid for a period of ten (10) years from the date of acceptance of the water proofing work by NPCIL.

1.7.6 PERFORMANCE BOND TOWARDS ROOF INSULATION AND WATERPROOFING

1.7.6.1 The Contractor shall be responsible for maintaining the roof top insulation for a period of 10 years from the date of acceptance of the water proofing work by NPCIL. The Contractor shall make periodical inspection especially before start of the rainy season and repair the waterproofing for any apparent defects to ensure effectiveness of water proofing during the guarantee period.

1.7.6.2 The Contractor shall submit a bank guarantee from a scheduled commercial bank (other than co-operative bank) for 10% of the cost of roof insulation and water proofing works carried out. The bank Guarantee shall be valid for a period of five years from the date of acceptance of the water proofing work by NPCIL.

1.7.7 NO CLAIM WHAT SO EVER MAY BE, WILL BE ENTERTAINED UNDER THIS CONTRACT, AFTER DULY SIGNING THE FINAL BILL ALONG WITH MEASUREMENT BOOKS AND ACCEPTED BY BHEL.

VOLUME-IA PART – I CHAPTER – VIII

TAXES AND DUTIES

1.8.1 All taxes and duty other than GST & Cess and BOCW Cess

The contractor shall pay all (except the specific exclusion viz GST &Cess and BOCW Cess, both of which are dealt with separately) taxes, fees, license charges, deposits, duties, tools, royalty, commissions, Stamp Duties, or other charges / levies, which may be levied on the input goods & services consumed and output goods & services delivered in course of his operations in executing the contract and the same shall not be reimbursed by BHEL. In case BHEL is forced to pay any of such taxes, BHEL shall have the right to recover the same from his bills or otherwise as deemed fit.

1.8.2 Goods and service Tax (GST) & Cess –

For GST Registered bidder:

1.8.2.1 The successful bidder shall furnish proof of GST registration under GST Law, covering the supply and services under this contract. Registration should also bear endorsement for the premises from where the billing shall be done by the successful bidder on BHEL for this project/ work. The bidder to specify in their offer the category of registration under GST i.e. Regular dealer or composite dealer**.**

1.8.2.2 Bidder's price/rates shall be exclusive of GST & Compensation Cess (herein after termed as GST).

1.8.2.3 This scope of work covered under Works contract services or other services, hence related GST rate shall be applicable (presently 18%).

1.8.2.4 Vendor / Contractor is required to ensure that all benefits as per existing laws have been considered.

1.8.2.5 Price quoted by the composite dealer shall be considered as inclusive of GST. In the event of any change in the status of vendor / Contractor from composite to regular dealer after the submission of the bid but before completion of supply of services or goods, Contract value shall be amended to remove the embedded GST and any ITC benefit arising due to change of status, which shall be passed on to BHEL. GST paid on the amended contract value shall be reimbursed at actuals against the Tax invoice if BHEL is able to take input tax credit. However, no reimbursement of GST shall be made if BHEL is not able to take input tax credit. The decision of BHEL in this regard will be final and binding on the vendor/contractor.

1.8.2.6 It is the responsibility of the vendor / contractor to adhere to all the provisions of E- Invoicing under GST Act (if applicable). As per the E-Invoicing provisions vendor / Contractor has to generate IRN and QR Code from the E-Invoicing system and the same need to be printed in the invoice submitted to their customer. Invoices that do not comply to the above requirements, will not be accepted by BHEL. If the successful Bidder is not falling under the preview of E-Invoicing, then he has to submit a declaration in that respect along with relevant financial statements. However, applicability of E-invoicing, shall be verified from the E-Invoicing portal on submission of vendor / Contractor GSTN. BHEL shall reimburse GST only if all the provisions of E-invoicing are complied with.

1.8.2.7 It is the responsibility of the vendor/ Contractor to issue the Tax Invoice strictly as per the format prescribed under the GST Act within the prescribed time period in order to enable BHEL to avail input tax

credit within the due date. Invoices shall be submitted on time to the concerned BHEL Engineer In-Charge. Tax invoice should also contain below details

a. Contractor Name and Contact details.
b. GST No of Contractor
c. PAN No of Contractor
d. Document Type: Tax Invoice/ Debit Note/ Credit Note
e. Category: B2B / B2C (B2B is only applicable w.r.t BHEL)
f. Customer Name and Contact details / Bill To Details (as mentioned below)
g. Unique Tax Invoice Number
h. Invoice Date
i. IRN No, QR Code, Acknowledgment No and Acknowledgment Date generated from E-Invoice Portal as per E-invoicing provisions under GST Act (If applicable)
j. Place of Supply (as mentioned below)
k. Description of service provided
l. 8 Digit SAC code
m. GST Rate
n. Gross value of Invoice
o. Taxable Value
p. Tax / GST Amount
q. Total Invoice value including GST.

Above are inclusive and not exhaustive list of requirements.

1.8.2.8 Bidder should mention the “Bill To “and “Place of supply” as below in the Tax Invoice

Bill To:
2 X 700 MWe PHWR 3 Kaiga-5&6 Atomic
Power Project Kaiga, Uttara Kannada District.
State: Karnataka
GSTN of BHEL: ----------

Place of Supply:
2 X 700 MWe PHWR 3 Kaiga-5&6 Atomic
Power Project Kaiga, Uttara Kannada District.
State: Karnataka
GSTN of BHEL: ----------

1.8.2.9 The amount equivalent to the GST amount shall be withheld from the vendor / contractor payments towards non-compliance of GST/ Statutory provisions if below requirements are not satisfied:

a. Vendor / Contractor submitted original copy of Tax invoice /debit note as per the prescribed format under the GST act within the prescribed time period in order to enable BHEL to avail input tax credit within the due date.
b. The details of the invoice or debit note referred to in clause (a) has been furnished/filed by the Vendor/ Contractor in the statement of outward supplies (presently in GSTR1 or IFF) and such

details get reflected in the BHEL GST login (Presently in GSTR 2B) in the manner specified under GST Act.

c. Details of vendor/contractor invoice reflected in BHEL GST login should match with the details in the tax invoice submitted by the vendor/contractor (Like Invoice no, Invoice date, GSTN, Place of supply).

d. The tax charged in the invoice /debit note referred to in clause (a) has been has been actually paid to the Government, either in cash or through utilization of input tax credit admissible by the Vendor/ Contractor.

1.8.2.10 In case, any GST credit is delayed/denied to BHEL or BHEL has to incur any liability (like interest / penalty) due to non/delayed receipt of goods or submission of tax invoice after the expiry of timeline prescribed in the relevant GST Act for availing ITC, or any other reasons not attributable to BHEL, Then the same shall be recovered from the vendor/contractor along with interest levied/ leviable on BHEL.

1.8.2.11 GST shall be levied on recoveries, wherever applicable and same shall be recovered from payments. BHEL shall issue / raise Tax invoice on contractor/vendors for such recoveries.

1.8.2.12 E-way bills / Transit passes / Road Permits, if required for materials / T&P etc., bought into the project site is to be arranged by the Vendor / Contractor themselves. BHEL shall not issue or raise any Road Permit/ E- Way Bill for this purpose. Any claim or demand raised by the GST department for non- generation / non submission of E-way bill shall be to the contractor/ vendor account

1.8.2.13 BHEL shall not reimburse any expenditure incurred by the contractor towards demand, additional liability or interest / penalty etc., raised by the GST department due to issues such as wrong rates / wrong classification of services or goods.

1.8.2.14 Where GST is payable by BHEL under reverse charge basis, any demand raised or any interest or penalty levied / leviable by the GST department due to non-submission or delayed submission of invoice by the contractor or for any other reason not attributable to BHEL, the same shall be recovered from the vendor/contractor.

1.8.2.15 Tax Deduction at Source (TDS) as per Sec 51 of the CGST Act shall be deducted (if applicable). GST TDS certificate in Form GSTR -7A shall be issued to be contractor. However, GST TDS certificate can be generated only if the contractor accepts the TDS details uploaded by BHEL and files his return. If any specific exemption from GST TDS is applicable to any contractor/vendor, then a declaration to that effect along with relevant documents as may be required by BHEL, substantiating such exemption in line with GST law provisions or notification, shall be submitted by the vendor/contractor.

For GST Unregistered bidder:

1.8.2.16 In case, bidder is not required to register under Goods and service Tax (GST) & Cess, the same is to be specified in the offer.

1.8.2.17 Successful bidder to furnish a Self-declaration that registration under GST is not required or not applicable as per the provisions of GST Law along with relevant document and provisions in the GST law.

1.8.2.18 In case BHEL has to incur any liability (like interest / penalty etc.) due to non- compliance of GST law in respect of the invoice submitted by the contractor, for the reasons attributable to the contractor, the same shall be recovered from the contractor.

1.8.2.19 TDS under GST (as & when applicable) shall be deducted at prevailing rates on gross invoice value.

1.8.2.20 If RCM is made applicable at a later date, GST will be paid by BHEL to the department at applicable rate treating the quoted the price as inclusive of GST if BHEL is not able to take Input tax credit.

1.8.2.21 In the event of any change in the status of bidder from unregistered to registered under the GST law after the submission of bid but before the completion of supply of services or goods, the same need to be intimated and all the clauses applicable for Registered bidder need to be followed. The vendor/ contractor is required to pass on the ITC benefit arising due to change of status, to BHEL. Contract value shall be amended accordingly. GST paid on the amended contract value shall be reimbursed at actuals against the Tax invoice only if BHEL is able to take input tax credit.

1.8.3 Statutory Variations

1.8.3.1 In general, Statutory variation for GST is payable to the Vendor/Contractor during the contract period including extension thereof. Further, for period beyond the contract period, BHEL will reimburse the actual applicable tax even if the same is higher than the amount applicable within the contractual period in case BHEL is able to take the input tax credit. However, the decision of BHEL in this regard will be final and binding on the vendor/contractor otherwise vendor/contractor has to bear the differential upward increase in tax and quoted price is to be adjusted accordingly.

1.8.3.2 No other variations except GST shall be payable by BHEL.

1.8.4 New Taxes/Levies –

In case Government imposes any new levy / tax after submission of bid during the tenure of the contract, BHEL shall reimburse the same at actual on submission of documentary proof of payment subject to the satisfaction of BHEL that such new levy / tax is applicable to this contract. However, Contractor/ Vendor shall obtain prior approval from BHEL before depositing new taxes and duties. Any benefits arise out of new tax levies and/or abolition of existing taxes must be passed on to BHEL. The decision of BHEL in this regard will be final and binding on the vendor/contractor.

1.8.5 Direct Tax

1.8.5.1 Vendor/ Contractor is required to update himself on its own and comply with provisions of Indian Income Tax Act as notified from time to time. Purchaser shall not be liable towards liability of income tax

accruing to the vendor/contractor of whatever nature including variations thereof, arising out of this Order/ Contract, as well as tax liability of the vendor/ Contractor and his personnel.

1.8.5.2 Deductions of Tax at source as per Income Tax Act, at the prevailing rates shall be effected by the Purchaser before release of payment, as a statutory obligation, if applicable. TDS certificate will be issued by the Purchaser as per the statutory provisions. The Vendor/Contractor has to mention their Permanent Account Number (PAN) and GSTIN in all invoices.

1.8.6 BOCW Act & BOCW Welfare Cess Act

1.8.6.1 Contractor's price/rates shall be exclusive of BOCW Cess.

1.8.6.2 The Contractor should Register their Establishment under BOCW Act 1996 read with rules 1998 by submitting Form I (Application for Registration of Establishment) and Form IV (Notice Of Commencement / Completion of Building other Construction Work) to the respective Labour Authorities i.e.,

a. Assistant Labour Commissioner (Central) in respect of the project premises which is under the purview of Central Govt.–NTPC, NTPL etc.
b. Appropriate State authorities in respect of the project premises which is under the purview of State Govt.

1.8.6.3 The Contractor should comply with the provisions of BOCW Welfare Cess Act 1996 in respect of the work awarded to them by BHEL.

1.8.6.4 The contractor should ensure compliance regarding Registration of Building Workers as Beneficiaries, Hours of work, welfare measures and other conditions of service with particular reference to Safety and Health measures like Safety Officers, safety committee, issue of Personal protective equipments, canteen, rest room, drinking water, Toilets, ambulance, first aid centre etc.

1.8.6.5 The contractor irrespective of their nature of work and manpower (Civil, Mechanical, Electrical works etc) should register their establishment under BOCW Act 1996 and comply with BOCW Welfare Cess Act 1996.

1.8.6.6 Contractor shall make remittance of the BOCW cess as per the Act in consultation with BHEL as per the rates in force (presently 1%). BOCW remittance should be made only after obtaining prior consent from BHEL. BHEL shall reimburse the same upon production of documentary evidence. However, BHEL shall not reimburse the Fee paid towards the registration of establishment, fees paid towards registration of Beneficiaries and Contribution of Beneficiaries remitted.

1.8.6.7 Non-compliance to Provisions of the BOCW Act & BOCW Welfare Cess Act is not acceptable. In case of any non-compliance, BHEL reserves the right to withhold any sum as it deems fit. Only upon total compliance to the BOCW Act and also discharge of total payment of Cess under the BOCW Cess Act by the Contractor, BHEL shall consider refund of the amounts.

VOLUME-IA PART – I CHAPTER - IX

BILL OF QUANTITY (BOQ)

1.9.1 Bidders shall only quote "Total amount" in the format given in the price bid. Any other elsewhere in the price bid shall be treated as Null and Void.

1.9.2 The above mentioned "Total amount" is for the entire Bill of Quantity (BOQ) given in Part-C of the Price bid.

1.9.3 BHEL has the pre-fixed the weightages for the amount of individual items of Bill of Quantity with respect to the "Total amount".

1.9.4 Based on the pre-fixed weightages, the amount for the individual items of the Bill of Quantity shall be arrived at. This amount shall be rounded off to the nearest rupee.

1.9.5 Based on the quantities of individual item and the amount arrived in Clause No. 1.9.4 above, unit rate of individual items shall be derived. This unit rate shall be rounded off to four decimal places.

1.9.6 Bidder to note that this is an item rate contract. Payment shall be made for the actual quantities of work executed as certified by BHEL Engineer at the unit rate arrived at as per Clause No. 1.9.5 above.

1.9.7 Quantity variation shall be as per GCC Clause no. 2.14 & modification in GCC mentioned in the tender.

1.9.8 Only brief description of items of work is given in the PRICE SCHEDULE. All the works are to be done as per tender specifications, descriptive notes and drawings to establish the complete facilities in all respects.

VOLUME-IA PART – I CHAPTER - X

GENERAL

The scope of the work will comprise of but not limited to the following:

(All the works mentioned hereunder shall be carried out within the accepted rate unless otherwise specified.)

1.10.1 Successful Bidder is requested to furnish the following at PSSR-HQ Chennai immediately after release of Letter of Intent (LOI)

i) Security Deposit

ii) Unqualified Acceptance for LOI, Detailed LOI / Work Order.

iii) Rs.100/- Stamp Paper for preparation of Contract Agreement.

1.10.2 Successful Bidder are requested to furnish the proof of documents for the following at the respective PSSR- Site

i) PF Regn No.

ii) Labour License No.

iii) Workmen Insurance Policy No.

1.10.3 In addition to the clause 2.8 of General Conditions of Contract (Volume-1C of Book-II) the contractor shall comply with the following.

1.10.3 PROVIDENT FUND

1.10.3.1 The contractor is required to extend the benefit of Provident Fund to the labour employed by you in connection with this contract as per the Employees Provident Fund and Miscellaneous Provisions Act 1952. For due implementation of the same, you are hereby required to get yourself registered with the Provident Fund authorities for the purpose of reconciliation of PF dues and furnish to us the code number allotted to you by the Provident Fund authorities within one month from the date of issue of the letter of intent. In case you are exempted from such remittance an attested copy of authority for such exemption is to be furnished. Please note that in the event of your failure to comply with the provisions of said Act, if recoveries therefore are enforced from payments due to us by the customer or paid to statutory authorities by us, such amount will be recovered from payments due to you.

1.10.3.2 The final bill amount would be released only on production of clearance certificate from PF / ESI and labour authorities as applicable.

1.10.4 OTHER STATUTORY REQUIREMENTS

1.10.4.1 The Contractor shall submit a copy of Labour License obtained from the Licensing Officer (Form VI) u/r25 read with u/s 12 of Contract Labour (R&A) Act 1970 & rules and Valid WC Insurance copy or ESI Code (if applicable) and PF code no. along with the first running bill.

1.10.4.2 The contactor shall submit monthly running bills along with the copies of monthly wages (of the preceding month) u/r78(1)(a)(1) of Contract Labour Rules, copies of monthly return of PF contribution

with remittance Challans under Employees Provident Fund Act 1952 and copy of renewed WC Insurance policy or copies of monthly return of ESI contribution with Challans under ESI Act 1948 (if applicable) in respect of the workmen engaged by them.

1.10.4.3 The Contractor should ensure compliance of Sec 21 of Contract Labour (R&A) Act 1970 regarding responsibility for payment of Wages. In case of "Non-compliance of Sec 21 or non-payment of wages" to the workmen before the expiry of wage period by the contractor, BHEL will reserve its right to pay the workmen under the orders of Appropriate authority at the risk and cost of the Contractor.

1.10.4.4 The Contractor shall submit copies of Final Settlement statement of disbursal of retrenchment benefits on retrenchment of each workmen under I D Act 1948, copies of Form 6-A (Annual Return of PF Contribution) along with copies of PF Contribution Card of each member under PF Act and copies of monthly return on ESI Contribution – Form 6 under ESI Act 1948 (if applicable) to BHEL along with the Final Bill.

1.10.4.5 In case of any dispute pending before the appropriate authority under ID Act 1948, WC Act 1923 or ESI Act 1948 and PF Act 1952, BHEL reserve the right to hold such amounts from the final bills of the Contractor which will be released on submission of proof of settlement of issues from the appropriate authority under the act.

1.10.4.6 In case of any dispute prolonged / pending before the authority for the reasons not attributable to the contractor, BHEL reserves the right to release the final bill of the contractor on submission of Indemnity bond by the contractor indemnifying BHEL against any claims that may arise at a later date without prejudice to the rights of BHEL.

1.10.5 DEPLOYMENT OF SKILLED / SEMI-SKILLED TRADESMEN

The following clause is applicable in case the contract value / contract price is Rs. Five crores and above.

The contractor shall, at all stages of work deploy skilled / semi-skilled tradesmen who are qualified and possess certificate in particular trade from CPWD Training Institute / Industrial Training. Institute / National Institute of Construction Management and Research (NICMAR), National Academy of Construction, CIDC or any similar reputed and recognized Institute managed / certified by State / Central Government. The number of such qualified tradesmen shall not be less than 20% of total skilled / semi-skilled workers required in each trade at any stage of work. The contractor shall submit number of man days required in respect of each trade, its scheduling and the list of qualified tradesmen along with requisite certificate from recognized Institute to Engineer-in-Charge for approval. Notwithstanding such approval, if the tradesmen are found to have inadequate skill to execute the work of respective trade, the contractor shall substitute such tradesmen within two days of written notice from Engineer-in-Charge. Failure on the part of contractor to obtain approval of Engineer-in-Charge or failure to deploy qualified tradesmen will attract a compensation to be paid by contractor at the rate of Rs. 100 per such tradesman per day. Decision of Engineer-in-Charge as to whether particular tradesman possesses requisite skill and amount of compensation in case of default shall be final and binding.

1.10.6 Site Visit by the Bidder

1.10.6.1 The bidder shall, prior to submitting his tender for the work, visit, examine and acquire full knowledge & information and necessary conditions prevailing at the site and its surroundings of the plant premises together with all statutory, obligatory, mandatory requirements of various authorities about the site of works at his own expense, and obtain and ascertain for himself on his own responsibility that may be for preparing his tender and entering into a contract, and take the same into account in the quoted contract price for the work.

1.10.6.2 The bidder shall satisfy themselves about the following factors:

i) Site conditions including access to the site, existing and required roads and other means of transport/communication for use by him in connection with the work including diverting and re-routing of services.

ii) Requirement and availability of land and other facilities of his enabling works, establishment of his nursery, office, stores etc.

iii) Ground conditions including those bearing upon transportation, disposal, handling and storage of materials required for the work or obtained there-from.

iv) Source and extent of availability of suitable materials, including water etc., and labour (skilled and unskilled) required for work, and laws and regulations governing their use and employment.

v) Geological, meteorological, topographical and other general features of the site and its surroundings as are pertaining to and needed for the performance of the work.

vi) The limit and extent of surface and subsurface water to be encountered during the performance of the work, and the requirement of drainage and pumping.

vii) The type of equipment and facilities needed, for and in the performance of the work;

viii) The extent of lead and lift required for the work in complete form over the entire duration of the contract, and

ix) All other information pertaining to and needed for the work including information as to the risks, contingencies and other circumstances which may influence or affect the work or the cost thereof under this contract.

1.10.6.3 The bidder should note that information, if any, in regard to the local conditions, as contained in these tender documents, has been given to tenderer merely for guidance and is not warranted to be complete.

1.10.6.4 A bidder shall be deemed to have full knowledge of the site, whether he inspects it or not, and no extra charges consequent on any misunderstanding or otherwise shall be allowed.

1.10.6.5 The bidder and any of his personnel or agents will be granted permission by the Site-In-Charge or his authorized nominee, on receipt of formal application in respect thereof a week in advance of the proposed date of inspection of site, to enter upon his premises and lands for purpose of such inspection, but only on the express condition that the tenderer (and his personnel and agents) will relieve and indemnify the Employer (and his personnel and agents) from and against all liability in respect thereof and will be responsible for personal injury (whether fatal or otherwise), loss of or damage to property and

any other loss, damage, costs and expenses however caused which, but for the exercise of such permission, would not have arisen.

1.10.6.6 All works shall be carried out in proper workmen like manner. Items of works covered by the following specification shall be carried out as per the best practices and according to the direction of the Engineer In- charge / BHEL, Site Engineer and to his satisfaction. Unless otherwise specified in this section or in the description of item, the cost of stage of works mentioned here under shall be deemed to have been included in the rates of items provided in the schedule.

1.10.6.7 Scope of work covered under this specification requires quality workmanship, engineering and green belt management along with the supply of all consumables, tools and tackles and testing instruments. The contractor shall ensure timely completion of work. The contractor shall have adequate tools, measuring instruments etc. in his possession. He shall also have adequate trained, qualified and experienced engineers, supervisory staff and skilled personnel. The manpower deployment identified by contractor shall match with above scope of works.

1.10.6.8 It is not the intent to specify herein all details of all material. Any item related this work not covered by this but necessary to complete the system will be deemed to have been included in the scope of the work.

1.10.6.9 All the necessary certificates and licenses required to carry out this scope of work are to be arranged by the contractor then and there at no extra cost.

1.10.6.10 Site testing wherever required shall be carried out for all items / materials installed by the contractor to ensure proper installation and functioning in accordance with drawings, specifications and manufacturer's recommendations.

1.10.6.11 The contractor shall carryout additional tests if any, which the Engineer feels necessary because of site conditions and also to meet system specification.

1.10.6.12 All the work shall be carried out as per instructions of BHEL engineer. BHEL engineer's decision regarding the correctness of the work and method of working shall be final and binding on the contractor.

1.10.6.13 Wherever work sequences are furnished by BHEL, the contractor shall follow the same sequence.

1.10.6.14 The Contractor may have to execute work in such a place and condition where other agencies also will be under such circumstances. The contractor shall co-operate with other contractors and agencies so that various activities can be carried out simultaneously in order to achieve an early completion.

1.10.6.15 Contractor shall execute the supply and works as per sequence prescribed by BHEL at site engineer. No claims for extra payment from the contractor will be entertained on the grounds of deviation from the methods of execution of similar job in any other site or for any reasons whatsoever.

1.10.6.16 If required by BHEL, the contractor shall change the sequence of his operation so that work on priority sectors can be completed within the projects schedule. The contractor shall afford maximum assistance to BHEL in this connection without causing delay to agreed completion date.

1.10.6.17 Contractor shall, transport all materials to site and unload at site / working area for inspection and checking. All material handling equipment required shall be arranged by the contractor.

1.10.6.18 Contractor shall retain all T&P / Testing instrument / Material handling equipments etc at site as per advice of BHEL engineer and same shall be taken out from site only after getting the clearances from engineer in charge.

1.10.6.19 The contractor at his cost shall arrange necessary security measures for adequate protection of his machinery, equipment, tools, materials etc. BHEL shall not be responsible for any loss or damage to the contractor's construction equipment and materials. The contractor may consult the Engineer-in-Charge on the arrangements made for general site security for protection of his machinery equipment tools etc.

1.10.6.20 The Contractor may have to execute work in such a place and condition where other agencies also will be under such circumstances. However, completion time for work agreed will be subject to the condition that contractor's work is not hampered by the agencies.

1.10.6.21 Contractor has to work in close co-ordination with other work agency at site. BHEL engineer will co-ordinate area clearance. In a project of such magnitude, it is possible that the area clearance may be less / more at a particular given time. Activities and work program have to be planned in such a way that the milestones are achieved as per schedule/ plans. Contractor shall arrange & augment the resources accordingly.

1.10.6.22 The contractor must obtain the signature and permission of the security personnel of the customer for bringing any of their materials inside the site premises. Without the Entry Gate Pass these materials will not be allowed to be taken outside.

1.10.6.23 Contractor shall remove all scrap materials periodically generated from his working area and collect the same at one place earmarked for the same. Load of scraps is to be shifted to a place earmarked by BHEL. Failure to collect the scrap is likely to lead to accidents and as such BHEL reserves the right to collect and remove the scrap at contractor's risk and cost if there is any failure on the part of contractor in this respect.

1.10.6.24 The contractor shall ensure that his premises are always kept clean and tidy to the extent possible. Any untidiness noted on the part of the contractor shall be brought to the attention of the contractor's site representative who shall take immediate action to clean the surroundings to the satisfaction of the Engineer-in-Charge.

1.10.6.25 The contractor is strictly prohibited from using BHEL's regular components like angles, channels, beams, plates, pipe / tubes, and handrails etc for any temporary supporting or scaffolding works. Contractor shall arrange himself all such materials. In case of such misuse of BHEL materials, a sum as determined by BHEL engineer will be recovered from the contractor's bill. The decision of BHEL engineer is final and binding on the contractor.

1.10.6.26 No member of the already erected structure / buildings, other component and auxiliaries should be removed / modified without specific approval of BHEL engineer.

1.10.6.27 Contractors shall ensure that all their Staff / Employees are exposed to periodical training programme conducted by qualified agencies/ personnel on ISO 9001 – 2008 Standards.

1.10.6.28 The terminal points decided by BHEL are final and binding on the contractor for deciding the scope of work and effecting the payment for the work done up to the terminals.

1.10.6.29 Crane operators deployed by the contractor shall be tested by BHEL before he is allowed to operate the cranes.

1.10.6.30 On Completion of work, all the temporary buildings, structures, pipe lines, cable etc. shall be dismantled and leveled and debris shall be removed as per instruction of BHEL by the contractor at his cost. In the event of his failure to do so, the expenditure towards clearance of the same will be recovered from the contractor. The decision of BHEL Engineer in this regard is final.

1.10.6.31 It is the responsibility of the contractor to do the checking, testing etc. if necessary, repeatedly to satisfy BHEL Engineer with all the necessary tools and tackles, manpower etc. without any extra cost. The testing will be completed only when jointly certified so, by the BHEL Engineer.

1.10.6.32 If any item or equipment not covered but requires being executed, same shall be carried out by the contractor. Equivalent or proportional unit rate shall be considered wherever possible from the BOQ. The rates quoted by the contractor shall be uniform as far as possible for similar items appearing in rate schedule.

1.10.6.33 The contractor's work shall not hinder other work, either underground or over ground, such as electrical, phone lines, water or sewage lines, etc. In areas of overlap, the contractor shall work in coordination with other related contractors. Any damage by the landscape contractor's team to such utilities will be penalized and contractor shall be responsible for cost for such damages.

1.10.7 SITE INSPECTION

1.10.7.1 BHEL or his authorized agents may inspect various stages of work during the currency of the contract awarded to him. The contractor shall make necessary arrangements for such inspection and carry out the rectification pointed out by the owner / employer without any extra cost to the owner / employer. No cost whatsoever such duplication of inspection of work be entertained.

1.10.7.2 BHEL will have full power and authority to inspect the works at any time, either on the site or at the contractor's premises. The contractor shall arrange every facility and assistance to carry out such inspection. On no account will the contractor be allowed to proceed with work of any type unless such work has been inspected and entries are made in the site inspection register by BHEL.

1.10.7.3 Wherever the performance of work by the contractor is not satisfactory in respect of workmanship, deployment of sufficient labour or equipment, leading to delay in execution of work or any other matter, BHEL shall have the right to engage labour at normal ruling rates and get the work executed through other agency and debit the cost to the contractor and the contractor shall have no right to claim compensation thereof. In such a case, BHEL shall have the right to utilize the materials and tools brought by the contractors for the same work.

1.10.8 DOCUMENTATION

1.10.8.1 The following information shall be furnished by the bidder within two weeks of award of contract for purchaser's approval:

1.10.8.2 Bar chart covering planned activities at site

a. Detailed organization chart

b. Details of T&P available with contractors with documents proofs.

1.10.8.3 The following information shall be furnished by the bidder after testing and inspection:

Test certificates of various tests conducted at site. All inspection and test certificates shall be signed by BHEL representative also.

1.10.9 RECORDS TO BE MAINTAINED AT SITE:

1.10.9.1 Record of Quantity of FREE/Chargeable items issued by BHEL must be maintained during contract execution. Also reconciliation statement to be prepared at regular intervals.

1.10.9.2 The under mentioned Records/ Log-books/ Registers applicable to be maintained.

a. Hindrance Register.

b. Site Order Book.

c. Test Check of measurements.

d. Supply and Consumption Daily Register of Cement and Steel

e. Records of Test reports of Field tests.

f. Records of manufacture's test certificates.

Records of disposal of scraps generated during and after the work completion.

VOLUME-IA PART – I CHAPTER - XI

PROGRESS OF WORK

The scope of work will comprise of following but not limited to the following:

1.11.0 PROGRESS AND MONITORING OF WORK

1.11.1 Refer forms F -14 to F-15 of volume I D of volume -I book-II. Plan and review will be done as per the formats.

1.11.2 Contractor is required to draw mutually agreed monthly construction programs in consultation with BHEL well in advance monthly as per the Form-14. Contractor shall ensure achievement of agreed program and shall also timely arrange additional resources considered necessary at no extra cost to BHEL. Progress review meetings will be held at site during which actual progress during the week vis-a-vis scheduled program shall be discussed for actions to be taken for achieving targets. Contractor shall also present the program for subsequent week. The contractor shall constantly update / revise his work program to meet the overall requirement. All quality problems shall also be discussed during above review meetings. Necessary preventive and corrective action shall be discussed and decided upon in such review meetings and shall be implemented by the contractor in time bound manner so as to eliminate the cause of nonconformities.

1.11.3 The contractor shall submit daily, weekly and monthly progress reports, manpower reports, materials report, consumables (gases / electrodes / ferules / lugs) report, T&Ps availability report and other reports as per Performa considered necessary by the Site Engineer as per the BHEL formats.

1.11.4 The contractor shall submit weekly / fortnightly / monthly statement report regarding consumption of all consumables for cost analysis purposes.

1.11.5 The monthly report ending on 24th of every month shall be submitted as a booklet and shall contain the following details

a) Colour Progress photographs to accompany the report should be submitted.
b) Construction progress in terms of quantity, CUM, etc., completed as relevant to the respective work areas against planned.
c) Site Organization chart of engineers & supervisors as on 24th of the month with further mobilization plan.

d) Category- wise man hours engaged during the previous month under the categories like fitters, electricians, welders, riggers, khalasis, grinder-men, gas-cutters, crane operators, store keepers, lab technicians, helpers, security, etc. Data will be spilt up under the work area.

e) Consumables report giving consumption of all types of gases and electrodes during the previous month.

f) Availability report of cranes/ T&Ps

g) Safety implementation report in the format

h) Pending material and any other inputs required from BHEL for activities planned during the subsequent month.

1.11.6 The manpower reports shall clearly indicate the manpower deployed, category wise specifying also the activities in which they are engaged.

1.11.7 During the course of construction, if the progress is found unsatisfactory, or if the target dates fixed from time to time for every milestone are to be advanced, or in the opinion of BHEL, if it is found that the skilled workmen like fitters, operators, technicians, etc. employed are not sufficient, BHEL will induct required additional workmen to improve the progress and recover all charges incurred on this account including all expenses together with BHEL overheads from contractor's bills.

1.11.8 It is the responsibility of the contractor to provide all relevant information on a regular basis regarding construction progress, labour availability, equipment deployment, testing, etc.

1.11.9 The progress reports shall indicate the progress achieved against plan, indicating reasons for delays, if any. The report shall also give remedial actions which the contractor intends to make good the slippage or lost time so that further works can proceed as per the original plan the slippages do not accumulate and affect the overall programme.

1.11.10 The contractor to reflect actual progress achieved during the month and will be submitted to BHEL, so that slippages can be observed and necessary action taken in order to ensure that the situation does not get out of control will update the construction schedule forming part of this contract each month.

VOLUME-IA PART – I CHAPTER – XII

MATERIAL HANDLING

1.12.1 Open land as available shall be provided by BHEL on free of cost basis as provided by NPCIL. Contractor shall maintain one centralized fenced store cum bar bending yard at his own cost. Hard surfacing of this yard and all round drain shall be carried out by the contractor at his own cost within the quoted rate. Batching plant area, shall be provided nearer plant premises and contractor shall make use of the area for installation and operation of the Batching Plant at his own cost. The bidder shall make complete arrangement of necessary security personnel, to safeguard all such materials in his custody at his own cost. Materials issued will be used only for construction of permanent work. The contractor shall take care of material issued by BHEL and shall protect the same from theft, damage and weathering at his own cost.

1.12.2 The system for receipt, storage & issue of materials shall be available with vendors for easy traceability.

1.12.3 Periodic audit of system of purchasing, storing and issue, etc. will have to be carried out by the vendors. BHEL will also audit the same.

1.12.4 The contractor shall construct waterproof cement store (capacity 400 MT) for initial period for storing and stacking of cement, CGI/ asbestos roofing (slope) with brick masonry wall, PCC flooring. Materials required for the same shall be provided by contractor at his own cost. Cement has to be kept over wooden raised platform. Stacking of cement is to be done as per IS codes with proper illumination and locking arrangements.

1.12.5 The contractor shall in no case be entitled for any compensation or damages on account of any delay in supply or non-supply thereof for all or any such material.

1.12.6 Clotting of cement and excessive rusting of steel must be avoided. In case, due to any cause attributable to the contractor, rusting of steel for BHEL issued steel occur rendering the same unusable, then such quantity of steel shall be recovered from the interim payment at the penal rate specified in the tender.

1.12.7 The contractor shall maintain proper store account for all the BHEL issued materials and shall give three copies of computerized reconciliation statement of such account to the BHEL with each running bill.

1.12.8 All TMT shall be stacked over sleeper's diameter wise.

1.12.9 All structural steel (issued for insert/ embedment) shall be stacked plate size wise and thickness wise. Beams, channels and angles shall be stacked separately on sleepers.

1.12.10 Materials shall not under any circumstances taken out of the project site unless otherwise permitted by BHEL.

VOLUME 1A PART-1 CHAPTER XIII

ACCOUNTING OF MATERIALS ISSUE

The material issued to the contractor by BHEL will be accounted as follows:

1.13.1 ISSUE OF CEMENT, CONSUMPTION, WASTAGE & RETURN OF MATERIALS

Please refer SPECIAL CONDITIONS OF CONTRACT (SCC)- Civil & Structural Chapter – VI: Material Handling, Storage & Preservation.

1.13.2 ISSUE OF STEEL, CONSUMPTION, WASTAGE & RETURN OF MATERIALS

Please refer SPECIAL CONDITIONS OF CONTRACT (SCC)- Civil & Structural Chapter – VI: Material Handling, Storage & Preservation

1.13.3 SCRAP & SERVICEABLE MATERIALS

Please refer SPECIAL CONDITIONS OF CONTRACT (SCC)- Civil & Structural Chapter – VI: Material Handling, Storage & Preservation

1.13.4 RECONCILIATION OF MATERIALS

Please refer SPECIAL CONDITIONS OF CONTRACT (SCC)- Civil & Structural Chapter – VI: Material Handling, Storage & Preservation

1.13.5 RECOVERY OF MATERIAL

Recovery of wastages shall be made from the bills of contractor at the penal rate mentioned in the table below for the following cases:

a) If wastage exceeds the specified limit

b) If the wastage not exceeded specified limit, but not returned to BHEL store except invisible wastage

c) For not returning the surplus serviceable materials.

13.2.1 PENAL RATE OF MATERIALS

1.	**REINFORCEMENT STEEL** Cold rolled steel, high strength, deformed bar or mild steel round bars including earthing rod	**Rs. 59,085 per MT** + GST and/or other taxes & duties
2.	**STRUCTURAL STEEL**	**Rs. 70,124 per MT** + GST and/or other taxes & duties
3.	**CEMENT**	**Rs. 6,563 per MT** + GST and/or other taxes & duties

VOLUME-IA PART – I CHAPTER - XIV

ENTRY OF CONTRACTOR'S PERSONNEL AND VEHICLES

1.14.1 The construction site is within the purview of authorized security force. The contractor shall follow at site all security rules as may be framed by the Corporation from time to time regarding removal/movement of materials and equipment from site, issue of biometry RFID identity cards, control of entry of personnel and all similar matters. Contractor shall also follow all rules and regulations applicable to the area being declared / pronounced from time to time by the authorities or state authority having sensitive structures within the vicinity of the site. Nothing extra will be payable on account of stoppage/hindrance of the work.

1.14.2 The contractor shall get the gate passes for their workers issued by Security agency deployed by NPCIL.

1.14.3 The identity cards/passes will be issued to the Contractor's staff and labour by NPCIL. A refundable amount as notified from time to time by NPCIL, shall be charged for issuing these cards. However, all such cards shall be essentially retuned back to NPCIL on completion of work or when the individual card holder leaves the site.

1.14.4 In case contract workers leave in between i.e. before the expiry of contract completion date, the contactor must inform the same to EIC & Security agency so that suitable remark can be added in the computer record for future checking. The contractor has to ensure deposition of gate pass issued to such worker to issuing authority through Engineer-In-Charge at the earliest.

1.14.5 In general, RFID cards with hand geometry shall be applicable for all the contract personnel and workmen. However, till the system for issue of RFID cards with hand geometry is established for, normal photo gate passes shall be issued. In case of damage or loss of RFID card a penalty of Rs. 200/- per card shall be imposed and recovered from the RA bill.

1.14.6 **Procedure for issue of gate pass is as below:**

i. Temporary passes will be issued for an initial period of 15 days on the basis of photo identity on recommendation of Engineer-In-Charge based on request & certification of contractor.

Following forms of photo identity shall be acceptable for issue of initial gate passes to contract personnel and workmen.

a. Voter ID card / Diving License / Passport /Photo bearing ration card/Aadhar Card

b. Letter from the following in their letter head with attested photo and individual's details

- Village Administrative officer
- Elected Councilor
- Panchayat President
- Member of Legislature Assembly (MLA)
- Member of Legislature Council (MLC)
- Member of Parliament (MP)
- Tehsildar

ii. Thereafter, renewal of above temporary gate passes will be done for a period of further two months after having completed safety induction training, first aid training and submission of medical fitness certificate.

iii. The Contractor shall submit the **police verification certificate (PVC)** for his staff and labour as a pre-condition to issue of RFID cards. On receipt of PVC,

RFID card shall be issued upto a period of one year or remaining contract period, whichever is less. In between, each of contractor's employee has to undergo safety training after every 6 months, which shall be coordinated by contractor's Head (IS&F) & NPCIL Head (IS&F)]. After expiry of this one-year duration, gate passes shall be further renewed as per the same guidelines.

iv. In case of receipt of any adverse information against an individual, the issued identity card shall be immediately cancelled and contractor has to surrender it with Security Agency.

v. Separate permission will have to be obtained by Contractor for entry of personnel, equipment's & material in night shift and also for Sunday / Holidays.

1.14.7 Permission for vehicles will be given for a period of six months or expiry of contract, whichever is earlier based on the recommendation of Engineer-In-Charge, after verification of relevant documents.

1.14.8 The contractor and his employees shall not disclose any information or drawings furnished to them by the Corporation. Any drawings, reports and other information prepared by the contractor/by the Corporation or jointly by both for the execution of the contract shall not be

disclosed without the prior written approval of the Engineer. No photographs of the works or plant within the site premises shall be taken.

1.14.9 On completion of work, contractor has to surrender all identity cards issued under the contract for their labour / staff to Issuing authority and a No Dues Certificate has to be submitted to Engineer-in-Charge of work before final bill payment.

VOLUME-IA PART – I CHAPTER - XV

HOUSEKEEPING

1.15.1 Housekeeping is very essential to provide safe working area for construction personnel and for movement of the machineries. In order to achieve this objective; a two part housekeeping policy is adopted at Kaiga-5&6. As first part, Contractor has to maintain certain housekeeping practices for his own works. In addition to this, for up keeping of overall plant area and areas where multiple agencies work simultaneously, different package Contractors shall be responsible for maintaining general housekeeping in the allocated specific area to them.

Scope of work under these two parts is detailed as below. No separate payment shall be made for this work and its cost to be included in the price bid.

1.15.2 **Housekeeping of own works**:

1) The Contractor shall at all-time keep his work spot, site office, workshops and surroundings clean and tidy from rubbish, scrap, surplus materials and unwanted tools and equipment.
2) Welding and other electrical cables shall be so routed to allow safe traffic by all concerned. Cables shall not be spread on floor; it shall be properly supported and clamped along the wall.
3) No materials on any of the sites of work shall be so stacked or placed as to cause danger or inconvenience to any person or the public. The Engineer-In- Charge may require the Contractor to remove any materials which are considered to be of danger or cause inconvenience to the public. In case Contractor fails to comply with the instruction of Engineer-In-Charge, he may get the work done at the risk and cost of Contractor.
4) The Contractor shall on day to day basis have removed from the work place all unwanted scaffoldings, surplus materials, rubbish, etc.
5) The Engineer-In-Charge has the right to stop work if the Contractor fails to improve upon the housekeeping after having been notified.
6) In addition, the Contractor shall comply with specific housekeeping requirements given in the tender specification.

1.15.3 **Housekeeping of the assigned area / Building:**

During the entire phase of execution of contract till facilities are taken over by BHEL/NPCIL (which also includes extended period of contract, if any), it shall be the responsibility of the

Contractor to maintain general cleanliness in the area assigned to him. The contractor shall estimate the total area for two nos. of turbine building based on the approved final layout.

1.15.3.1 General description of work

SL. NO.	OPERATION	MINIMUM FREQUENCY OF OPERATION
1.	Cleaning and Sweeping of all floors, staircase, platform, lifts and wiping of handrails, equipment, JBs, pipes and etc.	Daily
2.	Wet mopping of finished floors	Weekly
3.	Vacuum cleaning of finished floors	Monthly
4.	Debris removal from dust bin, baskets placed in the respective building.	Monthly or as and when required

1.15.3.2 **Procedures for execution of work:**

1) Cleaning and sweeping of floors, staircase, platform, anything and everything up to ceiling height and ceiling, as per the frequency indicated in the table. Cleaning activity shall start in the morning at 7.00 AM so as to complete all the cleaning/ moping work before 9.00 AM.
2) Continuous sweeping to be done at entrance of building and cleaning/ wiping of equipment and systems located at various floors of the building during working hours with lunch break and tea break.
3) Removal of cobwebs, putting the collected debris other than structural materials in the dustbin kept at the specified location on every day basis. Disposal of collected structural materials within a distance of 1.5 Km on daily basis
4) Lifting, carrying and disposal of all generated debris such as structural pieces, cable pieces, cable trays, ducts, wooden pieces, packing materials, piping material etc. and all other generated scrap from allotted building within a distance of 1 Km on daily basis.
5) Disposal of debris from dust bins/baskets placed in the respective building within a distance of 1 Km once in a monthly basis or as and when required.
6) In order to maintain quality services and minimize operational problems, the contractor must rotate the staff once in six months with prior written intimation to Engineer In Charge.

7) The Contractor shall arrange his own equipment's and tools required for this work like trolleys, ladders, buckets, dust bins, brooms, industrial vaccum cleaner, brushes, wiping cloths or any other material required for the cleaning.
8) The storage and security of his materials and equipment shall be the sole responsibility of the Contractor and shall have no right to claim for any loss/theft or damage of the same.
9) The exclusive work force shall be deputed for this work and work force deployed for this general housekeeping shall not be diverted for any other job or for his own house keeping jobs.
10) All deployed work force shall be provided with dress (with proper code), safety and cleaning gears and in no case work should stop for want of gears.
11) The Contractor shall make his own arrangements of water required to execute this job.

1.15.3.3 **Providing work force / staff:**

The Contractor shall deploy adequate housekeeping and supervisory manpower at his own account & responsibility. At the time of allotment of the area for up keeping, the name of NPCIL officials in charge for housekeeping, herein after referred as "Area in charge" (AIC) of the area will be conveyed to the Contractor.

1.15.3.4 **Reporting:**

1) The Housekeeping Supervisor(s) should report daily to the AIC & take day-to-day instructions
2) The Contractor shall make sure that Housekeeping Supervisor(s) is necessarily available during working hours for receiving & implementing the Instructions of the AIC.
3) It shall be the responsibility of the Contractor to get the attendance of the housekeeping staff verified by AIC.
4) The weekly/fortnightly/monthly jobs should be planned by Housekeeping Supervisor(s) in consultation with AIC in such a manner that these are spread over the entire week and done during office hours.
5) However, certain jobs will necessarily be carried out during Sundays, for which instructions should be taken by the Housekeeping Supervisor(s) from AIC.
6) Proper registers/records of the jobs carried out on daily, weekly, fortnightly and monthly basis will be maintained by the Housekeeping Supervisor(s) and will be countersigned by the AIC on daily basis and finally at the end of each month by EIC.

7) Housekeeping Supervisor shall remain in his area most of the time and shall have information about agencies working/ material stacked in his area. Suitable control system may be devised for the same.
8) The Contractor shall be equipped to handle the special/emergency services even at short notice.
9) All equipment deployed shall be of quality standard.
10) Housekeeping Supervisor shall not allow those materials which affect the up keeping and fire hazards to building. Ex: wooden planks, drums, scaffolding materials which are not painted

1.15.3.5 **Unsatisfactory performance and consequence thereof:**

1) Before commencement of job the Contractor shall submit procedure, manpower list and work plan on housekeeping of respective building under his control and he will follow the same. Monitoring of the levels of Quality of the housekeeping services shall be done on regular basis by BHEL as well as customer's AIC. In the event of unsatisfactory service or any failure at any time on the part of Contractor as reported by Customer (who shall be the sole judge and whose decision shall be final), the Contractor shall be liable to be penalised and accordingly deductions as determined by EIC in a rational manner (finalized by NPCIL) shall be made from the dues of contractor payable against Area housekeeping work.
2) Following penalties shall be imposed for Area House Keeping Work:
    - Non-deployment/Improper maintenance of toilets shall be liable for penalty of Rs. 500 per toilet per day.

The Contractor shall at all times ensure that his performance is satisfactory, failing which, BHEL shall be at the liberty to get the affected work done through any other agency, at the risk and cost of the Contractor and all expenses incurred on this account shall be recovered from RA bill.

VOLUME-IA PART – I CHAPTER - XIV

SAFETY

1.16.1 In addition to the HSE Obligations and HSE Plan for Site operations by Subcontractors (HSE14 Rev. 02) specified elsewhere in the tender specifications, the contractor will comply with the following:

i. The clauses listed in this chapter

ii. Any other conditions specified by the customer NPCIL

Stringent of the condition(s) stipulated in the above reference shall be applicable to the contractor.

1.16.2 The contractor shall strictly adhere to all the provisions spelt out in the document "AERB Safety Guidelines for Control of Works (guideline no. AERB/NRF/SG/IS Rev 1) and other safety requirements as applicable to the project site.

1.16.3 The contractor shall provide and maintain all lights, fencing, guards, warning signs and caution board and similar items as required ensuring safe working conditions at work site.

1.16.4 Contractor shall comply with the instructions given by the BHEL/NPCIL safety officer regarding safety precautions, protection measures and housekeeping etc.

1.16.5 The contractor shall provide proper access and working platforms for all place of work as per laid down standards or as advised by BHEL/Customer.

1.16.6 The contractor shall ensure that all floor openings in his work are guarded/barricaded during the course of work and at the end of each day's work.

1.16.7 The Contractor shall meet statutory requirements as well as regulatory requirements applicable to the project, in general, and NPCIL in particular, especially the requirements as per Factory Act-1948 (amended in 1987), Atomic Energy factories Rule-1996 (AEFR- 1996 or latest version available at the time of work execution), safety guidelines for Job Hazard Analysis (JHA) & AERB notifications on Industrial & Fire safety.

1.16.8 The contractors' safety professionals shall be well aware about Acts, Rules connected with Industrial Safety and practices particularly applicable to the project and to that effect they have

to undergo an assessment at the project within 15 days of their placement at the project at the cost of the contractor and then only he/she would be given permanent entry pass to plant and considered in the required strength of the safety professionals.

1.16.9 Workers in general shall not be deployed at work for more than I0 hrs/day and in no case more than 12 hrs/day.

1.16.10 All PPE procured and provided to workers shall conform to relevant Indian Standards and should be maintained in healthy condition by suitable storage, maintenance and inspection.

1.16.11 The contractor shall be held responsible for non-compliance of any of the safety measures, injuries, fatalities and compensation arising out of such situations or accidents. Penalty if any on this account levied by the customer will be recovered from the contractor's bills.

1.16.12 Employees Safety & Workmen Compensation:

Contractor shall be responsible for safety of all his employees during execution of the contract work. As per Workmen's Compensation Act, 1923 (Amended in 2000), the contractor will ensure the payment of compensation to his employees in case of an accident as early as possible within the time frame permitted by the law of land.

1.16.13 Safety organization of the contractor

1. Every contractor shall have an Industrial safety organization having qualified safety professionals as enumerated below prior to the execution of job at project. The minimum numbers of safety professionals and their qualifications shall be as per Health, Safety & Environment plan for site operations by Subcontractors (HSEP 14 Rev.02).

2. The above is the minimum requirement of safety professionals. BHEL/NPCIL, if required, can ask for more safety professionals depending upon nature of jobs being executed by the contractor.

3. Contractor's safety professionals shall report to BHEL's safety incharge at plant site. However, administrative control and management of safety in the contract work would be the responsibility of the contractor. Verification of safety professional qualification/competence shall be carried out time to time at site by BHEL/NPCIL. In case contractor fails to employ the required safety professionals, the additional/required safety

professionals may be deployed at the cost and risk of the contractor. The cost incurred towards this shall be deducted from contractor's bill at following the rates.

4. If the required safety professionals are not employed by the contractor, BHEL/NPCIL may deploy such safety professionals and the cost incurred towards this (at the risk and cost of contactor) and any other penalties levied by NPCIL in this regard shall be deducted from the contractor's bills.

1.16.14 Job Supervision at site

1. The contractor must ensure adequate job supervision through educated, qualified and experienced supervisors - at least one supervisor for each hazardous job activity to ensure safety during work execution. Similarly, there should be adequate on-site engineering support ensuring coverage of atleast one experienced engineer for every ten supervisors and part thereof.

2. In case, the contractor is unable to arrange required work supervisors and engineers for work technical support, BHEL/NPCIL may deploy such personnel and the cost incurred towards this (at the risk and cost of contactor) and any other penalties levied by NPCIL in this regard shall be deducted from the contractor's bills.

1.16.15 Training requirements

1. The contractor site-in-charge should arrange induction safety training of four hours duration to all workmen prior to engaging them to work and refresher training on monthly basis covering 20% of the workman in a month with 100% coverage within 6 months. This training should be given with necessary Audio, Visual, Posters aids and as per syllabus approved by NPCIL safety group The training should be in the language understandable to workmen. This training shall include mock trials of wearing of helmet, use of safety belt and it's hooking up to an independent lifeline etc. The safety-training instructor must certify the workmen for having understood safety aspects and use of PPEs successfully in mockup trial. To ensure proper understanding of safety instructions and safety training, the contractor shall employ literate (at least able to read safety instructions) workers only. In exceptional cases of not meeting literacy requirement the workers shall be imparted supplementary training.

2. The job supervisors and the engineers will have to undergo detailed safety training of at least three days' duration at the plant in safety supervision and accident prevention techniques. This training would at the cost of the contractor and then only he/she would be given permanent entry pass to plant.

3. **Contractor must note that in case the industrial safety induction training as per above clause is not conducted within 3 days his workmen shall not get plant entry pass.**

1.16.16 Requirements and specification of PPEs Tools and Tackles

1. Contractor must keep adequate stock of ISI certified (or of relevant international standards) personal protective equipment (PPE), safe working tools and safe working appliances like platforms and access ladders, guard railing etc. corresponding to his scope of work and shall ensure these are used during the job for safe execution of the work. These PPE, Tools and Appliances must be inspected quarterly. Contractor on demand by BHEL/NPCIL Authorities shall produce the record of such inspections.

2. All implements being used for height work like scaffold, access stairs/ladders, platform, railings etc. should be of ISI marked material meeting requirements of AEFR-1996 and should be certified by contractor safety professional prior to its safe use and to the effect that each implement should have display showing it can be safely used. If any workman is found using sub-standard or damaged PPE, tools & appliance, or any unsafe condition/practices is observed, contractor can be penalized as per the charges levied by NPCIL.

1.16.17 Work Practices

1. The Pre Job Briefing, prior to taking up the work, will be carried out by contractor Safety Engineer/Supervisor to all workers using plant guidelines. The Contractor shall make arrangements for adequate and qualified supervision using checklists during the execution of jobs. The contractor shall ensure that all his workmen must take safety permit for each high-risk job as per project procedure.

   If any hazardous work is found without safety work permit/ JHA/ safe working procedure, contractor can be penalized as per the charges levied by NPCIL.

2. Contractor working at height of more than 2.5 meter above stable floor or ground floor must acquire height pass as per procedure including the worker's medical fitness certificate by certifying surgeon (having MBBS qualification) and worker's height qualification etc. If in any height work, the worker is found working without having height pass, contractor can be penalized as per the charges levied by NPCIL.

3. Contractor shall ensure safe movement of man and material as well as vehicles in site premises as per rules/regulations applicable at or issued by plant. In case of violation of the rules/regulation contractor can be penalized as per the charges levied by NPCIL. The decision of the BHEL/NPCIL Engineer-in-charge, with regards to levying penalty in case above work practices are not ensured shall be final and binding.

1.16.18 Safety Plan

1. Contractor at his cost shall perform following tasks for the jobs having high risk as identified by BHEL/NPCIL Safety Group:

   i. Prepare Safe Working Procedures and ensure its implementation in field.
   ii. Carry out Job Hazard Analyses (JHA) and implement in field.
   iii. Based on JHA, the safe working procedures should be modified especially to include checklists as necessary checkpoints for job safety supervision.
   iv. Worker(s) must be trained based on the safe working procedure and explained about DOs & DON'Ts prior to assigning him the job.
   v. The workers must adhere to the safe working procedure for the job.
   vi. Contractor shall ensure that all Tools, Appliances, erecting equipment and their safe use by the contractor work force shall be meeting Indian standards. The contractor must ensure that necessary authorization exist with workmen prior to their deployment on a particular appliance/tool/equipment. The workmen would be required to acquire additional authorization for crane operation, crane signaling, blasting operation, welding and cutting operation, electrical work etc. and then only workmen shall be deployed for such job. He shall maintain all record of tools and equipment for their healthiness and safe use with a copy to BHEL/NPCIL safety group.
   vii. Employing of any sub-contractor by the main contractor shall be with concurrence of plant authorities & Engineer-In-Charge as per applicable procedure of the plant. The main contractor shall ensure that all safety requirements/conditions are effectively

communicated to and well understood by his sub-contractor. The main contractor should ensure safety training & availabilities of required PPEs and he will be responsible for the safety of the workmen of his sub-contractor.

1.16.19 Above clauses should be read in conjunction with relevant clauses elsewhere in the tender conditions and stringent of the condition shall be followed.

1.16.20 If the contractor fails to meet the safety requirements as stipulated under this chapter and mentioned elsewhere in the tender conditions, then penalty as levied by NPCIL will be recovered from the contractor's RA bills.

1.16.21 Penalties for the serious accidents

Following shall be the penalties for each category of serious accidents:

I. For each Serious accident (As per HSEP 14 Rev. 02) – Rs.1,00,000/-

II. For each fatality- Rs. 10,00,000/-

VOLUME-IA PART – I CHAPTER - XVII

QUALITY ASSURANCE

1.17.1 **Quality Assurance Program**

1.17.1.1 The equipment and services under the scope of this Contract whether manufactured or performed within the Contractor's Facilities or at his Sub-contractor's premises or at the project site or at any other place of work shall be subjected to quality surveillance commensurate with customer's QA programme to control such activities at all stages necessary, and inspection by the customer's (NPCIL) authorised Quality Surveillance Engineer.

1.17.1.2 The Quality Management System of the contractor shall generally cover, but not limited to the following:

a. His organization structure for the management and implementation of the proposed quality management system including interfaces.
b. Documentation control system.
c. Qualification data for Contractor's key personnel.
d. The procedure for purchase or materials, parts, components and selection of Sub-contractor's services including vendor analysis, source inspection, incoming raw material inspection, verification of materials purchased etc.
e. System for construction/fabrication and site erection controls through QA plans.
f. Control of calibration and testing of inspection, measuring and testing equipment
g. System of indication and appraisal of inspection status.
h. System of quality audits.
i. Training, certification and authorization of personnel.
j. System of intimation by the contractor, and approval by the customer of stages of completion of facilities.
k. System for maintenance of records.
l. System for handling, storage, preservation and delivery of items.

1.17.2 The contractor shall also submit a list of all key persons to be engaged in the contract, along with their qualification, experience, organizational position etc.

1.17.3 The Customer's duly authorized representative reserves the right to carry out Quality Audit and Quality Surveillance of the systems and procedures of the Quality Management and Control Activities of the Contractor/ his vendor.

1.17.4 **Inspection, Testing and Rejection**

1.17.4.1 BHEL's/Customer's Engineer-in-Charge, his duly authorised representative and/or an outside inspection agency acting on behalf of BHEL/Customer shall have at all reasonable times access to the Contractor's premises or facilities and shall have the power at all reasonable times to inspect and examine the materials and workmanship during manufacture or erection and if part of the Stores is being manufactured or assembled at other premises or works, the Contractor shall obtain for the BHEL/NPCIL and for his duly authorised representative permission to inspect as if the Stores were manufactured or assembled on the Contractor's own premises.

1.17.4.2 The Contractor shall give BHEL/Customer Personnel full opportunity to carry out these activities, including providing access, facilities, permissions and safety equipment. No such activity shall relieve the Contractor from any obligation or responsibility.

1.17.4.3 The Plant and Equipment / Facilities (in part or full) shall be offered by the Contractor for inspection at place of manufacture and/or on the site or at such places as may be specified by the Inspector at the Contractor's risk, expense and cost. The Contractor shall give notice of readiness of Stores/ facilities for inspection to the Inspector and shall perform all tests and inspection in presence of the Inspector as per the terms of the tender specifications and approved inspection plan. In default of such notice, BHEL/NPCIL shall be entitled to appraise the quality and extent thereof.

1.17.4.4 Test Certificates and Guarantee Certificates if required by the Inspector shall be obtained and furnished to him free of cost by the Contractor and/or from the specified agency.

1.17.4.5 The Contractor shall promptly forward to the BHEL/NPCIL duly certified reports of the tests. When the specified tests have been passed, the BHEL/NPCIL shall endorse the Contractor's test certificate, or issue a certificate to him, to that effect.

1.17.4.6 Where consignments are required to be delivered / despatched after inspection by the Inspector as per the Contract, a "Shipping Release" issued by the Inspector shall be enclosed

along with the delivery challan or other shipping documents viz. (Lorry Receipt, Railway Receipt) accompanying the consignments.

1.17.4.7 The Contractor agrees that neither the execution of a test and/or inspection of Plant and Equipment or any part of the Facilities, nor the attendance by the BHEL/Customer or the Engineer-in-charge, nor the issue of any test certificate, shall release the Contractor from any other responsibilities under the Contract.

1.17.4.8 Except as otherwise specified in the Contract, the Contractor shall provide all apparatus, assistance, documents and other information, electricity, equipment, fuel, consumables, instruments, labour, materials, and suitably qualified and experienced staff, as are necessary to carry out the specified tests efficiently. The Contractor shall agree, with BHEL the time and place for the specified testing of any Plant, Materials and other parts of the Facilities.

1.17.4.9 No part of the facilities shall be covered up or put out of view without the approval of the Engineer-in charge or his authorized representative and the Contractor shall afford full opportunity for examination and measurement of any part of the facilities which is about to be covered up or put out of view and for examination of foundations before permanent work is placed thereon.

1.17.4.10 The Contractor shall give due notice to the Engineer-in-charge or his authorized representative whenever any such part of the facilities or foundation is ready for examination and the Engineer-in-charge or his representative shall without unreasonable delay, unless he considers it unnecessary and advises the Contractor accordingly, attend for the purpose of examining and measuring such part of the facilities or of examining such foundations. In the event of the failure of the Contractor to give such notice, he shall, if required by the Engineer-in-charge, uncover such work at the Contractor's expense.

1.17.5 **Remedial Work**

1.17.5.1 If it shall appear to the Engineer-in-Charge or his representative at any time during construction or reconstruction or prior to the expiration of the Guarantee Period, that any work has been executed with unsound, imperfect or unskilled workmanship or that any materials or articles provided by the Contractor for execution of the work are unsound or of a quality inferior to that contracted for or otherwise not in accordance with the Contract that any defect, shrinkage or other faults have appeared in the work arising out of defective or improper

materials or workmanship, the Contractor shall, upon receipt of a notice in writing in that behalf from BHEL, forthwith rectify or remove and reconstruct the work so specified in whole or in part, as the case may require or as the case may be and/or remove the materials or articles so specified and provide other proper and suitable materials or articles so specified and provide other proper and suitable materials or articles at his own expense, notwithstanding that the same may have been inadvertently passed, certified and paid for and in the event of his failing to do so within the period to be specified by the Engineer-in-Charge in his notice aforesaid, the Engineer-in- Charge may rectify or remove and re-execute the work and/or remove and replace with others the materials or articles complained of, as the case may be, by other means at the risk and expense of the Contractor.

VOLUME-IA PART-II CHAPTER-I

CORRECTIONS / REVISIONS IN SPECIAL CONDITIONS OF CONTRACT, GENERAL CONDITIONS OF CONTRACT AND FORMS & PROCEDURES

Sl. No.: 01

Following Clauses in General Conditions of Contract (GCC) are modified/ revised/ added:

S.No	GCC Clause Reference	Modification / Revision / Addition in GCC Clause
1.	GCC Clause 1.9.1, Sl. No. (ii)	The following mode of deposit, Sl. No. (e) is added: e) Insurance Surety Bonds
2.	GCC Clause 1.10.3, Sl. No. (vi)	**The following Clause, Sl. No. (vi) is deleted**: Security deposit can also be recovered at the rate of 10% of the gross amount progressively from each of the running bills of the contractor till the total amount of the required security deposit is collected. However, in such cases at least 50% of the required Security Deposit, including the EMD, should be deposited in any form as prescribed before start of the work and the balance 50% may be recovered from the running bills as described above
3.	GCC Clause 1.10.3, Sl.No.(vii)	The following mode of deposit, Sl. No. (vii) is added: e) Insurance Surety Bonds
4.	Note mentioned under the GCC Clause 1.10.3	Note mentioned under GCC Clause 1.10.3 is revised as below: Note: **(1)** BHEL will not be liable or responsible in any manner for the collection of interest or renewal of the documents or in any other matter connected therewith. **(2)** In case of delay in submission of security deposit, enhanced security deposit which would include interest (Repo rate +4%) for the delayed period, shall be submitted by the bidder.
5.	GCC Clause 1.10.8	**GCC Clause 1.10.8 is revised as below:** Bidder agrees to submit security deposit required for execution of the contract within the time period mentioned. In case of delay in submission of security deposit, enhanced security deposit which would include interest (Repo rate+4%) for the delayed period, shall be submitted by the bidder. Further, if security deposit is not submitted till such time the first bill becomes due, the amount of security deposit due shall be recovered as per terms defined in NIT / contract, from the bills along with due interest
6.	GCC Clause 2.22.1	**GCC Clause 2.22.1 is revised as:** Retention Amount shall be 5% of the Contract Value and shall be furnished through BG in line with clause 1.12 of GCC before payment of first RA Bill. The validity of the said BG shall be initially for the contract period & shall be extended, if so required, up to acceptance of final bill. In case of increase in contract value, additional BG for 5% of differential amount shall be submitted by Contractor before payment of next RA Bill due.

S.No	GCC Clause Reference	Modification / Revision / Addition in GCC Clause
7.	New Clause for "Breach of Contract, Remedies and Termination" is added in place of existing clause of Risk & Cost (i.e. 2.7.2.1 to 2.7.3)	**Clause 2.7.2 and 2.7.3 are revised as:** **2.7.2 <u>Breach of Contract, Remedies and Termination</u>** **2.7.2.1** BHEL shall terminate the contract after due notice of a period of 14 days in any of the following cases, which if not rectified/ improved within the time period mentioned in the notice, then, 'Breach of Contract' will be considered to have been established: i). Contractor's poor progress of the work vis-à-vis execution timeline as stipulated in the Contract, backlog attributable to contractor including unexecuted portion of work does not appear to be executable within balance available period considering its performance of execution. ii). Withdrawal from or abandonment of the work by contractor before completion of the work as per contract. iii). Non-completion of work by the Contractor within scheduled completion period as per Contract or as extended from time to time, for the reasons attributable to the contractor. iv). Repeated failure of contractor in deploying the required resources, to comply the statutory requirements etc. even after given by BHEL is writing. v). Strike or Lockout declared is not settled within a period of one month. vi). Termination of Contract on account of any other reason (s) attributable to Contractor. vii). Assignment, transfer, subletting of Contract without BHEL's written permission. viii). Non-compliance to any contractual condition or any other default attributable to Contractor. **2.7.2.2 <u>Remedies in case of Breach of Contract is established</u>** In case 'Breach of Contract' is established, Security Deposit and Retention Amount shall be encashed/ forfeited. This is without prejudice to BHEL's right to levy of liquidated damages, debarment etc. which shall be applied as per the provisions of the contract. Sequence of recovery to be made in case of breach of contract is established, is as below: a) In case the value of Security Deposit & Retention Amount, available for the Contract, is less than 10% of the Contract Value, the balance amount shall be recovered from dues available in the form of Bills payable to contractor, BGs against the same contract etc. b) Demand notice for deposit of balance recovery amount shall be sent to contractor, if funds are insufficient to effect complete recovery against dues indicated in (a) above.

S.No	GCC Clause Reference	Modification / Revision / Addition in GCC Clause
		c) If contractor fails to deposit the balance amount to be recovered within the period as prescribed in demand notice, following action shall be taken for balance recovery: i) Dues payable to contractor against other contracts in the same Region shall be considered for recovery. ii) If recovery cannot be made out of dues payable to the contractor as above, balance amount to be recovered, shall be informed to other Regions/Units for making recovery from the Unpaid Bills/Running Bills/SD/BGs/Final Bills of contractor. iii) In-case recoveries are not possible with any of the above available options, Legal action shall be initiated for recovery against contractor. Note: 1) In addition to above, levy of liquidated damages, debarment, termination, short-closure etc. shall be applied as per provisions of the contract. 2) If tendering is done for the balance work, the defaulted contractor (including all the members/partners in case of JV/ partnership firm) shall not be eligible for either executing the balance work or to participate in the tender(s) for executing the balance work. **2.7.3** In case Contractor fails to deploy the resources as per requirement informed by BHEL in writing to expedite the work, BHEL can deploy own/hired/otherwise arranged resources and recover the expenses incurred from the dues payable to contractor. Recoveries shall be actual expenses incurred plus 5% overheads or as defined in TCC. **NOTE:** The above mentioned revised **cl 2.7.2- Breach of Contract, Remedies and Termination & cl 2.7.3** shall replace the existing Risk & Cost clauses mentioned elsewhere in the tender.
8.	GCC Clause 2.7.7	**GCC Clause 2.7.7 is revised as:** BHEL may permit or direct contractor to demobilize and remobilize at a future date as intimated by BHEL in case of following situations for reasons other than Force majeure conditions and not attributable to contractor: i) suspension of work(s) at a Project either by BHEL or Customer, or ii) where work comes to a complete halt or reaches a stage wherein worthwhile works cannot be executed and there is no possibility of commencement of work for a period of not less than three months

S.No	GCC Clause Reference	Modification / Revision / Addition in GCC Clause
		In such cases, charges towards demobilization and remobilization shall be as decided by BHEL after successful remobilization by contractor at site, and decision of BHEL shall be final and binding on the contractor. After remobilization, all conditions as per contract shall become applicable. In case Contractor does not remobilize with adequate resources or does not start the work within the period as intimated, then BHEL reserves the right to terminate the contract and effect remedies under Clause 2.7.2.2. Duration of the contract/time extension shall be revised suitably. In case of any conflict, BHEL decision in this regard shall be final and binding on the contractor.
9.	GCC Clause 2.11.3	**GCC Clause 2.11.3 is revised as:** However, if any 'Time extension' is granted to the contractor to facilitate continuation of work and completion of contract, due to backlog attributable to the contractor alone, then it shall be without prejudice to the rights of BHEL to impose penalty/LD for the delays attributable to the contractor, in addition to any other actions BHEL may wish to take under clause 2.7.2 of GCC i.e. "Breach of Contract, Remedies and Termination".
10.	GCC Clause 2.19.1	**GCC Clause 2.19.1 is revised as:** The contractor will be fully responsible for all disputes and other issues connected with his labour. In the event of the contractor's labour resorting to strike or the Contractor resorting to lockout and if the strike or lockout declared is not settled within a period of one month, it may be considered as 'Breach of Contract' under Clause 2.7 and the remedies under Clause 2.7.2.2 may be executed, at the discretion of BHEL.
11.	GCC Clause 2.24.1	**GCC Clause 2.24.1 is revised as:** Even though the work will be carried out under the supervision of BHEL Engineers the Contractor will be responsible for the quality of the workmanship and shall guarantee the work done for a period of Twelve months from the date of commencement of guarantee period as defined in Technical Conditions of Contract, for good workmanship and shall rectify free of cost all defects due to faulty erection detected during the guarantee period. In the event of the Contractor failing to repair the defective works within the time specified by the Engineer, BHEL may proceed to undertake the repairs of such defective works, by itself, without prejudice to any other rights and recover the cost incurred for the same along with 5% overheads from the Security Deposit.

12. Clause 2.13 of GCC is revised as below:

2.13 SECURED RECOVERABLE ADVANCES:

2.13.1 INTEREST FREE MOBILIZATION ADVANCE: Competent Authority of BHEL may approve proposals for payment of Interest Free Secured Mobilization Advance (limited to a maximum of 5% of the Contract Value) only in Installation Works in Power Plants under exceptional circumstances.

Interest Free Mobilization Advance shall be disbursed in specifically mentioned stages of major resource mobilization in the beginning of the contract, as specified in the TCC, in three or more instalments with the value of any instalment not more than 2.5% of the Contract Value. The next instalment will be due only on completion of the activities linked to the previous instalment.

Each such instalment is to be secured through BG of 100% of the instalment amount.

Recovery of Interest Free Secured Advance shall be made @ 10% of Running Bill Amount. As and when the total recovered amount exceeds any of the BG value submitted against the advance, that BG shall be returned.

In any case, Interest Free Advance shall be fully recovered by the time the contract reaches 50% of the original contract period either from Running Bills or by the Contractor directly depositing the amount. If
the Contractor fails to deposit the total amount by the stipulated date, the recovery shall be made by encashing BGs/ Securities available with BHEL for the balance amount.

2.13.2 INTEREST BEARING ADVANCE:

2.13.2.1 INTEREST BEARING MOBILIZATION ADVANCE: Competent authority may also approve need based Interest Bearing Mobilization advance after a certification from the Contractor for having achieved a financial progress of 10% of the original contract price. However, the total mobilization advance (including Interest Free Mobilization Advance) shall not exceed 10% of the Contract Value. Bank Guarantee towards 'Interest Bearing Recoverable Advance' shall be 110% of the advance so as to enable recovery of not only principle amount but also the interest portion, if so required.

2.13.2.2 INTEREST BEARING SECURED ADDITIONAL INTERIM ADVANCE: In exceptional circumstances, with due justification, Competent Authority of BHEL may approve proposals for payment of additional interim interest bearing advance against Bank Guarantee, for resource augmentation towards expediting work for project implementation. Contractor shall establish the utilization of advance drawn in the form of Utilization Certificate before the release of next installment.

Bank Guarantee shall be 110% of the advance so as to enable recovery of not only principle amount but also the interest portion, if so required. Unadjusted amount of advances (including Interest Free Mobilization Advance) paid shall not exceed 10% of the total contract value at any point of time.

NOTES for INTEREST BEARING ADVANCE:

(a) Recovery of Interest Bearing Advances shall be made from the Running Bills progressively. Recovery rate per month for Interest Bearing Advances shall be the sum of:
   i) Not less than 10% of Running Bill amount
   ii) Simple interest up to the date of RA Bill on the outstanding Principle amount/amounts

(b) In any case, Interest Bearing Advance shall be fully recovered by the time the contractor's billing reaches 90% of contract value either from Running Bills or by the Contractor directly depositing the amount. If the Contractor fails to deposit the total amount by the stipulated date, the recovery shall be made by encashing BGs/ Securities available with BHEL for the balance amount along with interest.

(c) Payment and recovery of any of the above advance(s) shall be at the sole discretion of BHEL and shall not be a subject matter of arbitration.

(d) The rate of interest applicable for the above advances shall be the repo rate prevailing on the date of release of advance plus 4%, and such rate will remain fixed till the total advance amount is recovered.

(e) Contractor to submit Bank Guarantee as per prescribed formats for each of the advance and shall be valid for at least one year or the recovery duration whichever is earlier. In case the recovery of dues does not get completed within the aforesaid BG period, the contractor shall renew the BG or submit fresh BG for the outstanding amount, valid for at least one year or the remaining recovery duration whichever is earlier. For each advance, the Contractor will be allowed to submit more than one BG so that the BGs can be returned progressively based on recovered amount. In case, the Contractor prefers to submit single BG against an advance, the amount of BG may be progressively reduced by the amount repaid by the Contractor.

(f) BHEL is entitled to make recovery of the entire outstanding amount in case the contractor fails to comply with the BG requirement.

2.13.3 SECURED ADVANCE AGAINST MATERIAL BROUGHT TO SITE:

Secured advance on the security of materials (which are not combustible, fragile or perishable in nature) brought to the site but not yet incorporated in the works will be made up to 75% of Invoice value, or the 75% of the corresponding value of the materials determined on the basis of BOQ rates, whichever is less, subject to the condition that their quantities are not excessive and shall be used within a period of 90 days and subject to the stipulations, as mentioned below:

(i) Contractor shall obtain prior permission of Engineer-in-charge before procurement of materials against which advance is being sought. Engineer-in-charge shall ensure formal approval of Construction Manager before communicating the permission to Contractor.

(ii) Secured advance shall not be allowed/ payable for materials procured by Contractor before the date of such permission.

(iii) Secured Advance shall be allowed only once against a single invoice. Multiple Secured Advance against single invoice is not allowed.

(iv) Secured advance against materials shall be paid only against non-perishable items. Engineer-in-charge to ensure that such items are adequately covered under insurance cover (to be taken by the Contractor if not covered under BHEL Insurance Policy).

(v) At any point of time, the unadjusted secured payments against material brought to site shall not be more than 5% of the Contract Value.

(vi) The advance will be repaid from each succeeding Running bill(s) to the extent materials for which advance has been previously paid have been incorporated into the works. In any case, such advance payment shall be fully recovered maximum from 3-4 subsequent RA bills whether the material is consumed in the work or not. In absence of sufficient value of RA bills for making the required recovery, the Contractor shall deposit the balance amount. If the Contractor fails to deposit the total amount by the stipulated date, the recovery shall be made by encashing the Securities available with BHEL for the balance amount.

(vii) Contractor has to give a formal deed of hypothecation, drawn up on non-judicial stamp paper under which the BHEL secures a lien on the materials and is safeguarded against losses, due to the contractor postponing the execution of the work or due to the shortage or misuse of materials and against the expenses incurred on their watch and safe custody.

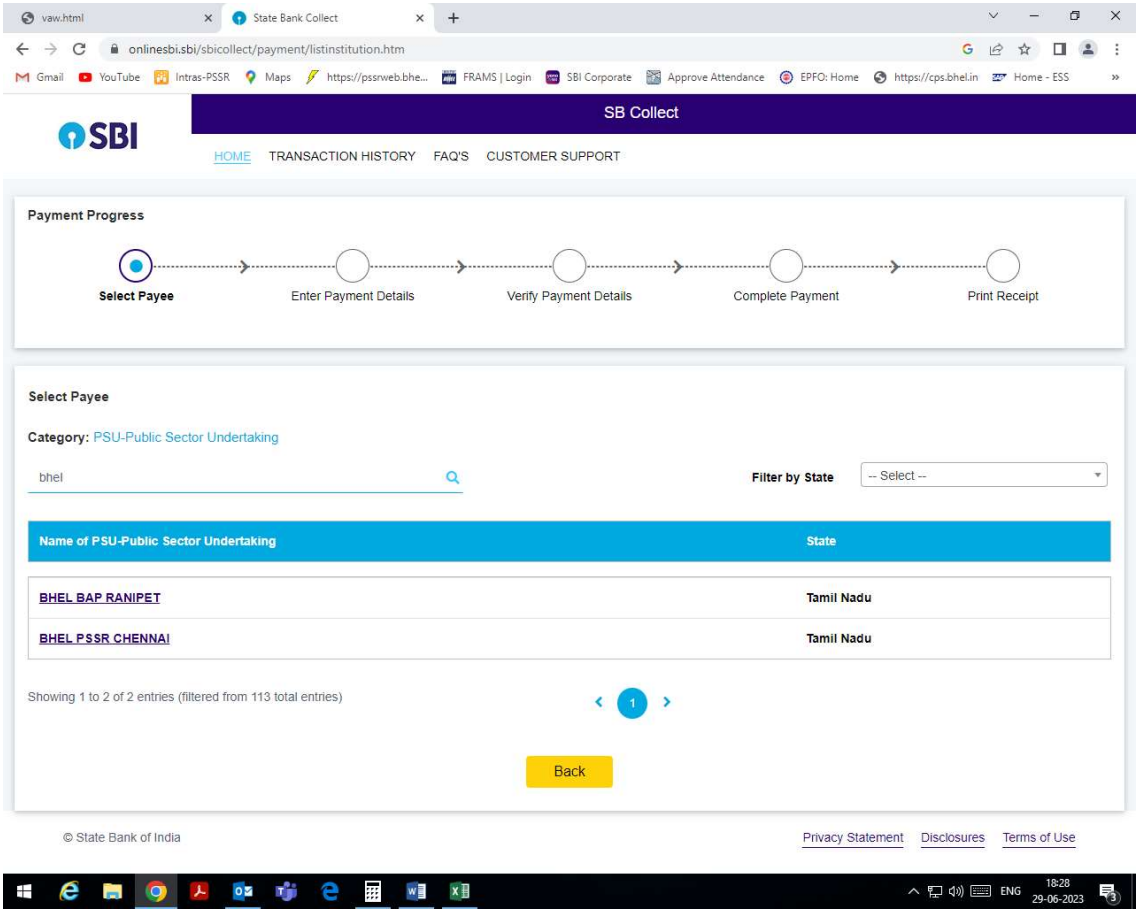
Sl. No.: 02

Detailed Instruction for EMD / Security deposits through SBI e-collect:

Step 1: Vendors may visit SBI collect website, the URL of which is https://www.onlinesbi.sbi/sbicollect where they get the home page with various categories of institutions.

Step 2: Select PSU - Public Sector Undertakings – leading to a page with list of PSUs

Step 3: Type BHEL and search, they get to see all BHEL divisions wherein they shall select BHEL PSSR Chennai. The screen shot of the same is given below.



Step 4: Select EMD receipts. Having selected the Payee in the Payment Progress, it will lead to the payment details – a drop down list of values. From that list, vendors shall select EMD receipts. Upon clicking the entry EMD receipts, a form will open asking for the remitters details and the details of the tender.

Step 5: Confirm details and pay

Fill in all the details correctly, verify the details, and complete the payment as it is leading to the payment gateway.

Step 6: Take a printout on completing the payment and enclose the copy of the same along with the bid submission. Store the copy of receipt for future reference.

Sl. No.: 03

GCC Clause 2.12.3.5 is revised as below:

The maximum amount of ORC payable for the month shall be limited to Rs 10,00,000/-

Sl. No.: 04

GCC Clause 2.15.5 is revised as below:

After eligibility of extra works is established and finally accepted by BHEL engineer/ designer, payment will be released on competent authority's approval at the following rate.

MAN-HOUR RATE FOR ELIGIBLE EXTRA WORKS: Single composite average labour man-hour rate, including overtime if any, supervision, use of tools and tackles and other site expenses and incidentals, consumables for carrying out any major rework/ repairs/ rectification/ modification/ fabrication as certified by site as may arise during the course of erection, testing, commissioning or extra works arising out of transit, storage and erection damages, payment, if found due will be at Rs 139/- per man hour.

Sl. No.: 05

GCC Clause 2.14.1 is revised as below:

2.14.1 Variation in Final Executed Contract Value

The quantities given in the contract are tentative and may change to any extent (both in plus side and minus side). No compensation becomes payable in case the variation of the final executed contract value is within the limits of Minus (-)20% of awarded contract value. Also, no compensation becomes payable in case the contract gets partially executed/ short closed/terminated/ work withdrawn under Rights of BHEL mentioned in Clause 2.7 of GCC. In case of work terminated / short closed under clause 2.7.4 of GCC, compensation may be considered only if BHEL receives compensation from customer.

Compensation due to variation of final executed contract value in excess of the limits defined in clause above, shall be as follows:

i) In case the finally executed contract value reduces below the lower limit of awarded Contract Value due to quantity variation specified above, the Contractor will be eligible for compensation @ 15% of the difference between the lower limit of the awarded contract value and the actual executed contract value.
ii) In case the finally executed contract value increases above the awarded Contract Value due to quantity variation, the Contractor is not eligible for any compensation.

Following Clauses are modified in the Special Conditions of Contract (SCC):

Sl. No.: 06

Clause No. 10.5 on RA Bill Payments, in Special Conditions of Contract (SCC), Volume- IB, Book-II, is revised as under:

"The payment for running bills will normally be released within 30 days of submission of running bill complete in all respects with all documents. It is the responsibility of the contractor to make his own arrangements for making timely payments towards labour wages, statutory payments, outstanding dues etc., and other dues in the meanwhile."

Following Clauses are added in the Special Conditions of Contract (SCC)

Sl. no. 07

6.3.4.10 Following shall be limit for the maximum quantity of BHEL issue materials that would be with the contractor at any point of time when work is in progress (excluding what has already been incorporated in the works).

SL NO	***ISSUE OF MATERIALS***	***MAX. QTY IN CONTRACTOR'S STORE***
1.	Reinforcement Steel & Earthing rod MS round	Requirement of one month
2.	Structural Steel	Requirement of one month

S. no. 08

6.3.5 ISSUE OF CEMENT

6.3.5.1 The cement issued by the BHEL shall be properly accounted (issue and reconciliation). Cement as received from the manufacturer/ stockiest will be issued free of cost to the contractor. The cement shall be provided normally in bulkers and shall be unloaded in the silos (2 Nos minimum each of 100MT capacity per batching plant) to be installed by the bidder nearer to their batching plants. Cement unloading arrangements to silo or stores, in case of cement bags and necessary manpower support shall be provided by the bidder at his own cost.

6.3.5.2 On advance request of the bidder, the cement shall be supplied in 50kg tamper proof sealed Bags for other than RCC works like masonry, flooring works etc. The theoretical weight of each bag of cement for issued purposes will be considered as 50 kg, the contractor shall be accountable for the cement issued to him on this notional weight only. No claim whatsoever will be entertained because of difference between theoretical and actual weight of the bags of cement. The empty cement bags duly accounted for against issue shall be in the custody of the contractor and the same shall be disposed by the contractor as per statutory regulation prevailing in the project.

6.3.5.3 The contractor shall submit to the engineer, a statement indicating estimated quantity of cement required during a quarter, at least two months in advance of the quarter. In addition, the contractor shall also furnish the estimated requirement of cement during a month by the third week of the previous month indicating his requirement.

6.3.5.4 Bidder is responsible for unloading the cement as soon as the arrival of cement, either in silo, if received in bulker or in the weather proof cement storage sheds, if received bags. Bagged cement shall be stored in a weatherproof sheds having dense impervious bituminous or concrete floors which shall be kept swept clean at all times. The storage arrangements (to be made by the contractor at his own cost) shall be fully completed and approved by the owner before any cement is delivered to site. The construction of cement storage sheds as per the requirement of BHEL, unloading of cement bags, stacking properly in the storage sheds, removal of the sheds after the completion of the work is in the scope of bidder within the quoted price. Though the cement is unloaded directly at the contractor storage shed, it will be deemed to be considered that the cement was issued from BHEL stores. Necessary documents are to be submitted by the contractor to BHEL stores for having received cement.

6.3.5.5 The contractor shall satisfy himself of the quality and quantity of supplied cement at the time of taking delivery from BHEL stores. No claims whatsoever will be entertained by BHEL because of quality or quantity after the materials are taken by the contractor from BHEL stores. Bidder is responsible for sampling and testing of cement as per Indian Standard/ Specification/ approved quality plan in the testing laboratory established by the bidder.

6.3.5.6 Bidder is responsible for carrying out design mix as per IS 456/10262 Latest revision and specification, using the cement provided by BHEL and submit the design mix proportions for the approval of BHEL/TANGEDCO. The design/trial mix shall be carried out time to time on change of brand/type of cement supplied by BHEL and suitable adjustments on the quantity of ingredients (sand, aggregates, admixture) of the concrete to get the required workability and durability, shall be the responsibility of the bidder without any extra cost to BHEL.

6.3.5.7 Following shall be limit for the maximum quantity of BHEL issue materials that would be with the contractor at any point of time when work is in progress (excluding what has already been incorporated in the works).

Sl No	***Issue of Materials***	***Max. Qty in Contractor's Store***
1.	Cement	Requirement of one month

VOLUME-IA PART – II

CHAPTERS 2 to 7

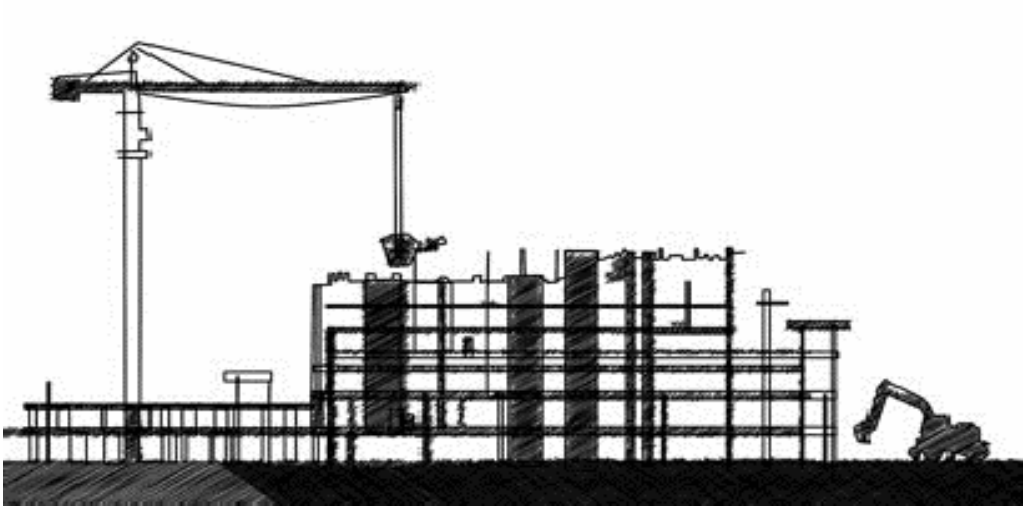
Next pages are as below

Chapter-2	"HSE Plan for Site Operations by Subcontractor" (Document No. HSEP: 14 Rev02)	131
Chapter-3	Hire Charges	13
Chapter-4	TB GA Drawings	14
Chapter-5	Technical Specifications Section - C	430
Chapter-6	Technical Specifications Section - D	380
Chapter-7	AERB Safety guideline	132

HSEP14

Health, Safety & Environment Plan for Site Operations by Subcontractors





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INDEX OF CONTENTS

SN	Description	Page No.
SECTION A: CRITICAL RESOURCES FOR HSE IMPLEMENTATION		
1	SHARING OF OPERATING COSTS OF FACILITIES	5
2	RESOURCES TO BE SOLELY PROVIDED BY CONCERNED SUBCONTRACTOR	5
3	ESTABLISHMENT OF COMMON FACILITIES	5
4	CRITICAL REQUIREMENTS W.R.T. EQUIPMENT & PPES	6
5	HSE PERSONNEL TO BE SOLELY PROVIDED BY THE SUBCONTRACTOR	8
6	COMPETENCY OF OPERATORS/ DRIVERS OF CRANE, WINCH, LIFTING/ CONSTRUCTION EQUIPMENT ETC.	11
7	STRINGENT REQUIREMENT OF BHEL'S CUSTOMER	11
8	REFERENCES	11
9	BHEL POWER SECTOR HSE MANAGEMENT SYSTEM	12
10	CLEARANCE OF MONTHLY RUNNING BILLS SUBJECT TO SAFETY COMPLIANCE	13
11	HSE PERFORMANCE EVALUATION	13
12	HSE PENALTIES	13
13	PUNITIVE ACTIONS ON WORKERS FOR CRITICAL SAFETY VIOLATIONS	16
14	LEGAL IMPLICATIONS	17
15	HSE REVIEW MEETING	17
16	OTHER REQUIREMENTS	18
17	MEMORANDUM OF UNDERSTANDING	19
SECTION B: OPERATIONAL REQUIREMENTS		
1	PURPOSE	22
2	SCOPE	22
3	OBJECTIVES AND TARGETS	22
4	BHEL HEALTH, SAFETY & ENVIRONMENT POLICY	23
5	ILLUSTRATIVE HSE RESPONSIBILITIES OF VARIOUS SUBCONTRACTOR OFFICIALS	24
6	HSE PLANNING BY SUBCONTRACTOR	27
7	MOBILIZATION OF MACHINERY/EQUIPMENT/TOOLS BY SUBCONTRACTOR	28
8	MOBILIZATION OF MANPOWER BY SUBCONTRACTOR	28
9	PROVISION OF PERSONAL PROTECTIVE EQUIPMENT (PPES)	29
10	ARRANGEMENT OF INFRASTRUCTURE	31
11	HSE TRAINING & AWARENESS	35
12	HSE COMMUNICATION AND PARTICIPATION	39
13	SAFETY DURING WORK EXECUTION	40

14	ENVIRONMENTAL CONTROL & SOCIAL RESPONSIBILITY	43
15	HOUSEKEEPING	44
16	WASTE MANAGEMENT	44
17	TRAFFIC MANAGEMENT SYSTEM	45
18	EMERGENCY PREPAREDNESS AND RESPONSE	48
19	HSE INSPECTION	49
20	TERMS AND DEFINITIONS	52
	ANNEXURES	
A	ANNEXURE A: Specification of Ambulance	
A.1	ANNEXURE A.1: Typical calculation for sharing of operational cost of common facilities	
B	ANNEXURE B: Specifications of HSE Displays	
C	ANNEXURE C: HSE Tools, Equipment and Devices to be Provided by the Subcontractor	
D	ANNEXURE D: Specifications of Rest Sheds	
E	ANNEXURE E: Minimum Requirements of Labor Accommodation/ Colony	
F	ANNEXURE F: Specifications & Availability for Toilets at Site	
G	ANNEXURE G: Specifications for Numbers and Types of Fire Extinguishers	
H	ANNEXURE H: HSE Compliance Certificate Sample	
I	ANNEXURE I: Detailed Safety Requirements/ Precautions for Various Hazardous Activities/ Conditions	
J	ANNEXURE J: Details & Contents of First-Aid Box	
K	ANNEXURE K: Vertigo Test Procedure	

SECTION A

CRITICAL RESOURCES FOR HSE IMPLEMENTATION

1. SHARING OF OPERATING COSTS OF FACILITIES

TABLE A.1

SN	FACILITY
1	Ambulance with 24 hr. First Aid Trained Driver (Specs in Annexure A)
2	Operation of Medical center, Nurses, Medical Consumables etc. (Specs in Annexure A)
3	Training Center Consumables
4	Water sprinkling for dust suppression
	(Others:)

Note:

i. Responsibility of operation of above facilities shall rest with BHEL
ii. Operating cost of the above shall be deducted from subcontractors on 'proportional to contract' value basis. Sample deduction table enclosed as Annexure A.1
iii. "Contract value" defined above & subsequently in the document shall be considered as "Awarded contract value".
iv. No overhead cost/ enabling cost of BHEL shall be levied on the contractors for common facilities.
v. These running costs shall be recovered from all the available subcontractors at site for the complete operational duration of the site
vi. No overheads shall be charged on shared operating costs

2. RESOURCES TO BE PROVIDED SOLELY BY THE SUBCONTRACTOR

TABLE A.2

SN	ITEM	SPECIFICATIONS
1.	HSE DISPLAYS, Posters and signage	Annexure B
2.	HSE Tools/ Equipment/ Devices	Annexure C
3.	Rest Sheds for Workers	Annexure D
4.	Labor Colony	Annexure E
5.	Toilets (Latrines & Urinals) - in Site and Labor Colony	Annexure F
6.	Fire Extinguishers	Annexure G

Note:

In case subcontractor fails to provide the required resources, same will be procured and deployed by BHEL with applicable overhead on total procurement cost

3. ESTABLISHMENT OF COMMON FACILITIES

In green field projects BHEL shall arrange and provide the following facilities which shall be used by all subcontractors for their employees and workers. These shall be

i. Medical Centre
ii. Safety park with facilities of audio-visual training & vertigo test center.
iii. No cost shall be deducted from the subcontractors for the structure part only.
iv. The running cost with basic inputs already mentioned at Point 1 above shall be shared by all contractors.
v. The sub-contractors shall be required to ensure participation in trainings, medical checkup and vertigo test as per the guidelines laid in this document and required as per statutory HSE requirements.

vi. However, in projects where in these facilities are not provided by BHEL, subcontractors shall ensure the training, medical/ vertigo test of all workers at site in consultation and guidance of BHEL HSE team at site in line with provisions of this document.

vii. The overall onus of compliance to HSE practices pertaining to training, medical checkup including vertigo test shall lie on the subcontractor only.

4. CRITICAL REQUIREMENTS W.R.T. EQUIPMENT & PPES

i. Conventional Hydra crane with carriage in front shall not be permitted. Pick & carry tyre mounted Front Cabin mobile crane (FX or TRX/ NextGen series of 'ESCORT" or equivalent make) shall only be permitted.

ii. Any Heavy equipment (cranes, winch machines, etc.) shall be deployed only after pre-safety Inspection by safety dept. Valid AMCs/ Fitness/ other statutory clearances as per local rules shall be required to be submitted before mobilizing the equipment at site.

iii. All other Hand tools and power tools should not be older than 5 years.

iv. For Chimney passenger lift, winch to have double drum rope for passenger and double safety devices must be used. Winch should not more than 3 years old and winch rope must be inspected with valid certificate from competent authority within 6 months and should meet the IS standard 9507 provision of OLR and push back button arrangement or dead man switch.

v. Gate pass for all the lifting T&Ps and construction machinery/ equipment shall be made after obtaining written acceptance (Pre-entry Safety Clearance) from BHEL Site Safety Department after physical verification and checking all requisite documents/ compliance to Safety norms

vi. All motor vehicles should have valid registration certificate, insurance, Pollution under control (PUC) and fitness certificate as per Motor Vehicle Act 2020. The certificates should be pasted in the glass from inside.

vii. PPEs shall be from reputed manufactures viz. 3M, Udyogi, Karam, Frontier, Freedom, Honeywell, Liberty, Bata, Nomex, Acme, Unicare, Life Gear or equivalent. In case Subcontractor recommends any other name the same can be approved at site level by the Construction manager & Site HSE

viii. For height work, where fall could result in death or disability, a secondary means of fall protection (Safety Net, Retractable Fall Arrestor etc.) shall be mandatorily provided by the subcontractor, failing which, a penalty of INR 10000 per case will be imposed. In addition, there should be constant supervision for such critical height work. Any non-erection activities at height eg. Housekeeping etc. shall also fall under the category of height work

ix. **Scaffold Tagging**

Scaffolds being erected, modified or dismantled must be tagged as suitable for use. Tagging shall be done with standard tag holder. Scaffolding tag should be certified by scaffolding inspector having valid certificate.

- **GREEN** scaffold tag- shall be fixed when scaffold is complete and safe for use, signed and dated by the scaffolding competent person daily.
- **RED** scaffold tag – to be fixed if scaffold is in some way defective and cannot be used or is still under erection.
- **YELLOW** scaffold tag – to be fixed if scaffold is in under construction/ maintenance.



FIG. A.4.1 SAMPLE SCAFFOLD TAGS AND TAG HOLDER

x. **T&P Color Coding:**

a. Inspections and tests shall be documented by means of color coding which shall verify that inspections or testing are current and that all receptacles, portable Power tools, Lifting Tools & Tackles have been inspected and tested as required. The color codes used on the project shall be:

GREEN	BLUE	YELLOW	PURPLE
January	April	July	October
February	May	August	November
March	June	September	December

TABLE. A.4.2: T&P COLOR CODES

b. The cycle of colors shall be Quarterly as a minimum or as decided by BHEL. The color code tape / Sticker shall be clearly visible to designate the period for which the inspections and tests were conducted.

c. Following the initial inspection, the equipment must be color-coded quarterly as per color-coding instructions that will be issued by the subcontractor.

d. Fire extinguisher with the current month color-coding inspection sticker must be provided and secured in the platform.

e. All slings shall be regularly inspected in accordance with the requirement of the project for frequent and periodic inspections and discard immediately if they fail to meet the minimum requirements of the project.

f. The Subcontractor's HSE Officer shall ensure that all PPE is inspected prior to its issue. He is to ensure all subcontractor personnel are using safe and proper PPE equipment. Regular

inspections on the PPE shall be carried out and personnel not adhering to those inspections shall be removed immediately from the site.

g. A Ten (10) day interval period shall be given into each monthly color code change. During this Ten (10) day period either color shall be acceptable.

xi. **T&P Tagging:**

All deployed Wire Rope Slings, Chain Pulley Blocks, Hooks, slings etc. shall be Tagged using aluminum or any other metal tag with punching.

5. HSE PERSONNEL TO BE PROVIDED SOLELY BY THE SUBCONTRACTOR

5.1. NUMBERS OF HSE PERSONNEL (APPLICABLE FOR EACH WORK SHIFT)

Number of HSE Officers and Supervisors shall be in proportion to number of workers as per Table A.6 below

TABLE A.5

No. of Workers	No. of HSE Supervisors	No. of HSE Officers
Up to 100	1	1
101 to 250	2	1
251 to 500	4	1
501 to 1000	6	2
1000 to 2000	6+ One additional supervisor up to every additional 250 workers	3
2000-3000	10+ One additional supervisor up to every additional 250 workers	4
3000-4000	14+ One additional supervisor up to every additional 250 workers	5

5.1.1. DEPLOYMENT PLAN

i. Above requirement is for every shift for each unit.

ii. The dynamic deployment plan of Safety manpower at various locations containing names, areas, time periods, shifts etc. shall be submitted to BHEL for approval by subcontractor

iii. BHEL may modify the deployment plan based on nature and volume of jobs, Risks and hazards associated etc.

iv. For less than 20 workers HSE Officer is not mandatory. In case the number of workers exceed 20 for 3 consecutive months, HSE Officer is to be engaged. The HSE Officer shall be deployed for a minimum period of 6 months even if the number of workers fall below 20 in any month subsequent to deployment. If within that 6-month period, the number of workers is more than 20 for at least 3 months, the deployment duration of HSE Officer will extend further 6 months after completion of previous 6-month period.

v. For Site Material Management/ Handling (Loading/ Unloading) contracts, 1 no. HSE Officer shall be required irrespective of the total manpower deployed.

vi. HSE Officers/Supervisors of all the vendors may be required to report directly to BHEL HSE Officer at site & shall comprise as a total team for handling all HSE issues. However, each safety officer/ agency shall be individually responsible for the safe execution of work in their respective areas.

5.2. Qualification & Experience Requirements Of HSE Personnel

5.2.1. HSE Officer

First HSE Officer to be mandatorily as per Option I as under and shall be designated Senior HSE Officer. In case of non-availability of HSE Officers with Option I configuration, the subsequent HSE Officers can be as per Option II below with recorded reasons and approval of Site Construction Manager of BHEL. All these deviations should be reported to Region HSE and PSHQ HSE.

A. Option I

i. possesses a recognized degree in any branch of engineering or technology or architecture and had a practical experience of working in a building or other construction work in a supervisory capacity for a period of not less than two years or possesses a recognized diploma in any branch of engineering or technology and has had practical experience of building or other construction work in a supervisory capacity for a period of not less than five years;

ii. possesses a recognized degree or diploma in industrial safety with at least one paper in construction safety (as an elective subject/ part thereof);

iii. has adequate knowledge of the language spoken by majority of building workers from the construction site in which he is to be appointed.

B. Option II:

Graduation Degree in Science with Physics & Chemistry and degree or diploma in Industrial Safety (All Degrees/ Diploma from any Indian institutes recognized by AICTE or State Council of Technical Education of any Indian State) with practical experience of working in a building, plant or other construction works (as HSE Officer, in line with Indian Factories Act, 1958 or BOCW Act, 1996) for a period of not less than five years

Note:

i. HSE Officer as per Option II shall be valid only on availability of Senior HSE Officer as per Option I at site.

ii. In case of resignation of the Senior HSE Officer, the same has to be replaced within 15 days else all subsequent HSE Officers as per Option II (in case of multiple HSE Officers with a single agency) shall not be considered as valid.

iii. The penalty shall be deducted considering non-availability of any HSE Officer at site.

5.2.2. HSE Supervisor: Either of X or Y below

X. Recognized Degree in any branch of Engineering OR Diploma in any branch of engineering with at least one-year construction experience

OR

Y. A recognized graduation Degree in Science (with Physics & Chemistry) or a recognized diploma in Engg. or Tech.

Additional requirements for option (Y) above

i. Trained in fire-fighting as well as in safety / occupational health related subjects, with:
ii. Minimum Two years of practical experience in construction work environment or in the field of safety and

Note:

i. Option a above is by default, b is under special approval from Site HSE & Construction manager
ii. In both cases the candidate should possess requisite skills to deal with construction & fire safety related day-to-day issues.

5.3. HSE In-Charge

In case there is more than one HSE Officer with any subcontractor, one of them, who is senior most by experience & meets qualification as per option 1 as mentioned in clause 2.1 A above (in HSE discipline), may be designated as HSE In-charge who will be the nodal point of contact on HSE matters.

5.4. Supporting Staff To HSE Team

i. Supporting Staff shall include scaffolders, scaffolding inspectors, riggers, skilled and unskilled manpower
ii. Subcontractor shall provide adequate number of workers as and when required, in order to attend and comply to Safety observations raised by BHEL/ Customer.

5.5. Availability And Penalty For Non-Deployment

i. The subcontractor shall submit the certificates of qualification & experience of HSE manpower before deployment for BHEL to assess suitability as per requirement detailed in this document
ii. In case of rejection, subcontractor shall arrange additional candidates and submit resume to BHEL. Penalties will be applicable during the period of non-deployment in such cases as well.
iii. Subcontractor shall ensure physical availability of safety personnel at the place of specific work locations.
iv. The Subcontractor shall deploy the HSE Officers as per the site's requirement. Non-deployment shall lead to stoppage of the work and final decision shall rest with Site HSE & Construction manager.
v. The Subcontractor shall prepare an organization chart identifying the areas of operations, responsibilities and reporting structure of all safety personnel for each shift and submit the same to BHEL.
vi. The subcontractor shall deploy sufficient HSE Officers, supervisors, as per numbers & qualifications mandated in this Section since mobilization of first batch of manpower and add more in proportion to the added strength in work force. Any delay in deployment will attract a penalty at following rates:

Non-deployment of HSE Officer –	Rs. 75,000 per man-month
Non-deployment of HSE Supervisor –	Rs. 50,000 per man-month

vii. Penalty shall be collected for the period of non-availability of safety personnel after allowing a grace period of 15 days for finding a replacement. The same shall be deducted on pro-rata basis till the required manpower is deployed.

viii. In case of abnormal delay & frequent rejections of candidates proposed by the subcontractor, BHEL shall exercise the right to deploy the safety manpower & deduct the amount from subcontractor's running bill with applicable overheads. In such cases also, the provision of logistics, transportation, food and other logistical support to the HSE personnel shall be in the scope of subcontractor in addition to the salary. After deployment of manpower by BHEL, the penalty for non-deployment specified above shall not be applicable.

6. COMPETENCY OF OPERATORS/ DRIVERS OF CRANE, WINCH, LIFTING/ CONSTRUCTION EQUIPMENT ETC.

i. The Operators/ Drivers of crane, winch, construction/ lifting equipment etc. shall be experienced and have valid driving license for the class of vehicle / machinery as applicable (like Crane/ Forklift/ Rig, Construction equipment driving license etc.).

ii. Minimum HMV driving license is required for all heavy equipment/ heavy vehicle (trailer/ Hyva /dumper /TM) operators at site.

iii. The subcontractor shall certify competence of these persons in writing as and when they are posted at site.

iv. Crane, Winch, Construction & lifting equipment operator should have certificate on subject course or experience certificate in employer letterhead.

v. Where state is providing license for operating crane, tractor and other construction vehicles, same to be ensured.

Note: In case the statutory requirements i.e. State or Central Acts and / or Rules as applicable like the Building and Other Construction Workers' Regulation of Employment and Conditions of Service- Act,1996 or State Rules (wherever notified), the Factories Act, 1948 or Rules (wherever notified), etc. are more stringent than above, the same shall be followed.

7. In case of any stringent requirement of BHEL's customer over and above the specifications mentioned in current document, the same shall also be required to be complied at site by subcontractor.

8. REFERENCES

The Safety Rules for Construction & Erection as outlined hereunder, while setting out a broad parameter of safety norms, are not exhaustive. The subcontractor and his agencies are advised to refer to the following statutory provisions as amended from time to time for details and strict compliance therewith.

8.1. FOR GREENFIELD PROJECTS

a) Building and Other Construction Workers (regulation of employment and conditions of service) Act, 1996 (briefly referred to as BOCW Act),
b) Building and other construction workers (regulation of employment and conditions of service) Central Rules, 1998 (briefly referred to as BOCW Rules) as adopted by the various State Governments,

8.2. For Expansion, Modification, Alteration and, Or Construction Activity Within An Existing Plant Operating As Per Approved Site Plan Under The Factories Act

a) Factories Act, 1948,
b) Factories Rules, as adopted by the various State Governments
c) BOCW Act
d) BOCW Rules
e) In case a new act/ statutory guideline/ modification/ consolidation of acts is implemented the same shall be required to be adhered by the subcontractor.
f) The latest amendment of the above-mentioned acts/ rules shall be followed at site.

9. BHEL POWER SECTOR HSE MANAGEMENT SYSTEM

The Systems and procedures of BHEL Power Sector HSE Management System shall be implemented by the subcontractor, including:

- HSE Procedure for Register of OHS Hazards and Risks
- HSE Procedure for Register of Environmental Aspects and Impacts
- HSE Procedure for Register of Regulations
- HSE Procedure for Training and Awareness
- HSE Procedure for Emergency Preparedness and Response Plan
- HSE Procedure for Permit to Work
- HSE Inspection and Other Formats

Note:

i. BHEL reserves the right to revise/ update these systems and procedure as per requirement to address any changing HSE needs

ii. BHEL will provide hard / soft copies of applicable HSE Procedures, Work Permits, Operational Control Procedures, Inspection/ Other Formats etc. that are necessary for ensuring safe work to the successful bidder at Site. It is the responsibility of the subcontractor to ensure availability of these documents before commencing work at site.

iii. The subcontractor can get soft copies of these documents from respective Region SCT/ HSE for reference. The signed hard copies of the same shall not be required to be submitted along with tender document

iv. Subcontractor shall use the Digital (Web & App-Based) HSE management Software Systems provided by BHEL whenever provided. In case not provided, hard copy systems will continue to be used. All information technology resources (Computers, mobile phones, mobile data, internet access etc.) for the use of such systems shall be ensured by the subcontractor.

10. CLEARANCE OF MONTHLY RUNNING BILLS SUBJECT TO SAFETY COMPLIANCE

i. The monthly running Bills of the subcontractor shall be released subject to compliance to HSE requirements as per checklist in Annexure H
ii. BHEL site HSE Head and Package In-charge shall be authorized to issue the clearance
iii. Site Construction Manager of BHEL shall be the final authority on the matter.

11. HSE PERFORMANCE EVALUATION

i. Subcontractor shall be assessed on monthly basis for HSE Compliance by BHEL Safety In-charge at site.
ii. The HSE evaluation shall be based on HSE Performance Evaluation System of BHEL covering the contractual, statutory and regulatory requirements of HSE.
iii. BHEL shall reserve the right to use these performance scores for evaluating bidder's capacity for future tenders
iv. If safety record of the subcontractor in execution of the awarded job is to the satisfaction of safety department of BHEL, issue of an appropriate certificate to recognize the safety performance of the subcontractor may be considered by BHEL after completion of the job, provided the execution performance is satisfactory.

12. HSE PENALTIES

i. Nonconformity of safety rules and safety appliances will be viewed seriously and BHEL has right to impose fines on the subcontractor for every instance of violation noticed.
ii. As per contractual provision HSE penalties shall be imposed on subcontractors for non-compliance on HSE requirement as per following format.
iii. Following are the applicable penalties for various Safety violations:

Sub: MEMO for Penalty for non-compliances in Safety

Following lapse (tick marked) was observed and penalty (in Rs.) is imposed as stated at the bottom of this memo. It is requested that such occurrences be please avoided in future.

S. No	Nature of Non - Compliance	Penalty (in INR)	Remarks
A. System Violations			
1	Working without valid Work Permit/ HIRA/ Method Statement / JSA	2000	Per case
2	Controls as per Work Permit/ HIRA/MS/JSA not ensured	2000	Per case
3	Reported Safety Violations Not Closed within Stipulated Time	1000-10000	Per case
4	Absence of required Subcontractor Officials (Site Head, HS Head) in Safety Reviews/Meetings	5000	Per case
5	Not providing required PPEs (Safety Harness, Lifeline, Safety Net, Fall arrestor, Safety Helmet, Gloves, Shoes etc.) for the work by subcontractor	2000	Per case
B. Competency/ Training/ Induction Violations			

1	Incompetent personnel deployed for specialized jobs like height work, hot work, rigging, vehicle operation etc. (without valid license/ certificate etc.)	3000	Per case
2	Work without induction training & medical check	2000	Per case
3	Height Work without Vertigo Test and height work training	2000	Per case
C. PPE Violations – Height Work			
1	Not wearing/ hooking Double Lanyard Safety Harness while working at height (> 1.2 meters) or not anchoring to lifeline	1000	Per case
2	Not Providing Lifeline for height work	3000	
3	Unsafe platforms – without Top, Mid Rails and Toe-Guards for Height Work	3000	
4	Not providing secondary means of fall protection for height work (Safety Nets, Retractable Fall Arrestors etc.)	3000	Per case
D. PPE Violations – General			
1	Not wearing safety helmet	1000	Per case
2	Wearing of helmets without chin straps	1000	Per case
3	Not Wearing safety shoes	500	Per case
4	Not wearing gloves	500	Per case
6	Not using grinding goggles/ face shield during grinding/ cutting	2000	Per case
E. Electrical Safety Violations			
1	Broken/ exposed wires/ cables	2000	Per case per day
2	Electrical plug not used for connection/ hand machines	1000	Per case per day
3	Not using proper ELCBs for electrical equipment	2000	Per case per day
4	Improper earthing of welding & Other electrical machines (Lack of double earthing, improper/ untested earth pit etc.)	2000	Per case per day
5	Not using 24 V supply for lighting in confined spaces	2000	Per case
6	Cables haphazard/ blocking way/ not organized properly	1000	Per case per day
F. Lifting & Rigging Violations			
1	Using Sling/ Chain Pulley Block and other Small T&Ps without proper, traceable Tag and Test Certificate	2000	Per T&P per day
2	Using damaged slings or not slinging properly	2000	Per T&P per day
3	Use of lifting equipment without having valid Test certificate	5000	Per equipment per seven days
4	Lifting hooks used without latches	2000	Per hook per day
5	Not effectively barricading area below lifting activity	5000	Per case
6	Using untrained/ unqualified rigger	5000	Per case
G. Housekeeping			
1	Non-removal of scrap from platforms	5000	Per Event Per location per 7 days
2	Not conducting scheduled housekeeping drives	5000	Per drive
H. Hot Work Safety Violations			
1	Gas cutting without flash back arrestor at both ends	5000	Per machine per incidence
2	Gas cutting at height without fire blanket	2000	Per event

3	Not keeping gas cylinders vertically	2000	Per event
4	Lifting cylinders without cage or rolling of cylinders	2000	Per incidence
5	Leakage in gas cylinder	2000	Per incidence
I. Vehicle Safety/ Operation			
1	Not having valid driving license for the type of vehicle/ T&P	2000	Per driver per incidence
2	Two-wheeler entry in construction area	2000	Per vehicle
3	Using Hydra for material movement at site in unsafe manner	2000	Per case
4	Using Two Hydra in Tandem for material movement without proper precautions as per OCP	2000	Per case
5	Vehicles, Hydras, Cranes, Dumpers and Earth Movers not having automatic back horns linked to gear	2000	Per Equipment per day
6	Not providing proper hard barricades around excavations/ unpermitted areas	5000	Per location per day
7	Not using guide rope while transporting material using Hydra or Cranes	2000	Per event
8	Over speeding	5000	Per case
9	Using Conventional Hydra crane	50000	Per day /crane
J. Accidents/ Incidents/ Near Misses			
1	Non-reporting of Near Miss/ Incident	20000	Per case
2	Major Accident – Worker unable to resume work within 48 hrs	100000	Per incident
3	Fatal Accident	500000	Per incident
K. Miscellaneous			
1.	Not providing the facility (drinking water, rest shed, labor colony etc. as per the specifications/ requirement)	5000	Per month per violation
2.	Not nominating the required number of workers for training as per plan	5000	Per incidence
3.	Lack of proper arrangement for disposal of sewage/ waste water/ effluents etc.	10000	Per incidence

Details (if any) related to non- compliance (Name of persons, Nature of deficiency, etc.):

_____
_____
_____

Penalty Amount:

1. Rate as per above chart
2. No. of Persons/ machine/ event/ labor
3. No. of times the same error is repeated: Repetition factor
4. Total Penalty= 1. X 2. X 3. =

Witnessed by:

(Sub- Subcontractor representative) (BHEL representative)

Signature _____

_____

Name _____

_____

Distribution: 1 Copy: to Sub- subcontractor Site In-charge,
1 Copy to Site Construction Manager (BHEL)
1 Copy to Site Finance

Note:

i. In case the amount of penalty imposed by BHEL's Client on BHEL for Safety violation/ incident due to or in the area of the subcontractor is more than those indicated above, same shall be imposed back-to-back on the subcontractor. However, in case such an amount is less than the specified above, penalty amount indicated above shall be imposed on the subcontractor.

ii. For same violation only one penalty (higher of the two mentioned below) shall be applicable
   a. Penalty imposed by BHEL's Customer over BHEL.
   b. Penalty as indicated in current document.

iii. For repeated violation for the same equipment/ location, the penalty would be double of the previous penalty. Date of "Repeated violation" will be counted from subsequent days.

iv. For repeated fatal incident in the same Unit incremental penalty shall be imposed: The subcontractor will pay 2 times the previously paid penalty in case there is repeated major/ fatal incident under the same subcontractor for the same package in the same unit.

v. Any other non-conformity noticed not listed above will also be fined as deemed fit by BHEL. The decision of BHEL engineer is final on the above.

vi. If principal customer/statutory and regulatory bodies impose some penalty on HSE due to the non-compliance of the subcontractor the same shall be passed on to them.

vii. The penalty amount shall be recovered by BHEL Finance department from subcontractors from the RA/Final bill.

13. PUNITIVE ACTIONS FOR "CRITICAL SAFETY VIOLATIONS":

"Critical Safety Violations" include:

i. Not wearing required PPEs when provided and not following safe work procedure

ii. Taking unnecessary risks especially in height work, hot work, radiation work, lifting activity

iii. Coming to work under influence of sedatives like alcohol, drugs etc.

iv. Coming to work without ID Card/ Gate Pass (if provided)

v. Intimidating/ threatening at work

vi. Using cell phones during height work, hot work, lifting activity, driving.

In case any worker carries out any of the critical safety violations as above, BHEL reserves the right to enforce punitive action in following manner:

First Offence:	1 Punch on Gate Pass/ Induction Card/ ID Card etc. and 1-hour HSE Training. With one day off from duty
Second Offence:	2 Punches and 2-hours HSE Training with one day off from duty

Third Offence:	3 Punches and the worker will be dismissed. Gate pass to be confiscated

In case any employee of subcontractor carries out any of the critical safety violations as above, subcontractor Site In-charge shall issue warning letter to concerned employee with copy to BHEL

Note:

i. For above violations, guilt of the worker/ employee has to be established through appropriate evidences and records maintained.

ii. If worker/ employee has not been given the required PPEs and safety equipment by the agency and/or not facilitated by the agency to follow safety rules, he/ she will not be considered liable but the agency will be penalized as per penalty provision in this document. In such cases, the subcontractor shall not pass the penalty over to the worker/ employee through wage deduction etc.

iii. These critical safety violations and their consequences shall be shared with all workers and employees during induction and other training programs/ meetings, toolbox talks etc.

iv. Gate Pass shall have provision of Tagging as indicated above

v. The appellate authority (only for final dismissal) in this case shall be the BHEL Site In-charge whose decision shall be final on the matter and binding on all parties.

14. LEGAL IMPLICATIONS

Any legal Costs incurred by BHEL, on account of accidents taking place in the activities of the subcontractor, shall be debited to the subcontractor on actual cost basis.
For any accident occurring at site to any worker/ employee of the subcontractor leading to legal implications to BHEL Employee/ Management shall be safeguarded by BHEL legal department. All legal expenses incurred by BHEL on this account shall be recovered from the subcontractor. The accident also includes fire, loss of property or life at site.

15. HSE REVIEW MEETING

i. Subcontractor Site In-charge and HSE In-charge shall attend the HSE Review Meeting as and when called by BHEL.
The indicative agenda points are given below:

a) Implementation of earlier MOM points
b) Compliance Status of HSE Observations
c) Incidents & Near Misses, their Root Causes and Actions Taken
d) HSE performance review
e) HSE inspection findings
f) HSE audit and CAPA
g) HSE training
h) Health check-up camp
i) HSE planning for the erection and commissioning and installation activities in the coming month

j) HSE reward and promotional activities

ii. MOM on the discussion along with HSE observations will be circulated to the subcontractor for action.

iii. The subcontractor shall close the observations to the satisfaction of BHEL within stipulated time frame

16. OTHER REQUIREMENTS

i. If the subcontractor fails to improve the standards of safety in its operation to the satisfaction of BHEL after being given reasonable opportunity to do so and/or if the subcontractor fails to take appropriate safety precautions or to provide necessary safety devices and equipment or to carry out instruction regarding safety issued by BHEL, BHEL shall have the right to take corrective steps and the cost shall be debited to the subcontractor with applicable overheads.

ii. If the subcontractor succeeds in carrying out its job in time without any fatal or disabling injury incident and without any damage to property BHEL may, at its sole discretion, favorably consider to reward the subcontractor suitably for the performance.

iii. In case of any damage to property due to lapses by the subcontractor, BHEL shall have the right to recover the cost of such damages from the subcontractor after holding an appropriate enquiry.

iv. The subcontractor shall take all measures at the sites of the work to protect all persons from incidents and shall be bound to bear the expenses of defense of every suit, action or other proceeding of law that may be brought by any persons for injury sustained or death owing to neglect of the above precautions and to pay any such persons such compensation or which may with the consent of the subcontractor be paid to compromise any claim by any such person, should such claim proceeding be filed against BHEL, the subcontractor hereby agrees to indemnify BHEL against the same.

v. The subcontractor shall not employ men below the age of 18 years and women on the work of painting with products containing lead in any form. Wherever men above the age of 18 are employed on the work of lead painting, overalls shall be supplied by the subcontractor to the workmen and adequate facilities shall be provided to enable the working painters to wash during the cessation of work.

vi. The subcontractor shall notify BHEL of his intention to bring to site any equipment or material which may create hazard.

vii. BHEL shall have the right to prescribe the conditions under which such equipment or materials may be handled and the subcontractor shall adhere to such instructions.

viii. BHEL may prohibit the use of any construction machinery, which according to the organization is unsafe. No claim for compensation due to such prohibition will be entertained by BHEL.

17. MEMORANDUM OF UNDERSTANDING:

After award of work, subcontractors are required to enter into a memorandum of understanding as given below:

Memorandum of Understanding

BHEL, Power Sector Region is committed to Health, Safety and Environment Policy (HSE Policy).

M/s……..do hereby also commit to comply with the same HSE Policy while executing the Contract Number _____

M/s……..have gone through and understood all the HSE requirements of the contract including HSE manpower, tools & equipment, systems & procedures, and agree to fulfill the same as a minimum. Any additional resources and support required for ensuring fulfillment of HSE Objectives shall be provided by subcontractor at no extra cost.

M/s…….. agree that in case they fail to comply to the HSE requirements as stipulated in the contract, BHEL shall have the right to implement the same and the cost shall be recovered from the subcontractor with applicable overheads.

M/s…….. shall ensure that safe work practices as per the HSE plan. Spirit and content therein shall be imbibed in all workers and supervisors for compliance.

In addition to this, M/s……..shall comply to all applicable statutory and regulatory requirements which are in force in the place of project and any special requirement specified in the contract document of the principal customer.

M/s……..shall co-operate in HSE audits/inspections conducted by BHEL /customer/ third party and ensure to close any non-conformity observed/reported within prescribed time limit.

M/s…….. agree that the subcontractor shall seek HSE clearance as per BHEL format before each RA bill as mentioned in clause no. 9. The penalty amounts for not providing Safety manpower and various Safety violations have also been reviewed and agreed.

M/s…….. agree to share the HSE Costs (running costs) of common facilities created by BHEL on proportional to contract value basis as calculated at Site by BHEL.

Signed by authorized representative of M/s ----------

Name :

Place & Date:

SECTION B

OPERATIONAL REQUIREMENTS

1. PURPOSE:

1.1. The purpose of this HSE Plan is to provide for the systematic identification, evaluation, prevention and control of general workplace hazards, specific job hazards, potential hazards and environmental impacts that may arise from foreseeable conditions during installation and servicing of industrial projects and power plants.

1.2. This document shall be followed by BHEL's subcontractors at all installation and servicing sites. In case customer specific documents are to be implemented, this document will be followed in conjunction with customer specific documents in complementary manner.

1.3. Although every effort has been made to make the procedures and guidelines in line with statutory requirements, in case of any discrepancy wherein the relevant statutory guidelines supersedes this document, the same shall be followed.

1.4. In case there's any specific HSE requirement from BHEL's Client, not explicitly indicated in this document the same shall be required to be fulfilled as per the decision of BHEL Site construction manager.

2. SCOPE:

The document is applicable to BHEL's Subcontractors at all installation / servicing activities of BHEL Power Sector as per the relevant contractual obligations

3. OBJECTIVES AND TARGETS:

i. To achieve "Zero Incident at Site"
ii. 100% compliance to all legal/statutory requirements related to EHS.
iii. 100% Health, Safety and Environmental Induction training attendance for all workers.
iv. 100% High Risk activities to be carried out only after approved Method Statement, HIRA / Aspect-Impact / JSA / OCP and Permit to Work are implemented.
v. 100% PPEs compliance in high and medium risk activities.
vi. 100% incident reporting, recording and reviewing for corrective actions.
vii. Regular Safety Reviews to assess HSE program compliance and closure of any recognized gaps to improve safety management and incident prevention
viii. Prevent injury and ill health of all workers at site ('Workers' refers to all personnel including managerial, supervisory, professional, technical, clerical and other workers including contract laborers)
ix. Prevent pollution to environment
x. Ensure the Health and Safety of all persons at work site is not adversely affected by the work.
xi. Ensure protection of environment of the work site.
xii. Comply at all times with the relevant statutory and contractual HSE requirements.
xiii. Provide trained, experienced and competent personnel. Ensure medically fit personnel only are engaged at work.
xiv. Provide and maintain plant, places and systems of work that are safe and without risk to health and the environment.

xv. Provide all personnel with adequate information, instruction, training and supervision on the safety aspect of their work.
xvi. Effectively control, co-ordinate and monitor the activities of all personnel on the Project sites including subcontractors in respects of HSE.
xvii. Establish effective communication on HSE matters with all relevant parties involved in the Project works.
xviii. Ensure that all work planning considers all persons that may be affected by the work.
xix. Ensure fitness testing of all T&Ps/Lifting appliances like cranes, chain pulley blocks etc. are to be certified by competent person.
xx. Ensure timely provision of resources to facilitate effective implementation of HSE requirements.
xxi. Ensure continual improvements in HSE performance.
xxii. Ensure conservation of resources and reduction of wastage.
xxiii. Capture the data of all incidents including near misses, process deviation etc. Investigate and analyze the same to find out the root cause.
xxiv. Ensure timely implementation of correction, corrective action and preventive action. The subcontractor shall also comply with HSE Targets stipulated by BHEL from time to time.

4. BHEL HEALTH, SAFETY & ENVIRONMENT POLICY:

In BHEL, Health, Safety and Environment (HSE) responsibilities are driven by our commitment to protect our employees and people we work with, community and environment. BHEL believes in zero tolerance for unsafe work/non-conformance to safety and in minimizing environmental footprint associated with all its business activities. We commit to continually improve our HSE performance by:

- Developing safety and sustainability culture through active leadership and by ensuring availability of required resources.
- Ensuring compliance with applicable legislation, regulations and BHEL systems.
- Taking up activities for conservation of resources and adopting sound waste management by following Reduce/Recycle/Reuse approach.
- Continually identifying, assessing and managing environmental impacts and Occupational Health & Safety risks of all activities, products and services adopting approach based on elimination/ substitution/reduction/control.
- Incorporating appropriate Occupational Health, Safety and Environment criteria into business decisions, design of products & systems and for selection of plants, technologies and services.
- Imparting appropriate structured training to all persons at workplace and promoting awareness amongst customers, subcontractors and suppliers on HSE issues.
- Reviewing periodically this policy and HSE Management Systems to ensure its relevance, appropriateness and effectiveness.
- Communicating this policy within BHEL and making it available to interested parties.

Chairman & Managing Director/ BHEL

5. ILLUSTRATIVE RESPONSIBILITIES OF SUBCONTRACTOR EMPLOYEES

5.1 HSE - A LINE RESPONSIBILITY

i. HSE is a “Line Responsibility”.
ii. The term "Line" includes management, Executives, Supervisors, Foremen, and Workers who are part of the workforce. Line is to be fully involved in HSE Planning & Implementation with the aid and advice of HSE organization.
iii. “Line”, having control of resources and manpower is responsible for overall implementation of HSE Systems and closure of HSE observations.

5.2 SITE IN -CHARGE:

i. Shall sign Memorandum of Understanding (MoU)
ii. Shall ensure availability of all necessary resources required for implementation of HSE at Site
iii. Shall engage qualified HSE Officer(s) and supervisors (s)
iv. Shall adhere to the rules and regulations mentioned in this code, practice very strictly in area of work in consultation with concerned engineer and the safety coordinator.
v. Shall screen all workmen for health and competence requirement before engaging for the job and periodically thereafter as required.
vi. Shall not engage any employee below 18 years.
vii. Shall arrange for all necessary PPEs like safety helmets, belts, full body harness, shoes, face shield, hand gloves etc. before starting the job.
viii. Shall ensure that all T&Ps engaged are tested for fitness and have valid certificates from competent person.
ix. Shall ensure closure of all HSE non-conformities reported by BHEL or observed during internal inspection by providing appropriate resources in a timely manner.
x. Shall ensure the implementation of provisions of applicable acts and rules pertaining to HSE.
xi. Shall ensure availability of updated (Hazard Identification and Risk Assessment) Register for the area of activity
xii. Shall ensure availability of Method Statements & Job Safety Analysis for all hazardous activities
xiii. Shall ensure necessary controls to minimize risk in all applicable hazardous activities including Height Work, Hot Work, Lifting & Rigging, Confined Space, Maintenance, excavation, Radiography, Loading/ Unloading, Drilling/ Blasting etc.
xiv. Shall ensure implementation of HSE requirements mentioned in this document and as specified in the BHEL HSE management System including training, inspection, awareness, reporting etc.
xv. Shall ensure that person working above 2.0 meter should use Safety Harness tied to a life line/stable structure.
xvi. Shall ensure a secondary means of fall protection (Safety Net, Retractable Fall Arrestor etc.) for preventing fall from height
xvii. Shall ensure that materials are not thrown from height. Cautions to be exercised to prevent fall of material from height.

xviii. Shall report all incidents (Fatal/Major/Minor/Near Miss) to the Site engineer /HSE officer of BHEL.
xix. Shall ensure that Horseplay is strictly forbidden.
xx. Shall ensure that adequate illumination is arranged during night work.
xxi. Shall ensure that all personnel working under subcontractor are working safely and do not create any Hazard to self and to others.
xxii. Shall ensure display of adequate signage/posters on HSE.
xxiii. Shall ensure that mobile phone is not used by workers while working.
xxiv. Shall ensure conductance of HSE audit, mock drill, medical camps, induction training and training on HSE at site.
xxv. Shall ensure full co-operation during HSE audits.
xxvi. Shall ensure submission of look-ahead plan for procurement of HSE equipment's and PPEs as per work schedule.
xxvii. Shall ensure good housekeeping.
xxviii. Shall ensure adequate valid fire extinguishers are provided at the work site.
xxix. Shall ensure availability of sufficient number of toilets (preferably bio-toilets) /restrooms and adequate drinking water at work site and labor colony.
xxx. Shall ensure adequate emergency preparedness.
xxxi. Shall be member of site HSE committee and attend all meetings of the committee
xxxii. Power source for hand lamps shall be maximum of 24 v.
xxxiii. Temporary fencing should be done for open edges if Hand – railings and Toe-guards are not available
xxxiv. To record all incidents including near miss and report to BHEL and to ensure analysis & corrective actions for the same
xxxv. Shall conduct weekly Safety Walks in the work area and record the findings.
xxxvi. Construction of Canteen at Site, Office Infrastructure: Printer, PC, Fire Extinguishers etc.
xxxvii. Shall analysis HSE Performance regularly in work area and take steps to improve the same
xxxviii. Shall ensure stoppage of work in case of unacceptable Safety hazards

5.3 HSE OFFICER:

i. Carry out safety inspection of Work Area, Work Method, Men, Machine & Material, P&M and other tools and tackles.
ii. Facilitate inclusion of safety elements into Work Method Statement and creation of Job Safety Analysis (JSA)
iii. (HSE Head) To prepare deployment plan of HSE personnel for all shifts, so as to ensure constant supervision of all areas. The plan to be submitted to BHEL
iv. Highlight the requirements of safety through Tool-box / other meetings.
v. Help concerned HOS to prepare Job Specific instructions/ JSA for critical jobs.
vi. Conduct investigation of all incident/dangerous occurrences & recommend appropriate safety measures.
vii. Advice & co-ordinate for implementation of HSE Systems & Procedures.
viii. To stop work in case of any critical safety violation until the violation is cleared
ix. Convene HSE meeting & minute the proceeding for circulation & follow-up action.

x. Plan procurement of PPE & Safety devices and inspect their healthiness.
xi. Report to BHEL on all matters pertaining to status of safety and promotional program at site level.
xii. Facilitate administration of First Aid
xiii. Facilitate screening of workmen and safety induction.
xiv. Conduct fire Drill and facilitate emergency preparedness
xv. Design campaigns, competitions & other special emphasis programs to promote safety in the workplace.
xvi. Apprise BHEL on safety related problems.
xvii. Notify site personnel non-conformance to safety norms observed during site visits / site inspections.
xviii. Recommend to Site In charge, immediate discontinuance of work until rectification, of such situations warranting immediate action in view of imminent danger to life or property or environment.
xix. To decline acceptance of such PPE / safety equipment that do not conform to specified requirements.
xx. Encourage raising Near Miss Report on safety along with, improvement initiatives on safety.
xxi. Shall work as interface between various agencies such customer, package-in-charges, subcontractors on HSE matters.

5.4 HSE SUPERVISOR:

i. All requirements as per 5.1
ii. To monitor allotted area for Safety violations, take required action and inform the concerned Safety Supervisor / Officer
iii. To assist HSE Officer

5.5 PACKAGE IN-CHARGES, ENGINEERS & ALL EMPLOYEES:

i. To be aware of, get involved in and ensure implementation of all HSE related Systems and Procedures including but not limited to:
    a. BHEL HSE Management System including HSE Procedures and OCPs, HIRA, JSA etc.
    b. Work Permit System
    c. Emergency Preparedness Response Plans
    d. Contractual HSE requirements
    e. Legal Requirements
    f. Penalty System
    g. Training requirements
ii. To ensure that the persons engaged in respective area follow the safety rules like using appropriate PPEs.
iii. To develop Method Statements and ensure availability of Job Safety Analysis for all activities in scope
iv. To ensure that the reported HSE non-conformities in the work area are resolved immediately before resuming work
v. To record all incidents including near miss and report to BHEL.

vi. To adopt safe working practices at all times and act as role model for Safety
vii. To take immediate corrective action actions in case any non-conformity is observed on product / process / system with respect to Occupational Health, Safety and Environment.
viii. In case any particular activity / work has extremely high consequential risk or high environmental impact, same shall be brought to the notice of BHEL Package In-charge before starting the work.
ix. To interfere/ stop work as & when identified unsafe.
x. To maintain & promote improved level of house-keeping all the time at site.
xi. To support/co-operate with audit team members as & when safety audits are carried out.
xii. To involve in investigation, if any incident occurs in his work area.
xiii. To participate in safety promotional programs
xiv. To attend the safety committee meeting, if member/invitee
xv. To ensure that only fit T&Ps and qualified persons are engaged for all activities.
xvi. Shall ensure that person working above 2.0 meter should use Safety Harness tied to a life line/stable structure.
xvii. Shall ensure that materials are not thrown from height. Cautions to be exercised to prevent fall of material from height.
xviii. Shall ensure that all T&Ps engaged are tested for fitness and have valid certificates from competent authorities.

6. HSE PLANNING BY SUBCONTRACTOR:

6.1 HAZARD ANALYSIS & RISK ASSESSMENT (HIRA), METHOD STATEMENT (MS) & JOB SAFETY ANALYSIS (JSA):

i. Subcontractor shall identify all OHS Hazards and Risks applicable to all activities in scope and plan & implement the required control measures. HIRA Register shall be maintained.
ii. Subcontractor shall develop Method Statements & Job Safety Analysis documents for all hazardous activities in scope and ensure the required control measures. Job Safety Analysis is to be attached along with any Work Permit request

6.2 REGISTER OF REGULATIONS:

Subcontractor shall prepare a register of applicable rules and regulations in the scope and plan to ensure compliance.

HIRA Register, Method Statements, Job Safety Analysis and Register of Regulations are dynamic documents and shall be revised (as applicable):

i. At fixed frequency of 3 months
ii. Addition/ deletion/ modification of a process/ activity
iii. After an accident/ incident
iv. After any change in applicable rules/ regulations/ laws.

6.3 MONTHLY HSE PLAN COVERING THE FOLLOWING AS A MINIMUM SHALL BE PREPARED AND SUBMITTED TO BHEL FOR APPROVAL:

i. HSE Trainings covering all activities/ hazards/ workers

ii. HSE Inspection Plan covering all areas/ activities/ equipment/ hazards

iii. HSE Activities: Safety walks, Awards, housekeeping, reviews etc.

Note: Online/ App-based system shall be used for HSE Planning and Implementation/ Update whenever provided by BHEL otherwise Hard-copy based system shall continue

6.4 Monthly HSE Planning & Review of HSE Activities along with BHEL:

Monthly planning and review of HSE activities shall be carried out by subcontractor as per provided **format** jointly along with BHEL

7. Mobilization Of Machinery/Equipment/Tools By Subcontractor:

i. Subcontractor shall notify the engineer, of his intention to bring on to site any equipment or any container, with liquid or gaseous fuel or other substance which may create a hazard. The Engineer shall have the right to prescribe the condition under which such equipment or container may be handled and used during the performance of the works and the subcontractor shall strictly adhere to such instructions. The Engineer shall have the right to inspect any construction tool and to forbid its use, if in his opinion it is unsafe. No claim due to such prohibition will be entertained.

ii. As a measure to ensure that machinery, equipment and tools being mobilized to the construction site are fit for purpose and are maintained in safe operating condition and complies with legislative and owner requirement, inspection shall be arranged by in-house competent authority for acceptance as applicable. Inspection by Third Party competent person shall be arranged:
   a. Before first time use at site
   b. After carrying out any modification
   c. After repairs subsequent to involvement in any accident/ incident

iii. As a further measure to ensure that machinery, equipment and tools being mobilized to the construction site are fit for purpose and are maintained in safe operating condition and comply with legislative and owner requirement, inspection as per provided format shall be arranged by in-house expert / competent authority (preferable) for acceptance. The equipment considered for this purpose shall include all those in the T&P list in the tender document.

8. Mobilization of Manpower by Subcontractor:

i. As a measure to ensure that manpower being mobilized to the construction site is fit and competent for safe working, screening arrangement shall be made by the sub-subcontractor to ensure competency and fitness through following measures:

a) **Medical Checkup:** Examination of medical fitness shall be conducted through qualified medical professional for all workers to be deployed as per provided **format**. For height workers, vertigo (height phobia) test to be carried out as qualification criteria as per Annexure K and recorded in provided **format**.

b) **Induction Training**: Induction training of all workers to be ensured as per **provided procedure and format**. Training evaluation to be carried out and training to be repeated if not passed

c) Only on successfully meeting above criteria, permanent gate passes to be issued

ii. The subcontractor shall arrange induction and regular health check of their employees as per schedule VII of BOCW rules by a registered medical practitioner.

iii. The subcontractor shall take special care of the employees affected with occupational diseases under rule 230 and schedule II of BOCW Rules. The employees not meeting the fitness requirement should not be engaged for such job.

iv. Ensure that the regulatory requirements of excessive weight limit (to carry/lift/ move weights beyond prescribed limits) for male and female workers are complied with.

v. Appropriate accommodation to be arranged for all workmen in hygienic condition.

vi. Cost of contractual, statutory and regulatory requirements like Training, medical checks, PPEs etc. shall not be transferred to the workers and such activities shall be considered as part of the job.

9. Provision of Personal Protective Equipment (PPEs):

i. Personnel Protective Equipment (PPEs), shall be provided by the subcontractor to all workers as per requirement of the job.

ii. The choice of PPEs to ensure multiple (at least more than 1) means of protection against any hazard. All applicable safety precautions for a job shall be ensured notwithstanding the duration or perceived importance of the task.

iii. The applicability of PPEs shall be as per the concept of Hierarchy of controls, i.e.:

iv. Elimination->Substitution->EngineeringControls->AdministrativeControls-PPEs

v. Relying solely on PPEs without ensuring necessary controls to be strictly avoided.

vi. The following matrix recommends usage of minimum PPEs against the respective job.

Activity	Type of Protection						Remarks, if any
	Hand	Eye	Ear	Body	Respiratory	Others	
Gas Welding & Cutting	LG	WG	-	LA	*SCBA/ OLBA	-	* for confined space
Electric Arc Welding	LG	HMWS	-	LA	*SCBA/ OLBA	-	* for confined space
Rigging	CG	SG	-				--
Working at Height	-	SG	-	DLFBH	-	*FAS	* for vertical columns
Grinding & Chipping	CG	FS / SG	-	LA	-	-	--
Working in High Noise	-	-	EP / EM	-	-	-	--
Handling of Cement Concrete	RG	SG	-	-	DM	-	

Blasting	CG	SG	EP*	-	-	-	* at noise area
Excavation	CG	SG	-	-	DM	-	*Gum boot in place of Safety shoe for foot
Chemical Handling	PVCG	CSG	-	PVCA	-	-	*Full body rubber suit with hood
Electrical and C&I	ERG*	SG	-	-	-	-	*For high voltages
Sand/shot blasting	CG	-	EP/ EM	CA	SAMH	-	

ABBREVIATIONS: FS: Face Shield, CSG: Chemical splash goggles, HMWS: Helmet mounted welder's shield, GB: gum boot, DLFBH: Double lanyard full body harness, SG: Safety goggles, DM: Dust mask, SAMH L Supplied air mask/hood, EP/EM: Ear plug/Ear Muff, CG: Cotton hand gloves, LG: Leather hand gloves, LA: Leather apron, RG: Rubber gloves, PVCG: PVC Gloves, PVCA: PVC Apron, SCBA: Self-contained breathing apparatus, WG: Welding goggles, ERG: Electrical Rubber Gloves. OLBA: Online breathing apparatus

The list is not exhaustive. Additional PPEs to ensure Safe Work may need to be deployed as per the requirement of the task at no additional cost.

vii. The PPEs shall conform to the relevant standards as below (illustrative list) and bear ISI mark.

RELEVANT IS-CODES FOR PERSONAL PROTECTION

PPEs	IS Codes
Industrial Safety Helmets.	IS: 2925 – 1984
Rubber gloves for electrical purposes.	IS: 4770 – 1968
Industrial Safety Gloves (Leather &Cotton Gloves).	IS: 6994 – 1973 (Part-I)
Leather safety boots and shoes.	IS: 1989 – 1986 (Part-I-II)
Industrial and Safety rubber knee boots.	IS: 5557 – 1969
Code of practice for selections care and repair of Safety footwear.	IS: 6519 – 1971
Leather Safety footwear having direct molding sole.	IS: 11226 – 1985
Eye protectors.	IS: 5983 – 1978
Ear protectors.	IS: 9167 – 1979
Eye & Face protection during welding	IS: 1179-1967
Industrial Safety Belts and Harness	IS: 3521 – 1983
Guide for selection of industrial Safety equipment for body protection	IS:8519 -1977
Respiratory Protective Devices	IS:9473-2002,14166-1994,14746-1999

viii. Where workers are employed in sewers and manholes, which are in use, the subcontractor shall ensure that the manhole covers are opened and ventilated at least for an hour before the workers are allowed to get into manhole, and the manholes so opened shall be cordoned off with suitable railing and provided with warning signals or boards to prevent incident to the public

ix. All the personnel and visitors shall mandatorily use safety helmet (with company logo), safety shoe and reflective vests, in addition to any other PPEs as deemed appropriate for the area of work/ visit.

x. Following Color scheme for Helmets shall be followed:
   a. Workmen: Yellow
   b. Safety staff: Green or white with green band
   c. Electrician: Red
   d. Others including visitors: White
   e. For height workers, special marking on helmets besides indication on Gate Pass/ ID Card

xi. The subcontractor shall maintain register for issue and receipt of PPEs.

xii. All the PPEs shall be checked for quality before issue and the same shall be periodically re-checked. The users shall be advised to check the PPEs themselves for any defect before putting on. The defective ones shall be replaced.

xiii. The Helmets shall have logo or name (abbreviation of agency name permitted) affixed or printed on the front.

xiv. The body harnesses shall be serial numbered.

10. ARRANGEMENT OF INFRASTRUCTURE:

10.1 DRINKING WATER:

i. Drinking water shall be provided and maintained at suitable places at different elevations such that minimum quantity of 5 liters is available for each worker during the day.

ii. Drinking water tank shall be so installed so as to be available within 200 meters of each working area

iii. Container should be labeled as “Drinking Water” in languages understood by the workers

iv. Cleaning of the container shall be ensured at least once in a week. Mild cleaning detergents as used for cleaning vessels shall be applied and scrubbers (3M or equivalent) shall be used for removing scales and deposits on the inside surface. The tank shall be thoroughly cleaned with potable water only before it is refilled (also applicable to labor colony).

v. Suitability of water source for drinking to be tested as per IS10500 at least once in six months.

10.2 WASHING FACILITIES:

i. In every workplace, adequate and suitable facilities for washing shall be provided and maintained.

ii. Separate and adequate cleaning facilities shall be provided for the use of male and female workers. Such facilities shall be conveniently accessible and shall be kept in clean and hygienic condition and dully illuminated for night use.

iii. Water suitable for washing and not for drinking shall be clearly indicated as “Not for Drinking” in language understood by workers.

iv. Overalls shall be supplied by the subcontractor to the workmen and adequate facilities shall be provided to enable the painters and other workers to wash during the cessation of work.

10.3 LATRINES AND URINALS:

i. Latrines and urinals shall be provided in every work place as indicated in Section A
ii. Urinals shall also be provided at different elevations.
iii. They shall be adequately lighted and shall be maintained in a clean and sanitary condition at all times, by appointing designated person.
iv. Separate facilities shall be provided for the use of male and female worker if any.

10.4 PROVISION OF REST SHEDS FOR WORKERS DURING REST PERIOD:

Proper Rest Shed (s) with shelter shall be provided for rest during break so as to accommodate all workers as indicated in Section A

10.5 MEDICAL FACILITIES:

10.5.1 GENERAL

i. Provision of Medical Center, Ambulance etc. shall be as per Section A of this document
ii. Medical waste shall be disposed as per prevailing legislation (Bio-Medical Waste – Management and Handling Rules, 1998)
iii. Every injury shall be treated, recorded and reported.
iv. All First Aid injuries shall be recorded as per provided Format
v. List of qualified first aiders and their contact numbers to be displayed at conspicuous places.

10.5.2 FIRST AIDER/ FIRST AID BOX

i. The first aider along with facilities should be available at a point nearest to the work location wherein majority of the workers are working.
ii. The subcontractor shall provide necessary first aid facilities as per schedule III of BOCW. At every work place first aid facilities shall be provided and maintained.
iii. The first aid box shall be kept by first aider who shall always be readily available during the working hours of the work place. His name and contact no to be displayed on the box.
iv. The first aid boxes should be placed at various elevations so as to make them available within the reach and at the quickest possible time.
v. The first aid box shall be distinctly marked with a Green Cross on white background.
vi. Details of contents of first aid box is given in Annexure J
vii. A slip of contents shall be pasted on the First Aid Box with following details
viii. Monthly inspection of First Aid Box shall be carried out by the owner as per provided format
ix. The subcontractor should conduct periodical first –aid classes to keep his supervisor and Engineers properly trained for attending to any emergency.

10.5.3 HEALTH CHECK UP

The persons engaged at the site shall undergo health check-up as per provided format before induction. In addition, the persons engaged in the following works shall undergo health check-up at least once in a year:

i. Height workers
ii. Drivers/crane operators/riggers
iii. Confined space workers
iv. Shot/sand blaster
v. Welding and NDE personnel

10.5.4 HEIGHT PHOBIA/ VERTIGO TEST:

i. The persons engaged in working at heights (above 2 meters) to be assessed for Vertigo and associated conditions and recorded as per provided format. Suggested Vertigo Test Procedure is given in Annexure K
ii. Such workers are to be allowed only on successful completion of test, otherwise shall be allocated ground-based jobs.
iii. IDs / Height passes shall be issued to such workers, besides special markings on helmets for easy identification.

10.5.5 PROVISION OF CANTEEN FACILITY:

i. Canteen facilities shall be provided for the workmen of the project inside the project site where worker strength is 250 or more.
ii. Proper cleaning and hygienic condition shall be maintained.
iii. Proper care should be taken to prevent biological contamination.
iv. Adequate drinking water should be available at canteen.
v. Fire extinguisher shall be provided inside canteen.
vi. Regular health check-up and medication to the canteen workers shall be ensured as per applicable regulations.
vii. Canteen waste to be disposed of in hygienic manner

10.6 PROVISION OF ACCOMMODATION/LABOR COLONY FOR WORKFORCE:

i. Proper accommodation for workforce to be provided in line with minimum requirements indicated in Section A
ii. Labor colony shall be inspected each week by HSE Officer and report submitted to BHEL as per provided format

10.7 PEST CONTROL:

Regular pest control should be carried out at all offices, mainly laboratories, canteen, labor colony and stores.

10.8 SCRAPYARD:

i. In consultation with customer, scrapyard shall be developed to store metal scrap, wooden scrap, waste, hazardous waste.
ii. Scrap/Waste shall be segregated as Bio-degradable and non-bio-degradable and stored separately.

10.9 ILLUMINATION:

i. The subcontractor shall arrange at his cost adequate lighting facilities e.g. flood lighting, hand lamps, area lighting etc. at various levels for safe and proper working operations at dark places and during night hours at the work spot as well as at the pre-assembly area.
ii. Lamp (hand held) shall not be powered by mains supply but either by 24V or dry cells.
iii. Lamps shall be protected by suitable guards where necessary to prevent danger, in case of breakage of lamp.
iv. Emergency lighting provision for night work shall be made to minimize danger in case of main supply failure.
v. Adequate and suitable light shall be provided at all work places & their approaches including passage ways as per IS: 3646 (Part-II).

SUITABLE ILLUMINATION LEVELS FOR VARIOUS AREAS SHALL BE DECIDED BASED ON BROAD GUIDELINES INDICATED BELOW:

S. No.	Location	Lux Level (lumens/sqm)
A.	**Construction Site**	
1	Outdoor areas like store yards, entrance and exit roads	20
2	Platforms	50
3	Entrances, corridors and stairs	100
4	General illumination of work area	150
5	Rough work like fabrication, assembly of major items	150
6	Medium work like assembly of small machined parts	300
7	Fine work like precision assembly, precision measurements etc.	700
8	Sheet metal works	200
9	Electrical and instrument labs	450
B.	**Office**	
1	Outdoor area like entrance and exit roads	20
2	Entrance halls	150
3	Corridors and lift cars	70
4	Lift landing	150
5	Stairs	100
6	Office rooms, conference rooms, library reading tables	300
7	Drawing table	450
8	Manual telephone exchange	200

vi. Illuminations shall be inspected on weekly basis as per provided **format** using a calibrated lux meter.

11. HSE TRAINING & AWARENESS:

11.1 TRAINING PLAN:

i. All training programs to be carried out in a planned manner. Monthly/ Annual Training Calendar to be submitted to BHEL for approval and shall cover HSE Training requirements of all activities, workers, hazards applicable to the area(s) of work.
ii. Subcontractor shall nominate workers as per the schedule of specific training plan, failing which, penalty shall be imposed.
iii. Training records of all workers along with attendance, signatures, faculty details etc. shall be maintained in soft/ hard copy as per provided **formats**.
iv. Each labor should undergo at least 0.5% of total man-hours worked in HSE training.

11.2 HSE INDUCTION TRAINING

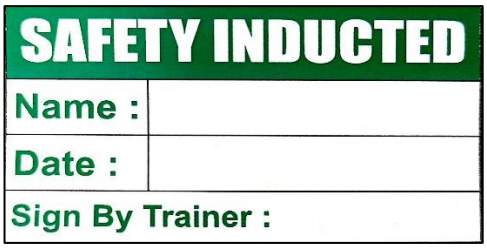
i. All persons entering into project site shall be given HSE induction training by the HSE officer of BHEL /subcontractor before being assigned to work.
ii. The induction training shall be imparted through audio-visual medium (Classroom specialized training), and shall be minimum of 1 Complete Day.
iii. Evaluation to be carried out after training and training shall be repeated in case of failure.
iv. Safety Induction Card shall be printed by Subcontractor and provided to all trained workers. A Safety induction book shall also be printed and issued to each worker after induction training (Format for the same may be provided by BHEL).
v. Induction training subjects shall include but not limited to:

   a. Briefing of the Project details.
   b. Safety objectives and targets.
   c. Site HSE rules.
   d. Critical Safety Violations and consequences
   e. Site HSE hazards and aspects.
   f. First aid facility.
   g. Emergency Contact No.
   h. Incident & Near Miss reporting.
   i. Fire prevention and emergency response.
   j. Rules to be followed in the labor colony (if applicable)
   k. Accident case studies

vi. General:

   a. Proper safety wear & gear must be issued to all the workers being registered for the induction (i.e., Shoes/Helmets/Goggles/Leg guard/Apron etc.)
   b. They must arrive fully dressed in safety wear & gear to attend the induction.
   c. Any one failing to conform to this safety wear& gear requirement shall not qualify to attend.

d. On completing attending subcontractor's in-house HSE induction, each employee shall sign an induction training form to declare that he had understood the content and shall abide to follow and comply with safe work practices.
e. They may only then be qualified to be issued with a personal I.D. card, for access to the work site subject to clearing the medical fitness test.



ABOVE STICKER SHALL BE PASTED ON HELMET OF WORKERS AFTER SAFETY INDUCTION TRAINING

11.3 JOB-SPECIFIC SKILL BASED HSE TRAINING

The contracting agency shall also impart job specific skill-based safety training to all its employees (Minimum one day) on various related safety topics using internal/external safety professionals/consultants as per the matrix given below. Record of such trainings and attendance particulars shall be maintained in a register for ready reference to statutory authorities/engineer-in charge as per provided format.

TRAINING MATRIX

Name of topic	Executives	Supervisors	Skilled Workmen	Other Workers
Safety Induction	Y	Y	Y	Y
Accident_ Causes, factors, cost	Y	Y	Y	-
Industrial hazards & Accident Prevention	Y	Y	Y	-
Investigating, reporting, records	Y	Y	-	-
Personal Protective Equipment	-	Y	Y	Y
Construction Safety & Role of Supervisory personnel	-	Y	-	-
Permit to Work (PTW)	-	Y	Y	y
Statutory Provisions (BOCW Act/Rules, Factories Act 1948 etc.)	Y	Y	y	y
Material handling	-	y	Y	Y
Emergency Management	Y	Y	Y	-
Electrical Safety	-	Y	Y	-
Fire safety	Y	Y	Y	Y
First Aid & CPR (cardio pulmonary resuscitation)	-	Y	Y	Y (Selected)
Safety in Welding & Cutting	-	-	Y	-
Safety Audit	Y	Y	-	-
Safety in Lifting Tools & Tackles	-	Y	Y	y

Safety in Working at height	-	Y	Y	Y
Safety in Confined space work	-	Y	Y	Y
Defensive Driving	-	Y*	Y*	Y*

*for construction vehicle operators, helpers & crane operators

Y=YES

Note:

i. Subcontractor shall prepare a training plan/ matrix covering all hazards and implement the same after approval of BHEL.
ii. It is to be ensured that every worker undergoes Job-Specific training once every 3 months.
iii. Records of training programmes along with attendance shall be maintained by the subcontractor
iv. Each worker to be issued a Card indicating the types of trainings undergone.

11.4 HSE TOOL-BOX TALK:

i. HSE tool Box talk shall be conducted by frontline foreman/supervisor of subcontractor to specific work groups prior to the start of work and shall be randomly attended by subcontractor engineers/ officials. The agenda shall consist of the following:

   a. Details of the job being intended for immediate execution.
   b. The relevant hazards and risks involved in executing the job and their control and mitigating measures.
   c. Specific site condition to be considered while executing the job like high temperature, humidity, unfavorable weather etc.
   d. Recent non-compliances observed.
   e. Appreciation of good work done by any person.
   f. Any doubt clearing session at the end.

ii. Tool box talk to be conducted before start of work in every shift.
iii. During toolbox talk, visual check-up of workers regarding health, any signs of fatigue, intoxication etc. shall be conducted and any suspected workers to be acted upon.
iv. Record of Tool box talk shall be maintained as per provided **format**

11.5 TRAINING ON HEIGHT WORK:

i. Training on height work shall be imparted to all workers working at height by in-house/external faculty at least once every 3 months.
ii. For Height Workers Separate pass shall be provided by the subcontractor.
iii. The training shall be of minimum 2-hour duration, through audio-visual medium and followed by evaluation. In case of poor scoring, training shall be repeated.
iv. The training shall include following topics:

   a. Proper use of PPEs – safety harness, lanyard, fall arrester, retractable fall arrester, life line, safety nets etc.
   b. Provision of secondary means of fall protection

c. Safe climbing through monkey ladders.
d. Inspection of PPEs.
e. Medical fitness requirements.
f. Mock drill on rescue at height.
g. Dos & Don'ts during height work.
h. Accident case Studies

11.6 Re-Induction Training

The induction training shall be repeated for every worker after at least 1 year and shall be a pre-requisite for renewal of Gate Pass/ ID card.

11.7 Penalty Training

The personnel involved in Safety Violations/ Incidents shall mandatorily undertake penalty training pertaining to the violation/ incident. Penalty training shall be at least half-day duration.

11.8 HSE Promotion-Signage, Posters, Competition, Awards etc.:

i. HSE Displays shall be installed as indicated in Section A
ii. Contracting agencies shall arrange for display of safety hoardings depicting suitable safety cartoons/messages/ cautionary notices at appropriate places of project site to remind the workers to perform their duties safely.
iii. Apart from safety hoardings, each agency should maintain a safety bulletin board at all their work locations. Such safety bulletin boards should depict the activities being planned for the day, good practices, permit details etc.
iv. Safety suggestion boxes shall be kept at each subcontractor's office at site for obtaining safety suggestions from the workers. Best suggestions should be implemented and may be rewarded suitably to encourage the workers for safety.
v. Safety awareness campaigns, competitions, plays, movie shows, songs etc. to be organized for workers at Site and Labor colony from time to time to enhance Safety Awareness

11.9 HSE Rewards & Incentive Scheme

Subcontractor shall implement a reward & incentive scheme for workers & supervisors displaying adherence to safety principles. Such workers shall be felicitated in a monthly function, attended by Subcontractor top management and BHEL representatives. Suitable gift shall be given to such workers for encouragement.

11.10 HSE Awareness Program for Officials:

Subcontractor shall arrange monthly HSE awareness program on different topics including medical awareness for all engineers/ supervisors / officials working at site. This program can be part of progress/ safety review meetings.

12. HSE COMMUNICATION AND PARTICIPATION:

12.1 HSE INCIDENT REPORTING, INVESTIGATION & CORRECTIVE ACTION:

i. All incidents (near misses, property damage, first-aid cases, minor, major and fatal incidents) shall be reported to BHEL as they happen immediately through SMS and Hard/Soft copy as per provided format

ii. All incidents including near miss, minor, major and fatal incidents shall be recorded

iii. All incidents shall be investigated for Root Causes and corrective actions ensured to prevent recurrence shall be implemented.

iv. Work shall be put on hold in the area till corrective actions are verified by BHEL

v. The Root Cause Analyses and Corrective actions taken shall be recorded

12.2 HSE EVENT REPORTING:

i. Important HSE events like HSE training, Medical camp etc. organized at site shall be reported to BHEL site management in detail with photographs for publication in different in-house magazines

ii. Celebration of important days like National Safety Day, World Environment Day etc. shall also be reported as mentioned above.

12.3 MONTHLY HSE REPORTING:

i. All routine and non-routine HSE activities shall be reported to BHEL on monthly basis by the subcontractor as per provided format. The reporting medium can be hard/soft as per BHEL requirement.

ii. The period of reporting shall be 25th of the preceding month to 24th of the present month and shall be submitted by the end of the calendar month.

iii. Report shall include good quality images of HSE Activities

12.4 DAILY HSE ACTIVITY REPORTING:

Daily HSE activities shall be reported by subcontractor to BHEL as per provided format

12.5 HSE SUGGESTIONS:

All workers and employees shall be encouraged to provide suggestions for improvement in Health, Safety & Environment performance at site. The suggestions shall be recorded in a “Suggestions Register” as per provided format. Suggestions found suitable for implementation shall be implemented and recognition / reward to be given to the submitter.

Suggestion Register to be placed at Site and Labor Colony and shall be reviewed on periodic basis

12.6 CLIENT COMMUNICATION:

All HSE related communication from BHEL, customer / external statutory and regulatory agencies to be handled on priority. Same to be recorded and issues to be resolved in expeditious manner

13. SAFETY DURING WORK EXECUTION:

Safety during work execution shall be ensured by following appropriate Safety Rules, providing adequate resources, deploying competent and trained manpower, regular training & inspection and non-conformity resolution. Main aspects are indicated as under:

13.1 OPERATIONAL CONTROL PROCEDURES:

In order to reduce the risk associated with hazardous activities, applicable OCPs (Operational control procedures) will be followed by subcontractor as per BHEL instructions, outcomes of Hazard Analysis & other requirements. This will be done as part of normal scope of work. Illustrative list of reference OCPs is given below.

TABLE 13.1 ILLUSTRATIVE LIST OF REFERENCE OCPS

No.	Topic	No.	Topic	No.	Topic
0	General Safety	**22**	Steam blowing	**44**	Material preservation
1	Handling of chemicals	**23**	Working in confined area	**45**	Electro-resistance heating
2	Electrical safety	**24**	Operation of passenger lift, material hoists & cages	**46**	Blasting
3	Energy conservation	**25**	Vehicle/ Crane maintenance	**47**	Transformer charging
4	Welding and gas cutting operation	**26**	Radiography	**48**	Handling of battery system
5	Fire safety	**27**	Waste disposal	**49**	DG set
6	Use of hand tools	**28**	Handling & storage of mineral wool	**50**	Sanitary maintenance
7	First aid	**29**	Working at night	**51**	Piling rig operation
8	Food safety at canteen	**30**	Computer operation	**52**	Passivation
9	Use of cranes	**31**	Storage in open yard	**53**	EDTA Cleaning
10	Storage and handling of gas cylinders	**32**	Drilling, reaming and grinding(machining)	**54**	Chemical cleaning of Pre boiler system
11	Manual arc welding	**33**	Stress relieving	**55**	Boiler Light up
12	Use of helmets	**34**	Hydraulic test	**56**	Rolling and Synchronization
13	Good house keeping	**35**	Trial run of rotary equipment	**57**	Loading of Unit

14	Safe excavation	**36**	Batching	**58**	Air compressor
15	Working at height	**37**	Cable laying/tray work	**59**	Hydra Operation
16	Filling of hydrogen in cylinder	**38**	Spray insulation	**60**	Duct Pre-assembly
17	Illumination	**39**	Compressor operation	**61**	Resumption of construction activities after lockdown and prevention of coronavirus infection during site operations
18	Handling and erection of heavy metals	**40**	Gas distribution test		
19	Acid cleaning	**41**	Cleaning of Hot well / Deaerator		
20	Oil flushing	**42**	Electrical maintenance	**61A**	Prevention of Covid-19 infection in labour colony
21	Alkali boil out	**43**	O&M of control of AC plant & system	**62**	Truss/ Structure fit-up and alignment

a. The reference OCPs shall be suitably modified by subcontractor as per specific requirements to control the hazards.

b. In case any other OCP is found to be applicable during the execution of work at site, then subcontractor will prepare and follow those as well.

13.2 Work Permit System:

i. The following activities shall be carried out by the subcontractor strictly after obtaining Permit to Work from BHEL
   a) Height working
   b) Hot working
   c) Confined space Work
   d) Excavation more than 2-meter depth
   e) Radiography
   f) Heavy / Complex / Critical Lifting Activity
   g) Night / Holiday Work
   h) Material Loading / Unloading
   i) Grating, Safety Net, Safety Facility Removal
   j) Live Electrical Maintenance etc. - Lockout / Tagout
   k) Beam / truss/ duct/ structure alignment

ii. The Work Permit Formats shall be provided by BHEL at Site. It is the responsibility of the subcontractor to ensure their availability

iii. The above list is not exhaustive. BHEL reserves right to introduce additional Permits or modify requirements for usage of existing Permits. The conditions for using the Permit are specified in the Format (General Requirements).

iv. Where customer is having separate Work Permit System the same shall be followed in conjunction / merged to ensure all activities and checks are covered in all systems.

v. Details of working Group to be attached along with work permit request.

vi. All the Permits along with JSA/HIRA must be initiated by Agency Execution Team
vii. Permit applicant shall apply for work permit of particular work activity at particular location before starting of the work with Job Hazard Analysis.
viii. All Permit signatories (including subcontractor's package in-charge and HSE Officer) shall physically visit the work area and check that all the safety control measures necessary for the activity are in place. Only then the permit shall be issued.
ix. Signatory shall physically visit the area of work and ensure all required safeguards before signing the Permit
x. Signatory shall periodically visit the area to confirm the availability of required safeguards throughout the currency of the permit
xi. In case any Permit requirement is not available, work will be stopped till it is made available
xii. Permit holder shall implement and maintain all control measures during the period of permit. The permit will be closed after completion of the work.
xiii. Online Work Permit System shall be used whenever provided by BHEL, otherwise hard copy shall be used

13.3 Activity-Specific Precautions/ Controls

Detailed HSE precautions for various activities undertaken at Site by the subcontractors are specified in **Annexure I**. Same are to be ensured by the Sub-subcontractor while carrying out respective activities at Site

Index of **Annexure I** is given as under

SN	Description	Page No.
1.	General	2
2.	Work at height	2
2.1	Personnel fall protection system must include	3
2.2	Working Platform	4
2.3	Scaffolding	5
2.4	Ladder Safety	7
3.	Excavation & Civil Works	8
3.1	Excavation	8
3.2	Piling	9
3.3	Batching Plant Operation	9
3.4	Mobile Plant	10
3.5	Concrete Vibrators	11
3.6	Concrete Mixers	11
4.	Welding & Gas Cutting Safety (Hot Work)	11
5.	Lifting & Rigging Safety	13
5.1	Cranes & Hoisting Equipment	15
6.	Demolition Work	20
7.	T&Ps General	20
8.	Chemical Handling	20
9.	Electrical Safety	20

10.	Use of Hand Tools and Power-Operated Tools	25
11.	Start Up, Commissioning and Testing:	27
12.	Fire Safety	27
13.	Painting	28
14.	Hazardous Energy" Control Procedure/ Lockout/Tagout (LOTO)	29
15.	Risk Assessment	36
16.	HSE Preparedness for Adverse Climates and Weather	37
16.1	Summer	37
16.2	Monsoon	38
16.3	Emergency Weather Conditions	40
16.4	Prevention of Covid-19 At Project Site & Labor Colony	41
16.5	Noise Mitigation	43

14. ENVIRONMENTAL CONTROL & SOCIAL RESPONSIBILITY

i. Environment protection has always been given prime importance by BHEL. Environmental damage is a major concern of the principal subcontractor and every effort shall be made, to have effective control measures in place to avoid pollution of Air, Water and Land and associated life. Banned substances like asbestos and Chlorofluorocarbons such as carbon tetrachloride and trichloroethylene shall not be used. Waste disposal shall be done in accordance with the guidelines laid down in the project specification.

ii. Any chemical including solvents and paints, required for construction shall be stored in designated bonded areas around the site as per Material Safety Data Sheet (MSDS).

iii. In the event of any spillage, the principle is to recover as much material as possible before it enters drainage system and to take all possible action to prevent spilled materials from running off the site. The subcontractor shall use appropriate MSDS for clean-up technique

iv. All subcontractors shall be responsible for the cleanliness of their own areas

v. Regular dust suppression using sprinklers shall be carried out in respective area

vi. The subcontractors shall ensure that noise levels generated by plant or machinery are as low as reasonably practicable. Where the subcontractor anticipates the generation of excessive noise levels from his operations the subcontractor shall inform to Construction Manager of BHEL accordingly so that reasonable &practicable precautions can be taken to protect other persons who may be affected.

vii. It is imperative on the part of the subcontractor to join and effectively contribute in joint measures such as tree plantation, environment protection, contributing towards social upliftment, conversion of packing woods to school furniture, enhancing good relation with local populace etc.

viii. The subcontractor shall carry out periodic air and water quality check and illumination level checking in his area of work place and take suitable control measure.

15. HOUSEKEEPING

i. Keeping the work area and access roads clean/ free from debris, removed scaffoldings, scraps, insulation/sheeting wastage /cut pieces, temporary structures, packing woods etc. will be in the scope of the subcontractor. Such cleanings have to be done by subcontractor within quoted rate, on daily basis.

ii. If such activity is not carried out by subcontractor / BHEL is not satisfied, then BHEL may get it done by other agency and actual cost along with BHEL overheads will be deducted from subcontractor's bill. Such decisions of BHEL shall be binding on the subcontractor

iii. Dedicated Housekeeping gangs shall be deployed, who shall be provided all required PPEs and safety training

iv. Mass housekeeping shall be carried out for half a day in a week

v. Proper housekeeping to be maintained at work place and the following are to be taken care of on daily basis.

vi. All surplus earth and debris are removed/disposed off from the working areas to identified locations.

vii. Unused/Surplus cables, steel items and steel scrap lying scattered at different places/elevation within the working areas are removed to identified locations.

viii. All wooden scrap, empty wooden cable drums and other combustible packing materials, shall be removed from workplace to identified locations.

ix. Sufficient waste bins shall be provided at different work places for easy collection of scrap/waste. Scrap chute shall be installed to remove scrap from high locations.

x. Access and egress (stair case, gangways, ladders etc.) path should be free from all scrap and other hindrances.

xi. Workmen shall be educated through tool box talk about the importance of housekeeping and encourage not to litter.

xii. Labor camp area shall be kept clear and materials like pipes, steel, sand, concrete, chips and bricks, etc. shall not be allowed in the camp to obstruct free movement of men and machineries.

xiii. Fabricated steel structures, pipes & piping materials shall be stacked properly.

xiv. No parking of trucks/trolleys, cranes and trailers etc. shall be allowed in the camp, which may obstruct the traffic movement as well as below LT/HT power line.

xv. Utmost care shall be taken to ensure over all cleanliness and proper upkeep of the working areas.

16. WASTE MANAGEMENT

i. Take suitable measures for waste management and environment related laws/legislation as a part of normal construction activities. Compliance with the legal requirements on storage/ disposal of paint drums (including the empty ones), Lubricant containers, Chemical Containers, and transportation and storage of hazardous chemicals will be strictly maintained.

ii. Details of E-Waste, Hazardous Waste, biomedical waste etc. and their disposal plan, shall be submitted to BHEL every 6 months as per provided **formats**.

16.1 Bins At Work Place

i. Sufficient rubbish bins shall be provided close to workplaces.
ii. Bins should be painted yellow and numbered.
iii. Sufficient nos. of drip trays shall be provided to collect oil and grease.
iv. Sufficient qty. of broomsticks with handle shall be provided.
v. Adequate strength of employees should be deployed to ensure daily monitoring and service for waste management.

16.2 Storage And Collection

i. Different types of rubbish/waste should be collected and stored separately.
ii. Paper, oily rags, smoking material, flammable, metal pieces should be collected in separate bins with close fitting lids.
iii. Rubbish should not be left or allowed to accumulate on construction and other work places.
iv. Do not burn construction rubbish near working site.

16.3 Segregation

i. Earmark the scrap area for different types of waste.
ii. Store wastes away from building.
iii. Oil spill absorbed by non-combustible absorbent should be kept in separate bin.
iv. Clinical and first aid waste stored and incinerated separately.

16.4 Disposal

i. Sufficient containers and scrap disposal area should be allocated.
ii. All scrap bin and containers should be conveniently located.
iii. Provide self-closing containers for flammable/spontaneously combustible material.
iv. Keep drainage channels free from choking.
v. Make schedule for collection and disposal of waste.

16.5 Warning And Signs

i. Appropriate sign to be displayed at scrap storage area
ii. No toxic, corrosive or flammable substance to be discarded into public sewage system.
iii. Waste disposal shall be in accordance with best practice.
iv. Comply with all the requirements of Pollution Control Board (PCB) for storage and disposal of hazardous waste.

17. Traffic Management System

17.1 Safe Workplace Transport System

i. Traffic routes in a work place shall be suitable for the persons or vehicles using them. This shall be sufficient in number and of sufficient size. This shall reflect the suitability of traffic routes for vehicles and pedestrians.

ii. Where vehicles and pedestrians use the same traffic routes there shall be sufficient space between them. Where necessary all traffic routes must be suitably indicated. Pedestrians or vehicles must be able to use traffic routes without endangering those at work. There must be sufficient separation of traffic routes from doors, gates and pedestrian traffic routes.
iii. For internal traffic, lines marked on roads / access routes and between buildings shall clearly indicate where vehicles are to pass.
iv. Temporary obstacles shall be brought to the attention of drivers by warning signs or hazard cones.
v. Speed limits shall be clearly displayed for each kind of vehicle.
vi. Speed ramps preceded by a warning signs or marker are necessary.
vii. The traffic route should be wide enough to allow vehicles to pass and re-pass oncoming or parked traffic and it may be advisable to introduce on-way system or parking restrictions.
viii. Safest route shall be provided between places where vehicles have to call or deliver.
ix. Avoid vulnerable areas/items such as fuel or chemicals tanks or pipes, open or unprotected edges and structures likely to collapse
x. Safe areas shall be provided for loading and unloading.
xi. Avoid sharp or blind bends. If this is not possible hazards should be indicated e.g. blind corner.
xii. Ensure road crossings are minimum and clearly signed.
xiii. Entrance and gateways shall be wide enough to accommodate a second vehicle without causing obstruction.
xiv. Set sensible speed limits which are clearly sign posted.
xv. Where necessary ramps should be used to retard speed. This shall be preceded by a warning sign or mark on the road.
xvi. Forklift trucks shall not pass over road hump unless of a type capable of doing so.
xvii. Overhead electric cable, pipes containing flammable hazardous chemical shall be shielded by using goal posts height gauge posts or barriers.
xviii. Road traffic signs shall be provided on prominent locations for prevention of incidents and hazards and for quick guidance and warning to employees and public. Safety signs shall be displayed as per the project working requirement and guideline of the state in which project is done. Vehicles hired or used shall not be parked within the 15m radius of any working area. Any vehicle, that is required to be at the immediate/near the vicinity, shall be approved by the person in-charge of the site.

17.2 Traffic Route For Pedestrians

i. Where traffic routes are used by both pedestrians and vehicles road shall be wide enough to allow vehicles and pedestrians safely.
ii. Separate routes shall be provided for pedestrians to keep them away from vehicles. Provide suitable barriers/guard at entrances/exit and the corners or buildings.
iii. Where pedestrian and vehicle routes cross, appropriate crossing shall be provided.

iv. Where crowd is likely to use roadway e.g. at the end of shift, stop vehicles from using them at such times.

v. Provide high visibility clothing for people permitted in delivery area.

17.3 WORK VEHICLE

Work vehicle shall be as safe stable efficient and roadworthy as private vehicles on public roads. Site management shall ensure that drivers are suitably trained. All vehicle e.g. heavy motor vehicle forklift trucks dump trucks mobile cranes shall ensure that the work equipment conforms to the following:

i. A high level of stability.
ii. A safe means of access/egress.
iii. Suitable and effective service and parking brakes.
iv. Windscreens with wipers and external mirrors giving optimum all round visibility.
v. Provision of horn, vehicle lights, reflectors, reversing lights, reversing alarms.
vi. Provision of seat belts.
vii. Guards on dangerous parts.
viii. Driver protection - to prevent injury from overturning and from falling objects/materials.
ix. Driver protection from adverse weather.
x. No vehicle shall be parked below HT/LT power lines.
xi. Valid Pollution Under Control certification for all vehicles
xii. Wheel stopper shall be use during the parking of vehicle
xiii. Helper to be deployed in each vehicle as per site requirement.

17.4 DAILY CHECK BY DRIVER

1. There should also be daily safety checks containing below mentioned points by the driver before the vehicle is used.

Brakes	Mirrors	Warning signals
Tires	Windscreen waters	Specific safety systems i.e. controls & interlocks
Steering	Wipers	

2. Management should ensure that drivers carry out these checks.

17.5 TRANSPORTATION OF PERSONNEL AND MATERIALS BY VEHICLES

i. All drivers shall hold a valid driving License for the class of vehicle to be driven and be registered as an authorized BHEL driver with the Administration Department.

ii. Securing of the load shall be by established and approved methods, i.e. chains with patented tightening equipment for steel/heavy loads. Sharp corners on loads shall be avoided when employing ropes for securing.

iii. All overhangs shall be made clearly visible and restricted to acceptable limits

iv. Load shall be checked before moving off and after traveling a suitable distance.

v. On no account is construction site to be blocked by parked vehicles Drivers of vehicles shall only stop or park in the areas designate by the stringing foreman.

vi. Warning signs shall be displayed during transportation of material.
vii. All vehicles used by BHEL shall be in worthy condition and in conformance to the Land Transport requirement.
viii. Wheel stopper shall be use during the parking of vehicle
ix. Helper to be deployed in each vehicle as per site requirement.

17.6 MAINTENANCE

All Vehicles used for transportation of man and material shall undergo scheduled inspections on frequent intervals to secure safe operation. Such inspections shall be conducted in particular for steering, brakes, lights, horn, doors etc. Site management shall ensure that work equipment is maintained in an efficient, working order and in good repair. Inspections and services carried out at regular intervals of time and or mileage. No maintenance shall be carried below HT/LT power lines.

18. EMERGENCY PREPAREDNESS AND RESPONSE

i. Emergency preparedness and response capability of site shall be developed as per Emergency Preparedness and Response plan issued by BHEL
ii. Availability of adequate number of first aiders and fire warden shall be ensured with BHEL and its subcontractors
iii. All the subcontractor's supervisory personnel and sufficient number of workers shall be trained for fire protection systems. Enough number of such trained personnel must be available during the tenure of contract. Subcontractor should nominate his supervisor to coordinate and implement the safety measures.
iv. Assembly point shall be earmarked and access to the same from different location shall be shown
v. Fire exit shall be identified and pathway shall be clear for emergency escape.
vi. Appropriate type and number of fire extinguisher shall be deployed as per Fire extinguisher deployment plan and validity shall be ensured periodically through inspection
vii. Adequate number of first aid boxes shall be strategically placed at different work places to cater emergency need. Holder of the first aid box shall be identified on the box itself who will have the responsibility to maintain the same.
viii. First aid center shall be developed at site with trained medical personnel and ambulance
ix. Emergency contact numbers (format given in EPRP) of the site shall be displayed at prominent locations.
x. Tie up with fire brigade shall be done in case customer is not having fire station.
xi. Tie up with hospital shall be done in case customer is not having hospital.
xii. Disaster Management group shall be formed at site
xiii. Mock drill shall be arranged at regular intervals. Monthly report of the above to be given to BHEL HSE Officer as per prescribed BHEL formats
xiv. Mock drill shall be conducted on different emergencies periodically to find out gaps in emergency preparedness and taking necessary corrective action

19. HSE INSPECTION

Inspection on HSE for different activities being carried out at site shall be done to ensure compliance to HSE requirements. The subcontractor shall maintain and ensure necessary safety measures as required for inspection and tests HV test, Pneumatic test, Hydraulic test, Spring test, Bend test as applicable, to enable inspection agency for performing Inspection. If any test equipment is found not complying with proper safety requirements then the Inspection Agency may withhold inspection, till such time the desired safety requirements are met.

Online/ App-based HSE Inspection system shall be used for inspection whenever provided by BHEL otherwise Hard-copy based system shall continue

	OK	NOT OK
Contractor Name:		
Equipment Identification No :		
Inspection Date :		
Next Inspection Date :		
Inspected By :		

Every Inspected Equipment shall display above sticker

19.1 INSPECTION PLAN

Subcontractor shall prepare an inspection plan covering all areas/ activities/ equipment/ hazards and implement the same after getting approval of BHEL. Responsibility to ensure coverage of all areas/ activities rests with the subcontractor.

All Inspections shall be witnessed by BHEL – only then they shall be considered as valid

19.2 INSPECTION REPORTS

Monthly inspection reports as per plan shall be submitted to BHEL HSE Head

19.3 NON-CONFORMANCES

Any non-conformances identified during inspection observed shall be addressed on priority.

The responsibility of resolution shall rest with the Subcontractor Site In-charge

In case immediate closure of non-conformities is not possible:

a. work to be halted in the area
b. non-conformance to be generated and submitted to responsible person and BHEL
c. non-conformance to be resolved through responsible agency / person

Only after closure of non-conformances, work to be allowed to resume

19.4 DAILY HSE CHECKS

Both the Site Supervisors and HSE Officer of Subcontractor are to conduct daily site Safety inspection around work activities and premises to ensure that work methods and the sites

are maintained to an acceptable standard. The following are to form the common subjects of a daily safety inspection:

i. Personal Safety wears & gear compliance.
ii. Complying with site safety rules and permit-to-work (PTW).
iii. Positions and postures of workers.
iv. Use of tools and equipment etc. by the workers.

The inspection should be carried out just when work starts in beginning of the day, during peak activities period of the day and just before the day's work ends.

19.5 Indicative List of Inspections And Periodicities

Indicative list & periodicity of Inspections is given as under. It is the responsibility of the subcontractor to develop an inspection plan covering all areas & activities in the scope.

SL. No.	Format Name	Frequency of check (if applicable)
01	Inspection of First Aid Box	Weekly
02	Inspection of PPE	Weekly
03	Inspection of T&Ps	Monthly
04	Inspection of Cranes	Monthly
05	Inspection of Winches	Monthly
06	Inspection on Height Working	Weekly
07	Inspection on Welding & Gas Cutting	Monthly
08	Inspection on Electrical Installation	Monthly
09	Inspection on Elevator	Weekly
10	Inspection of Excavation	Weekly
11	Inspection of Labor Colony	Monthly
12	Inspection of Illumination Levels	Weekly

The checklists shall be provided by BHEL at Site. It is the responsibility of the subcontractor to ensure their availability before start of work

19.5.1 Inspection Of PPE

i. PPEs shall be inspected by HSE officer at random once in a week as per provided **format** for its compliance to standard and compliance to use and any adverse observation shall be recorded in the PPE register.
ii. The applicable PPEs for carrying out particular activities are listed below.

19.5.2 Inspection Of Tools & Plants (T&Ps)

i. A master list of T&Ps shall be maintained by each subcontractor in provided **format**.
ii. All T&Ps being used at site shall be inspected by HSE officer once in a month as per provided **format** for its healthiness and maintenance.
iii. The T&Ps which require third party inspection shall be checked for its validity during inspection. The third-party test certificate should be accompanied with a copy of the concerned competent person's valid qualification record.

iv. BHEL shall be given advance intimation of Third-Party Inspection. BHEL shall associate with Inspection as per discretion.
v. The validity of T&P shall be monitored as per provided **format**

19.5.3 Inspection Of Cranes And Winches

i. Cranes and winches shall be inspected by the operator through a daily checklist for its safe condition (as provided by the equipment manufacturer) before first use of the day.
ii. Cranes and Winches shall be inspected by HSE officer once in a month as per provided **format** for healthiness, maintenance and validity of third-party inspection.
iii. The date of third-party inspection and next due date shall be painted on cranes and winches.
iv. The operators/drivers shall be authorized by sub-subcontractor based on their competency and experience and shall carry the I-card.
v. The operator should be above 18 years of age and should be in possession of driving license of HMV man & goods), vision test certificate and should have minimum qualification so that he can read the instructions and check list.

19.5.4 Inspection Of Height Working

i. Any activity carried out at more than 2 m height is classified as height work.
ii. Inspection of height working shall be conducted daily by Supervisors before start of work to ensure safe working condition including provision of
   a. Fall arrestor
   b. Lifelines – connected to rigid & independent structure
   c. Safety nets deployed below all height work activities
   d. Fencing and barricading
   e. Warning signage
   f. Covering of opening
   g. Proper scaffolding with access and egress.
   h. Illumination
iii. For full duration of height work, constant supervision to be maintained by dedicated HSE personnel
iv. Inspection on height working shall be conducted once in a week by HSE officer as per provided **format**.
v. Medical fitness of height worker shall be ensured.
vi. Height working shall not be allowed during adverse weather.

19.5.5 Inspection Of Welding And Gas Cutting Operation

i. Supervisor shall ensure that no flammable items are available in near vicinity during welding and gas cutting activity.
ii. Gas cylinders shall be kept upright.
iii. Use of Flash back arrestor shall be ensured at both ends.

iv. Inspection during welding and gas cutting operations shall be carried out by HSE officer once a month as per provided **format**.
v. Use of fire blanket to be ensured to avoid falling of splatters during welding or gas cutting operation at height.
vi. Availability of fire extinguisher at vicinity shall be ensured.

19.5.6 Inspection Of Electrical Installation / Appliances

i. Ensure proper earthing in electrical installation
ii. Use ELCB at electrical booth
iii. Electrical installation shall be properly covered at top where required
iv. Use appropriate PPEs while working
v. Use portable electrical light < 24 V in confined space and potentially wet area.
vi. Inspection shall be carried out as per provided **format**.

19.5.7 Inspection Of Elevator

i. Elevators shall be inspected by concerned supervisors once in a week as per provided **format**
ii. All elevators shall be inspected by competent person and validity shall be ensured.
iii. The date of third-party inspection and next due date shall be painted on elevator.

19.5.8 Inspection Of Excavation

Excavation activities shall be inspected as per provided **format**

19.5.9 Internal/ External HSE Audits/Inspections

i. All non-conformities and observations on HSE identified during internal or external HSE audit shall be disposed of by site in a time bound manner and reported back the implementation status.
ii. Corrective action and Preventive action on HSE issues raised by certification body issued by BHEL shall be implemented by site and reported to Site management.

20. Terms and Definitions:

1. **Incident**
   Work- related or natural event(s) in which an injury, or ill health (regardless of severity), damage to property or fatality occurred, or could have occurred.

2. **Near Miss:**
   An incident where no ill health, injury, damage or other loss occurs, but it had a potential to cause, is referred to as “Near-Miss”.

3. **Man-Hours Worked:**
   The total number of man hours worked by all employees including subcontractors working in the premises. It includes managerial, supervisory, professional, technical, clerical and other workers including contract labors. Man-hours worked shall be calculated from the payroll or time clock recorded including overtime. When this is not feasible, the same shall be estimated by multiplying the total man-days worked for the

period covered by the number of hours worked per day. The total number of workdays for a period is the sum of the number of men at work on each day of period. If the daily hours vary from department to department separate estimate shall be made for each department and the result added together.

4. **First Aid Cases:**
   First aids are not essentially all reportable cases, where the injured person is given medical treatment and discharged immediately for reporting on duty, without counting any lost time.

5. **Lost Time Injury:**
   Any work injury which renders the injured person unable to perform his regular job or an alternative restricted work assignment on the next scheduled work day after the day on which the injury occurred.

6. **Medical Cases:**
   Medical cases come under non-reportable cases, where owing to illness or other reason the employee was absent from work and seeks Medical treatment.

7. **Type of Incidents & Their Reporting:**
   The three categories of Incident are as follows:

8. **Non-Reportable Cases:**
   An incident, where the injured person is given medical help and discharged for work without counting any lost time.

9. **Reportable Cases:**
   In this case the injured person is disable for 48 hours or more and is not able to perform his duty.

10. **Injury Cases:**
    These are covered under the heading of non-reportable cases. In these cases, the incident caused injury to the person, but he still continues his duty.

11. **Total Reportable Frequency Rate**
    Frequency rate is the number of Reportable Lost Time Injury (LTI) per one Million Man hours worked. Mathematically, the formula read as:

    Number of Reportable LTI x 1,000,000/ Total Man Hours Worked

12. **Severity Rate:**
    Severity rate is the Number of days lost due to Lost Time Injury (LTI) per one Million Man hours worked. Mathematically, the formula reads as:
    Days lost due to LTI x 1,000,000/ Total Man Hours Worked

13. **Incidence Rate:**
    Incidence Rate is the Number of LTI per one thousand manpower deployed. Mathematically, the formula reads as:
    Number of LTIx1000/Average number of manpower deployed

14. HIRA:

Hazard Identification and Risk Assessment (HIRA) is a process of identifying Hazards in work area and then assessing them properly

15. Method Statement:

A method statement is prepared by the Execution/ Engineering Department detailing the steps, equipment, competencies and safety precautions required for carrying out any activity

16. Job Safety Analysis:

A job safety analysis (JSA) is a procedure which helps integrate accepted safety and health principles and practices into a particular task or job operation. In a JSA, each basic step of the job is to identify potential hazards and to recommend the safest way to do the job. Other terms used to describe this procedure are job hazard analysis (JHA) and job hazard breakdown.

17. Safety Walk:

It's conducted periodically by an official - it's a walk through a portion or whole of a site as a HSE officer who notes down HSE observations, speak to concerned workmen and supervisor on observation, get the same corrected with personal follow up- this sends out a strong message on Management's commitment to safety.

18. Heavy & Complex Lifting:

A heavy and complex lifting activity includes:

1. Lifting above 20 Tons
2. Tandem Lifting using multiple cranes
   Total load exceeding 75% of capacity of crane. Depending up the condition of cranes, hydra cranes, winch machines & other lifting accessories
3. Lift of unusual difficulty or geometry or rigging
4. Lift over operating units
5. Any other lift as decided by site HSE / Erection

19. Safety Committee:

As per the BOCW, Safety Committee shall be constituted if there are more than five hundred or more construction workers are employed at any site. As per the Factories Act, 1948 it is for 250 workers. It shall be represented by equal number of representatives of employer and construction workers.

20. Night Work:

Work conducted after sunset when only a fraction of total manpower is available



ANNEXURES

ANNEXURE A

Medical Centre & Ambulance

A. Medical Centre

1. Paramedical staff
    a. When < 500 workers, 1 Trained Male Nurse (round the clock deployment)
    b. When >=500 workers*:
        i. Registered Medical Practitioner (Qualified MBBS) to be deployed for at least 8 hours in a day, 5 days per week
        ii. 2 Trained Male Nurses (round the clock deployment)
2. All articles as per Schedule IV of BOCW Central Rules, 1998 to be made available in the Medical Centre (given under for convenience)
3. Basic Facilities/ Requirements to be provided as per location eg. Refrigerator, Air Conditioner, Anti Venom Serums etc.
4. Tie-ups with speciality hospitals to be ensured for referring serious patients

* In case the number of workers is envisaged to exceed 500, a medical practitioner is to be engaged.

SCHEDULE IV (BOCW CENTRAL RULES, 1998) ARTICLES FOR AMBULANCE ROOM
[SEE RULE 226 (C)]

i. A glazed sink with hot and cold water always available.
ii. A table with a smooth top at least 180 cm x 105 cm.
iii. Means for sterilising instruments.
iv. A couch.
v. Two stretchers.
vi. Two buckets or containers with close fitting lids.
vii. Two rubber hot water bags
viii. A kettle and spirit stove or other suitable means of boiling water.
ix. Twelve plain wooden splints 900 cm x 100 cm x 6 cm.
x. Twelve plain wooden splints 350 cm x 75 cm x 6 cm.
xi. Six plain wooden splints 250 cm x 50 cm x 12 cm.
xii. Six woollen blankets.
xiii. Three pairs of artery forceps.
xiv. One bottle of spiritus annemia aremations (120 ml).
xv. Smelling salt (60 gm).
xvi. Two medium size sponges.
xvii. Six hand towels.
xviii. Four kidney trays.
xix. Four cakes of toilet, preferably antiseptic soap.
xx. Two glass tumblers and tow wine glasses.
xxi. Two clinical thermometers.
xxii. Two tea spoons.
xxiii. Two graduated (120 ml) measuring glasses.
xxiv. Two minimum measuring glasses.
xxv. One wash bottle (1000 cc) for washing eyes.
xxvi. one bottle (one litre) carbolic lotion 1 to 20.
xxvii. Three chairs.
xxviii. One screen.
xxix. One electric hand torch.
xxx. Four first-aid boxes or cupboards stocked to the standards prescribed in
xxxi. An adequate supply of tetanus toxide.
xxxii. Injections—morphia, pethidine, atrophine, adrenaline, coramine, novocaine (6 each).
xxxiii. Cramine liquid (60 ml).
xxxiv. Tablets—antihistaminic antispasmodic (25 each).
xxxv. Syringes with needles—2 cc, 5 cc, 10 cc and 500 cc.

xxxvi. Three surgical scissors.
xxxvii. Two needle holders, big and small.
xxxviii. Suturing needles and materials.
xxxix. Three dissecting forceps
xl. Three dressing forceps
xli. Three scalpels.
xlii. One stethoscope and a B. P. apparatus.
xliii. Rubber bandage—pressure bandage.
xliv. Oxygen cylinder with necessary attachments.
xlv. Atropine eye ointments.
xlvi. I. V. Fluids and sets 10 nos.
xlvii. Suitable, foot operated, covered, refuse containers.
xlviii. Adequate number of sterilised, paired, latex hand gloves.

B. Ambulance

1. When number of workers is <500:
   If the distance to a major hospital capable of handling critical injuries expected at Site is <= 50 KM from Site, then 1 BLS (Basic Life Support)/ Type B Ambulance otherwise ALS* (Advanced Life Support)/ Type D Ambulance
2. If no. of workers increases to >2000 workers one additional BLS Ambulance to be deployed
3. Minimum Articles as per Schedule V of BOCW Central Rules to be ensured in each Ambulance. (given under for convenience)

*Final call to be taken at Site in consultation with all the contractors

SCHEDULE V (BOCW CENTRAL RULES, 1998)
CONTENTS OF AMBULANCE VAN OR CARRIAGE
[SEE RULE 227]

The Ambulance Van shall have equipment prescribed as under:

a) General—a portable stretcher with folding and adjusting devices with the Head of the stretcher capable of being tilted upward. Fixed suction unit with equipment. Fixed oxygen supply with equipment. Pillow with case, sheets, blankets, towels, emergency bag, bed pan, urinal glass.
b) Safety Equipment-Flaros with life of three thousand minutes, floor lights, flash lights, fire extinguishers (dry power type), insulated guntlets.
c) Emergency Care Equipment—
   i. **Resuscitation**—Portable suction unit, portable oxygen unit, bag valve mask, hand operated artificial ventilation unit, airways, mouth gag tracheostomy adapters, short spine board, I.V. FLUIDS with administration unit, B. P. manometer cuff stethoscope.
   ii. **Immobilisation**—Long and short padded boards, wire ladder splints, triangular bandage—long and short spine boards.
   iii. **Dressing**-Gauze pads—100 m x 100 mm universal dressing 250 x 1000 mm, roll of aluminium foils—soft roller bandages 150 mm x 5 mm yards adhesive tape in 75 mm roll safety pins, bandage sheets, burn sheets.
   iv. **Poisoning**—Syrup of Ipecac, activated charcoal pre packeted dose, snake bit kit, drinking water.
   v. **Emergency Medicines**—As per requirement (under the advice of construction Medical Officer).

ANNEXURE A.1

Sample calculation for deduction of operational cost of facilities

Annexure A.1

Cost Calculation Methodology of Operation of Facilities (Data is indicative only)

(Period of 48 months is considered - shall be on actual basis)

A. Project Info:

Total time of Project	48 months
Project cost	1000 Crore
No. of packages	10 (A1-A10)

B. Item-wise Calculation:

Item	Nos.	Rate	Unit	Amount
Ambulance with Driver	2		Monthly/Unit	170000
Nurse/First aider	2 X 2 shifts	15000	Per month	30000
Training center one time cost	1	100000	Once	100000
Medical center one time cost	1	200000	Once	200000
Medicines at medical center	1	10000	Monthly	10000
Dust supression water tank	2	2000	Monthly	4000
Doctor	1	70000	Monthly	70000
Cleaning staff	1	12000	Monthly	12000
			Recurring monthly expenditure	296000
			Total one-time expenditure	300000

C. Package-wise Deduction Plan for a period of 48 months

Period (In Months)	6	36	6
	For 1-6 months	For 7-42 months	For 43-48 months
Cost to be incurred from contractors	7%	81%	12%
	1.17% per month	2.25% per month	2.00% per month

D. Calculation For One-Time Running Cost

Packages/ Contracts	A1	A2	A3	A4	A5	A6	A7	A8	A9	A10			
Contract Values (in Thousands)	100000	250000	2000000	200000	500000	1500000	1000000	1000000	250000	200000	7000000		
Share of common facilities one time running cost (in Thousands)	4	11	86	9	21	64	43	43	11	9	Individual Pkg value X Total one time running cost / All Pkg award values		
Timeline of work	1-6	1-8	2-48	6-36	7-15	10-48	6-48	7-40	40-48	41-48			
Month Count of work	6	8	47	31	9	39	43	34	9	8			
Deduction per month (in Thousands)	1	1	2	0	2	2	1	1	1	1	Total of One time Running cost (in thousands)	% deduction share of one time running cost per month	Nos. of active packages in month
Month No.													
1	1	1									2	1%	2
2	1	1	2								4	1%	3
3	1	1	2								4	1%	3
4	1	1	2								4	1%	3
5	1	1	2								4	1%	3
6	1	1	2	0			1				5	2%	5
7		1	2	0	2		1	1			8	3%	6
8		1	2	0	2		1	1			8	3%	6
9			2	0	2		1	1			7	2%	5
10			2	0	2	2	1	1			8	3%	6
11			2	0	2	2	1	1			8	3%	6
12			2	0	2	2	1	1			8	3%	6
13			2	0	2	2	1	1			8	3%	6
14			2	0	2	2	1	1			8	3%	6
15			2	0	2	2	1	1			8	3%	6
16			2	0		2	1	1			6	2%	5
17			2	0		2	1	1			6	2%	5
18			2	0		2	1	1			6	2%	5
19			2	0		2	1	1			6	2%	5
20			2	0		2	1	1			6	2%	5
21			2	0		2	1	1			6	2%	5
22			2	0		2	1	1			6	2%	5
23			2	0		2	1	1			6	2%	5
24			2	0		2	1	1			6	2%	5
25			2	0		2	1	1			6	2%	5
26			2	0		2	1	1			6	2%	5
27			2	0		2	1	1			6	2%	5
28			2	0		2	1	1			6	2%	5
29			2	0		2	1	1			6	2%	5
30			2	0		2	1	1			6	2%	5
31			2	0		2	1	1			6	2%	5
32			2	0		2	1	1			6	2%	5
33			2	0		2	1	1			6	2%	5
34			2	0		2	1	1			6	2%	5
35			2	0		2	1	1			6	2%	5
36			2	0		2	1	1			6	2%	5
37			2			2	1	1			6	2%	4
38			2			2	1	1			6	2%	4
39			2			2	1	1			6	2%	4
40			2			2	1	1	1		7	2%	5
41			2			2	1		1	1	7	2%	5
42			2			2	1		1	1	7	2%	5
43			2			2	1		1	1	7	2%	5
44			2			2	1		1	1	7	2%	5
45			2			2	1		1	1	7	2%	5
46			2			2	1		1	1	7	2%	5
47			2			2	1		1	1	7	2%	5
48			2			2	1		1	1	7	2%	5
Total	4	11	86	9	21	64	43	43	11	9	300	100%	

D. Calculation For Recurring Running Cost

Packages/ Contracts	A1	A2	A3	A4	A5	A6	A7	A8	A9	A10		
Contract Values (in Thousands)	100000	250000	2000000	200000	500000	1500000	1000000	1000000	250000	200000	7000000	
Timeline of work	1-6	1-8	2-48	6-36	7-15	10-48	6-48	7-40	40-48	41-48	Total of Recurring cost (in thousands)	Nos. of active packages in month
	6	8	47	31	9	39	43	34	9	8		
Month No.												
1	85	211									296	2
2	13	31	252								296	3
3	13	31	252								296	3
4	13	31	252								296	3
5	13	31	252								296	3
6	8	21	167	17			83				296	5
7		15	120	12	30		60	60			296	6
8		15	120	12	30		60	60			296	6
9			126	13	31		63	63			296	5
10			95	10	24	72	48	48			296	6
11			95	10	24	72	48	48			296	6
12			95	10	24	72	48	48			296	6
13			95	10	24	72	48	48			296	6
14			95	10	24	72	48	48			296	6
15			95	10	24	72	48	48			296	6
16			104	10		78	52	52			296	5
17			104	10		78	52	52			296	5
18			104	10		78	52	52			296	5
19			104	10		78	52	52			296	5
20			104	10		78	52	52			296	5
21			104	10		78	52	52			296	5
22			104	10		78	52	52			296	5
23			104	10		78	52	52			296	5
24			104	10		78	52	52			296	5
25			104	10		78	52	52			296	5
26			104	10		78	52	52			296	5
27			104	10		78	52	52			296	5
28			104	10		78	52	52			296	5
29			104	10		78	52	52			296	5
30			104	10		78	52	52			296	5
31			104	10		78	52	52			296	5
32			104	10		78	52	52			296	5
33			104	10		78	52	52			296	5
34			104	10		78	52	52			296	5
35			104	10		78	52	52			296	5
36			104	10		78	52	52			296	5
37			108			81	54	54			296	4
38			108			81	54	54			296	4
39			108			81	54	54			296	4
40			103			77	51	51	13		296	5
41			120			90	60		15	12	296	5
42			120			90	60		15	12	296	5
43			120			90	60		15	12	296	5
44			120			90	60		15	12	296	5
45			120			90	60		15	12	296	5
46			120			90	60		15	12	296	5
47			120			90	60		15	12	296	5
48			120			90	60		15	12	296	5
Total	143	388	5676	329	235	3102	2334	1772	132	96	14208	

ANNEXURE B

HSE Displays

A. Types of Displays

1. Based on Content

SN	Type
1.	**HSE Hazards & Precautions** Height Work, Housekeeping, Fire Safety, PPEs, Hot Work, Lifting & Rigging Activity, Site-specific Hazards – eg. for Refineries, Nuclear plants etc.; COVID Precautions; Environment Protection etc.
2.	**Other Displays, Signage etc.** HSE Policy, ISO Certificate, Safety Statistics, Assembly Area Location/ Route, Emergency Contact Numbers, Site Safety Rules & Regulations, Speed Limit, Work in Progress, Lock-Out Tag-Out (LOTO) Boards etc.

2. Based on Mounting

[Type 1]	[Type 2]	[Type 3]
Flex Sign Boards of Wooden Frame – directly mounted on Structures (walls, stairs, railings etc.)	Flex Sign Boards with Wooden Frame – mounted on metallic/ wooden legs – preferably double-sided	Coloured weather-proof Paintings on Walls (after due concurrence of BHEL/ Customer – Type 1 in case of no concurrence/ space)

B. <u>General Requirements:</u>

a. Displays should be weather-proof as per installation location, i.e. rain-proof, wind-proof and sun-proof.
b. Installation location and size to ensure visibility for the intended viewers (workers and moving personnel)
c. Displays to have at least 50% graphical elements preferably (as applicable). Language should be understandable by majority of the workers
d. Displays to be relevant to the hazards in the area
e. Proper installation to ensure boards don't obstruct activities and should not be prone to fall so as to pose danger
f. In case of multiple elevations (eg. Boiler, Power-house etc.), each elevation to have displays for applicable hazards including Height-Work, Housekeeping
g. For temporary work locations, posters/ boards may be erected and shifted after task is over
h. Minimum size of displays should be A1 unless otherwise specified
i. In case of damage, displays shall be reviewed and repaired/ replaced
j. In areas where night work is envisaged, fluorescent displays shall be installed and these should comprise of at least 20-30% of total displays
k. Total Number of displays to be not less than 1 per 10 workers and are to be dynamically updated based on number of workers

C. Area-wise Displays

Below is list of Area-wise displays that are to be installed at Sites (Numbers, locations may be adjusted for specific requirements)

SN	Area	Suggested Subjects	Minimum Size	Minimum Quantity	Locations
1	**Walls/ Foundations/ Cement Structures etc. belonging to the package area**	Safety Hazards Prevention and other HSE Awareness content	**[Type 3]**	As per BHEL assessment from time to time	
2	**Site Interior Roads belonging to the package area**	At least every 20 meters: 1. Speed Limit Indication, Safe Driving board 2. Boards for hazard awareness	1.As needed **[Type 2]** **2.** A1 or equivalent each [**Type 2]**	As indicated	Sides of Roads; Height to ensure good visibility
3	**Specific Package Areas**	**A. Common** At entry to respective Package/ Work Area, each contractor to put up daily updated board with following for each shift: 1. Scope of work and start date 2. Emergency Contact Numbers 3. Emergency Assembly Location, Escape Plan 4. Locations and supervisors of various gangs in the area, 5. Current Work permit Details 6. Safety Supervisor Location assignments - Names, Mobile Nos., Assigned Locations 7. Details (Name, Contact No. etc.) of Package In-charge - Contractor & BHEL 8. Details (Name, Contact No. etc.) of Safety In-charge - Contractor & BHEL 9. LTI Free Man-days & details of last LTI also to be indicated In addition, Area-Specific Displays as indicated in Table 1	**A0** **[Type 2]**	1 per Package Area	Entry/ Ground Level

Table 1

(Area/ Package-wise HSE Display Plan – As applicable)

Prepared By (Subcontractor)				
S. No.	**Area**	**Suggested Minimum No. of Displays & Types**	**Type**	**Numbers Installed**
1	Boiler	3 per working elevation	**[Type 1]**	
2	Powerhouse	5 per elevation	**[Type 1]**	
3	ESP	5 Per Pass	**[Type 1]**	
4	Buildings	5 per elevation	**[Type 1]**	
5	Cooling Tower (NDCT/ IDCT/ ACC)	20 per Structure	**[Type 1]**	
6	Chimney	20 per Structure	**[Type 1]**	
7	Fabrication Yard	10 per Yard	**[Type 2]**	
8	Batching Plant	5 per Plant	**[Type 1]**	
9	Material Storage Yard – Open	20 per Yard	**[Type 2]**	
10	Material Storage Shed – Semi-Closed/ Closed	10 per Shed	**[Type 1]**	
11	Electrical Booths	2 per booth + Line diagram, Emergency contact details	**[Type 1]**	
12	Medical & First Aid Centre	2 per Centre	**[Type 1]**	
13	Rest Shed	2 per Shed	**[Type 1]**	
14	Canteen	2 per Canteen	**[Type 1]**	
15	Drinking Water Area	1 Per Outlet	**[Type 1]**	
16	Washing Water Area	1 Per Outlet	**[Type 1]**	
17	Training Centre	10 per room	**[Type 1/2]**	
18	Assembly Area	5	**[Type 1/2]**	
19	Stairs	1 per landing elevation	**[Type 1]**	
20	Cylinder Storage Area	5 + Signage: Type of Gas, Empty, Filled etc.	**[Type 1/2]**	
21	Labor Colony	Electrical Safety with Distribution Plan/ Line Diagram - 1 COVID Precautions Posters – 5 Safety Awareness Posters – 10 Hygiene awareness posters - 2	**[Type 1]**	
22	Others	As per requirement	**[Type 1/2]**	

Date:

Sign (Contractor) **Sign (BHEL)**

ANNEXURE C

HSE Tools/ Equipment/ Devices

Following equipment conforming to relevant IS/ISO/BS Codes/ Standards in indicated quantities shall be ensured by subcontractor. This list is tentative, not exhaustive. Quantity and date/ period of deployment shall be as per site requirement.

A. HSE Tools/ Equipment/ Devices

SN	Item
1	Lifelines
2	Retractable Fall Arrestors
3	Safety Nets (10m X 5m) fire proof double mesh
4	Sky Climbers
5	Fire Blanket
6	Honey Bee Removal Suit & Kit
7	Scaffolding Pipes
8	Flashback Arrestors
9	Barricading Tape
10	Binoculars
11	Walkie-Talkies
12	LOTO kit
13	24-Volt light
14	Sand Buckets
15	Hard barricading Pipes
16	Standby Fire kits
17	Hand-held Megaphone
18	Small Public Address System
19	Foldable Stretcher
20	Height Rescue Kit (Non-Motorized)
	(Others:)

B. Test & Measurement Devices

SN	Device
1	ELCB Tester
2	Multi meter (Light cables)
3	Earth Resistance Meter
4	Lux Meter
5	Sound Meter
6	Anemometer
7	Breath Analyzer (Alcohol)
8	Multi-gas dozi-meter/ detector
9	Gas leakage detector / alarm
10	Gas monitor (confined space)
11	Radiation meter & Badges
12	Blood Pressure Monitor
13	Fire detectors
14	Hand held signaling light
	(Others:)

ANNEXURE D

Rest Sheds

1. Determining the Number, Sizes and Locations of Rest Shelters

i. **Numbers:**

The number of rest shelters shall be determined based on maximum number of workers at any one time (across all shifts). Formula is:

Wmax = Maximum number of workers at any time in the Site

Space per worker = 1.1 sq meter

Total space required, Tspace = Wmax X 1.1

Based on total space requirement calculated above, the number of rest sheds can be decided according to availability of locations and concentration of workers – so as to ensure the required space.

ii. **Locations:**

The rest sheds should be so located so as to minimize the distance to be travelled by the workers from their locations of work considering all the practical constraints

iii. **Other:**

The Rest shelter should be fenced so that it cannot be used as parking area.

2. Design & Construction of Rest Sheds

a. Permanent/ Long duration Rest Sheds

i. For locations where, permanent rest sheds can be constructed without possibility of removal for relatively long period of time, a semi-closed shed can be constructed covered with tin roof and supported with well-grouted beams. The floor of the shed to be preferably cemented/ solidified.

ii. Adequate structural requirements suitable to the local weather (wind/ rain etc.) to be ensured.

iii. The design of the rest shed to be approved by Civil Engineering Department of BHEL Site before commencing work

b. Temporary/ Movable/ Portable Rest Sheds

i. For locations where, permanent rest sheds cannot be constructed either due to non-availability of permanent location or other reasons, temporary rest shed shall be constructed.

ii. Temporary rest sheds shall comprise of Tent arrangement carried out by professional agencies

3. Amenities in Rest Sheds

a. Essential Amenities

Following amenities shall be essentially ensured in a rest shed:

i. Hygienic environment with regular cleaning and housekeeping (with records)
ii. Adequate illumination
iii. Adequate ventilation/ heating as per weather conditions
iv. Clean Drinking water source
v. Hand Washing area
vi. Toilets & Urinals
vii. Benches/ mats for sitting/ lying
viii. Any other essential requirement deemed necessary by the Site
ix. Dust bins of sufficient quantity/ size that are vacated each day/ as per requirement

b. Additional/ Optional Amenities

Following amenities are optional but are recommended to enhance the level of satisfaction of work force:

i. Hot/ Cold drinks (Tea, Coffee, Glucose etc.) as per requirement
ii. Snacks
iii. Fans/ Coolers/ Heating arrangements as per requirement and weather conditions
iv. A nice, welcoming interior design, music etc.
v. Water cooler

4. Health & Safety Requirements of Rest Sheds

Use of asbestos in construction is banned and shall not be used.
In addition, following essential Safety features shall be ensured in Rest sheds:

i. Availability of Fire extinguishers (preferably CO2 type)
ii. Display of Safety Posters
iii. Pest/ reptile protection
iv. Mosquito prevention measures

5. Note:

Any suitable closed spaces/ newly constructed buildings etc. available at project may also be used for the purpose of rest shed with due concurrence of BHEL

ANNEXURE E

Labor Colony

1. These Guidelines suggest minimum requirements. However, additional requirements based on feasibility and circumstances, while adhering to directions of GOI/District Administration/Local Authority guidelines to be considered
2. Norms for social distancing, training/ awareness, face masks, disinfection, sanitization, gate entry, quarantine, medical, action in case of suspect cases of COVID and other communicable diseases etc. to be followed as per Govt. and BHEL guidelines issued from time to time
3. Labor colony to be developed as close to the Site as possible to avoid lengthy commute
4. A "Suggestion Register" shall be made available at the labor colony for residents. The feedback shall be reviewed on weekly basis and acted upon by concerned Contractor. Same shall be reviewed periodically by authorized BHEL Site Official.
5. **Canteens, Latrines & Urinals, Washing Facilities, Creches, Residential Accommodation and other infrastructure/ facilities:**
   Numbers/ Quantities and Features of these facilities shall be in line with the following as applicable:

   a. BOCW Act & State Rules
   b. The Inter-State Migrant Workmen (Regulation of Employment and Conditions of Service) Act & State Rules
   c. Factories Act & State Rules
   d. Other Relevant Acts & Rules

6. **Cleanliness & Hygiene/ Housekeeping:**
   a. Regular cleaning of the labor colony to be ensured.
   b. Daily cleaning of Sanitary facilities.
   c. Proper drainage system to prevent water-logging
   d. Regular fogging to prevent spread of mosquitoes
   e. Prevention of foul smell through necessary interventions
   f. Dust suppression as per requirement
   g. Cutting of Grass at regular intervals and other necessary measures to prevent pests & reptiles
   h. Stray animals to be banned from labor colony.
   i. Outside every common facility, eg. Toilet, washroom, food hall/ canteen etc., provision of washbasin with flowing water and soap (preferably liquid soap) to be ensured
7. **Power Supply Layout:**
   Electrical supply Layout of Labor Colony shall have the provision of Safety devices like MCBs, ELCBs etc. and to be clearly displayed
8. **Washing & Drinking Water Availability**
   a. Adequate water to be provided in line with: "Estimation of Water Requirements for Drinking and Domestic Use (Source: National Building Code 2016, BIS)"
   b. Drinking water tank to be cleaned every week and sticker for the same pasted on the tank
   c. Drinking water source should be tested as per IS 10500
9. **Waste Disposal:** Separate bins for dry, wet and biomedical waste to be installed. These bins to be evacuated regularly
10. **Training & Awareness/ Displays**
    a. **HSE Awareness Displays**: Posters/ banners/ boards to be displayed in labor colony. Subjects of displays shall be precautions for applicable hazards at work site.
    b. **Emergency Contact Numbers** including that of Doctor, Hospital, Labor Colony Supervisor, HSE Officials to be displayed prominently

11. **Doctor Visits:**
    Regular and need-based visits by Doctors to be ensured through tie-ups etc.
12. **Inspection & Review:** Regular inspection of labor accommodation to be carried out by the Contractor as per prescribed format. Last inspection date, inspector and next due date to be prominently indicated near main gate
13. Provision of a Fair Price shop in the premises to be ensured as per requirement
14. Adequate arrangements to be ensured in case of children/ families

ANNEXURE F

Toilets

Toilets (Latrines and urinals shall be ensured at Site and Labor Colony in accordance with the Inter-State Migrant Workmen Act, 1979 as given below:

LATRINES	URINALS
1. Latrines shall be provided in every establishment on the following scale, namely: - a. Where females are employed, there shall be at least one latrine for every 25 females; b. Where males are employed, there shall be at least one latrine for every 25 males: Provided that where the number of males or females exceeds 190, it shall be sufficient if there is one latrine for 25 males or females, as the case may be, up to the first 100, and one for every 30 thereafter 2. Every latrine shall be under cover and so partitioned off as to secure privacy, and shall have a proper door and fastenings.	1. There shall be at least one urinal for male workers up to fifty and one for female up to fifty employed at a time: Provided that where the number of male or female workmen, as the case may be, exceeds 500 it shall be sufficient if there is one urinal for every fifty females up to the first 500 and one for every 100 or part thereof thereafter. 2. The urinals shall be designed and located so as to ensure privacy.

Important:

1. Where workers of both sexes are employed there shall be displayed outside each block of latrine and urinal a notice in the language understood by the majority of the workers 'For Men Only', or For Women Ónly', as the case may be.
2. The notice shall also bear the figure of a man or of a woman, as the case may be.
3. The latrines and urinals shall be conveniently situated and accessible to workers at all times at the establishment.
4. The latrines and urinals shall be adequately lighted and shall be maintained in a clean and sanitary condition at all times.
5. Latrines and urinals other than those connected with a flush sewage system shall comply with the requirements of the public health authorities.
6. Water shall be provided by the means of tap or otherwise so as to be conveniently accessible in or near the latrines and urinals.
7. At Site, on ground, Modular Bio-toilets as per industry standard specifications and regular professional cleaning shall be ensured. The toilets should be sufficient in number and easily accessible to workers from every work area
8. At Site, in various elevations, suitable urinals with proper drainage to be ensured at each elevation in line with IS 2064 (1993). Same to be cleaned regularly

ANNEXURE G

Fire Extinguishers

SN	Type of Fire Risk (Class of Fire)	Extinguishing Medium & Relevant INDIAN STANDARD	Scale of Equipment (Minimum recommended)
1.	**CLASS 'A'** Fires involving ordinary combustible materials like wood, paper, textiles, rubber etc. (Ordinary hazard or low fire load)	WATER Soda acid type, water type (gas pressure) and water type (constant air pressure) IS: 934 -1976; IS: 940 -1976; IS: 6234 -1971	For every 600 square meter floor area or part, one 9-litre capacity. Minimum 4 numbers per floor or room; should not be required to travel more than 15 meter to reach any extinguisher.
2.	**CLASS 'A'** (Extra hazard &high fire load)	-do	-do – (Also, consult local fire authority).
3.	**CLASS 'A'** (Special hazards)	-do	-do – Extra provision For every 100 square meter floor area or part, one 4.5 Kg. CO2; minimum 2 numbers per room; should not be required to travel more than 10 meter to reach any extinguisher.
4.	**CLASS 'B'** (Fires in flammable liquids like oils, solvents, petroleum, products, varnishes, paints, etc. where blanketing effect is essential) (Storage and handling in small quantities)	FOAM / CARBON DIOXIDE / DRY CHEMICAL POWDER IS: 933 -1976; IS: 2878 1976; IS: 2171 1976; IS: 4308 -1982	For every 50 square meter floor area or part, 2 numbers 9 -liters foam or 5 kg dry powder; should not be required to travel more than 10 m in the area of storage to reach any extinguisher.
5.	**CLASS 'B'** (Bulk storage other than in tank form))	-do -	-do- (but minimum 3 numbers per room)
6.	**CLASS 'C'** (Fires involving gaseous substances under pressure where it is necessary to dilute the burning gas at a very fast rate with an inert gas or powder) (storage and handling of gas cylinders)	CARBON DIOXIDE / DRY CHEM. POWDER. The best way to extinguish such fire is by stopping the flow of fuel gas to the fire. Container is kept cool with water spray. IS: 2878 1976; IS: 2171 -1976; IS: 4308 -1982	For every 100 square meter floor area or part; 2 numbers, 10 kg powder extinguisher or 6 kg C02; minimum 3 nos. per room; should not be required to travel more than 10 meter to reach any extinguisher.
7.	**CLASS'D'** Fires involving metals like magnesium, aluminum, zinc, potassium etc. where the burning metal is reactive to water and which require special extinguishing media or technique	SPECIAL DAY POWDER IS: 2171 -1976 IS: 4861 -1968	For every 50 square meter floor area or part, 2 nos. 5 kg special dry powder; minimum 3 nos. per room; should not be required to travel more than 10 meter to reach any extinguisher.
8.	**MIXED OCCUPANCY** (electrical); Generators; Transformers; etc.	CARBON DIOXIDE DRY POWDER, IS: 2878 1976; IS: 2171 -1976	For every 100 square meter floor area or part one 10 kg C02. Minimum 2 numbers for every location should not be required to travel more than 10 meter to reach an extinguisher.
Note: Due to peculiarities of the power plant construction sites, there would be locations in the construction areas of Boiler, Turbine, Generator, Transformer, etc. where different types of fire risk (classes of fire) may co-exist. Special care shall be taken while selecting and installing portable fire extinguishers for such locations so that all types of fire risk that may co-exist, are adequately covered. Similar special care shall be taken for storage areas.			

a. All Electrical welding booths shall be equipped with appropriate Fire Extinguisher

b. Appropriate Fire Extinguishers shall be made within easy reach of all welding operations
c. Fire extinguishers shall be regularly tested and last checked date to be indicated on each. Master list shall be prepared with location and details
d. Providing appropriate fire-fighting equipment at designated work place and nominate a fire officer/warden adequately trained for his job.
e. Subcontractor shall provide enough fire protecting equipment of the types and numbers at his office, stores, temporary structure in labour colony etc. Such fire protection equipment shall be easy and kept open at all times.
f. The fire extinguishers shall be properly refilled and kept ready which should be certified at periodic intervals. The date of changing should be marked on the Cylinders.
g. All other fire safety measures as laid down in the “codes for fire safety at construction site” issued by safety coordinator of BHEL shall be followed.
h. Non-compliance of the above requirement under fire protection shall in no way relieve the subcontractor of any of his responsibility and liabilities to fire incident occurring either to his materials or equipment or those of others.
i. Emergency contacts nos. must be displayed at prominent locations
j. Tarpaulin being inflammable should not be used (instead, only non-infusible covering materials shall be used) as protective cover while preheating, welding, stress relieving etc. at site.

ANNEXURE H

HSE Compliance Certificate

Bill Ref no:_____Date:_____

NAME OF THE AGENCY: _____ Work-Area/Package:_____

Sl. No.	Description	Remarks
1	**HOUSE KEEPING**:	
1.1	All working areas at site (specific to the agency) are free from garbage's, scraps & any other undesired non-plant materials. There is no encroachment in safe passage of man, material & T&P to carry out activities safely	
1.2	All the plant materials under the custody of the agency are stacked & stored properly.	
2	**GENERAL ILLUMINATION**:	
2.1	ALL the working areas at site & office of the agency including passages are having proper & sufficient illumination.	
3	**STATUTORY & REGULATORY REQUIREMENT**:	
3.1	Sufficient water for drinking & other purposes and sanitation in work area and labour colony are available.	
3.2	Periodical Medical check-up of workers & staff done regularly & report submitted to BHEL	
3.3	Regular EYE testing is done for Crane operators/Welders and data's are available with agency	
3.4	All the T&P, Cranes etc used by the agency are having proper T.Cs & Fitness certificate available from competent authority.	
4	**SAFETY COMPLIANCE:**	
4.1	Number of Tool box meetings between Safety officers, erection staff & workers of the agency held in this month with location mentioned	
4.2	All precautions & Safety measures including PPE compliances are taken before working at HEIGHT	
4.3	Permit for working at Height is taken & complied accordingly	
4.4	ELCB is used in Construction Power Supply source by the agency & Proper Distribution board and electrical cabling has been used by the agency and regularly checked by electrician & safety officer of the agency	
4.5	Unsafe areas barricaded properly &unsafe opening closed properly	
4.6	Proper Platforms & Hand-rails used In areas earmarked earlier	
4.7	Proper safety signage's, Slogans & Emergency contact phone numbers including FIRE contact nos. are made available by the agency in locations mentioned	
5	Whether any penalty imposed by BHEL towards non-compliance of above points.	

VENDOR'S SIGNATURE	
Erection Engineer	
HSE Officer	
Site-in-Charge	

BHEL'S SIGNATURE	
Erection Engineer	
HSE Officer	
Package-in-Charge	

ANNEXURE I

Activity-Specific Safety Precautions/ Controls

INDEX OF CONTENTS

S. No.	Description	Page No.
1.	General	2
2.	Work at height	2
2.1	Personnel fall protection system must include	3
2.2	Working Platform	4
2.3	Scaffolding	5
2.4	Ladder Safety	7
3.	Excavation & Civil Works	8
3.1	Excavation	8
3.2	Piling	9
3.3	Batching Plant Operation	9
3.4	Mobile Plant	10
3.5	Concrete Vibrators	11
3.6	Concrete Mixers	11
4.	Welding & Gas Cutting Safety (Hot Work)	11
5.	Lifting & Rigging Safety	13
5.1	Cranes & Hoisting Equipment	15
6.	Demolition Work	20
7.	T&Ps General	21
8.	Chemical Handling	21
9.	Electrical Safety	21
10.	Use Of Hand Tools And Power-Operated Tools	25
11.	Start Up, Commissioning And Testing:	27
12.	Fire Safety	27
13.	Painting	28
14.	Hazardous Energy" Control Procedure/ Lockout/Tagout (LOTO)	30
15.	Risk Assessment	37
16.	HSE Preparedness For Adverse Climates And Weather	38
16.1	Summer	38
16.2	Monsoon	39
16.3	Emergency Weather Conditions	41
16.4	Prevention Of Covid-19 At Project Site & Labor Colony	42
16.5	Noise Mitigation	44

General

The philosophy of hierarchy of controls as below shall be followed

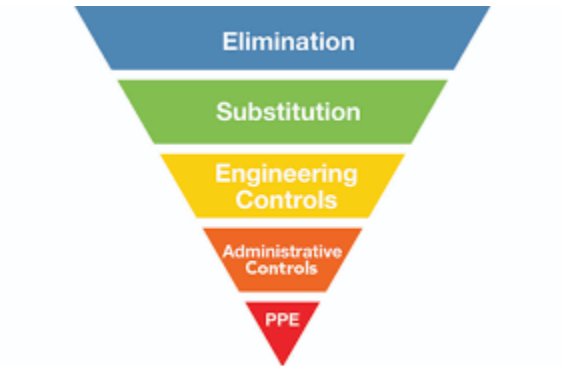


Fig. 1.1

It shall be ensured that there are multiple protections against any accident/ incident. For example, for height work there shall be safe platforms and walkways, Safety Nets and Lifelines for hooking double lanyard Safety harness by workers.

Monitoring and modifying worker behavior shall be part of ensuring safety. All personnel should be competent and trained for the job

Brief Safety guidelines for various hazardous activities are indicated below, besides the mandatory requirements based on Hazard Identification studies, HSE Procedures, Operational Control Procedures, Work Permits, applicable Indian Standard Codes and other provisions detailed in this document. Constant supervision at all times to be maintained by Execution & Safety Team to ensure implementation of these provisions.

1. WORK AT HEIGHT:

a. All work at height above 2 meter above ground level without complete platforms, handrails and other related fall protection shall require a work permit in the prescribed form. This shall require approval by the competent authority. The HSE officer of sub-contractors shall follow the checklist religiously by physically verifying the condition of the work area before recommending for approval.

b. Prior to the start of work at elevation, the HSE Officer involved with the work must meet the work supervisor to review the scope of work, and must review all the possible fall hazards and effective safety responses. The evaluation / analysis must be documented and kept on file and on site by the HSE Officer.

c. Whenever a fall hazard or other exposure exists for working at heights more than 2.0m/6ft, the nature and scope of work will be evaluated for conditions and environmental factors before selecting the appropriate fall protection system (active, passive or a combination of measures, as appropriate).

d. All Engineering and Administrative Controls including barricading, safe platform, Safety Nets etc. shall be made available at work location. Under no circumstances, there shall be total reliance on PPEs only

e. **Safety Nets**

   i. Contractor shall maintain sufficient stock of Safety Nets for deployment

   ii. Safety Nets as per IS: 11057:1984 should be used extensively for prevention / arrest men and materials falling from height.

   iii. The safety nets shall be fire resistant, duly tested and shall be of ISI marked.

iv. Safety Nets shall be deployed below all platforms where height work is envisaged. Duration of work, delay shall be no excuses for non-installation of Safety Net

f. Reaching beyond barricaded area without lifeline support, moving with support of bracings, walking on beams without support, jumping from one level to another, throwing objects and taking shortcut must be discouraged.
g. Monkey Ladder shall be fitted with cages. Rope ladder should be discouraged.
h. In case of pipe-rack, persons should not walk on pipes and walk on platforms only.
i. In case of roof work, walking ladder/ platform should be provided along with lifeline and/ or fall arrestor.
j. For chimney or structure painting, both hanging platform and men should be anchored separately to a firm structure along with separate fall arrestor.
k. The procedures for the safety response to identified fall hazards developed and rescue plans must be reviewed with all individuals exposed to the hazards.
l. The HSE Officer must establish an inspection process of fall protection systems. Some equipment requires documented inspections by its manufacture on a regular schedule. Such equipment must have evidence of the inspection and re-certification process on it. This information must be reviewed before the equipment is actually used. Individuals must visually inspect the fall protection equipment before each use. Failure to complete this inspection process could result in serious injury or death.
m. Immediately remove from service any fall protection equipment that is identified as defective, damaged, or has been subjected to an impact. Damaged fall protective equipment must be destroyed to prevent re-use and not be discarded into trash containers, as the worn or damaged equipment could be unintentionally re-used.
n. Aerial lifting devices, excluding scissor lifts require the use of full body harnesses and lanyards in any elevated position.
o. Where Height related works are applicable then rescue team (consist of 5- 10 person) shall be identified and trained for potential rescue.

1.1 Personnel fall protection system must include:

a. Safety Harness

All height workers must use Full Body Safety harness with double lanyards with shock absorber (only). The primary lanyard is never unhooked until the secondary lanyard is secure. The design of the working platform should be such that under no circumstances, worker should have both lanyards unhooked while at height.

b. Lanyard

i. The type of work and the environment conditions determine lanyard and lifeline selection. If welding, chemical cleaning that may damage lanyards, connectors or lifelines, sandblasting, etc., either protect the components or use more appropriate type of system.
ii. Lanyards and lifelines must incorporate, or be used with, an appropriate deceleration (shock absorbing) device. Deceleration devices include rope grabs, rip-stitch lanyards, specially woven lanyards, tearing, or deforming lanyards, automatic self-retracting lifelines and lanyards which dissipate or limit the energy imposed on the employee during fall arrest.
iii. Once in use, the system's effectiveness is to be monitored. In some cases, a program for cleaning and maintaining the system may be necessary. Lanyard and lifelines must use locking snap hooks only and under

no circumstances must two lanyard snap hooks be connected.

c. Lifeline

All lifelines in general are to be made of min 12mm dia. steel rope (plastic coated) and tied to columns with 3 clamps at each end. Wherever columns are not available to tie the lifelines, the vertical posts as per the design below are to be provided after carrying out drop load test initially. A load of 240kg to be dropped off the mid-point of lifeline in this test.

d. Lifeline Post

DIAGRAM : LIFELINE POST

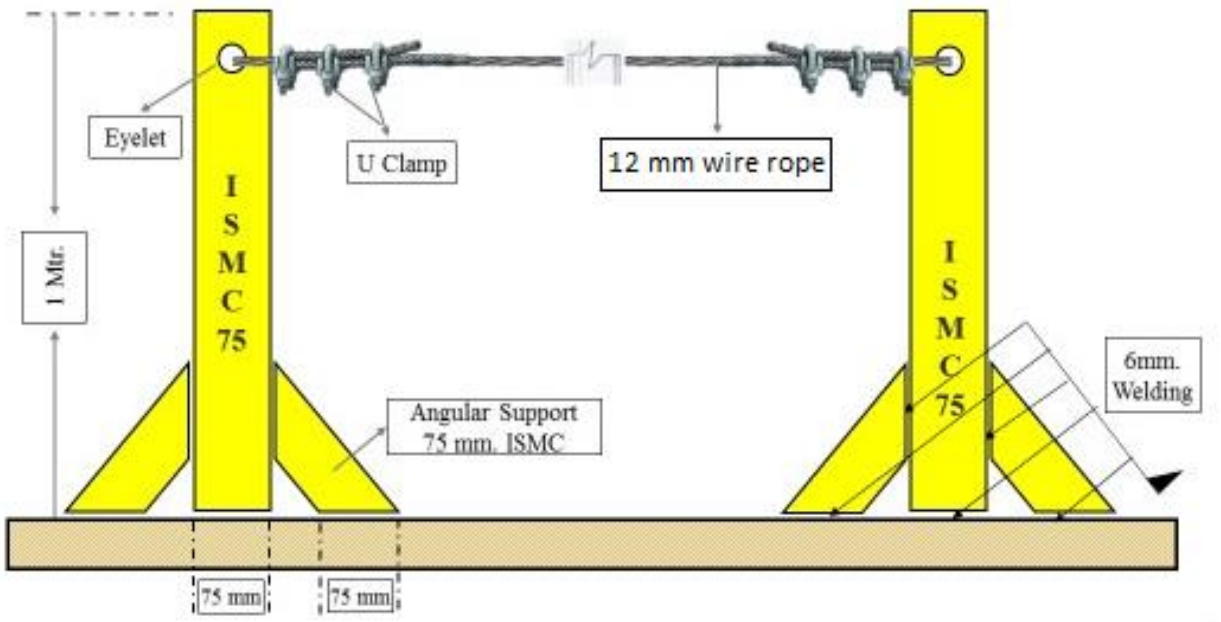


Fig. 2.1 Lifeline Post

i. The support at vertical post shall be fixed at end-to-end (welded/ bolted). The maximum length of one end to another end shall be 6 meters

ii. If the length of a lifeline is more than 6 meters, then intermediate vertical post(s) are to be used. Such intermediate post(s) will act as supports and the lifeline rope should simply pass through the eyelets (holes) of such supports without being anchored

iii. The lifeline need not be wrapped / clamped to any intermediate post

iv. Such intermediate posts must be used at an interval of every 6 meters

v. The post(s) in which the original lifeline is to be installed should be capable of sustaining a tensile stress of 2268 Kgs.

vi. In a horizontal lifeline installation, maximum allowable sagging is 500-600 mm

vii. For a single spun lifeline, no more than 3(Three Nos.) persons are allowed to work; for more than two workers, another lifeline should be installed

viii. Horizontal lifeline should be so installed that it does not impede safe movement of workers

ix. All the installation work must be carried out by competent person with adequate knowledge

1.2 Working Platform

a. Working platforms, gangways and stairways shall be so constructed that they do not sag unduly or unequally and if the height of the platform gangways provided is more than 3.6 m above ground level or

floor level, they shall be closely boarded and shall have adequate width, which shall not be less than 750 mm and be suitably fenced.

b. <u>Precautions against the fall of Materials, Persons and Collapse of Structures:</u>

i. Every opening in the floor or a building or in a working platform shall be suitably barricaded to prevent the fall of persons by providing suitable fencing or railing whose minimum height shall be 90 cm.

ii. Adequate precautions should be taken such as the provision of fencing, or barriers to protect any person who might be injured by the fall of materials, or tools or equipment being raised or lowered. Hard barricading shall be made at such places made of scaffolding pipe & clamps covered with reflective net. Cradle may be used for lifting materials - however this shall be made of MS angles and flats only and duly certified by the HSE officer. Operators may also use designed containers for lifting small tools.

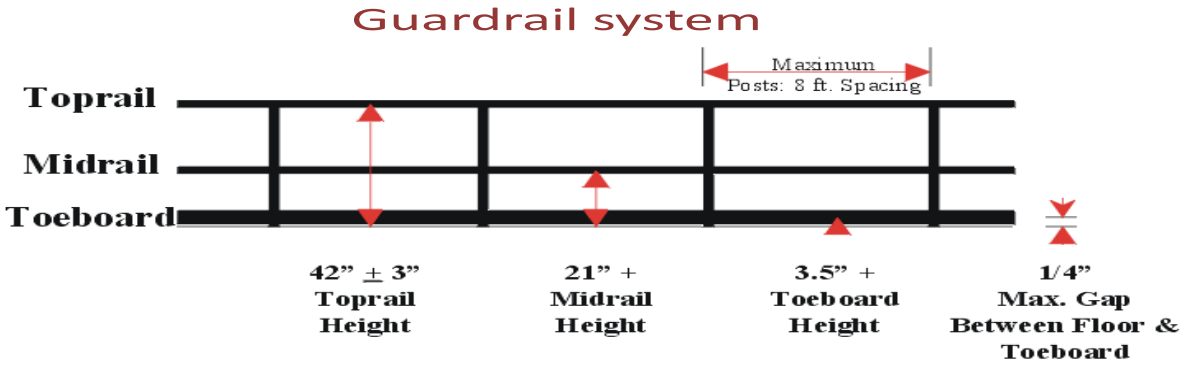
iii. Guardrails (including scaffolding) erected over/adjacent working areas must have the guardrails screened (opening < 0.5), to prevent material from falling outside the platform/decking.

iv. Guardrails must be able to withstand a 200-pound force exerted in any one direction.

v. Where necessary to prevent danger, guys, stays or supports should be used or other effective precautions should be taken to prevent the collapse of structures or parts of structures that are being erected, maintained, repaired, dismantled or demolished.

vi. All openings through which workers are liable to fall should be kept effectively covered or fenced and indicated in the most appropriate manner.

vii. Guardrails and toe-board/barricades and sound platform conforming to IS: 4912-1978 and other Indian laws and regulations as depicted below should be provided.



<u>Fig. 2.2 Guard Rail System</u>

viii. Guardrails shall be provided to protect workers from falling from elevated work places. The rails are generally made of MS pipes of suitable dia. Rebar shall not be used for any handrails, ladder or cover purpose. Wherever the guard-rails and toe-boards cannot be provided:

a. adequate safety nets or safety sheets shall be erected and maintained; or
b. adequate safety harnesses shall be provided and used and / or
c. adequate fall arrestor shall be provided and used.

As mentioned under PPE clause, all these PPEs shall be defect free and regularly inspected for any defect. The full body safety harness shall have double lanyard only with max 1.8m length.

ix. The monkey ladders shall have sufficient fall arrestors. Adequate lifelines of 8mm steel wire rope shall be provided across the work area.

x. The HSE officer shall recommend appropriate PPEs after analyzing hazards and risks involved.

1.3 Scaffolding

All scaffolds shall be conformant to the relevant standards including IS 3696 and IS 4014 as applicable. A sketch of the scaffolds proposed to be used shall be prepared and approval of the BHEL Engineer obtained prior to construction / use. Only cup lock type scaffoldings will be allowed in site. Where cup lock type scaffolding arrangement is not feasible by the virtue of the location, in that case only pipe and clamp type scaffolding will be allowed.

a. The scaffolding work must be carried out by a competent person, who shall train the scaffold users on safety aspects
b. All scaffolds shall be erected / dismantled by scaffolding crew under direct supervision of competent scaffolding supervisors.
c. All scaffolds shall be capable of supporting 4 times maximum intended load and erected on sound, rigid footing, capable of carrying the maximum intended load without settling or displacement. Bamboo scaffolding is not permitted for use on site.
d. Each employee on the scaffold shall use an approved safety harness attached to an independent lifeline. The lifeline is to be securely attached to substantial members of the structure (not the scaffold itself) or to securely rigged lines, which shall safely suspend a worker in event of a fall.
e. Guard rails and toe boards shall be installed on all open sides and ends of platforms more than (2) meters above ground or floor
f. Scaffold planks must be at least 5 cm x 25 cm (2” x 10”) full thickness lumber scaffold grade or better.
g. Scaffold planks shall not span distances greater than 2.5 meters (8 feet).
h. Scaffold planks shall extend over end supports not less than 6 inches nor more than 12 inches and be secured to the scaffold. Scaffolding and accessories with defective parts shall be immediately repaired or replaced.
i. All scaffolding must be a minimum of two planks wide. No one may work from a single plank.
j. Scaffold planks must be inspected before use. Planks that have been damaged must be removed from the site.
k. Access ladders must be provided for each scaffold. Climbing the end frames is prohibited unless the design incorporates an approved ladder.
l. Adequate mudsills or other rigid footing capable of withstanding the maximum intended load must be provided.
m. Scaffolds more the 6 meters (20 feet) in height must be tied to the building or structure at intervals which do not exceed 4 meters (13 feet) vertically and 6 meters (20 feet) horizontally.
n. Do not overload scaffolds. Material should be brought up as needed. Scaffolding must not be loaded in excess of its rated capacity.
o. Barrels, boxes, kegs, blocks or similar unstable object must never be used as work platforms or to support scaffold.
p. Where persons must work under or pass under a scaffold then a 18 gauge wire mesh screen must be installed between the toe board and guard rail.
q. Employees exposed to overhead hazards while working on a scaffold will be protected by 5 cm (2”) thick planks.
r. Wooden/bamboo ladders shall not be allowed at any cost. Ladder’s rungs shall be fitted /welded

properly. Before every use the rungs should be checked for safe use.

s. Wooden scaffolds shall not be used in areas where fire / fire products are expected

t. Ropes made of jute / Plastic and other fire prone material shall not be used to tie up scaffolding components together

u. The platform should have permanent hand rail and mid rail with Toe board without fail.

v. All platforms are to be tightly planked for the full width of the scaffold, except as may be necessary for entrance openings. Platforms shall be secured in place.

w. On suspension scaffolds designed for a working load of 500 pounds, no more than two workers are permitted to work on the scaffold simultaneously. On suspension scaffolds with a working load of 750 pounds, no more than three workers are permitted on the scaffold simultaneously.

x. Requirements for different types of Scaffolds:

A. Suspended Scaffold

i. Suspended scaffolds are platforms suspended by ropes, or other non-rigid means, from an overhead structure.

ii. Requirements for use are to be preapproved by HSE Head, under a specific Permit to Work.

B. Rolling Scaffolds

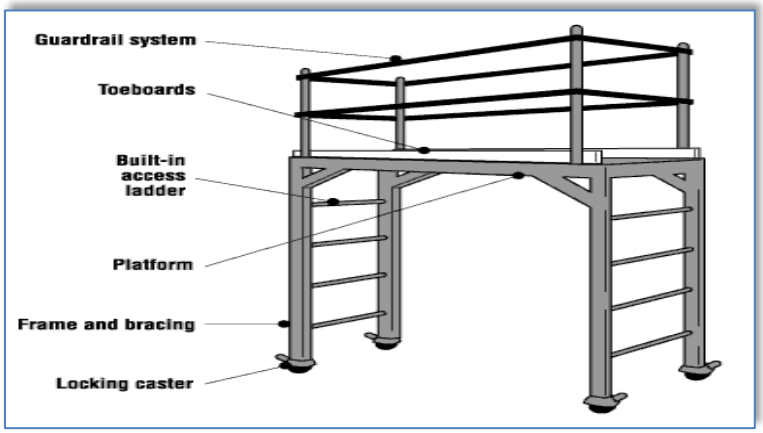
i. The height of rolling scaffolds shall not exceed three times the minimum base dimension.

ii. The minimum base dimension of rolling scaffold will be 1.25 meters (4 feet).

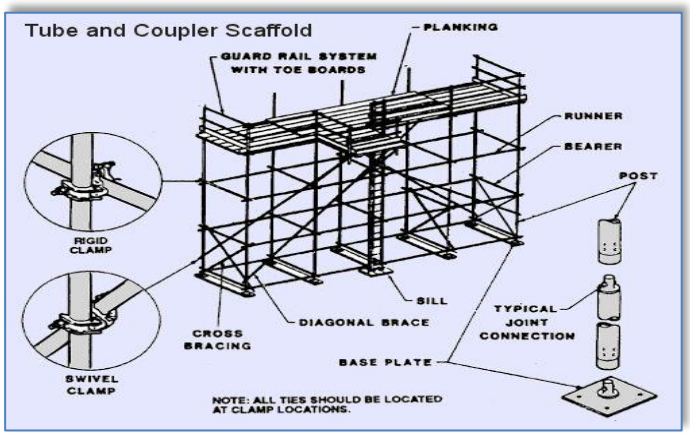
iii. Adequate help must be provided when moving a rolling scaffold.

iv. Secure or remove all loose materials, equipment and tools before moving a rolling scaffold.

v. No one is permitted to ride a rolling scaffold when it is being moved. Castor brakes must be locked-on when the scaffold is not being moved.



Rolling Scaffold



Tube & Coupler Scaffold

Fig. 2.3 Types of Scaffolds

1.4 Ladder Safety

A sketch of the ladders proposed to be used shall be prepared and approval of the BHEL Engineer obtained prior to construction / use

a. Safe Use of Ladders:

i. Fall protection is required when working on a ladder above 2 meters and when climbing above nearby guardrails.

ii. Ladders must be inspected prior to use and by a competent person quarterly, with documentation.
iii. Use portable ladders for height up to 4 M only
iv. Provide fixed ladders for height above 4 M
v. Place the ladder at an angle of 75 degrees (approx.) from the horizontal (1:4)
vi. Extend ladder at least 1 M above the top landing
vii. Secure top and bottom of the ladder firmly to prevent displacement- anti skid lining at the bottom
viii. Ensure that the width of the ladder is not less than 300 mm and distance between rungs is not more than 300 mm
ix. Provide landings of minimum size 600 x 600 mm at intervals not more than 6 M for fixed ladders. Check the ladders daily for any defects
x. Ensure that the areas around base and top of the ladder are clear. Getting on and off the ladder is more hazardous than using it. Use a mudsill if the ladder is to rest on soft, lose or rough soil
xi. Do not use ladders of conducting material near power lines, and only use ladders near power line or other energize system with exposed parts if they are confirmed locked-out and de-energized.
xii. Stand no higher than the fourth rung from the top for carrying out any job standing on a ladder.
xiii. Never reach out from a ladder to perform work where your belt buckle protrudes past the ladder rung.
xiv. Always face the ladder while climbing up or down
xv. Maintain three-point contact while climbing up or down a ladder i.e. two hands and one foot or two feet and one hand on the ladder at all the times.
xvi. Avoid climbing up or down a ladder while carrying anything in hands. Lift tools, equipment and materials with a rope.
xvii. Work from portable and extension ladders near guardrail where fall expose exists over the guardrail regardless of height, and above 2.0 mtr. heights from the working/walking surface will require the use of personal fall arrest equipment

2. EXCAVATION & CIVIL WORKS

All safety precautions shall be taken for foundation and other excavation marks as per IS-3764.

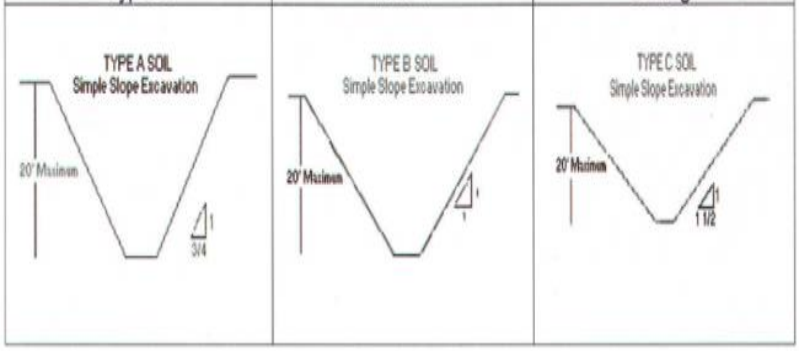
2.1 Excavation

The following safety measures are to be ensured before and during excavation:

a. All Excavation activities more than with depth of 1.22 meter or more shall require and Excavation Work Permit
b. Check for underground utilities like electrical / telephone cables, sewage, water lines and proper care has to be exercised to protect and prevent damage to it.
c. Electrical cables and service lines to be identified using cable detector/locator device before carrying out the excavation work
d. Proper and adequate slope is maintained while excavating
e. Adequate shoring or sheeting is done wherever require to prevent soil sliding
f. Safe access through ladder or steps for exit & entry to excavation
g. No material /excavated soil is kept within one meter from the edge
h. Safe way is planned and provided for movement of HEM /transport equipment near excavation
i. Safety helmet and shoes/gum boots are provided and worn by the workmen at excavation works

j. Dewatering arrangement is made where water seepage is prevailed.
k. Stop blocks are provided to avoid vehicles reversing into the excavated trenches
l. Danger signs /Caution boards are displayed at work spot
m. Hard Barricading is provided at excavated pits. It should be made of scaffolding pipe and clamp with reflective nets.
n. All Excavated area of depth 3mtr or more is to be hard barricaded with pipe.

Soil Type	Height/Depth ratio	Slope Angle
Stable Rock	Vertical	90 deg.
Type A	¾ : 1	53 deg.
Type B	1 : 1	45 deg.
Type C	1½ : 1	34 deg.



Determining Soil Type

Type	Description	Examples
A	Cohesive soils with an unconfined compressive strength of 1.5 tons per square foot or greater.	Clay, silty clay, sandy clay, clay loam and in some cases: silty clay loam and sandy clay loam.
B	Cohesive soils with unconfined compressive strength greater than 0.5 tsf but less than 1.5 tsf.	Angular gravel (similar to crushed rock), silt, silt loam, sandy loam and, in some cases silty clay loam and sandy clay loam.
C	Cohesive soils with unconfined compressive strength greater than 0.5 tsf or less.	Granular soils such as gravel, sand and loamy sand; submerged soil or soil from which water is freely seeping; submerged rock that is not stable.

Fig. 3.1 Excavation Reference

2.2 Piling

Ensure the following precautionary measures before starting piling works:

a. Inspection of piling equipment by responsible person for its condition before initiating piling operation.
b. Checklist and OCP for piling to be prepared using manufacturer's instructions and used
c. Testing and its certification wire rope, slings, D-shackles, chain pulley blocks using in the process of piling work by competent person
d. Adequate support and secured foundation of the piling equipment to avoid toppling
e. Hoses should be lashed and adequately secured
f. Proper work platform is to be provided on piling frame
g. Safe work procedures and close supervision to prevent unsafe acts of operators/any unsafe conditions that may arise
h. Only experienced and trained operators are engaged for the piling operation
i. Provision of Personal Protective Equipment (PPE) like safety shoes/gumshoes/safety helmet/safety belt etc. and its use by their workmen.
j. Special care and precautions If work is near electrical live cables/ electrical equipment
k. Cordoning of work area to prevent un authorized entry
l. Guarding of revolving parts
m. Specific measures to prevent over turning of pile driver/missing of hammer/ hammer movement out of range

2.3 Batching Plant Operation

Following Safety considerations for batching plant are to be ensured:

1. Modern type batching plant should be used in which all the moving parts are protected and emergency

and safety features are incorporated.

2. Installation of external Electric moto-vibrators in the feeding hopper of all batching plants to reduce human intervention.
3. Installation of safety devices like pull-chord on both the sides of conveyor for stopping the conveyor in emergency
4. Workers carrying cement / sand to be given appropriate PPEs like respiratory masks & gloves.
5. Conveyor belt/rotating parts must be guarded properly.
6. Safety awareness shall be inculcated in workmen about the risk involved in rotating parts.
7. The agency shall ensure to erect the batching plant as per drawing including installation of all safety devices as provided by manufacturer and witnessed by BHEL Engineer in charge before starting of machine in future.
8. Safety audit to also focus on Batching plant.
9. The site shall impose penalty on the agency who has violated the safety norms as per contract.

2.4 Mobile Plant

Mobile plant includes tractors, trailers, dumpers, excavators, bulldozers, road rollers etc. for earthmoving purpose and concrete mixers, concrete transit mixtures, concrete pumps etc for concreting purpose. Due to the very nature of their function and movement in difficult terrains, congested areas, working in tandem with manual work and other operations the danger is inherent.

Automatic reverse camera with reverse horn connected with reverse gear is compulsory for all moving machineries.

Following Safety measures to be ensured for Mobile Plant:

a. Where movement around site is involved, routes should be planned, obstruction free and well maintained
b. Observe specified speed limits
c. Operating personnel should be aware of associated risks and its preventive measures
d. Only experienced, trained and authorized persons with valid license (wherever applicable) should operate the mobile equipment/vehicles
e. Provide and use Warning lights and reverse horn for cautioning the people around
f. Operation should be on level and stable ground with adequate working clearance.
g. Loading of out riggers/stabilizers should be well within safe ground bearing capacity
h. No person should be on equipment or vehicle during loading and unloading of material
i. Operators should be protected by warning barriers or switching off power when working in close proximity of overhead power lines
j. The equipment /vehicles should be well maintained and provided with effective brake system and other safety devices (wherever require)
k. Rotating parts of equipment should be adequately guarded
l. Provide necessary personal protective appliances and ensure its use by the operating personnel Ensure effective measures at source to control harmful emissions, dust, fumes contaminating atmosphere and cause health hazards to the operators and people in the vicinity.
m. No overloading/over stressing of vehicles/plant is allowed
n. Hoses, pipes, receivers, gauges and valves involved in carrying out hydraulic fluid/ compressed air should be checked for leaks and tested prior to operation.

o. Adequate safe clearance for swing and movement is to be judged during operation of Concrete mixer
p. Setting of machines on firm and level ground with wheel locked to prevent movement of machine
q. Proper instructions and Special precautions are to be ensured to prevent entry in to the danger zone of projectile of bucket while dropping bucket
r. Operator leaving work spot should ensure that the equipment/vehicle is kept in neutral position and place on firm and level ground.
s. The hand brake should be kept in position and block road wheels as additional safety measure
t. Blades/buckets should be kept low while moving
u. The dozer blades should not be used as brakes except in emergency
v. The ground should be examined for its bearing capacity and general safety especially when operating road roller at the edges of slopes, embankments.
w. The roller should not be moved downhill with the engine out of gear
x. If operating near excavations the following precautionary measures are to be ensured
y. Barricading, edge protection to prevent fall of persons/vehicles over running while reversing etc.
z. Suitable support system and adequate allowance to avoid the danger of side collapsing
aa. Experienced signaler /attendant should be always accompanied with operator/driver for proper direction /signal and also to caution others in the working Zone during operation of mobile plant

2.5 Concrete Vibrators

a. Revolving parts/belt drives should be adequately guarded and Vibrating unit shall be completely enclosed and have suitable overload relays and effectively earthed
b. Ensure sufficient length of cable to the Vibrator.
c. Ensure electric starters and other accessories are firmly fixed adequately supported
d. Ensure locking of needle load while inserting needle in to the vibrator,
e. Ensure periodical lubrication and maintenance

2.6 Concrete Mixers

a. Setting of machines on firm and level ground with wheel locked to prevent movement of machine
b. Proper instructions and Special precautions are to be ensured to prevent entry in to the danger zone of projectile of bucket while dropping bucket

3. WELDING & GAS CUTTING SAFETY (HOT WORK)

a. All Hot Work shall require a Hot Work Permit
b. Inbuilt Voltage Reduction Device (VRD) equipped arc welding machine will only be allowed for work.
c. There shall be flash-back arrestors conforming to IS-11006 at both cylinder and burner ends. Damaged tube and regulators must be immediately replaced.
d. All safety precautions shall be taken for welding and cutting operations as per IS-818.
e. When possible, items to be welded, cut, heated, etc. shall be moved to a safe location free of combustible or flammable material. If this is not possible, then all combustibles/ flammables that can be removed from the area shall be removed within a 35-foot circumference and a positive means of confining arcs and sparks generated by the process shall be ensured and additional person(s) shall be stationed as fire-watch for the area(s) still exposed, along with obtaining the Hot Work Permit as applicable.
f. Appropriate fire-fighting equipment is to be available in close proximity of any welding and gas cutting operations at all times suitable for the type of Fire.

g. Drums, tanks, and similar containers that have contained flammable or toxic material shall not be welded, cut, or heated until they have been made safe by water filling, thorough cleansing or similar accepted practices. The container shall also be ventilated during the welding, cutting, or heating process.
h. Proper ventilation is required for any welding or torch operations performed in a confined space.
i. Any welding or gas cutting operations performed on metals of toxic compounds or coating such as zinc, stainless steel, lead, cadmium, chromium, and beryllium shall be properly ventilated and/or proper respiratory protection shall be worn by any person that could be exposed to fumes, vapors, and gasses created by the welding and gas cutting processes.
j. Wherever it is practical, all arc welding operations shall be shielded to prevent direct light rays or sparks from contacting persons in the vicinity or from reaching areas normally used to travel through or into the vicinity. Where this is not practical, persons who shall be in the area are to use proper eye and skin protection. Other persons who are not participating in the welding or gas cutting operations are not to be allowed into the hazard zone.
k. Welders and other employees who are exposed to arc welding radiation shall wear suitable clothing and protective apparel to prevent burns and other types of ultraviolet radiation damage to the skin.
l. Arc welding machines shall be shut down when being moved or when they are not in continuous use. Electrode holders left unattended shall have electrodes removed and shall not be left where they might contact employees or conducting objects.
m. Arc welding power supply cable shall be of proper rating and material, e.g. copper.
n. Welders shall guard against allowing materials adjacent to or behind them to reflect radiation back toward them or towards others in the area. Reflected radiation can cause skin burns and eye flash burns.
o. Valve caps shall be in place when cylinders are not in use. Valve caps shall never be used for lifting the cylinder vertically.
p. Torches shall only be lit by approved strikers; never with matches, cigarette lighters, or hot-work.
q. Splatter / Slag Collector:

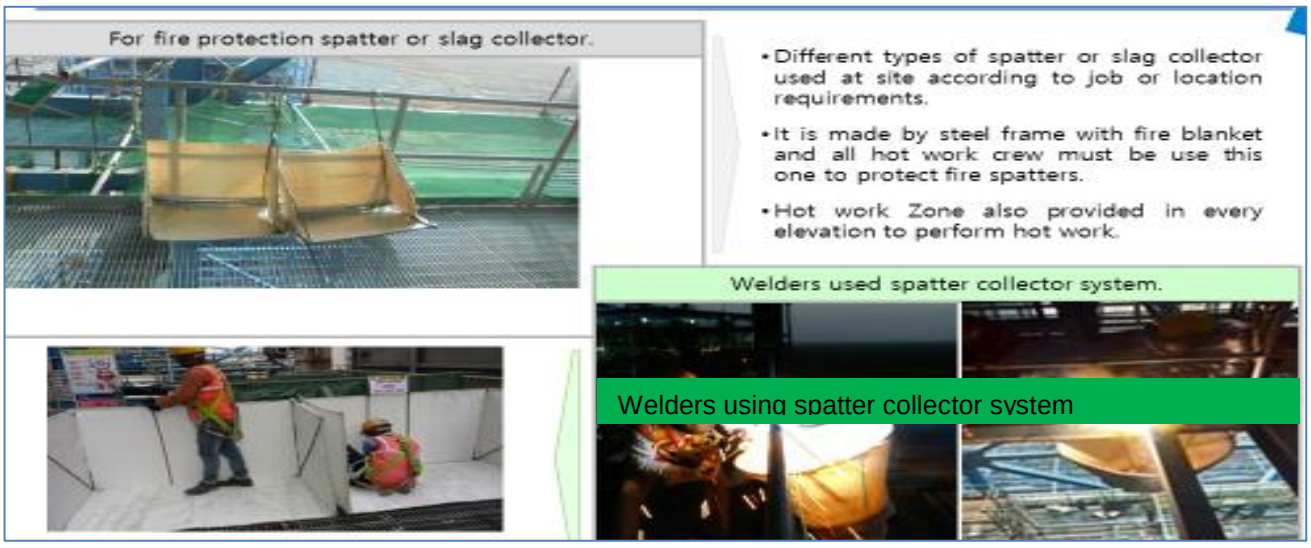


Fig. 4.1 Splatter / Slag Collector

While carrying out job at height, the sparks or molten slag shall be prevented from falling down by putting a fire-resistant (non-asbestos) sheet or patter/ slag collector or even MS Sheet. The passage of falling sparks

or molten slag shall be barricaded till ground floor and any cable/ tubes/ any other objects interfering in the passages hall either be removed or covered with Fire-resistant sheet or MS Sheet.

r. COMPRESSED GAS

i. All cylinder valves shall be closed when any work is finished and when any Cylinders are empty or being moved. Valve protection caps shall be placed and secured properly before gas cylinders are transported, moved or stored.

ii. Compressed gas cylinders shall be secured in an upright position with chain or appropriate means during storage & use. However, a trolley shall be used for transportation.

iii. Compressed gas cylinders shall always be secured from tipping or falling, whether in use, in storage or in transit. The cylinders shall always be secured upright, except during times when actually being hoisted or carried.

iv. When cylinders are transported by powered vehicle they shall be secured in a vertical position.

v. Regulators shall be removed when cylinders are not in use or are in transit, unless the cylinder is firmly secured on a special carrier designed for this purpose.

vi. Gas cylinders are not allowed to be used in man-basket when occupied.

vii. Cylinders containing oxygen or fuel gasses shall not be taken into confined spaces.

viii. Oxygen cylinders shall be stored a minimum of 6 meters from fuel gas cylinders or shall have an approved firewall between them.

ix. All cylinders shall be kept at a safe distance from welding or cutting operations or shielded from arc/ sparks / slag.

x. All cylinders shall be placed where they cannot become part of the electrical circuit.

xi. Oxygen and acetylene shall not be stored together. Oxygen must be separated from acetylene (or ANY fuel gas) or combustible material by at least 20ft or a barrier with a 30-minute fire resistance rating.

xii. All Cylinders should be stored upright in a designated area with labels for the type of gas. All applicable precautions to be ensured during storage

xiii. Oxygen and fuel gas regulators, hoses and associated equipment shall not be altered and shall be in proper working order while in use.

xiv. Compressed air can be extremely dangerous if allowed to penetrate the skin. As such, the use of compressed air to clean off yourself or other workers shall be strictly prohibited.

xv. All gas cylinders shall be stored in upright position. Suitable trolley shall be used for cylinder movement, the design of which shall be submitted to BHEL Engineer for approval.

xvi. No of cylinders shall not exceed the specified quantity as per OCP

xvii. Cylinders shall be moved by tilting and rolling them on their bottom edges. They shall not be intentionally dragged, struck or permitted to strike each other violently.

xviii. All cylinder should be kept only in cylinder trolley.

xix. Cylinder shall be transported in upright vertical position by suitable mean.

4. LIFTING & RIGGING SAFETY

a. All Heavy / Complex Lifting operations as defined in Clause 6.12 shall require a Lifting Work Permit. A written rigging procedure and plan must be prepared for all individual heavy/ complex lifting operations.

b. All the cranes and lifting tools & tackles shall be inspected on daily / weekly basis as well as monthly by expert as per applicable formats.
c. In addition, inspection / certification as mandated by law shall be carried out wherein these shall be tested and certificates of fitness shall be obtained from 3rd party State Govt. approved competent agency before deploying at site and later periodically. BHEL shall be given advance intimation of any such inspections
d. The last date of Third-Party Inspection and the next Due date shall be conspicuously displayed on all cranes. A copy of certificate shall be pasted on operator's cabin of all the lifting equipment.
e. Specifically designed heavy steel plates lifting clamps shall be used for lifting heavy metal sheets. Manmade lifting clamp chapa shall not be used for lifting/shifting of plates.
f. Following requirements shall be mandatorily followed, wherever applicable:
    i. The manufacturer's instruction for maintenance shall also be followed. All safety measures shall be followed.
    ii. All tools tackles, lifting appliances; material-handling equipment etc. used by the subcontractor shall be of safe design and construction.
    iii. The operators, slingers and signalers shall be qualified as per IS 13367 (part-1):2003 "Safe use of cranes- code of practices".
    iv. There shall be a person responsible for co-ordination among cranes where multiple cranes are used, and lifting over load chart of the crane to be avoided.
    v. Mobile phone should be banned for crane operator and lifting operation. Only walkie talkie shall be allowed in rigging/Lifting purpose.
g. Lifts/Movements between 5 Tons and 20 Tons:
    i. Shall include a rigging plan, detailing schematic representation of the handling/lifting operations that must be included on the Method Statement.
    ii. When performing similar lifts of identical items, only one rigging plan need be prepared, provided each of the lifts can be performed in accordance with the rigging plan.
h. Lifts/Movements Less Than 5 Tons:
    i. An equipment rigging plan is not required for lifts less than 5 tons, safety measures are covered in the JSA. This could change as per BHEL requirement

i. Personnel Lifts (Man-Basket / Jhoola):

The design of personnel man basket shall be submitted to BHEL Engineer for approval before use. Relevant permit (Height work & others as applicable) shall be completed prior to lifting any people, along with a rigging plan.

i. A separate Lifeline / fall arrestor anchored to a fixed structure outside of Jhoola shall be provided for the workers inside the basket. All occupants of the basket shall have Safety Harnesses equipped with rope grabs, which are to be hooked to the vertical lifeline.
ii. Man-basket shall be used where access through ladders or scaffolding is not feasible.
iii. Man-baskets shall be designed and engineered by a manufacturer (job made man-baskets are not allowed, unless designed and tested by a certified engineer), and built robust with MS Angles and flats or plates or channels only.
iv. Guard rails top and mid, must be in place and screened-in to avoid material from falling out of

basket. The factor of safety shall be 200%.

v. It shall have a door with double latches and shall open inside. Anchor points shall be identified within the man-basket.

vi. The man-basket shall be thoroughly inspected and load tested and a trial run performed without personnel before being put to job.

vii. It shall be treated as a lifting tool (T&P Item) and shall undergo same certification cycle and inspection as other lifting equipment.

viii. An additional sling of required lifting capacity shall be fixed the man-basket main lifting point and attached to the crane above the ball or block.

ix. While lifting man-basket, the crane shall maintain a uniform speed of lift without any swing.

x. Once man-basket reaches the destination, the lift brakes shall be locked as long as the basket
   a. remains at that point. The same care shall be taken in its descent.

xi. As for hanging man-basket, the same shall be hung off a rigid structure with help U-shaped handle welded to man-basket. This shall be tested once in a year by a competent person.

xii. Use of Rebar steel for making and monkey-ladder must be avoided.

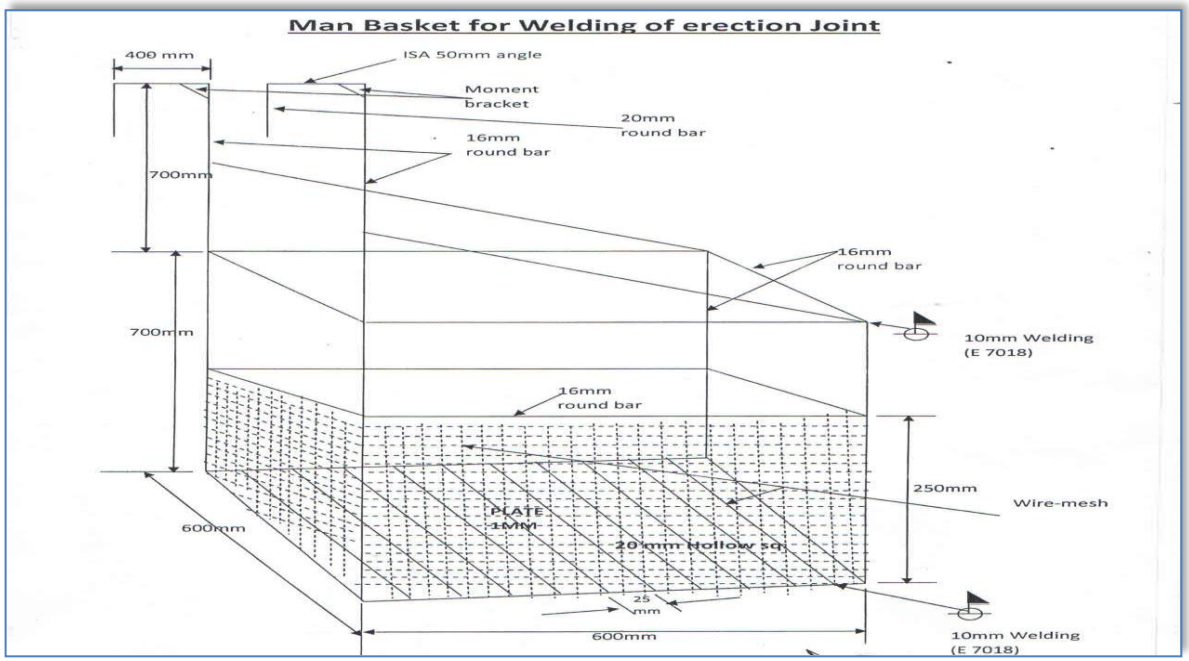


Fig. 5.1 Man Basket for Welding Erection Joint

4.1 Cranes & Hoisting Equipment:

This section provides the guidelines to ensure proper rigging and lifting activities are accomplished safely and in accordance with applicable specifications, codes, and regulations.

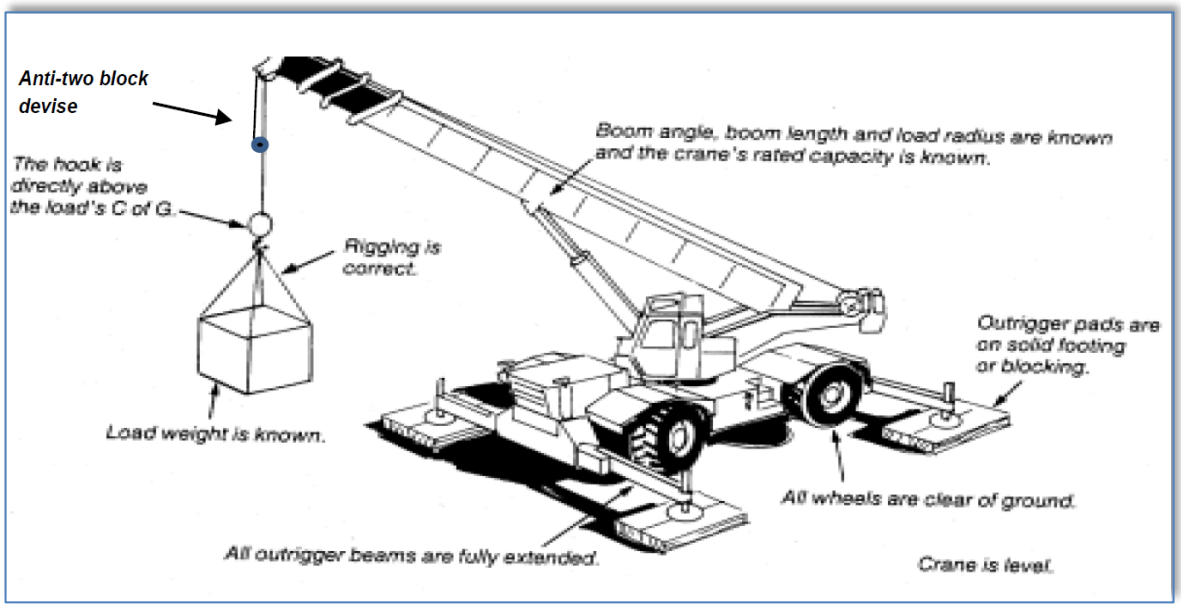


Fig. 5.2 Proper Crane Setup

a. On every crane or piece of hoisting equipment notices of all rated load capacities, recommended operating speeds, and any hazard warnings or special instructions shall be conspicuously posted. All instructions and warning shall be visible from the equipment operator ‘s station.
b. Cranes shall have an Anti-Two-block safety device installed
c. All mobile cranes shall have overload and backup alarms, load angle indicators and limit switches
d. All areas within swing radius of cranes that are potentially accessible by pedestrian, vehicular, or equipment movement shall be barricaded to prevent anyone or any vehicle or equipment from being struck by the crane or hoisting equipment, or its load(s).
e. No part of the lifting equipment or its load shall be within the distance as specified in the Indian Electricity Act from an energized power line
f. Cranes shall have annual certified third-party inspection and be inspected before use by the operator. Any defects shall be corrected before use. Logs of crane inspection shall be kept with the crane.
g. Make certain that the rigging personnel, material, and equipment have the necessary capabilities for the job and are in safe condition.
h. Communicate with person(s) directly responsible for accomplishing the work and / or work area to establish requirements/responsibilities and make certain that all preparatory work is complete.
i. Mats/Pads must be used on all lifting equipment, equipped with out riggers.
j. Pick and carry must have the load secured to the rig in front.
k. Only BHEL Approved Plate Lifting Spreader Beam configuration shall be used (Sample in Fig. 11.3.5.3)
l. Crane operators must follow the following:
    i. Pass an annual Operator’s Physical examination
    ii. Carry a valid training certification card at all time while operating issued by the Govt. or other recognized institute.

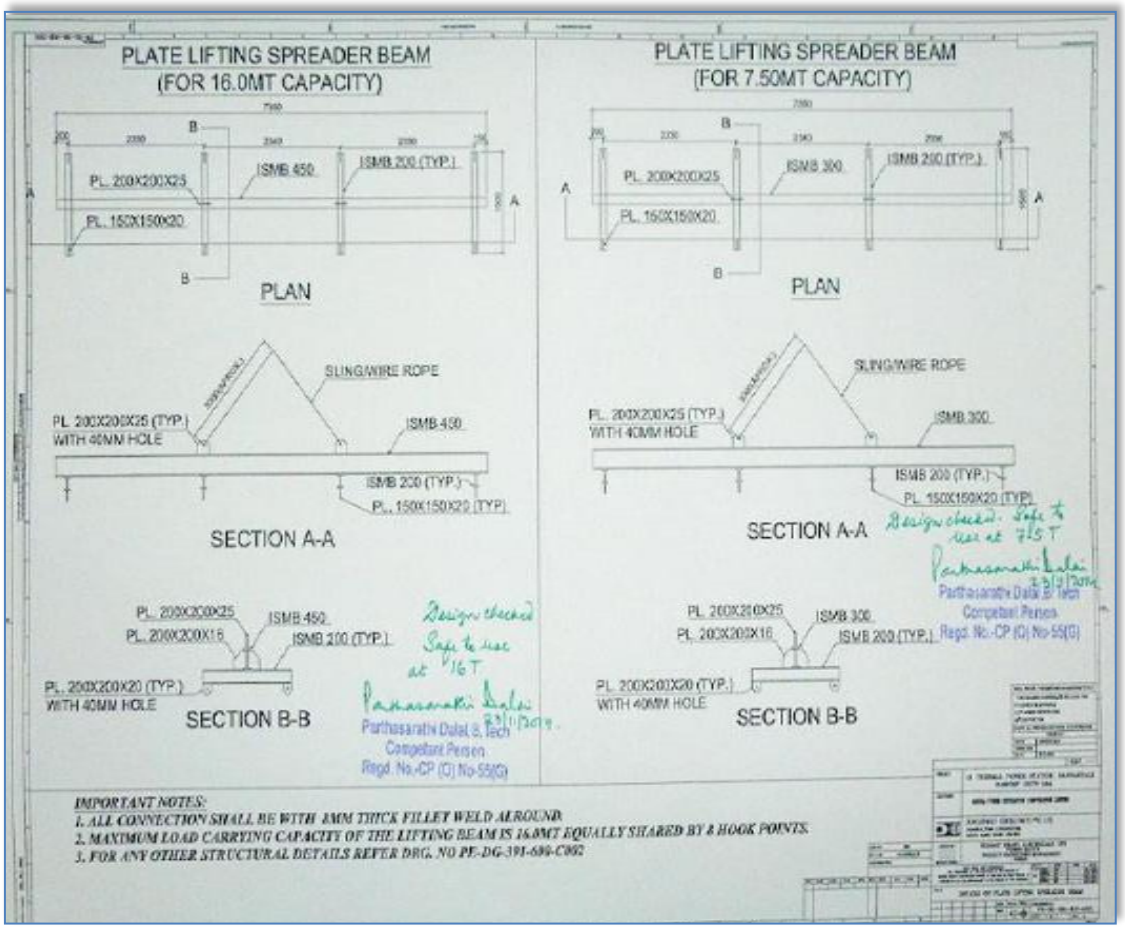


Fig. 5.3 Typical Plate Lifting Spreader Beam Configuration for 7.5 MT and 15 MT Loads

m. Safe Rigging Practices

i. Review the planned operation and requirements with the operator and rigging crew.

ii. Ensure a pre-lift meeting is conducted with crane operator, tagline operator, signal personnel, and Safety Manager.

iii. Designate a qualified person from the rigging crew to observe clearance of the equipment and give timely warning for all operations where it is difficult for the operator to maintain the desire clearance by visual means.

iv. Clear the lift area of all unnecessary personnel.

v. Hydras shall only be allowed for loading & unloading works & shall not be allowed to move with load

n. Rules for Safe Rigging

i. Use loops, thimbles and corner pads to prevent damage to slings when used around corners or on cutting edges.

ii. Never allow wire rope to lie on the ground for any length of time or on rusty steel or near solvents, chemicals or corrosive substances.

iii. Slings must not be pulled from between or under loads with load resting on the sling.

iv. Keep all rope away from flame cutting or welding operations.

v. Never use rope as sling material.

vi. Never wrap a wire rope completely around a hook.

vii. Do not bend wire rope near any attached fitting.

viii. The sling must be selected to suite the most heavily loaded leg rather than the total weight when using multi-legged sling to lift loads in which one end is heavier than the other.

ix. When using 3 and 4-legged sling configurations, any two legs must be capable of supporting the entire load.

x. Where possible, wire rope choker hitches must include a shackle with the eye around the shackle pin to prevent breaking wires of the choke. The choker hitch must be “snugged down” prior to lifting, not after tension is applied.

xi. Unless authorized by the hook manufacturer when more than two rope eyes are placed over a hook, install a shackle, pin resting in the hook, and place the rope eyes in the bowl of the shackle.

xii. Properly rig all loads to prevent dislodgment of any part.

xiii. Use guide ropes or tag lines to prevent the rotation or uncontrolled motion of the load when necessary.

xiv. Loads must be safely landed and properly blocked before being unhooked and unslung. Tag lines must not be used in situations that jeopardize the safety of the lift.

xv. Lifting beams must be plainly marked with their weight and designed working load and must only be used in the manner for which they were designed.

xvi. The hoist rope or chain must never be wrapped around the load. The load must be attached to the hook by slings or other rigging devices that are adequate for the load being lifted.

xvii. Multiple part lines must not be twisted around each other.

xviii. The hook must be brought over the center of gravity of load before the lift is started.

xix. If there has been a slack rope condition, determine that the rope is properly seated on the drum and in the sheaves prior to lifting.

xx. Keep hands away from pinch points as the slack is being taken up.

xxi. Leather gloves are recommended when handling wire rope.

xxii. Avoid impact loading caused by sudden jerking when lifting or lowering. Lift the load gradually until the slack is eliminated.

xxiii. Never ride on a load that is suspended.

xxiv. Avoid allowing the load to be carried over the heads of any personnel.

xxv. Never work under a suspended load until the load has been adequately supported from the floor and all conditions have been approved by the supervisor in charge of the operation.

xxvi. Never leave a load suspended unless emergency evacuation is required.

xxvii. Never make temporary repairs to sling.

xxviii. The capacity of a sling is determined by its angle, construction, type of hitch and size.

xxix. Never lift loads with one leg of a multi-leg sling until the unused legs are made secure.

xxx. Never point load a hook unless it is especially designed and rated for such use.

xxxi. Make certain that the load is broken free before lifting and that all legs are taking the load.

xxxii. When using two or more slings on a load make certain all slings are made from the same materials.

xxxiii. Lower the loads on to adequate blocking to prevent damage to the slings.

xxxiv. Materials and equipment being hoisted must be loaded and secured to prevent any movement which could create a hazard in transit.

xxxv. The weight of the hook, load block and any material handling devices must be included when determining crane capacity.

xxxvi. Calculated weights cannot exceed load chart without written approval.

xxxvii. Personnel must be completely clear of loads being picked up or set down by crane. Tag lines will be used to control the loads. Loads must not be touched by hand while placing/ moving.

o. Slings

The following are rules for safe use of synthetic slings:

i. Synthetic slings must be marked to show the rated capacity for each type of hitch and type of web material.

ii. Nylon web slings must not be used where fumes, vapors, sprays or mists or liquids of acids or phenolic are present. Web slings with aluminum fittings must apply in this category.

iii. Synthetic web slings must be removed from service and destroyed if any of the following conditions are present:

a. Acid or caustic burns
b. Melting or charring of any part of the sling surface
c. Snags, punctures, tears or cuts
d. Broken stitches
e. Distortion of fittings
f. Synthetic web slings of polyester or nylon must not be used at or come in contact with temperatures in excess of 82°C
g. Polypropylene web slings must not be used at or come in contact with temperatures in excess of 93°C
h. Insulated hooks must be tested yearly to ensure insulation integrity to at least manufacturer's specifications.

p. Wire Rope Slings must be removed from service and destroyed if any of the following conditions are present:

i. In (10) randomly distributed wires broken in one (1) rope lay, or five (5) broken wires in one (1) strand in one (1) rope lay.
ii. Wear or scraping of one-third the original diameter of outside wires.
iii. Kinking, crushing, bird caging or any other damage resulting in distortion of the wire rope structure such as:
iv. Evidence of heat damage.
v. End attachments that are cracked, deformed worn.
vi. Corrosion of the rope or end attachments.

q. Metal mesh slings must be immediately removed from service if any of the following conditions are present:

i. A broken weld or broken brazed joint along the sling edge.
ii. Reduction in wire diameter of 25 percent due to abrasion or 15 percent due to corrosion.
iii. Lack of flexibility due to distortion or corrosion.

r. Requirements of Plate Clamps:

i. The rated load of the plate clamp must be marked on the main structure.

ii. Care must be taken to make certain the load is correctly distributed for the plate clamp being used.
iii. Do not allow load or plate clamp to come into contact with any obstruction.
iv. The plate clamp must not be used for side pulls or sliding the load.
v. When lifting stainless steel or special alloys, ensure plate clamp is designed for use on the specific metal.

s. Signaling Practices:

- The "slinger" is responsible for attaching and detaching the load to and from the crane. He shall:
  – have received appropriate training on general safe lifting operations;
  – be capable of selectings lifting gears suitable for the loads;
  – liaise with the operator and direct the movement of the crane safely.
- The "signaller" is responsible for relaying the signal from the slinger to the crane operator. He shall:
  – have received appropriate training on general safe lifting operations;
  – be able to direct the movement of the crane and loads.

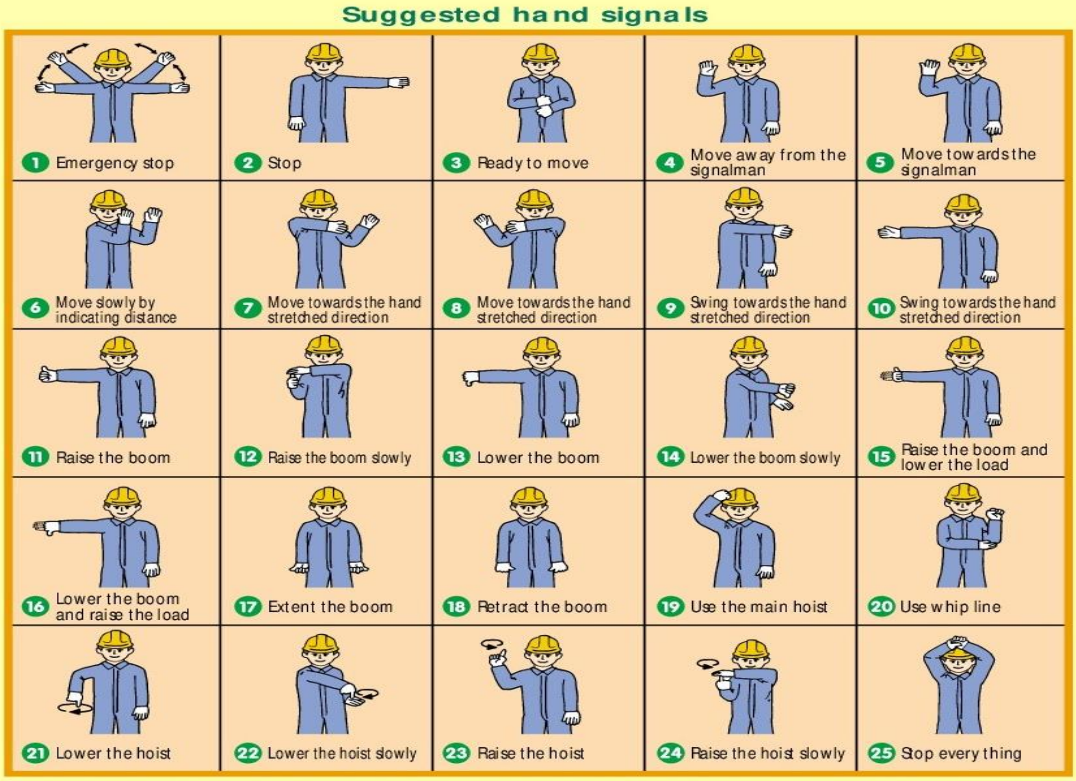


Fig. 5.4 Recommended Signaling Practices

5. DEMOLITION WORK

Before any demolition work is commenced and also during the process of the work the following shall be ensured, besides using the Work Permit:

a. All roads and open areas adjacent to the work site shall either be closed, suitably protected or restricted for movement
b. No electric cable or apparatus which is liable to be a source of danger nor a cable or an apparatus used by the operator shall remain electrically charged.

c. All practical steps shall be taken to prevent danger to persons employed from the risks of fire or explosion or flooding. No floor, roof or other part of the building shall be so overloaded with debris or materials as to render them unsafe.

6. T&PS GENERAL

a. All T&Ps/ MMEs should be of reputed brand/appropriate quality & must have valid test /calibration certificates bearing endorsement from competent authority of BHEL.
b. Subcontractor to also submit monthly reports of T&Ps deployed and validity test certificates to BHEL safety Officer as per the format/procedure of BHEL.
c. Tagging and punching in all lifting tool is compulsory with SWL, sr. no. and due date.
d. All T&Ps shall be inspected by authorized Third Party agency as per applicable frequency. BHEL shall be kept informed of any such scheduled inspection
e. All T&Ps shall be internally inspected in each quarter and colour coded.

7. CHEMICAL HANDLING

a. Displaying safe handling procedures & MSDS for all chemicals such as lube oil, acid, alkali, sealing compounds etc. at work place.
b. Where it is necessary to provide and/or store petroleum products or petroleum mixture & explosives, the subcontractor shall be responsible for carrying out such provision / storage in accordance with the rules & regulations laid down in the relevant petroleum act, explosive act and petroleum and carbide of calcium manual, published by the chief inspector of explosives of India. All such storage shall have prior approval if necessary from the chief inspector of explosives or any other statutory authority. The subcontractor shall be responsible for obtaining the same.
c. The used containers of chemicals shall be segregated and disposed of suitably
d. In case the used containers need to be re-used, all traces of the chemical to be removed by thorough cleaning with detergents etc. under trained supervision

8. ELECTRICAL SAFETY

a. Only electricians licensed by appropriate statutory authority shall be employed by the subcontractor to carry out all types of electrical works. The subcontractor shall maintain adequate number of qualified electricians to maintain his temporary electrical installations.
b. No PDB or any other distribution board shall be more than 03 (three) years of purchase. Only modern PDB with industrial sockets as shown in layout below to be allowed to use at site.
c. Power supply to all equipment at site to be routed through MCBs of appropriate rating. A 'Power Supply Distribution Plan' shall be prepared and submitted to BHEL Engineer for approval
d. All power supplies through cables shall be underground or overhead with height > 3mtrs.
e. All power distribution boxes shall be locked and the key controlled by site management of concerned subcontractor.
f. All individual equipment & tools at site shall be powered through Earth Leakage Circuit Breakers of 30 mA sensitivity.
g. These MCBs and ELCBs shall be regularly tested as per Clause 14
h. All fuses and fuse wires shall be of standard size and rating.
i. All electrical appliances used in the work shall be in good working condition and shall be properly double earthed other that armour earthling.

j. All extension boards shall have separate switches for all sockets / connections.

k. All portable electric tools used by the subcontractor shall have safe plugging system (industrial top & socket) to source of power and be appropriately earthed.

l. Providing adequate no. of 24 V sources and ensure that no hand lamps are operating at voltage level above 24 Volts especially in confined spaces like inside water boxes, turbine casings, condensers etc.

m. Electrical appliance shall have proper earthing and for appliances equal to & more than 415V shall have two separate earthing (as per IS-3043-1987)

n. Portable Electric Lights

i. Portable electric lights used in wet or potentially wet locations must be either low voltage type (24 volts or less) or protected by a GFI (ground fault interrupter).

ii. They must be visually checked before each use and periodically while in use to assure their original integrity is maintained.

iii. Cords with cuts, breaks, deep abrasions, etc. shall be taken out of service immediately.

iv. Repairs to extension cords shall only be performed by qualified/ licensed electricians.

v. Must not be allowed to lie in wet or potentially wet areas.

o. Underground Cables:

i. Every electric line or cable of unknown origin that is discovered or exposed during a digging, drilling, probing, or similar operation is to be considered as energized and life threatening.

ii. The senior company employee on the site will ensure that all necessary safety precautions are taken in order to isolate the line from all workers and the public.

iii. Such precautions may include halting the operation if appropriate.

iv. The senior company employee on the site is to then contact the proper authorities to have the line identified and either confirmed to be abandoned and/or made safe for continuing the work.

v. Any and all underground lines that are discovered or become severed must be considered energized on both sides, and be treated accordingly.

p. Details of earth resource and their test date to be given to BHEL safety officer as per the prescribed formats of BHEL

q. The subcontractor shall use only properly insulated and armoured cables and conform to the requirement of Indian Electricity Act and Rules for all wiring, electrical applications at site.

r. BHEL reserves the right to replace any unsafe electrical installations, wiring, cabling etc. at the risk & cost of the subcontractor.

s. No maintenance work shall be carried out on live equipment

t. Adequate precautions shall be taken to prevent danger for electrical equipment. No materials on any of the sites of work shall be so stacked or placed as to cause danger or inconvenience to any person or the public

u. The subcontractor shall carefully follow the safety requirement of BHEL/ the purchaser with the regard to voltages used in critical areas.

v. Wiring and Branch Circuits Must be protected by a proper amperage over-current device such as a HRC fuse or circuit breaker. Such installations must be located so as to prevent physical damage to the wire conductors & panels.

w. The sub-contractor shall supply modern power distribution board of different combination (1-phase & 3-phase). All the distribution of power should be through modern PDB. Equipment drawing is mentioned below.

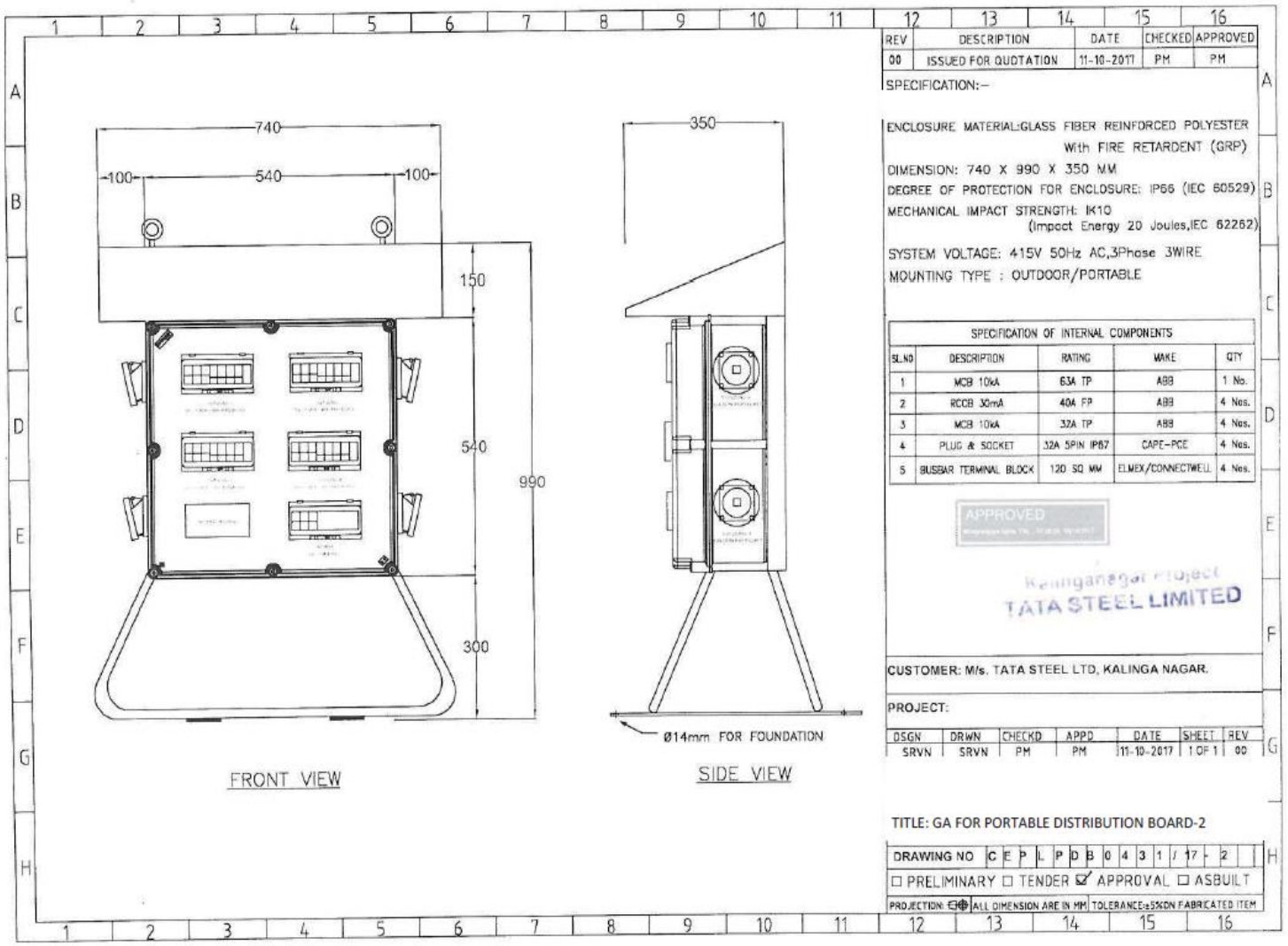


Fig. 9.1 Layout of a modern Power Distribution Board

x. General Electrical Safety

i. In general, equipment or machinery being moved or transported must maintain minimum clearances of 25 ft. to all power lines.

ii. TAG IN/ TAG OUT must be in force in Switch Room and all Distribution Boxes for live power line. The authorized person's name and contact no shall be displayed

iii. Ensure "double insulated" three - core cables and three pin connectors are used and are properly ground "all insulated" types, all electrical tools and appliances must be manufactured for industrial use.

iv. All connections shall be electrically and mechanically sound and properly insulated. Taped joints are not permitted. Connections to socket outlets must be made with proper plugs (industrial top and socket).

v. Splices in electrical cords are not permitted. Repairs must be made at the socket connection and retain the same mechanical and dielectric condition of the original connection.

vi. Damaged or defective electric tools, equipment and extension cords, etc. must not be used and shall be tagged out of service, removed from the work area and taken back to stores.

vii. Only licensed electricians are authorized to repair and work on electrical equipment. Tampering with electric tools or equipment by others could result in termination.

viii. Temporary electric cabling should be elevated 2.2 meters above the floor/ground or covered for protection. It must be kept clear of walkways and other locations where it may be exposed to damage or create a tripping hazard.

ix. Energized wiring in junction boxes, circuit breaker panels and similar places must be covered and locked at all times.

x. Areas with live high voltage wires or terminals must be barricaded against entry and warning signs posted Danger – High Voltage and Authorized Personnel Only.

xi. Personnel should never work on energized equipment, de-energizing (lockout/tag out) the equipment is always the first requirement.

xii. The lockout and tag out procedure will be used when testing or working on, or around, energized installation.

xiii. Working around energized equipment should never be done alone. A second electrician must always be available for assistance.

xiv. If lockout/tag out of the work is infeasible (must be demonstrated), work on energized electrical circuits must be approved by the Site In-charge. All safety precautions necessary must be taken, PPE use must be evaluated per the exposure and used, i.e high/low voltage gloves, insulated shoes, overcoats/aprons, face shields, and other protective equipment like insulated tools, blankets, mats, etc. must be used.

xv. The welding machines earth leads shall be properly fixed without loose contacts. The earth cable only has to be used. No steel members shall be used as earth leads.

xvi. Electrical crews must be qualified for the equipment and tools they work on, including being trained in Cardio-Pulmonary Resuscitation (CPR) methods and First Aid for rendering help in the event of electric shock.

y. Qualified Persons for Electrical Works

(One who is trained and wiremen licensed to Govt. of Respective State and familiar with the construction, operation and safety hazards of the equipment upon which they are permitted to work.)

i. Qualified persons are intended to be only those who are well acquainted/experienced with and thoroughly conversant in the electric equipment and electrical hazards involved with work being performed.

ii. Only qualified persons may be permitted to work on or near exposed energized parts. Such persons are required to have been trained in three specific areas:

iii. Qualified persons must be capable of working safely on energized circuits;

iv. Must be familiar with the proper use of special precautionary techniques and procedures bases on equipment and exposure; and

v. Must be familiar with required personal protective equipment, insulating and shielding materials, and insulated tools.

vi. Qualified persons are expected to be able to evaluate unknown situations and adjust their activities in such a way that only safe work practices are used. Such behavior is the responsibility of the qualified person.

vii. It is possible and likely for an individual to be 'qualified' with regard to certain equipment in the work place, and unqualified on other equipment they must know their limitation and stop work if not qualified on what equipment they were to work on.

viii. An employee who is undergoing on-the-job training, who, in the course of such training, has demonstrated an ability to perform duties safely at his or her level of training, and who is under the direct supervision of a qualified person is considered to be a qualified person for the performance of those duties. The process must be documented as proof.

z. Mandatory PPEs of electrical work on LV & HV

i. HV arc flash suit with protective hood (for protection of face and head) as specified for hazard risk category-4 in NFPA-70E or similar IS specification for working on HT switch gear (for all voltage >690 V) to the concerned licensed electrician or competent person.

ii. LV arc flash jacket/FR as specified for hazard risk category-4 in NFPA-70E or similar IS specification having ATPV rating of 8.5 to 9 cal/cm2 for working on LV (>260V and <=690V) to the concerned licensed electrician or competent person.





iii. The LV arc flash jacket as shown above shall be worn continuously while working on LV (>260V and <=690V). The color specification of LV arc flash jacket should be blue.

iv. Electrical hand gloves should have following specification: Flame resistance, arc flash and cut protection of voltage rating (>260V and <=690V).

v. Electrical safety over shoe of relevant IS make for foot protection of licensed electrician or competent person while working in HV & LV line or equipment.

9. USE OF HAND TOOLS AND POWER-OPERATED TOOLS

a. General Provisions

i. All hands and power tools and similar equipment, shall be maintained in safe condition.

ii. When power operated tools are designed to accommodate guards, they shall be equipped

iii. with such guards, when in use;

iv. Belts, gears, shafts, pulleys, sprockets, spindles, drums, fly wheels, chains and other reciprocating, rotating or moving parts of the equipment shall be similarly guarded;

v. Personnel using hand and power tools and exposed to the hazard of falling, flying, abrasive, and splashing objects, or exposed to harmful dusts, fumes, mists, vapors, or gases shall be provided with the particular personal protective equipment necessary to protect them from the hazards;

vi. All hand-held powered platen sanders, grinders, grinders with wheels of 5 cm or less, routers, planers, laminate trimmers, nibblers, shears, scroll saws and jigsaws with blade shanks of 0.5 cm wide or less shall be equipped with only a positive on-off control.

vii. All hand-held powered drills, tappers, fastener drivers, horizontal, vertical or angle grinders with wheels greater than 5 cm in diameter, disc sanders, belt sanders, reciprocating saws, saber saws and other operating powered tools shall be equipped with a momentary contact on control provided that turnoff can be accomplished by a single motion of the same finger or fingers that turn it on.

b. Hand Tools

i. The subcontractor shall not issue or permit the use of unsafe hand tools;

ii. Wrenches including adjustable pipe end and socket wrenches shall not be used when saws are sprung to the point that slippage occurs;

iii. Impact tools such as drift pins, wedges and chisels shall be kept free of mushroomed heads;

iv. The wooden handles of tools shall be kept free of splinters or cracks and shall be kept tight on the tools.

c. Power Operated Tools

i. Electric power operated tools shall be either of the approved double-insulated type or shall be grounded;

ii. The use of electric cords for hoisting or lowering loads shall not be permitted;

iii. Pneumatic power tools shall be secured to the hose or whip by some positive means to prevent the tool from becoming incidentally disconnected;

iv. Safety clips or retainers shall be securely installed or maintained on pneumatic impact (percussion) tools to prevent attachments from being incidentally expelled;

v. All pneumatically riveting machine staplers and other similar equipment provided with automatic fastener feed, which operate at more than 7 kg/cm2 pressure at the tool a safety device on the muzzle to prevent the tool from ejecting the fasteners unless the muzzle is in contact with the work surface;

vi. Compressed air shall not be used for cleaning purposes except when the pressure is reduced to less than 2 kg/cm2 and that too with effective chip guarding. The 2 kg/cm2 pressure requirement does not apply to concrete form, mill scale and similar cleaning purposes;

vii. The manufacturer's safe operating for hoses, pipes, valves, filters and other fittings shall not be exceeded;

viii. Only personnel who has been trained in the operation of the particular tool shall be allowed to operate power-actuated tools;

ix. The tool shall be tested each day before loading to see that the safety devices are in proper working condition. The method of testing shall be accordance with the manufacturer's recommended procedure;

x. Any tool found not in proper working order, or that which develops a defect during use, shall be immediately removed from service and not used until properly repaired;

xi. Tools shall not be loaded until just prior to the intended firing time. Neither loaded nor empty tools are to be pointed at any other person. Hands shall be kept clear of the open barrel end;

xii. Loaded tools shall not be left unattended;

xiii. Fasteners shall not be driven into very hard or brittle materials including, but not limited to, cast iron, glazed tiles, surface hardened steel, glass block, live rock, face brick or hollow tiles;

xiv. Driving into materials that can be easily penetrated shall be avoided unless backed by a
xv. substance that will prevent the pin or fastener from passing completely through and creating a flying missile hazard on the other side;
xvi. No fastener shall be driven into a palled area caused by an unsatisfactory fastening;
xvii. Only non-sparking tools shall be used in an explosive or flammable atmosphere;
xviii. All tools shall be used with the correct shield, guard or attachment as recommended by the manufacturer.

d. Abrasive Wheels and Tools

i. All grinding wheel must be ISO certified only.
ii. All grinding machines shall be supplied with sufficient power to maintain the spindle speed at safe levels under all conditions of normal operation;
iii. Grinding machines shall be equipped with suitable safety guards;
iv. The maximum angular exposure of the grinding wheel periphery and sides shall not be more than 900, except that when the work requires contact with the wheel below the horizontal plane of the spindle, the angular exposure shall not exceed 1200. In either case, the exposure shall begin not more than 8.650 above the horizontal plane of the spindle. Safety guards shall be strong enough to withstand the bursting of the wheel;
v. Floor and bench-mounted grinders shall be work-rests, which shall be rigidly supported and readily adjustable. Such work-rests shall be kept at a distance not to exceed 5 mm from the surface of the wheel;
vi. Cup type wheels used for external grinding shall be protected by either revolving cup guard or a band type guard;
vii. When safety guards are required, they shall be mounted as to maintain proper alignment with the wheel and the guard and the guard and its fastening shall be adequate strength to retain the fragments of the wheel in case of incidental breakage. The maximum angular exposure of the grinding wheel periphery and sides shall not exceed 1800;
viii. Portable abrasive wheel used for internal grinding shall be provided with suitable safety flanges;
ix. When safety flanges are required, they shall be used only with wheels designed to fit the flanges. Only safety flanges, of a type and design and properly assembled so as to ensure that the pieces of the wheel will be retained in case of incidental breakage, shall be used;
x. All abrasive wheels shall be closely inspected and ring tested before mounting to ensure that they are free from cracks or defects;
xi. Grinding wheels shall fit freely on the spindle and shall not be forced on. The spindle nut shall be tightened only enough to hold the wheel in place;
xii. All employees using abrasive wheels shall be protected by suitable eye protection equipment.

e. Wood Working Tools

i. All fixed power-driven woodworking tools shall be provided with a disconnect switch that can either be locked or tagged in the off-position;
ii. The operating speed shall be attached or otherwise permanently marked on all circular saws over 0.5 m in diameter or operating at over 3000 peripheral rpm. Any saw so marked shall not be operated at a speed other than that marked on the blade. When a marked saw is re-tensioned for a different speed,

the marking shall be corrected to show the new speed;

iii. Automatic feeding devices shall be installed on machines wherever the nature of the work will permit. Feeder attachments shall have the feed rolls or other moving parts covered or guarded so as to protect the operator from hazardous points;

iv. All portable power-driven circular saws shall be equipped with guards above and below the base plate or shoe. The upper guard shall cover the saw to the depth of the teeth, except for the minimum arc required to permit the base to be tilted for bevel cuts. The lower guard shall cover the saw to the depth of the teeth, except for the minimum arc required to allow proper retraction and contact with the work. When the tool is withdrawn from the work, the lower guard shall automatically and instantly return to the covering position.

10. START UP, COMMISSIONING AND TESTING:

There are various activities involved prior to commissioning- the major ones are -Hydraulic Test, Steam Blowing, Transformers Charging, Boiler Light Up, Rolling and Synchronisation and Full loading of unit.

a. These activities shall be personally supervised by the site executive along with the commissioning engineer.
b. Appropriate Work Permits shall be taken as applicable
c. The readiness of upstream and downstream system shall be ensured before taking up.
d. These shall be handled strictly by the authorized persons only and the team shall be suitably briefed about the activity including hazards & risks involved and control plan by the concerned executive-in-charge before start.
e. Entry of persons to the area of activity shall be suitably restricted and the emergency functions like Ambulance, first aid center and Fire station shall be intimated about the plan well in advance.
f. Tag-in/ Tag-out shall be in place while charging transformer and whenever necessary.
g. Electricians with valid wiremen license only shall be permitted to work on power lines.
h. The area and the passage shall be adequately illuminated.

11. FIRE SAFETY

a. The Fire Prevention, Protection and Preparedness Program is an integral part of the overall HSE Program. Effort and consideration must be given to safety, life and potential for delays in construction schedules and plant startup, as well as protection of property on a given project. The purpose of which is to prevent
    i. Inception of fire
    ii. Loss of life or personal injury
    iii. Loss of Property
    iv. Interruption of operations
b. Site-in-charge / Safety Officer will make periodical review of the site Fire Protection, Prevention Preparedness Programme, Site conditions and available fire protection equipment. It is very imperative that the Sub-contractors along with BHEL to establish good contact with Local fire station for availability of Fire tender in case of emergencies, in additional to their own fire equipment.
c. Fire Protection, Prevention and Preparedness Inspections - The Contractor /Sub-Contractor will be required to make frequent fire prevention inspections of his work site and operating facilities.
   Deficiencies will be corrected at once.
d. Area where Hot work activities are carried out (Gas cutting / Welding/ any other spark producing work)

above a working spot, a GI / fire-resistant non-asbestos sheet or suitable material shall be placed to prevent the fall of hot sparks. A bucket of water shall be kept nearby while doing hot work

e. Hot work shall be preferably carried out in a designated area with a standing Hot Work Permit, to be renewed monthly. The designated area shall have fire extinguishers.

f. Any hot work outside designated area shall require a Hot Work permit and fire watch. No flammable material shall be stored within 35 feet from any fire load.

12. PAINTING:

a. Requirements provide a detailed procedure to be implemented by all concerned employees and sub-contractors involved in painting activities.

b. Significant Environmental Hazards:

i. Chemical hazard due to inhalation of lead fumes (lead containing paint)

ii. Chemical hazard due to inhalation of VOC's from paining operations

iii. VOC's from painting and coating operation

iv. Disposal of paints and coats drums

c. Control Procedure for Paining:

i. Chemical products used in painting and coating operation shall have proper MSDS sheet in place. Whenever any doubt arises with respect to handling and safety point of view it should be accessed to all concerned.

ii. Toxic substances and hazards relate the toxic chemicals shall be identified.

iii. Proper PPE shall be used including plastic gloves appropriate overall etc.,

iv. Arrangement for cleaning of spillage shall be ensured

d. Only trained workers shall be allowed and proper training should be imparted to the works.

e. Exposure limits of the toxic substances shall be checked before starting the work and nobody shall be allowed to carry the work beyond the permissible limit.

f. Ventilation or exhaust facility shall be provided at place where painting and coating operations are carried out.

g. Overalls shall be supplied by the contractors/subcontractors to the workmen and adequate facilities shall be provided to enable the painters to wash at the cessation of work.

h. Smoking, open flames or sources of ignition shall not be allowed in places where paints and other flammable substances are stored.

i. A caution board in national /regional language "**smoking strictly prohibited**" shall be displayed in the vicinity.

j. Suitable fire extinguishers/sand buckets shall be kept available at places where flammable paints are stored, handled or used.

k. In case of indoor painting or painting in confined spaces, exhaust ventilating shall be provided. If adequate ventilation is not provided a proper respirator shall be provided and used by persons who are trained and fit tested.

l. The VOC's from painting and coating operations shall not exceed the permissible level of CPCB/ SPCB norms. The paints and coats must be selected as per the guidelines.

m. Workers shall thoroughly wash their hands and feet before leaving the work.

13. "HAZARDOUS ENERGY" CONTROL PROCEDURE/ LOCKOUT/TAGOUT (LOTO)

Hazardous Energy Control Procedures, known as "Lockout/Tagout (LOTO)" refers to specific practices and procedures to safeguard employees from the unexpected energization or startup of machinery and equipment, or the release of hazardous energy during service or maintenance activities.

Contractors must develop and submit a written LOTO program This requires that a designated qualified individual turns off and disconnects the machinery or equipment from its energy source(s) before performing service or maintenance and that the authorized employee(s) either lock and tag the energy- isolating device(s) to prevent the release of hazardous energy and test the machine or equipment to verify that the energy has been isolated effectively.

a. Minimum Requirements:

The following are minimum requirements that must be included in the Contractor's LOTO program:

i. Inspection of equipment by a trained individual who is thoroughly familiar with the equipment operation and associated hazards.
ii. Identification and labeling of lockout devices. Purchase of locks, tags, and blocks Development of a standard written operating procedure, permitted through a controlling authority that is followed by all workers.

b. General Requirements

The following steps must be taken to protect workers that install or service equipment and systems:

Follow the hazardous energy procedures and statutory regulations. Follow the manufacturer's service/repair instructions. Identify and label all sources of hazardous energy. Before beginning work, accomplish the following:

i. De-energize all sources of hazardous energy:
ii. Disconnect or shut down engines or motors.
iii. De-energize electrical circuits.
iv. Block fluid (gas or liquid) flow in hydraulic or pneumatic systems.
v. Block or secure machine parts against motion.
vi. Block or dissipate stored energy.
vii. Discharge capacitors.
viii. Release or block springs that are under compression or tension.
ix. Vent fluids from pressure vessels, tanks, or accumulators—but never vent toxic, flammable, or explosive substances directly into the atmosphere

c. Lockout and tag out all forms of hazardous energy including electrical breaker panels, control valves, etc. Make sure that only one key exists for each of your assigned locks and that access to the key is controlled. Verify by test and/or observation that all energy sources are de- energized.

d. After completion of the work, accomplish the following:

i. Inspect repair work before removing the lock and activating the equipment.
ii. Make sure that only the worker that installed the lock removes his/her assigned lock.
iii. Make sure that all workers are clear of danger points before re-energizing the system.

e. LOTO Procedure

PURPOSE AND SUMMARY

This procedure provides the requirements and responsibilities of Hazardous Energy Control and the process for Lockout / Tag out (LOTO) of energy isolating devices (valves, circuit breakers, disconnect, etc.). Its use

shall ensure that machinery, equipment, or systems are isolated from all potentially hazardous energy to prevent unexpected energization, startup, or release of stored energy which may cause personnel injury or property damage.

This procedure applies to all BHEL personnel and subcontractors working on the WBPDCL (1X660MW) STAGE-III projects where equipment must be taken out of service for the performance of work activities such as installation, maintenance, repair, construction, or equipment removal. The procedure may also be used to isolate equipment of which the energization or operation may present danger to personnel or property.

Lockout / tag out are not required for electrical equipment that can be unplugged from the source and the person performing the work has control of the plug.

This procedure shall be applied to prevent injury or damage caused by the unexpected release of active or stored energy. Hazardous energy sources could be in the form of the following:

- Electrical
- Hydraulic
- Chemical
- Thermal
- Mechanical
- Pneumatic

Preplanning of work activities includes the identification of all potential hazardous energy sources so that they may be properly controlled and isolated, locked, and tagged out.

Prior to initiating work activities on or around locked out / tagged out equipment, the equipment must be tested and tried by or in the presence of the person(s) performing the work activities.

RESPONSIBILITIES

- The Engineers in Charge is responsible for implementing and enforcing this procedure and approving lockouts /tag outs that impact the operation of the project.
- The Engineer in Charges responsible for authorizing Lockout /Tag out Requests.
- The Lockout / Tag out Coordinator is responsible for maintaining the Lockout / Tag out Log. Each shift should have a designated Lockout / Tag out Coordinator.
- The Isolator is responsible for determining the proper isolation devices and device positions required to isolate all potential energy sources so that the work stated on the Lockout /Tag out Request Permit may be safely performed. The Isolator must be familiar with the equipment and energy type(s) that require isolation. For this reason, in some cases the Isolator may be more than one person (i.e. Engineer, System Operator and/or Electrician). The Isolator shall position the specified device points, and apply locks and tags, and sign the tags and the LOTO Permit isolation point blocks.
- The Safety Manager is responsible for conducting an annual audit that is documented to ensure all procedures and requirements are current and being followed as written.

DEFINITIONS

Affected Employee: -

An employee whose job requires him/her to operate or use machinery or equipment on which servicing or maintenance is being performed under a lock out/tag out procedure or whose job requires him/her to work in an area in which servicing or maintenance is being performed under a lockout/tag out procedure

Authorized Employee: -

An employee who implements a lockout/tag out procedure on machinery, equipment, or systems in order that servicing or maintenance may be performed. Often an authorized employee and an affected employee may be the same person.

Danger "Do Not Operate" Tag

A tag used to identify energy isolation devices and specify the required position of the device. The tag should be affixed to the isolation device such that it is in plain view of anyone attempting to operate the device. The tags shall be sequentially numbered and shall specify the lockout/ tag out request number. The tag shall also state the purpose, and the expected duration of the lockout /tag out

Isolation Device

A device that is designed and intended to prevent the passage of energy. These devices, usually located at the energy source, are typically valves, circuit breakers, etc. Isolation devices should have a means of being locked in position

Lockout Device

A device that uses a positive physical means such as a lock, either key or combination type to maintain an energy isolation device in the safe position and prevent the in advertent energization of machinery, equipment, or systems. Device locks should serve no other purpose other than hazardous energy control isolation

Lockout Tag out Request Permit

A pre-numbered form used to request that machinery, equipment or systems be taken out of service. A Lockout/Tagout Request Permit may be initiated by any one requiring energy isolation for work activities or for taking faulty equipment out of service

Lockout / Tag out Request Log

A record of all Lockout /Tag out Request Permits shall be maintained by the Lockout /Tag out Coordinator.

PROCEDURE

1. REQUESTING A LOCKOUT / TAGOUT PERMIT

When machinery, equipment, or systems are partially or completely taken out of service for work activities or equipment protection, a lockout / tag out shall be requested. The requestor shall be familiar with scope of work required and shall provide a brief description of the work on the Lockout / Tag out Request Permit. The requestor shall also provide the proposed start time and estimated duration of lockout / tag out. If familiar with the machinery, equipment, or system to be taken out of service, the requestor may identify the devices that are required to be isolated. The LOTO Request Permit shall be forwarded to the Authorized Lockout / Tag out Coordinator for reviewed and signature, along with Permit to Work number to be entered on the LOTO Request Permit.

a. The Lockout / Tag out Coordinator shall record the necessary information on the Lockout / Tag out Request Log and forward the request to the Engineer in Charge for approval.
b. The Safety Manager or Engineer in Charge shall review the Lockout / Tagout Request Permit for impact on project operations. Project operations could be impacted by the equipment being taken out of service or by the required isolation to take the equipment out of service. If project operations are impacted by the Lockout / Tagout, the request shall be forwarded to the Engineer in Charge for approval.
c. The Engineer in Charge shall provide the lockout / tag out isolation points necessary to perform the task stated on the request. The device identification, device location, device position, and locking mechanism

shall be entered into the appropriate blocks on the Lockout / Tag out Request Permit.

d. The Engineer in Charge indicates approval of the Lockout / Tagout Request Permit by signing in the appropriate space on the request. If the Lockout /Tag out Request Permit is rejected, the Engineer in Charge shall return it to the requestor, via the Lockout / Tagout Coordinator with a written explanation of the rejection.

e. Once approved, the Lockout / Tag out Request Permit shall be forwarded to the Lockout / Tag out Coordinator to assign tags and locks.

f. The log shall show current status of all Lockout / Tag out Request Permits from submittal to approval, through lifting of locks and tags to final closeout. The log shall be maintained by the Lockout / Tag out Coordinator in their office.

2. PLACEMENT OF LOCKS AND TAGS

a. The tags shall be filled out to match the information on the LOTO Request Permit. Appropriate locks for the types of isolation devices specified shall be collected and placed with the tags and the Lockout / Tag out Request Permit.

b. The isolator(s) shall take the device locks, tags, and the Lockout / Tagout Request Permit to position the specified isolation devices, sign and hang the tags, and place the locks. If the isolator does not agree with or understand the Lockout / Tagout Request Permit, or has a problem performing the isolation, the problem should be brought to the attention of the Safety Representative or Area Supervisor immediately and the lockout / tag out should be postponed until the situation is resolved.

c. Once the Isolator has placed all “locks” on isolation points, they will “test ”and “try” the machinery, equipment, or system to ensure all hazardous energy has been completely removed and the isolation is one totally accomplished, and has initialed and signed the Lockout /Tag out Request Permit indicating all isolation points have been confirmed. Examples of “lock”, “test” and “try”:

- by checking that all locks on the LOTO Request Permit have been applied and are in the specified position open/closed, on/off, etc.; metering test of electrical circuits, opening of drain valves, checking pressure gauges or indicators; and try by pushing start buttons and on/off switches, etc.
- Testing shall be performed by person(s) knowledgeable of the energy source(s) being isolated (e.g., an electrician should meter electrical circuits).

d. A copy of the completed Lockout /Tag out Request Permit shall remain with the Work Package and used as part of the daily Pre-Job Briefings

3. WORKING UNDER A LOCKOUT / TAGOUT REQUEST

a. Prior to starting the work activity, the person(s) performing the work shall review the Lockout / Tag out Request Permit and place the necessary tags and personal locks on the identified isolation devices. Personal locks may be placed only on devices that have already been locked and tagged in accordance with the Lockout / Tag out Request Permit.

- All personal locks shall be accompanied by a tag that is signed and dated by the worker(s) and specifies the work activity being performed.
- Personal locks should be of a different color than device locks for ready identification.

b. Verification of the effectiveness of the isolation by the Isolator shall be performed for Worker’s working under the lockout / tag out, by demonstrating the checks on “lock”, “test” and “try”,

c. When the work activity is finished, personal locks and tags shall be removed and the Safety Representative

shall be notified that the Lockout / Tagout is no longer required. If work under a lockout / tag out is to be delayed or interrupted for a period in excess of 24 hours, personal locks shall be removed until the work restarts. Personal locks shall be removed prior to the worker(s) leaving the project at the end of shift unless the key(s) are maintained at the project.

4. REMOVAL OF LOCKS AND TAGS

a. When the lockout / tag out is no longer required, the Safety Representative or Area Supervisor shall obtain the Lockout / Tagout Request Permit from the work package for LOTO removal. Prior to removing locks or tags that may allow equipment to be energized, a check shall be made to verify that the equipment is free to safely operate (i.e., will not cause damage or injury). The locks and tags shall be removed and returned to the Lockout / Tagout Coordinator. Isolation devices may be repositioned at the discretion of the Engineer in Charge according to operational requirements. The Isolator shall complete the Lockout / Tagout Request Permit indicating each lock and tag has been removed and the Safety Representative or Area Supervisor forward to the Lockout / Tagout Coordinator.

b. The Lockout / Tagout Coordinator shall discard the tags and maintain the completed Lockout / Tagout Request Permit for future reference.

c. In the event that an employee leaves the job site without removing the personal lock I tag, the following measures shall be taken and documented. The measures listed below are a minimum set of guidelines and under all circumstances, refer to the site-specific safe work plan for detailed procedures:

- Attempt calling / contacting the employee to return to the site for removal.
- In the event an employee cannot be contacted, the Site Manager and Safety Manager shall sign an Emergency Lockout/Tagout Removal Form, which has been completed by the Area Supervisor.
- Employee shall be notified upon returning to the site, prior to beginning any work.

5. INTERRUPTION OF A LOCKOUT / TAGOUT

Operational Emergency

The Engineer in Charge / Safety Manager /Area Supervisor may deem it necessary to temporarily remove the locks and tags from isolation devices, prior to the end of the work activity. The standard procedure for removal of locks and tags shall be followed. Extreme caution shall be taken by the Isolator removing the locks and tags to prevent personnel injury.

Testing

When the performance of a work activity requires the functional testing of a machine, component, or system, the locks and tags may be temporarily removed in accordance with the tag removal, to perform the test. As a result of the testing, if it is determined that the equipment needs further work, the locks and tags shall be positioned back on to the device. If it is not necessary to replace all the locks and tags, then the unnecessary locks and tags may be returned to the Lockout / Tagout Coordinator. The Engineer in Charge shall initial the Lockout / Tag out Request Permit in the removal block to indicate that these locks and tags have been removed. When testing has been satisfactorily completed, the locks and tags shall be removed.

ISOLATION DEVICES

- In most industrial applications, there are isolation devices that were not designed to accommodate a locking device. In these instances, an acceptable alternative that physically obstructs or prevents the use of the isolation device shall be found. Chains shall be placed on valves or electrical panels. Wires shall be determinate, pulled back, taped, and secured.

- If an isolation device does not accept a lock, a tag only is acceptable; however, all possible precautions shall be undertaken to provide a level of safety for the workers. The tag shall be readily visible to anyone attempting to operate the device.
- If more than one Lockout / Tagout Request Permit requires that a single isolation device be locked and tagged, a lock and tag for each request shall be placed. Each lock in itself prevents the inadvertent operation of the device.

GROUP / COMPLEX LOCKOUT

In a multiple lockout / tag out procedure, each person working on the machinery or equipment must place a lock or tag on the energy isolating device. If the energy isolating device will not accept multiple locks or tags, a hasp (a multiple lockout device, may be used. The locks or tags must be placed in such a way that energy cannot be restored to the machinery or equipment until every lock or tag is removed. As each employee involved no longer needs to maintain lockout / tag out protection that employee removes his - her lock and/or tag. The employee attaching the lock or tag is the only person authorized to remove the lock or tag.

6. TRAINING

The training must include recognition of hazardous energy source, type and magnitude of energy available, methods and means necessary for energy isolation and control. Each authorized employee shall receive adequate training. The training should address that all affected employees are instructed in the purpose and use of the energy control procedure. There should be training provisions included for any other employee whose work operations are or may be in an area where energy control procedures may be utilized. The employee training should also address when tag out systems are used including the limitations of a tag (tags are warning devices and do not provide physical restraint). The training should also include that a tag is not to be removed without authorization. The tag is never to be ignored or defeated in any way. Retraining is required when there is a change in job assignments, in machines, a change in the energy control procedures, or a new hazard is introduced. All training and I or retraining must be documented with employee's name and dates of training.

7. PROGRAM REVIEW

The lockout / tag out program must be reviewed at least annually. The review must ensure that procedures are being followed and that they are effective. A documented review of the inspection must include the date, the equipment, employees involved & the inspector. The inspector must be someone other than those actually using the lockout / tag out in progress.

ATTACHMENTS

#1. Danger (DO NOT OPERATE) Tags



#2. Device & Personal Locks and Multi Lock Hasp:



#3. Lockout / Tagout Request Permit

BHEL	**LOCKOUT / TAGOUT REQUEST PERMIT**	LOTO Request Permit No.:
		Work Permit No.:
Equip. Out of Service:	LOTO Date Required by: _____/_____/_____	Estimated Duration:
		LOTO Requested Date:
Scope of Work:		**LOTO Authorization** Signed by:
		Date:
		LOTO Removal Authorization Signed by:
		Date: Time:

Tag No.	Device to be Tagged / Locked I.D. No.	Device Location	Device Position *OPEN / CLOSED* -	Lock No.	Tag/Lock Placed by Print/Sign - Date/Time		Tag /Lock Removed by Print/Sign - Date/Time	

Comments Instructions: **Attachment 3.Lockout / Tag out Request Permit:**

#4. Lockout / Tag out Request Log

LOTO Permit No.	**Requestor Name**	**Equipment & Location**	**Est. Work Completed Date**	**Approval Date**	**LOTO Placed Date**	**LOTO Removed Date**	**Comments**

14. RISK ASSESSMENT

Risk and Hazard Analysis

In order to produce an overall Project EHS Plan, a project must be assessed for its risks. There are two components to the risk and hazard analysis. The procedure used to examine and plan for the identified risks and hazards is called a General Hazard and Risk Assessment.

JSA/HIRA review

Prior to commence the following activities Method statement and JSA/HIRA to be prepared by the concern engineer in coordination with EHS officer and submit to the client for review and approval. After getting approval the work will be started under PTW after clearance. For HIRA and criteria for the defining the high, medium & low risk the relevant annexure be referred. In case any deviations required in the approved method statement the concerned engineer/supervisor has to prepare additional HIRA/JSA to cover the new activities and associated risk. Following activities to be covered,

- Deep excavation (more than 5 feet)
- Significant concrete pouring (like heavy foundation, TG deck, Slab casting etc.)
- Confined entry
- Blasting
- Working on electrical/ energized equipment's
- Steel erection more than 5-Ton weight
- Working at height prior to completion of stairs/ladders/hand railing etc.

Definition:

HAZARD - Any potential or present danger to persons or property within the project site, e.g., oil on the floor is a hazard.

INCIDENT - An unintended happening that may result in injury, loss or damage, e.g., Slipping on the oil is an Incident.

INJURY – Physical harm, the result of an Incident, e.g., a sprained wrist from the fall would be an injury.

Hazard Analysis Document

- For high risk and dangerous work identified, the Applicant shall complete and submit a Hazard Analysis Document together with the PTW request. It will be a JSA (Job Safety Analysis) or Preliminary Hazard Analysis Checklist. And it shall be reviewed and approved by respective Construction and HSE Representatives.
- Issues such as work interface, coordination, drawings, toolbox meetings and work type/duration shall be detailed and included with supporting documentation for the Applicant's request for PTW.
- If applicable, Hazard Analysis Document shall be used as the foundation for development of Safe Work Method Statement. Each hazard identified shall be addressed in the Safe Work Method Statement and be submitted as part of the Applicant's submittal package.

Evaluation of Sub-contractor Risk Assessments includes

- Experience and expertise in performing similar type work.
- Duration of work performed
- Location of the work to be performed.

- Nature of the work to be performed.
- Potential for a subcontractor performing the work to expose themselves, other persons or employees, to hazards.
- Potential for exposure to work site hazards.

Review of Subcontractor specific issues

Preventive and protective measures must be introduced according to the following order of priority

- Eliminating the hazard by removing the activity from the work process. Examples include substitution with less hazardous chemicals, using different manufacturing processes, etc.
- Controlling the hazard at its source through use of engineering controls. Examples include local exhaust ventilation, isolation rooms, machine guarding, acoustic insulating, etc.
- Minimizing the hazard through design of safe work systems and administrative or institutional control measures. Examples include job rotation, training safe work procedures, lock-out and tag-out, workplace monitoring, limiting exposure or work duration, etc.
- Providing appropriate personal protective equipment (PPE) in conjunction with training, use, and maintenance of the PPE.

15. HSE PREPAREDNESS FOR ADVERSE CLIMATES AND WEATHER

All Preventive and Precautionary measures to ensure Health & Safety of workers in all possible adverse weather conditions based on the analysis of the local area conditions to be taken by the subcontractor

15.1 SUMMER

1. The Working Time and Lunch Hour will be as per instruction of Statutory Authorities (no work between 11am to 3:30pm). However, in case temp comes down due to rain/cloudy weather work will continue as per normal routine.
2. During long lunch break, worker will be allowed to go back home for rest. Those who will like to stay back will avail at the facility of rest shed or other designed area.
3. They will be allowed to take small break during work as per their need.
4. Water sprinkling will be done on roads to reduce dust concentration.
5. Workers will be provided with adequate cool drinking water and Butter milk/Lemon water etc.
6. Adequate ORS stock will be made available at the work location in the First-Aid Box for use as needed and at First-aid Centre for emergency need.
7. Fire prevention shall be on high alert, with removal of dry grass and bushes, etc, inside and outside the surrounding work areas. No smoking, and control of open flame/sparks shall be maintained and monitored.
8. Worker will be informed about the Do's and Don'ts to be followed during summer in the Pre Job Brief.

Dos & Don'ts

1. Drink plenty of cool water and other non-alcoholic fluid and keep body well hydrated.
2. Eat salt in food to replenish loss of salt through sweating.
3. Avoid over physical exercise.
4. Have adequate sleep at night.
5. Eat light and less spicy food
6. Avoid eating food which was cooked long time ago.

7. Nobody should use small water bodies such as pits, running rain water through crevices etc. for drinking and cleaning purpose as it may be unhygienic.

Emergency Handling

In case of emergency due to heat disorder:

1. Rescue the victim from workplace and place under shed.
2. If to be rescued from height, use stoke basket or rescue kit.
3. Inform Ambulance immediately.
4. If nearby any air conditioned room/shed is available, place him inside the room/shed.
5. Administer First aid by trained First aider for Heat Disorder
6. If conscious, give him ORS solution to drink.
7. If required send the victim hospital immediately.

15.2 MONSOON

A. Height Work & Structural Safety:

1. Ensure that all height work platforms are barricaded and avoid any highly hazardous
2. Height work.
3. Ensure that all personnel have good quality and intact safety shoes
4. Stop all dangerous height work during rain
5. Explain Do's and Don'ts to workers during Tool Box Meetings
6. Ensure that there are no weak structures, boards etc. that can fall during high winds
7. Do not allow any loose material (e.g. GI sheet, Ply board, empty cement bag, aluminium foil, foam sheets etc.) on roof sheds or top of structures.
8. Do not permit any one to ride up or come down scaffolds frame work during heavy wind or rain.
9. Provide "anchor" of adequate strength to scaffolds and other high-rise structures.
10. All rest sheds and GI sheds will be anchored into the round and wall and roof panels will be secured with J hook to prevent shed from blowing over or parts/pieces becoming airborne. Proper earthing per IS standard is also to be installed.
11. Do not go alone nor permit anyone to stay at tower-tops, roof-tops, high structures or on electrical poles during the course of stormy weather or heavy rain.

B. Electrical:

1. All electrical connections / loads have to be routed through ELCB / RCCB (residual current circuit breaker) whose rating should be 30mA.
2. RCCB operational checks need to be done DAILY / WEEKLY during monsoon season.
3. Avoid joints on power cables which need to be laid over-head or under-ground, better not to have any joint at all. In case joints become essential, such cables must be housed rigidly and insulation must be provided as per approved standard. The joint shall be suitable for outdoor use.
4. All electrical distribution board shall be properly covered at top and sides to protect from rain water. Extension boards shall be protected from rain water.
5. Ensure proper "earthing" for each and every electrical appliance.
6. Double earthing need to be provided for 3-phase power supply and for voltage more than 220V.

7. Provide lightening arrestors at the top of Boiler 3 and boiler 4 and rest sheds which are not covered by existing lightening arrestor of other installation.

C. Others:

1. Maintain smooth flow on open drains. i.e. no obstruction or blockade shall be made on storm water drains. If required, make temporary drains.
2. Arrange back-filling of excavated pits on war-footing basis.
3. Arrange bringing down booms of all cranes, hydra machines during stormy weather (wind speed 40-50 km/hr)
4. Confirm that all gantry cranes are effectively choked to prevent rolling and toppling.
5. Do not forget to deep ready a dew battery operated lights at site-offices during rainy season.
6. Avoid using wet damp clothes.
7. Hard Barricade excavated zone filled with water with scaffolding pipe & clamp with reflective net
8. Engage diesel operated water pump to dewater work area. For electrically operated water pump, the starter shall be protected from rain water. All rotating parts shall be guarded. Ensure availability of sufficient water pumps.

D. Health and hygiene:

1. Monsoon reduces the immunity of our body and makes us vulnerable to many diseases which are commonly associated with this season. It is time for us to keep our body challenging against disease by boosting our immunity and taking safety measures against these diseases.
2. The diseases associated with monsoon are Malaria, Jaundice, Gastro-intestinal infections, like typhoid, cholera etc. apart from these viral infections like cold and cough also make their presence felt. Majority of above said diseases are on account of:
3. Puddle of water formed due to rain become breeding grounds for mosquitoes which spread disease like, malaria and dengue fever. As a precautionary measure against mosquito-bite disease one can use mosquito net around the end which is better choice to mosquito repellents like mats and coils.
4. Pollution of drinking water during monsoon is very common. It is very necessary to drink clean and pure water when water-borne monsoon diseases like diarrhoea and gastro-intestinal infections threaten us.
5. Walking in dirty water during rainy season leads of numerous fungal infection which affect toes and nails. Diabetic patients have to take a special care about their feet. Keeping feet always dry and clean is very necessary. Avoid walking in dirty water. Keep shoes socks and raincoats dry and clean.

E. Workmen will be made aware of following Do’s and Don’ts:

1. Do not sleep in daytime.
2. Avoid over physical exertion.
3. During lightning and thunder storm, do not take shelter under tree. Take shelter inside rest shed or store room.
4. Wash vegetables with clean water and steam them well to kill germs.
5. Avoid eating un-cooked foods and salads should be washed properly before consumption.
6. Drink plenty of water and keep body well-hydrated.
7. Always keep the surrounding area dry and clean. Don’t allow to get water accumulated around.
8. Keep body warm as viruses attack immediately when body temperature goes down.

9. Do not enter air conditioned room with wet hair and damp cloths.
10. Dry your feet and webs with soft dry cloth whenever they are wet.
11. Eat light and less spicy food.
12. Avoid eating food which was cooked long time ago.
13. Eat salt in food to replenish loss of salt through sweating.

15.3 EMERGENCY WEATHER CONDITIONS

Cyclone/Severe thunder storm

In the event of Cyclone/Severe thunder storm, alert will be issued by subcontractor on notification received by Govt. authorities/Metrological departments Customer or BHEL.

The actions required during cyclone/rough weather:

1. Check and advice subcontractors to clean-up work area. Pick up all loose and unused material of respective supervisor's area.
2. Tie to secure all gas cylinders to avoid displacement and unsafe conditions which could be due to wind pressure.
3. Secure portable electricity generating sets and other equipment, pumps, hoses etc.
4. Make preparation for removal of water logging.
5. Take review of work activity and make preparation for removal of equipment and material from vulnerable areas.
6. Isolate/turn off all electrical power form the main panel/switches. Secure and anchor panels properly.
7. Recheck anchorage/tie of all temporary structures/sheds, tall objects, cranes, rigs, scaffolds etc. to avoid toppling due to wind force.
8. Cranes boom shall be secured, either locked or lowered the booms as reasonably and practicably possible and rigs to safe position for the safety point of view.
9. Group up all trash barrels, wooden pallets, forms; wooden decks etc. and anchor properly.
10. Welding machines, air compressors and such equipment are to be grouped together and secured to the stable objects. Welding leads, electrical cables, hoses are to be rolled up and secured properly.
11. Set on site vehicles on high ground in the site area with brakes set firmly.
12. Anchor all tanks, vessels, gas cylinders that may be moved by high wind and water.
13. Evacuate job site.

Personnel Evacuation:

1. Personnel Evacuation will be required if predicted wind speed and storm surge heights are beyond acceptable limits as per the instructions from Govt. Authorities/ Metrological departments or Customer.
2. Once the warning is received for personnel evacuation, an emergency response team shall be formed. The team will work with local authorities and other agencies formed/deployed to evacuate and transport all personnel involved in the project to the cyclone shelter.
3. Cyclone may be followed by the calm "EYE", be aware of it. If the wind suddenly drops, don't assume the cyclone is over. Violent wind may resume from the opposite side direction. Wait for the official "All clear Signal".

4. After the cyclone, do not go outside until officially communicated about safe situation outside. Use recommended routes for returning. Do not panic or rush while returning.
5. Checking of gas leaks and well-being of electrical appliances is essential before leaving the site.
6. Follow local communications for official warning and advice. The construction Manager shall also obtain updates from customer/metrological departments and communicate to the personnel on project site.

15.4 PREVENTION OF COVID-19 (COVID-19 HERE TO BE READ AS COVID-19 AND OTHER PANDEMICS/ COMMUNICABLE DISEASES) AT PROJECT SITE & LABOUR COLONY:

Resumption of Construction Activities after Lock Down and Prevention of Coronavirus Infection during Site Operations and OCP 61A: Prevention of COVID-19 Infection in Labor Colony will be strictly followed.

A. <u>Preventive measures at project site:</u>

- BHEL and Agencies shall nominate COVID Marshalls, who will be responsible for monitoring the COVID prevention measures and apprising management on the same.
- Mandatory health check-up for every worker/ official joining the site
- All activities to be carried out using least amount of paperwork and physical proximity as far as possible.
- ***HSE Observer App*** to be used to monitor HSE Activities and follow up with agencies for closure of non-conformities.

<u>a. Strict Control at the Gate/ Banning Entry to Anyone Not Wearing Masks</u>

i. Security personnel at the gate may erect a barricade preferably approx. 10 meters from the gate and only allow personnel who are wearing proper masks inside.

ii. Public address system may be used to warn any non-compliant visitors

iii. Near entry gate, round markers at minimum 1-meter distance to be ensured so that distancing is ensured

iv. A hand-wash or hand sanitiser facility is preferable at the gate to allow entry after hand wash or hand sanitisation. These are also to be provided at key locations to enable hand wash / hand sanitisation before starting work, before eating, etc.

v. Gutkha, Paan, tobacco etc. to be banned from the site. Spitting to be strictly prohibited.

<u>b. Screening at Gate with Contactless Thermometer & Action on Suspected Cases</u>

i. Security Personnel at the Gate to screen each person entering the premises using a non-contact infrared thermometer, which is duly serial numbered and calibrated.

ii. In case any site worker/ official is found to have fever more than 99 Degrees Fahrenheit or found coughing/ sneezing, he/she may be advised rest till recovery and entry to be permitted after obtaining clearance from medical officer/assistance/attendants.

- Parcel to be collected from gate by concerned person preferably with provision of Special Box
- Any construction material received at site, unless properly sanitized, to be kept undisturbed for at least 3 days and to be used only after that period.
- During Toolbox Talks, minimum 1-meter distance between any two workers to be ensured

<u>c. During site execution activities:</u>

For all site execution activities, social distancing is to be maintained. In case this is not possible due to nature of work, speciality of work, etc, ensure sensitisation of the labour/staff involved and use of appropriate PPEs, especially mandatory face mask. In any case, close working to be allowed only in special

circumstances and ensuring these activities are preferably time staggered to the extent possible

d. In office premises:

i. Sharing of items like pens, water bottles etc. in office premises to be avoided

ii. Doors preferably to be in open condition to avoid contact

iii. All common touch points to be frequently disinfected in a day.

e. Regular disinfection of all Areas, Equipment and facilities

i. A dedicated disinfectant gang to be identified for the task by each agency. The disinfectant gang to be provided full body suits for the task.

ii. All areas (including office premises, site areas, chairs, tables, furniture etc.), tools & equipment to preferably be disinfected by dedicated gang every day before resumption of work.

iv. Common touch points like handrails, lift buttons, door/window knobs or handles, vehicle door handles, taps, conference room & dining hall tables/chairs, common sofas/chairs, visitor sofa/chairs, files & folders, etc to preferably be disinfected regularly at frequent intervals every day.

v. Pool vehicles, to be disinfected after every use. Social distancing to be maintained inside the common pool vehicles as per Govt./ statutory body guidelines.

f. Disinfecting the operator/driver touch points of Vehicles/cranes, T&Ps etc.

Disinfection to also be carried out for all Cranes, Vehicles, Equipment, consoles, T&Ps etc. which come into contact with operating personnel.

g. Posters on COVID-19

Sufficient Posters on COVID-19 to be ensured across the site in languages understood by most workers.

h. Brief guidelines for hand washing are as below:

i. Soap to be provided at each wash basin and replenished regularly.

ii. Washing with soap for at least 20 seconds is recommended.

iii. As a general guideline, for every 100 workers, 1 wash-basin may be provided at site areas.

iv. Close queue to be avoided near wash-basins and 1-meter distance to be maintained. Round markers at 1-meter distance can be ensured as guidance

Composition of Disinfectant:

i. Readily available 1% hypochlorite solution or 4%

ii. Liquid chlorine-1% solution

Iii. Surgical spirit-95% alcohol content

iv. Hand sanitizer should have: Isopropyl alcohol-75%, Gycerol-1.45%, Hydrogen Peroxide-0.125%

B. Prevention of COVID-19 Infection in Labor Colony:

- Spacing of minimum 2 meters between living areas of workers inside a room may be maintained. Preferably, the living area of each worker may be partitioned using sheet of cloth, plastic etc.
- Rooms to be properly ventilated as far as possible
- Sanitation to be given prime importance and personal hygiene to be promoted
- Face masks shall be worn by everyone inside the colony premises
- Spitting of Pan. Gutkha etc. inside the colony and urinating etc. outside the toilets to be strictly avoided
- Regular visits by Doctors to the labor colony can be arranged on non-working day for check-up of all workers
- **Identification of "COVID Wardens" (CWs) by each agency for maintaining the following:**

  i. Keeping an eye on the health of workers and report any suspected cases of fever, coughing etc. to the

management

ii. Keeping an eye on the social distancing measures in the labor colony and report any non-conformances to the management.

iii. Educate the workers about social distancing and COVID prevention measures.

- Training/ Awareness regarding COVID-19 to be provided to workers regularly.
- Workers to be instructed to maintain social distancing of minimum 1 m at all time
- **Posters on COVID-19:** Sufficient Posters on COVID-19 to be ensured across the labor colony in languages understood by most workers.
- All workers to be instructed to inform any suspected cases of illness (individual or others) to an emergency contact number of CW, the emergency contact numbers and CW contact numbers to be displayed at prominent locations
- **Inspection & Review**

  i. Daily Inspection by concerned COVID Wardens and reporting to Agency

  ii. Regular inspection by Agency & BHEL

15.5 Noise Mitigation

High noise is harmful to the human health and it can cause impairment if exposed for long duration at regular intervals, and also cause disruption in nearby communities.

- Noise monitoring shall be carried out in all construction locations periodically.
- Use of silent DG is allowed at site during construction.
- Low noise generation equipment's to be preferred.
- Work areas where noise levels exceed the 85db shall be posted as hearing protection required.
- Use of PPEs / ear plug/ear muff for personnel entering into high noise area.
- Activities generation High noise will be planned in day shift.

Noise Level Chart

Parameter	Night Noise level dBA	Daytime Noise Level dBA
At 1-meter from each piece of equipment	85	85
At Property boundary	70	70

ANNEXURE J

First-Aid Box

Details & Contents of First Aid Box as per Contract Labor (Regulation & Abolition Act), Central Rules, 1971

(1) The first-aid box shall be distinctively marked with a Red Cross on a white background and shall contain the following items, namely:

(a) For establishments in which the number of contract labor employed does not exceed fifty, each first aid box shall contain the following equipment:

(i)	6 small sterilized dressings
(ii)	3 medium size sterilized dressings
(iii)	3 large size sterilized dressings
(iv)	6 pieces of sterilized eye pads in separate sealed packets.
(v)	6 roller bandages 10 cm wide.
(vi)	6 roller bandages 5 cm wide.
(vii)	One tourniquet
(viii)	A supply of suitable splints
(ix)	Three packets of safety pins.
(x)	Kidney tray.
(xi)	3 large sterilized burn dressings.
(xii)	1 (30ml) bottle containing a two percent alcoholic solution of iodine
(xiii)	1 (30 ml) bottle containing Sal volatile having the dose and mode of administration indicated on the label
(xiv)	1 snake bite lancet
(xv)	1 (30gms) bottle of potassium permanganate crystals.
(xvi)	1 pair scissors
(xvii)	1 copy of the First-Aid leaflet issued by the Director General, Factory Advice Service and Labor Institutes, Government of India.
(xviii)	A bottle containing 100 tablets (each of 5 grains) of aspirin
(xix)	Ointment for burns
(xx)	A bottle of suitable surgical anti-septic solution

(b) For establishment in which the number of contract labor exceeds fifty each first-aid box shall contain the following equipment:

(i)	12 small sterilized dressings
(ii)	6 medium size sterilized dressings
(iii)	6 large size sterilized dressings.
(iv)	6 large size sterilized burn dressings
(v)	6 (15 grams) packets sterilized cotton wool
(vi)	12 pieces of sterilized eye pads in separate sealed packets.
(vii)	12 roller bandages 10 cm wide.
(viii)	12 roller bandages 5 cm wide.
(ix)	One tourniquet.
(x)	A supply of suitable splints.
(xi)	Three packets of safety pins.
(xii)	Kidney tray.
(xiii)	Sufficient number of eye washes bottles filled with distilled water or suitable liquid clearly indicated by a distinctive sign which shall be visible at all times.
(xiv)	4 per cent Xylocaine eye drops, and boric acid eye drops and soda by carbonate eye drops.
(xv)	1 (60ml) bottle containing a two percent alcoholic solution of iodine
(xvi)	One (two hundred ml) bottle of mercurochrome (2 per cent) solution in water.
(xvii)	1 (120ml) bottle containing Sal volatile having the dose and mode of administration indicated on the label.
(xviii)	1 roll of adhesive plaster (6 cmX1 meter)
(xix)	2 rolls of adhesive plaster (2 cmX1 meter)
(xx)	A snake bite lancet.
(xxi)	1 (30 grams) bottle of potassium permanganate crystals.
(xxii)	1 pair scissors
(xxiii)	1 copy of the First-Aid leaflet issued by the Director-General, Factory Advice service and labor Institutes, Government of India.
(xxiv)	a bottle containing 100 tablets (each of 5 grains) of aspirin
(xxv)	Ointment for burns
(xxvi)	A bottle of a suitable surgical anti septic solution.

(2) Adequate arrangement shall be made for immediate recoupment of the equipment when necessary.

ANNEXURE K

Vertigo Test

Vertigo Test Procedure/ Guidelines

This document specifies minimum requirements for vertigo test. These may be supplemented by any additional requirements deemed fit by the medical examiner/ HSE department)

Fear of height may be physiological or psychological. Therefore, to rule out any possibility of physiological factor, detailed medical check-up of workers is carried out before vertigo test. Medical check-up of workers includes the following:

history of past illnesses (like epilepsy, drug allergy, diabetics/ hypertension, unconsciousness etc.), general physical examination (like height, weight, BMI, build and nourishment etc.), measurement of pulse rate, Blood Pressure, respiratory rate.

After this check-up, those who are found suitable for height work by examining doctor, are allowed to undergo vertigo test.

During this health check-up, psychology of workers is also studied. If any worker finds it extremely difficult/ frightening to climb the monkey ladder & walk on the beam, during/after performing vertigo test or even before performing, then he is treated as disqualified.

As per standard, during vertigo test, worker is allowed to climb on a foundation through monkey ladder, walk on a beam, then steps down at the other end of beam, through monkey ladder. Height of the beam should be at least six feet from ground level. All necessary safety precautions are taken during this test. Worker has to wear full body harness with double lanyard. A horizontal lifeline is run parallel to the beam and worker has to put his lanyards into the lifeline. Additionally, a safety net is also put below the beam for rescue of the victim in case of a fall from beam.

Following activities are suggested to be carried out during testing:

1. **Walking Bench Training:**
   a. Person should walk over the channel. He should maintain balance & walk without much problem.
   b. If the person has problem to balances himself on repeated chances, he may be having flat foot or some other problem. So, he may not be fit for height work.
2. **Rope Climb Training:**
   Person should be able to climb the rope up to the top channel for ensuring that in case of fall, a person hanging on the safety harness, will be able to safely climb back to the platform within minimum time period before the safety harness start breaking down under the load.
3. **Height Work Training:**
   Person should walk freely on the middle channel while holding the top channel with the help of safety harness.
4. **Ladder for Vertical fall arrestor Training:**
   Vertical fall arrestor rope is fixed from top to bottom of the ladder. It will ensure:
   - Usage of vertical fall arrestor.
   - Usage of two lanyards of a safety harness.
   - Ensure 3-point contact on the ladder while climb.
5. **Chair for work at height Training:**
   - Climb though vertical ladder with two lanyard ropes.
   - Hooking of two lanyard ropes to life line. With this safe arrangement, he can walk to chair.
   - Sits in the chair safely, comes out & walks back to the vertical ladder & come down from vertical ladder. After completion of vertigo test, blood pressure of worker is again measured. If it is not within acceptable limits for any worker, concerned worker is denied height pass.

Only those who pass the above training are to be considered as fit for height work.

Annexure
C1

DATE:31/08/2021

T&P HIRE CHARGES

REVISED RATES OF T&P HIRE CHARGES FOR CRANES & TRAILERS ETC. FOR
SUB-CONTRACTORS WORKING FOR BHEL FOR DOING BHEL JOBS

SL NO.	ITEM DESCRIPTION	USEFUL LIFE (IN YRS)	Revised rates (Rs./Hour) valid from 01/09/2021 to 31/8/2023 (WITHIN USEFUL LIFE)	Revised rates (Rs./Hour) valid from 01/09/2021 to 31/8/2023 (BEYOND USEFUL LIFE)
I.	CRANES:-			
1	Portal Gantry Crane 500T	15	24500.00	24500.00
2	100MT Crawler Crane ZOOMLION CRANE-QUY-100	10	11370.00	10940.00
3	Heavy Lift Crawler Crane 600MT Class DEMAG Model CC2800	15	56290.00	53560.00
4	PORTAL CRANE, 360T	15	14070.00	13390.00
5	600MT Class Crawler Crane- Manitowoc Model 18000-UPGRADED	15	55460.00	52770.00
6	600MT Class Crawler Crane- Liebherr Model LR1600-2 (Upgraded version)	15	68610.00	65280.00
7	CRAWLER CRANE FMC/LINKBELT 718, 250T (WITH RINGER)	15	33510.00	31880.00
8	CRAWLER CRANE FMC/LINKBELT 718, 250T (WITH-OUT RINGER)	15	20940.00	19920.00
9	MANITOWOC M-250T TRUCK CRANE	15	30160.00	28690.00
10	270 MT Class Crawler Crane- Manitowoc Model 2250	15	31660.00	30130.00
11	300MT Crane Crawler Crane LIEBHERR Model LR-1350/1	15	26390.00	25110.00
11.A	300MT Crane Crawler Crane LIEBHERR Model LR-1350/1 (UPGRADED)	15	36110.00	34580.00
12	250MT Class Mid range Crawler Crane- Kobelco Model CKE2500-2	15	15130.00	14390.00
12.A	250MT Class Mid range Crawler Crane- Kobelco Model CKE2500-2 (UPGRADED)	15	18850.00	18050.00
13	LINKBELT LS- 248H CRAWLER CRANE (180T)	15	16750.00	15940.00
14	MANITOWAC MODEL 888 CRAWLER CRANE (200 MT)	15	21780.00	20720.00
15	CRAWLER CRANE SUMITOMO, 150T	15	10890.00	10360.00
16	All Terrain Crane, 150MT- Liebherr Model LTM1150	15	13400.00	12750.00
17	CRAWLER CRANE, 120 T Fushun Model QUY120	10	10830.00	10420.00
18.A	CRAWLER CRANE 135MT Kobelco Model CK1350- 1F	15	10720.00	10200.00
18.B	CRAWLER CRANE 135MT Kobelco Model CK1350	15	8880.00	8440.00
19	CRAWLER CRANE 120MT - Tata-Sumitomo Model SCX1200-2	15	10050.00	9560.00
20	CRAWLER CRANE 100 T (KH 500)	15	10050.00	9560.00
21	Hydraulic Crawler Crane 80MT, Fushun Model QUY 80B	10	5410.00	5210.00
22	ROUGH TERRAIN CRANE 75T (RT880)	12	6140.00	5880.00
23	CRAWLER CRANE, 75T -Tata Model 955ALC/TFC280	12	5370.00	5150.00
24	Mobile Crane, 55MT (TIL)	12	4410.00	4230.00
25	CRAWLER CRANE, 25T -Tata Model TFC75	10	3030.00	2910.00
26	MOBILE CRANE, 20MT (TIL)	10	2270.00	2180.00
27	MOBILE CRANE, 20MT (ESCORTS)	10	2270.00	2180.00
28	MOBILE CRANE ESCORTS- 14MT	10	710.00	680.00
29	HYDAULIC PICK & CARRY CRANE, 8/9/10/11/12 MT	10	390.00	370.00

Annexure

C1

DATE:31/08/2021

REVISED RATES OF T&P HIRE CHARGES FOR CRANES & TRAILERS ETC. FOR
SUB-CONTRACTORS WORKING FOR BHEL FOR DOING BHEL JOBS

SL NO.	ITEM DESCRIPTION	USEFUL LIFE (IN YRS)	Revised rates (Rs./Hour) valid from 01/09/2021 to 31/8/2023 (WITHIN USEFUL LIFE)	Revised rates (Rs./Hour) valid from 01/09/2021 to 31/8/2023 (BEYOND USEFUL LIFE)
30	FORK LIFT 5T	5	650.00	640.00
31	FORK LIFT 3T	5	540.00	530.00

Annexure C2 DATE:31/08/202

REVISED RATES OF T&P HIRE CHARGES FOR CRANES & TRAILERS ETC. FOR OUTSIDE AGENCIES

SL NO.	ITEM DESCRIPTION	USEFUL LIFE (IN YRS)	Revised rates (Rs./Hour) valid from 01/09/2021 to 31/8/2023 (WITHIN USEFUL LIFE)	Revised rates (Rs./Hour) valid from 01/09/2019 to 31/8/2021 (BEYOND USEFUL LIFE)
I.	CRANES:-			
1	Portal Gantry Crane 500T	15	27230.00	27230.00
2	100MT Crawler Crane ZOOMLION CRANE-QUY-100	10	12630.00	12160.00
3	Heavy Lift Crawler Crane 600MT Class DEMAG Model CC2800	15	62550.00	59520.00
4	PORTAL CRANE, 360T	15	15630.00	14880.00
5	600MT Class Crawler Crane- Manitowoc Model 18000-UPGRADED	15	61620.00	58630.00
6	600MT Class Crawler Crane- Liebherr Model LR1600-2 (Upgraded version)	15	76230.00	72540.00
7	CRAWLER CRANE FMC/LINKBELT 718, 250T (WITH RINGER)	15	37230.00	35420.00
8	CRAWLER CRANE FMC/LINKBELT 718, 250T (WITH-OUT RINGER)	15	23270.00	22140.00
9	MANITOWOC M-250T TRUCK CRANE	15	33510.00	31880.00
10	270 MT Class Crawler Crane- Manitowoc Model 2250	15	35180.00	33480.00
11	300MT Crane Crawler Crane LIEBHERR Model LR-1350/1	15	29320.00	27900.00
11.A	300MT Crane Crawler Crane LIEBHERR Model LR-1350/1 (UPGRADED)	15	40120.00	38420.00
12	250MT Class Mid range Crawler Crane- Kobelco Model CKE2500-2	15	16810.00	15990.00
12.A	250MT Class Mid range Crawler Crane- Kobelco Model CKE2500-2 (UPGRADED)	15	20950.00	20060.00
13	LINKBELT LS- 248H CRAWLER CRANE (180T)	15	18610.00	17710.00
14	MANITOWAC MODEL 888 CRAWLER CRANE (200 MT)	15	24200.00	23020.00
15	CRAWLER CRANE SUMITOMO, 150T	15	12100.00	11510.00
16	All Terrain Crane, 150MT- Liebherr Model LTM1150	15	14890.00	14170.00
17	CRAWLER CRANE, 120 T Fushun Model QUY120	10	12030.00	11580.00
18.A	CRAWLER CRANE 135MT Kobelco Model CK1350- 1F	15	11910.00	11330.00
18.B	CRAWLER CRANE 135MT Kobelco Model CK1350	15	9860.00	9380.00
19	CRAWLER CRANE 120MT - Tata-Sumitomo Model SCX1200-2	15	11170.00	10620.00
20	CRAWLER CRANE 100 T (KH 500)	15	11170.00	10620.00
21	Hydraulic Crawler Crane 80MT, Fushun Model QUY 80B	10	6010.00	5790.00
22	ROUGH TERRAIN CRANE 75T (RT880)	12	6830.00	6540.00
23	CRAWLER CRANE, 75T -Tata Model 955ALC/TFC280	12	5970.00	5720.00
24	Mobile Crane, 55MT (TIL)	12	4900.00	4700.00
25	CRAWLER CRANE, 25T -Tata Model TFC75	10	3370.00	3240.00
26	MOBILE CRANE, 20MT (TIL)	10	2520.00	2430.00
27	MOBILE CRANE, 20MT (ESCORTS)	10	2520.00	2430.00
28	MOBILE CRANE ESCORTS- 14MT	10	790.00	760.00
29	HYDAULIC PICK & CARRY CRANE, 8/9/10/11/12 MT	10	430.00	410.00

Annexure C2 DATE:31/08/202

REVISED RATES OF T&P HIRE CHARGES FOR CRANES & TRAILERS ETC. FOR OUTSIDE AGENCIES

SL NO.	ITEM DESCRIPTION	USEFUL LIFE (IN YRS)	Revised rates (Rs./Hour) valid from 01/09/2021 to 31/8/2023 (WITHIN USEFUL LIFE)	Revised rates (Rs./Hour) valid from 01/09/2019 to 31/8/2021 (BEYOND USEFUL LIFE)
30	FORK LIFT 5T	5	720.00	710.00
31	FORK LIFT 3T	5	600.00	590.00

Annexure I

RATES FOR INTER REGIONAL HIRE CHARGES FOR CRANES OF CAPACITY 75 TON OR MORE FOR PERIOD 01-09-2021 TO 31-08-2023

Dt : 31/08/2021

SL NO.	ITEM DESCRIPTION	Rates (Rs./MONTH) valid from 01/09/2021 to 31/8/2023
I.	CRANES : -	
1	Portal Gantry Crane 500T	1243192
2	100MT Crawler Crane ZOOMLION CRANE-QUY-100	631183
3	Heavy Lift Crawler Crane 600MT Class DEMAG Model CC2800	2717358
4	PORTAL CRANE, 360T	679333
5	600MT Class Crawler Crane- Manitowoc Model 18000-UPGRADED	2676917
6	600MT Class Crawler Crane- Liebherr Model LR1600-2 (Upgraded version)	3311783
7	CRAWLER CRANE FMC/LINKBELT 718, 250T (WITH RINGER)	1617475
8	CRAWLER CRANE FMC/LINKBELT 718, 250T (WITH-OUT RINGER)	1010917
9	MANITOWOC M-250T TRUCK CRANE	1455725
10	270 MT Class Crawler Crane- Manitowoc Model 2250	1528508
11	300MT Crane Crawler Crane LIEBHERR Model LR-1350/1	1273758
11.A	300MT Crane Crawler Crane LIEBHERR Model LR-1350/1 (UPGRADED)	1754150
12	250MT Class Mid range Crawler Crane- Kobelco Model CKE2500-2	730283
12.A	250MT Class Mid range Crawler Crane- Kobelco Model CKE2500-2 (UPGRADED)	915892
13	LINKBELT LS- 248H CRAWLER CRANE (180T)	808733
14	MANITOWAC MODEL 888 CRAWLER CRANE (200 MT)	1051358
15	CRAWLER CRANE SUMITOMO, 150T	525675
16	All Terrain Crane, 150MT- Liebherr Model LTM1150	646983
17	CRAWLER CRANE, 120 T Fushun Model QUY120	601125
18.A	CRAWLER CRANE 135MT Kobelco Model CK1350- 1F	517592
18.B	CRAWLER CRANE 135MT Kobelco Model CK1350	428625
19	CRAWLER CRANE 120MT - Tata-Sumitomo Model SCX1200-2	485242
20	CRAWLER CRANE 100 T (KH 500)	485242
21	Hydraulic Crawler Crane 80MT, Fushun Model QUY 80B	300558
22	ROUGH TERRAIN CRANE 75T (RT880)	321758
23	CRAWLER CRANE, 75T -Tata Model 955ALC/TFC280	281533

ANNEXURE-T I
DT: 31/08/2021

RATES OF T&P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILERS ETC. FOR SUB-CONTRACTORS WORKING FOR BHEL FOR DOING BHEL JOBS

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
I.	LIFTING EQUIPMENTS	
1	Strand Jack System for Boiler Drum Lifting	20930
2	MULTI SHEAVE PULLEY BLOCK 40/50T/60T	310
3	MULTI SHEAVE PULLEY BLOCK 100T	630
4	MULTI SHEAVE PULLEY BLOCK 150T	1260
5	ELCTRIC WINCH 5T	1270
6	ELCTRIC WINCH 10T	2360
7	ELECTRIC WINCH 15 T	2150
8	PASSENGER CUM GOODS HOIST 1T	2270
9	FURNACE MAINTENANCE PLATFORM	5040
10	Gang Operated Hydraulic Jack (Set of 4 Jacks - 175 MT each)	2100
II	WELDING & HEAT TREATMENT EQUIPMENT	
1	125KW, 3KHZ, AIR-COOLED INDUCTION HEATING EQUIPMENT	16380
2	75KW, 10 KHZ, COMPACT INDUCTION HEATING EQUIPMENT	8190
3	WELDING GENERATOR 320/300 A	300
4	WELDING RECTIFIER 400A/300A	300
5	WELDING RECTIFIER 600A	400
6	DIESEL WELDING GENERATOR 400A/300A	400
7	TRANSFORMER,600A	300
8	TRANSFORMER 300/400A	200
III	SERVICE PLANTS & ALLIED EQUIPT.	0
1	500KVA DIESEL GENERATOR	3800
2	TRANSFORMER OIL FILTERATION EQUIPMENT 6000LPH CAPACITY WITHOUT STORAGE TANK	6370
3	-DO- , WITH STORAGE TANK	7280
4	OIL FILTERATION M/C, 250/500 LPH (OTHER THAN SILICON OIL)	910
5	OIL FILTERATION M/C, 250GPH/1000LPH (OTHER THAN SILICON OIL)	1360
6	OIL FILTERATION M/C, 500GPH/2500LPH (OTHER THAN SILICON OIL)	1820
7	OIL FILTERATION M/C, 1000GPH/5000LPH (OTHER THAN SILICON OIL)	3640
8	Portable Lube Oil Purification Unit (Centrifuge M/c) Capacity: 750 LPH	1270
9	Low Vacuum de-hydration unit	630
10	DIESEL GENERATING SET,250 KVA	1770
11	DIESEL GENERATING SET,25 KVA	500

ANNEXURE-T I
DT: 31/08/2021

RATES OF T&P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILERS ETC. FOR SUB-CONTRACTORS WORKING FOR BHEL FOR DOING BHEL JOBS

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
12	VACUUM PUMP(ABSOLUTE V.C.)	540
13	ACID CIRCULATING PUMP WITH MOTOR 120M HEAD, 150T/HR	1090
14	ACID TRANSFER PUMP 20/50 T/HR	540
15	DEWATERING PUMP (Kirloskar make,11KW/15HP)	80
16	HP Air compressor (32 Kg/Sq. Cm, 150 CFM)	4240
17	AIR COMPRESSORS 250/300/330/360/350 CFM	2730
18	AIR COMPRESSORS 140/150/190/210 CFM	910
19	ACID CIRCULATING PUMP WITH MOTOR & STARTER, 200T/HR, 150M, 220 HP	1820
20	Industrial Blower 2000CFM	1270
21	Air Leak Test Blower (Flow: 40000 m^3/Hr)	1160
22	Air Blower (Flow: 20000 m^3/Hr)	940
IV	METAL FORMING /CUTTING EQUIPMENT	
1	TUBE EXPANDING M/C PNEUMATIC 60-100 MM	630
2	ELECTRO HYDRAULIC PIPE BENDING M/C 4"	1630
3	BOLTING MACHINE (ALCOA/AVLOCK/ HUCK)	1800
4	-do- Gun with nose Assembly only	540
V	TESTING/INSPECTION EQUIPMENT	
1	DATA LOGGER for PG TESTING	36980
2	MOTORISED HYDRAULIC TEST PUMP 250kg/cmsq	800
3	MOTORISED HYDRAULIC TEST PUMP 400-450kg/cmsq	1090
4	MOTORISED HYDRAULIC TEST PUMP 600 KG/CMSQ	1270
5	HYDRAULIC TEST PUMP 800 KG/CMSQ	1330
6	HYDRAULIC TEST PUMP 1000 KG/CMSQ	2230
7	BOLT STRETCHING DEVICE	910
8	BOROSCOPE/FIBROSCOPE FLEXIBLE TYPE (FLEXUX) IMPORTED	3640
9	ULTRASONIC FLAW DETECTOR	2730
10	MPI TEST KIT	360
11	GAS LEAK DETECTOR	270
12	VIBRATION/SOUND LEVEL METER IRD-306	360
13	VIBRATION/SOUND LEVEL METER IRD-308	360
14	VIBRATION ANALYSER/DYNAMIC BALANCING M/C IRD 350	1450
15	VIBRATION ANALYSER/DYNAMIC BALANCING M/C IRD 360	2540
16	SHOCK PULSE METER	630
17	HV.DC TEST KIT UPTO 50 KV	540
18	HV.DC TEST KIT ABOVE 50 KV	1000
19	HV.AC TEST KIT UPTO 50KV	810
20	HV.AC TEST KIT ABOVE 50KV	2910
21	MOTORISED MEGGER 2.5KV	400
22	MOTORISED MEGGAR 5KV	450
23	OSCILLOSCOPE-DUAL BEAM INDIGENOUS	450
24	OSCILLOSCOPE-DUAL BEAM IMPORTED	1090
25	WAVEFORM ANALYSER	910
26	OSCILLOGRAPH/UV RECORDER 24 CHANNEL	1630
27	OSCILLOGRAPH/UV RECORDER 12 CHANNEL	1090
28	OSCILLOGRAPH/UV RECORDER 6 CHANNEL	910

ANNEXURE-T I
DT: 31/08/2021

RATES OF T&P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILERS ETC. FOR SUB-CONTRACTORS WORKING FOR BHEL FOR DOING BHEL JOBS

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
29	DIGITAL LOW RESISTANCE METER	630
30	DC POTENTIOMETER	180
31	PRECISION DEAD WEIGHT TESTER	1000
32	OPTICAL ALIGNMENT KIT	1360
33	BOROSCOPE/FIBROSCOPE(NON FLEXIBLE)	1200
34	VERNIER THEODOLITE,PRECISION	1200
35	VERNIER THEODOLITE,ORDINARY	200
36	ENGINEERS PRECISION LEVEL/DUMPY LEVEL	120
37	ISKAMATIC 'A'	3200
38	CALIBRATOR '03'	1000
39	48 POLE EXTENDER CARD	200
40	MULTIJET NPM	400
41	OSCILLOMETER	10190
42	VOC EQUIPMENT	1400
43	BINARY SIGNAL GENERATOR	290
44	ELECTRIC COUNTER	690
45	FREQUENCY GENERATOR	1000
46	DBF 3 VIBRATION RECORDER/ANALYSER	3270
47	L&T GOULD OSCILLOGRAPH 2-CHANNEL	490
48	L&T GOULD OSCILLOGRAPH 6-CHANNEL	1180
49	VIBROPORT 41/FFT ANALYSER	5460
50	ELCID kit	10010
51	UNIVERSAL CALIBRATION SYSTEM	2730
52	NATURAL FREQUENCY TESTER	2910
53	DIGITAL HARDNESS TESTER	360
54	ADRE 208 VIBRATION ANALYSER	7280
55	PCB DIAGONISTIC REPAIR KIT	2000
56	SECONDARY INJECTION RELAY TEST KIT	5270
57	MICRO OHM METER	1450
58	DIGITAL MICRO OHM METER MEASURING RANGE: 200 μΩ TO 20KΩ	3230
59	PMI Machine OLYMPUS make	3350
60	Mobile Lighting Mast - 9 metres (4X400 W)	860
61	10KVA RESISTANCE BRAZING MACHINE	140
62	RECURRENT SURGE OSCILLOGRAPH (RSO) TEST KIT WITH PORTABLE HANDHELD OSCILLOSCOPE.	460
63	HYDROGEN GAS LEAK DETECTOR	50
64	STATOR WEDGE ANALYZER KIT WITH COMPLETE ACCESSORIES	4980
65	WEDGE DEFLECTION KIT	80
66	TILE PRESSING MACHINE FOR GAS TURBINE	270
67	INDUCTION BRAZING MACHINE	4870
68	MAGNETIC COHESIVE FORCE (MCF) EQUIPMENT	3640
69	ULTRASONIC FLOW METER	180
70	PORTABLE VIBRATION ANALYSER (MODEL 811T)	40
71	CENTRIFUGAL PUMP SET FOR ACID CLEANING (WITH MOTOR AND PANEL) : PRESSURE -14KG/SQ CM. ; FLOW 60 M3/HR	470
72	CENTRIFUGAL PUMP SET FOR ACID CLEANING (WITH MOTOR AND PANEL) : PRESSURE -30KG/SQ CM. ; FLOW 15 M3/HR	430

ANNEXURE-T I
DT: 31/08/2021

RATES OF T&P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILERS ETC. FOR SUB-CONTRACTORS WORKING FOR BHEL FOR DOING BHEL JOBS

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
73	HI SPEED MEMORY RECORDER, MAKE -YOKOGAWA, MODEL DL850E-Q-HE/B5/HD1	1810
74	TROLLEY MOUNTED HYDRAULIC JACK (100 MT)	1260
75	5KV Insulation Tester	450
76	4 Channel Digital Oscilloscope /Fast Recorder	1710
77	4 Channel Oscillographic Recorder	580
78	Sound Level Meter	230
79	Thermal Imaging Camera	770
80	Videoscope (Video Boroscope)	1510
81	DO (Dissolve Oxygen) Meter (0 to 1500 ppb)	1310
82	Conductivity Meter	80
83	Core Flux Test Kit	7280
84	Primary Current Injection Kit (2000A)	870
85	3 Phase Secondary Injection Kit (Relay Test)	3760
86	FRF Filtration Kit	1330
87	FFT Analyser	2290
88	Flue Gas Analyser	1030
89	Oil Test Kit (Mineral Oil)-Transformer	1010
90	Winding Resistance kit (R L C Load)	880
91	SFRA test Kit	1190
92	Tan Delta test Kit	4060
93	PF Meter	330
94	Ultrasonic Flow Meter	830
95	Oil Particle Counter	360
96	Plasma Cutting Machine (With complete accessories)	310
97	JCB make DG Set 80 KVA	670
98	Diesel Generating Set 82.5 KVA	610
99	Portable Jacking Oil Pump	1080
100	Alloy Analyser	1770

ANNEXURE-T II
DT: 31/08/2021

RATES OF T & P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILLERS ETC. FOR OUTSIDE AGENCIES

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
I.	LIFTING EQUIPMENTS	
1	Strand Jack System for Boiler Drum Lifting	23250
2	MULTI SHEAVE PULLEY BLOCK 40/50T/60T	350
3	MULTI SHEAVE PULLEY BLOCK 100T	700
4	MULTI SHEAVE PULLEY BLOCK 150T	1400
5	ELCTRIC WINCH 5T	1410
6	ELCTRIC WINCH 10T	2620
7	ELECTRIC WINCH 15 T	2390
8	PASSENGER CUM GOODS HOIST 1T	2520
9	FURNACE MAINTENANCE PLATFORM	5600
10	Gang Operated Hydraulic Jack (Set of 4 Jacks - 175 MT each)	2330
II	WELDING & HEAT TREATMENT EQUIPMENT	
1	125KW, 3KHZ, AIR-COOLED INDUCTION HEATING EQUIPMENT	18190
2	75KW, 10 KHZ, COMPACT INDUCTION HEATING EQUIPMENT	9090
3	WELDING GENERATOR 320/300 A	330
4	WELDING RECTIFIER 400A/300A	330
5	WELDING RECTIFIER 600A	440
6	DIESEL WELDING GENERATOR 400A/300A	440
7	TRANSFORMER,600A	330
8	TRANSFORMER 300/400A	220
III	SERVICE PLANTS & ALLIED EQUIPT.	
1	500KVA DIESEL GENERATOR	4220
2	TRANSFORMER OIL FILTERATION EQUIPMENT 6000LPH CAPACITY WITHOUT STORAGE TANK	7070
3	-DO- , WITH STORAGE TANK	8080
4	OIL FILTERATION M/C, 250/500 LPH (OTHER THAN SILICON OIL)	1010
5	OIL FILTERATION M/C, 250GPH/1000LPH (OTHER THAN SILICON OIL)	1510
6	OIL FILTERATION M/C, 500GPH/2500LPH (OTHER THAN SILICON OIL)	2020
7	OIL FILTERATION M/C, 1000GPH/5000LPH (OTHER THAN SILICON OIL)	4040
8	Portable Lube Oil Purification Unit (Centrifuge M/c) Capacity: 750 LPH	1410
9	Low Vacuum de-hydration unit	700
10	DIESEL GENERATING SET,250 KVA	1970
11	DIESEL GENERATING SET,25 KVA	560
12	VACUUM PUMP(ABSOLUTE V.C.)	600
13	ACID CIRCULATING PUMP WITH MOTOR 120M HEAD, 150T/HR	1210
14	ACID TRANSFER PUMP 20/50 T/HR	600
15	DEWATERING PUMP (Kirloskar make,11KW/15HP)	90
16	HP Air compressor (32 Kg/Sq. Cm, 150 CFM)	4710
17	AIR COMPRESSORS 250/300/330/360/350 CFM	3030
18	AIR COMPRESSORS 140/150/190/210 CFM	1010

ANNEXURE-T II
DT: 31/08/2021

RATES OF T & P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILLERS ETC. FOR OUTSIDE AGENCIES

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
19	ACID CIRCULATING PUMP WITH MOTOR & STARTER, 200T/HR, 150M, 220 HP	2020
20	Industrial Blower 2000CFM	1410
21	Air Leak Test Blower (Flow: 40000 m^3/Hr)	1290
22	Air Blower (Flow: 20000 m^3/Hr)	1040
IV	METAL FORMING /CUTTING EQUIPMENT	
1	TUBE EXPANDING M/C PNEUMATIC 60-100 MM	700
2	ELECTRO HYDRAULIC PIPE BENDING M/C 4"	1810
3	BOLTING MACHINE (ALCOA/AVLOCK/ HUCK)	2000
4	-do- Gun with nose Assembly only	600
V	TESTING/INSPECTION EQUIPMENT	
1	DATA LOGGER for PG TESTING	41090
2	MOTORISED HYDRAULIC TEST PUMP 250kg/cmsq	880
3	MOTORISED HYDRAULIC TEST PUMP 400-450kg/cmsq	1210
4	MOTORISED HYDRAULIC TEST PUMP 600 KG/CMSQ	1410
5	HYDRAULIC TEST PUMP 800 KG/CMSQ	1480
6	HYDRAULIC TEST PUMP 1000 KG/CMSQ	2480
7	BOLT STRETCHING DEVICE	1010
8	BOROSCOPE/FIBROSCOPE FLEXIBLE TYPE (FLEXUX) IMPORTED	4040
9	ULTRASONIC FLAW DETECTOR	3030
10	MPI TEST KIT	400
11	GAS LEAK DETECTOR	300
12	VIBRATION/SOUND LEVEL METER IRD-306	400
13	VIBRATION/SOUND LEVEL METER IRD-308	400
14	VIBRATION ANALYSER/DYNAMIC BALANCING M/C IRD 350	1610
15	VIBRATION ANALYSER/DYNAMIC BALANCING M/C IRD 360	2830
16	SHOCK PULSE METER	700
17	HV.DC TEST KIT UPTO 50 KV	600
18	HV.DC TEST KIT ABOVE 50 KV	1110
19	HV.AC TEST KIT UPTO 50KV	900
20	HV.AC TEST KIT ABOVE 50KV	3230
21	MOTORISED MEGGER 2.5KV	440
22	MOTORISED MEGGAR 5KV	500
23	OSCILLOSCOPE-DUAL BEAM INDIGENOUS	500
24	OSCILLOSCOPE-DUAL BEAM IMPORTED	1210
25	WAVEFORM ANALYSER	1010
26	OSCILLOGRAPH/UV RECORDER 24 CHANNEL	1810
27	OSCILLOGRAPH/UV RECORDER 12 CHANNEL	1210
28	OSCILLOGRAPH/UV RECORDER 6 CHANNEL	1010
29	DIGITAL LOW RESISTANCE METER	700
30	DC POTENTIOMETER	200
31	PRECISION DEAD WEIGHT TESTER	1110
32	OPTICAL ALIGNMENT KIT	1510
33	BOROSCOPE/FIBROSCOPE(NON FLEXIBLE)	1330
34	VERNIER THEODOLITE,PRECISION	1330
35	VERNIER THEODOLITE,ORDINARY	220

ANNEXURE-T II
DT: 31/08/2021

RATES OF T & P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILLERS ETC. FOR OUTSIDE AGENCIES

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
36	ENGINEERS PRECISION LEVEL/DUMPY LEVEL	130
37	ISKAMATIC 'A'	3550
38	CALIBRATOR '03'	1110
39	48 POLE EXTENDER CARD	220
40	MULTIJET NPM	440
41	OSCILLOMETER	11320
42	VOC EQUIPMENT	1550
43	BINARY SIGNAL GENERATOR	320
44	ELECTRIC COUNTER	760
45	FREQUENCY GENERATOR	1110
46	DBF 3 VIBRATION RECORDER/ANALYSER	3630
47	L&T GOULD OSCILLOGRAPH 2-CHANNEL	540
48	L&T GOULD OSCILLOGRAPH 6-CHANNEL	1310
49	VIBROPORT 41/FFT ANALYSER	6060
50	ELCID kit	11120
51	UNIVERSAL CALIBRATION SYSTEM	3030
52	NATURAL FREQUENCY TESTER	3230
53	DIGITAL HARDNESS TESTER	400
54	ADRE 208 VIBRATION ANALYSER	8080
55	PCB DIAGONISTIC REPAIR KIT	2220
56	SECONDARY INJECTION RELAY TEST KIT	5860
57	MICRO OHM METER	1610
58	DIGITAL MICRO OHM METER MEASURING RANGE: 200 μΩ TO 20KΩ	3590
59	PMI Machine OLYMPUS make	3730
60	Mobile Lighting Mast - 9 metres (4X400 W)	960
61	10KVA RESISTANCE BRAZING MACHINE	160
62	RECURRENT SURGE OSCILLOGRAPH (RSO) TEST KIT WITH PORTABLE HANDHELD OSCILLOSCOPE.	510
63	HYDROGEN GAS LEAK DETECTOR	60
64	STATOR WEDGE ANALYZER KIT WITH COMPLETE ACCESSORIES	5530
65	WEDGE DEFLECTION KIT	90
66	TILE PRESSING MACHINE FOR GAS TURBINE	300
67	INDUCTION BRAZING MACHINE	5410
68	MAGNETIC COHESIVE FORCE (MCF) EQUIPMENT	4040
69	ULTRASONIC FLOW METER	200
70	PORTABLE VIBRATION ANALYSER (MODEL 811T)	50
71	CENTRIFUGAL PUMP SET FOR ACID CLEANING (WITH MOTOR AND PANEL) : PRESSURE -14KG/SQ CM. ; FLOW 60 M3/HR	520
72	CENTRIFUGAL PUMP SET FOR ACID CLEANING (WITH MOTOR AND PANEL) : PRESSURE -30KG/SQ CM. ; FLOW 15 M3/HR	480
73	HI SPEED MEMORY RECORDER, MAKE -YOKOGAWA, MODEL DL850E-Q-HE/B5/HD1	2010
74	TROLLEY MOUNTED HYDRAULIC JACK (100 MT)	1400
75	5KV Insulation Tester	500

ANNEXURE-T II
DT: 31/08/2021

RATES OF T & P HIRE CHARGES FOR ITEMS OTHER THAN CRANES & TRAILLERS ETC. FOR OUTSIDE AGENCIES

SL NO.	ITEM DESCRIPTION	Revised rates (Rs./Day) valid from 01/09/2021 to 31/8/2023
76	4 Channel Digital Oscilloscope /Fast Recorder	1900
77	4 Channel Oscillographic Recorder	650
78	Sound Level Meter	260
79	Thermal Imaging Camera	860
80	Videoscope (Video Boroscope)	1680
81	DO (Dissolve Oxygen) Meter (0 to 1500 ppb)	1460
82	Conductivity Meter	90
83	Core Flux Test Kit	8090
84	Primary Current Injection Kit (2000A)	960
85	3 Phase Secondary Injection Kit (Relay Test)	4180
86	FRF Filtration Kit	1480
87	FFT Analyser	2550
88	Flue Gas Analyser	1140
89	Oil Test Kit (Mineral Oil)-Transformer	1120
90	Winding Resistance kit (R L C Load)	970
91	SFRA test Kit	1320
92	Tan Delta test Kit	4510
93	PF Meter	360
94	Ultrasonic Flow Meter	920
95	Oil Particle Counter	400
96	Plasma Cutting Machine (With complete accessories)	340
97	JCB make DG Set 80 KVA	740
98	Diesel Generating Set 82.5 KVA	680
99	Portable Jacking Oil Pump	1200
100	Alloy Analyser	1970

COMPLIANCE REPORT

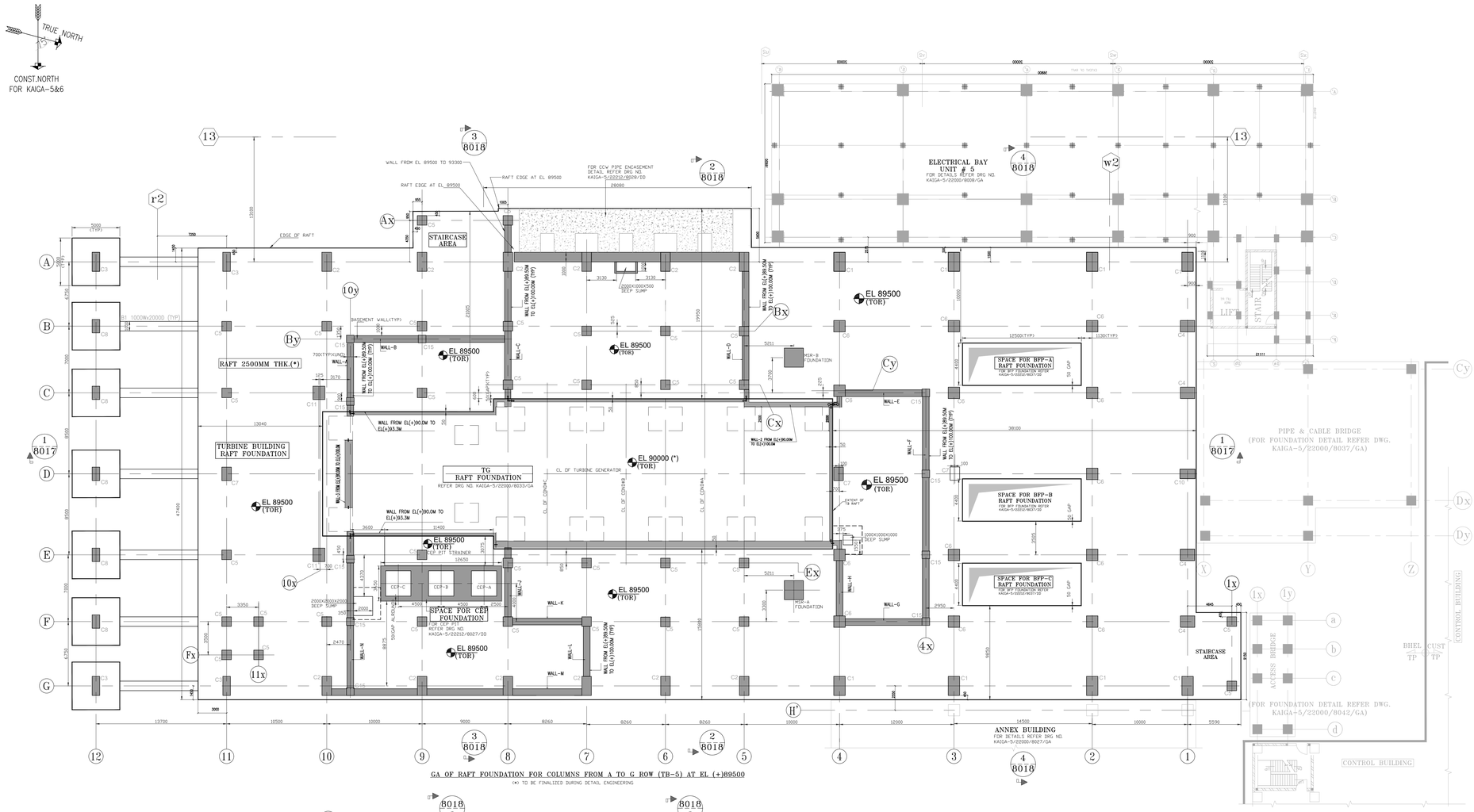
NUCLEAR POWER CORPORATION OF INDIA LTD

KAIGA ATOMIC POWER PROJECT - UNITS 5&6

(2 X 700 MWe)

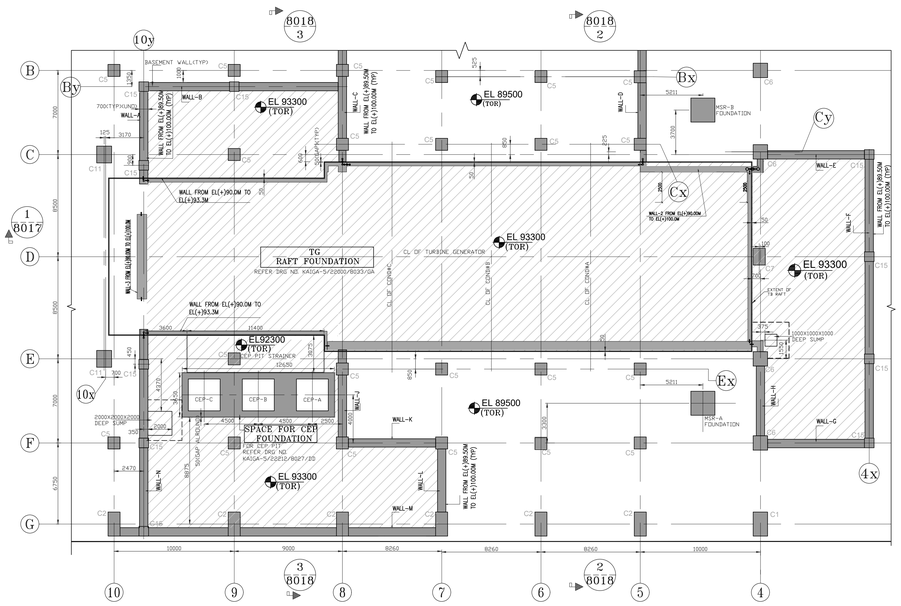
DRAWING/DOC TITLE	TURBINE BUILDING - GA OF RAFT FOUNDATION (UNIT 5)
CUSTOMER DRG/DOC No.	Kaiga-5/22000/8016/GA
BHEL DRG/DOC No.	PE-DG-488-611-C1002
COMMENTS ON REV. No.	RA

Sl. No.	DCPL Comments dated 15.12.2023	BHEL Reply	Remarks
1	DO NOT SPECIFY TOP OF RAFT LEVELS. THESE ARE TO BE ARRIVED AT DURING DETAILED ENGINEERING (TYP.)	Noted & Incorporated.	
2	PLEASE CHECK WITH KAIGA_5_22000_8035_GA	50mm gap revised in KAIGA_5_22000_8035_GA.	
3	Mention (+)	Noted & Incorporated.	
4	TO BE FINALIZED DURING DETAIL ENGINEERING	Noted & Incorporated.	
5	LOCATION TO BE SPECIFIED	Noted & Incorporated.	
6	LEVEL TO BE FINALIZED DURING DETAILED ENGG.	Noted & Incorporated.	
7	DIM. TO BE SHOWN PROPERLY	Noted & Incorporated.	
8	CHECK AND CORRECT ACCORDINGLY	Noted & Incorporated.	
9	INCLUDE GRADE OF PCC	Noted & Incorporated.	
10	AS PER IS : 456	Noted & Incorporated.	

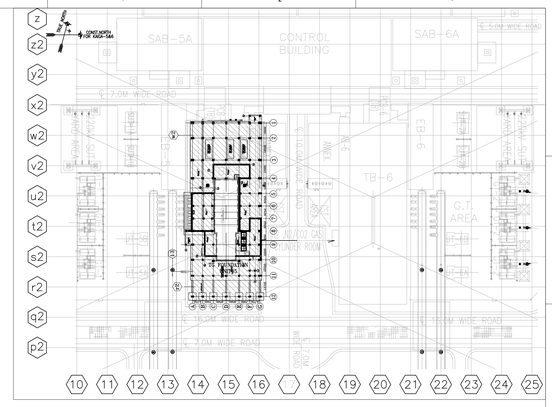


GA OF RAFT FOUNDATION FOR COLUMNS FROM A TO G ROW (TB-5) AT EL (+)89500

(*) TO BE FINALIZED DURING DETAIL ENGINEERING



PLAN AT EL (+)93300



KEY PLAN

LEGENDS:

DWG	- DRAWING	MSR	- MOISTURE SEPARATOR AND REHEATER
EL	- ELEVATION	PG	- PLANT GRID
FFL	- FINISHED FLOOR LEVEL	UN	- UNLESS NOTED
GA	- GENERAL ARRANGEMENT	TOR	- TOP OF RAFT
H	- HIGH	COL	- COLUMN
TB	- TURBINE BUILDING	TP	- TERMINAL POINT
THK.	- THICKNESS	TIP	- TURBINE ISLAND PACKAGE
TOC	- TOP OF CONCRETE	TOT	- TOP OF TUNNEL
TYP.	- TYPICAL	BOT	- BOTTOM OF TUNNEL
◯	- BUILDING GRID	W	- WIDE
⬡	- PLANT GRID	BXXXX	- BEAM NUMBER
	- BASEMENT AREA	CXX	- COLUMN NUMBER
		℄	- CENTER LINE

- CHEQUERED PLATE PLATEFORM
- REMOVABLE CHEQUERED PLATE
- GRATED FLOORING
- REMOVABLE GRATED FLOORING
- LAY DOWN AREA
- REMOVABLE CONCRETE COVER

NOTES:

1. ALL DIMENSIONS AND ELEVATION ARE IN MILLIMETERS AND CO-ORDINATE ARE IN METERS UNLESS NOTED OTHERWISE.
2. ALL ELEVATIONS INDICATED IN THE DRG. ARE W.R.T. TURBINE BUILDING FINISHED GROUND FLOOR LEVEL AS EL. 100 WHICH CORRESPONDS TO RL. +82.80M.
3. ALL ELEVATION ARE FINISHED FLOOR LEVEL UN.
4. ALL STRUCTURAL CONCRETE SHALL BE DESIGN MIX CONC. OF GRADE M35 AS PER IS : 456 UNLESS OTHERWISE NOTED.
5. ALL REINFORCEMENTS SHALL BE TMT BARS GRADE FE 500 CONFORMING TO IS:1786. FOR DETAILS REFER KAIGA-5&6/22210/8001/DD.
6. WATERPROOFING TREATMENT SHALL BE PROVIDED AS PER TECHNICAL SPECIFICATION.
7. PCC SHALL BE GRADE M15 UNLESS OTHERWISE NOTED.

IMP. NOTES:

1. THIS DRAWING IS TENTATIVE AND SIZES/OPENING ARE INDICATIVE ONLY. SHALL BE FINALIZED DURING DESIGN.
2. SECONDARY AND TERTIARY BEAMS ARE NOT SHOWN IN THIS DRAWING.
3. THE DRAWING HAS BEEN INTERFACED AND CLEARED BY MECHANICAL PIPING LAYOUT(MPL), MECHANICAL AUX. SYSTEM (MAX), ELECTRICAL AND C&I DEPARTMENT WITH RESPECT TO THEIR SYSTEM REQUIREMENT THROUGH DOCUMENT MANAGEMENT SYSTEM SOFTWARE WRENCH.

TABLE -A

ENGINEERING REFERENCE DRAWINGS (TITLE)	DRAWING NOs.
GENERAL NOTES & STANDARD DETAILS FOR STRUCTURAL STEEL WORKS (UNIT#3 & 6)	KAIGA-5&6/22400/8001/DD
GENERAL NOTES & STANDARD DETAILS FOR CIVIL WORKS (UNIT#3 & 6)	KAIGA-5&6/22210/8001/DD
TURBINE BUILDING - GA OF LONGITUDINAL SECTIONS OF RAFT FOUNDATION (UNIT#3)	KAIGA-5/22000/8017/GA
TURBINE BUILDING - GA OF TRANSVERSE SECTIONS OF RAFT FOUNDATION (UNIT#3)	KAIGA-5/22000/8018/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 1 TO 6 (UNIT#3)	KAIGA-5/22000/8019/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 6 TO 12 (UNIT#3)	KAIGA-5/22000/8020/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 1 TO 6 (UNIT#3)	KAIGA-5/22000/8021/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 6 TO 12 (UNIT#3)	KAIGA-5/22000/8022/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 1 TO 6 (UNIT#3)	KAIGA-5/22000/8023/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 6 TO 12 (UNIT#3)	KAIGA-5/22000/8024/GA
TURBINE BUILDING -GA OF FLOOR AT EL 127.0M GRID 1 TO 12 (UNIT#3)	KAIGA-5/22000/8025/GA
TURBINE BUILDING -GA OF ROOF (UNIT#3)	KAIGA-5/22000/8026/GA
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 1 (UNIT#3)	KAIGA-5/22222/8033/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#3)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#3)	KAIGA-5/22222/8035/DD
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN BELOW 100.0M FOR TB-5	KAIGA-5/22000/8001/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN AT 100.0M FOR TB-5	KAIGA-5/22000/8002/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 111.0M FOR TB-5	KAIGA-5/22000/8003/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 118.0M FOR TB-5	KAIGA-5/22000/8004/GA
GENERAL ARRANGEMENT DRAWING -TURBINE BUILDING PLAN VIEW AT 127.0M FOR TB-5	KAIGA-5/22000/8005/GA
CROSS SECTION OF TB-5	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&6/10000/2001/GA

SCHEDULE OF TB-5 COL.

COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	
C2	1000	2000	
C3	800	2000	
C4	1500	1200	
C5	1000	1000	
C6	1200	1200	
C7	1000	1400	
C8	800	1400	
C9	400	400	NOT USED
C10	1600	1000	
C11	1250	1400	
MSR-A&B	2000	2000	
C15	800	800	

NOTE:-

1. THIS DRAWING IS TENTATIVE AND SIZES ARE INDICATIVE ONLY, SHALL BE FINALIZED DURING DESIGN.

PROOF CONSULTANT STAMP

DEVELOPMENT CONSULTANTS PVT. LIMITED

Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.

ACTION	1
✓	APPROVED
2	COMMENTED
3	FOR INFORMATION

REVIEWED BY : ANIRBAN SARKAR
SIGNATURE:
DATE : 18.12.2023

REV. No.	DESCRIPTION	DATE	BY
R0	FOR NPCIL APPROVAL	15.12.2023	BHEL
	DRAWING ISSUED FOR		NPCIL
			SIGNATURE WITH DATE

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DES'D.	CHK'D.	REV'D.	APPD.

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TO SUND. PKG/XE

TITLE :-
TURBINE BUILDING
GA OF RAFT FOUNDATION AT EL 89500 AND EL 93300 (TOC) (UNIT#5)

DES'D. DATE	A.KAPOOR 28.11.2023	DRN. DATE	S.MAN 01.12.2023	REV'D. DATE	S.MISHRA 01.12.2023
DES. CHK'D. DATE	V.SHARMA 01.12.2023	DRG. CHK'D. DATE	A.KAPOOR 01.12.2023	APPD. DATE	A.KUMAR 01.12.2023

PROJECT: 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE:- NTS
PROJECTION

NPCIL DRG. No. KAIGA-5/22000/8016/GA
SHEET 1 OF 2
REV. No. R0

BHEL DRG NO: PE-DG-488-611-C1002_(RA) FILE NAME: KAIGA-5-22000-8016-GA

DRG. TO BE READ IN CONJUNCTION WITH DON'FCN/ECN, IF ANY.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE 12.5 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO 0.15 / 0.40 X 45°
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.15 / 0.40.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	240 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

TOLERANCES ON ANGULAR DIMENSIONS ± 0°30'

REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

DRG. No. KAIGA-5/22000/8016/GA (SH 1 OF 2)

AO

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COMPLIANCE REPORT

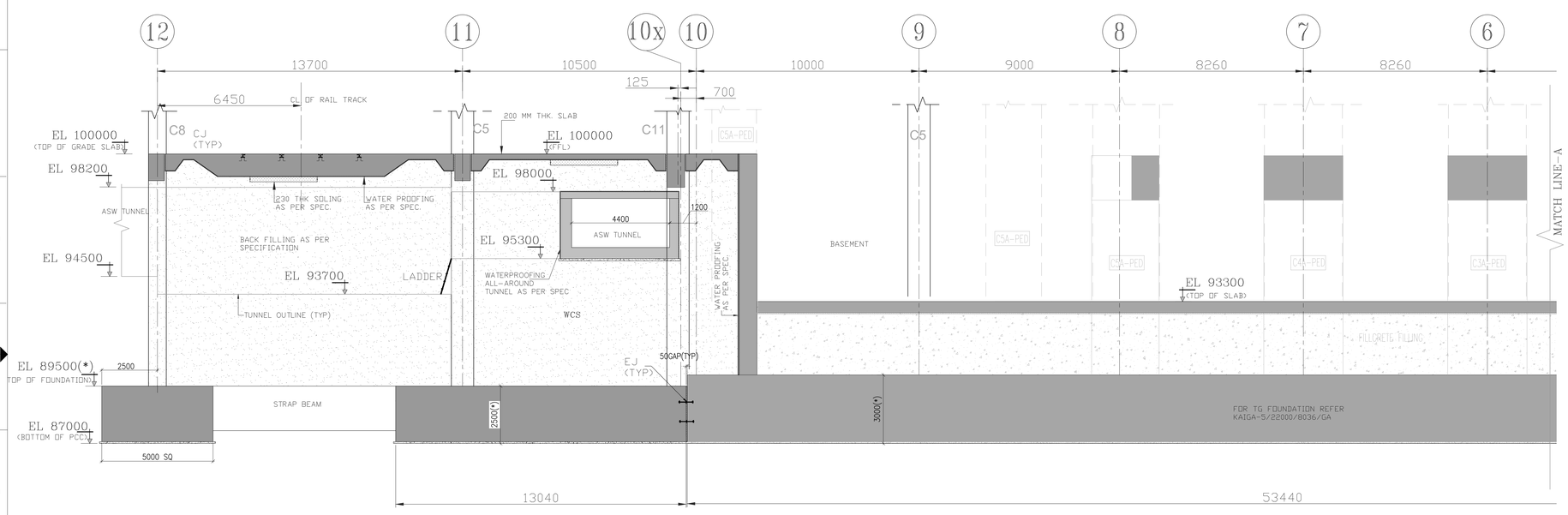
NUCLEAR POWER CORPORATION OF INDIA LTD

KAIGA ATOMIC POWER PROJECT - UNITS 5&6

(2 X 700 MWe)

DRAWING/DOC TITLE	TURBINE BUILDING - GA OF RAFT FOUNDATION (UNIT 5)
CUSTOMER DRG/DOC No.	Kaiga-5/22000/8017/GA
BHEL DRG/DOC No.	PE-DG-488-611-C1003
COMMENTS ON REV. No.	RA

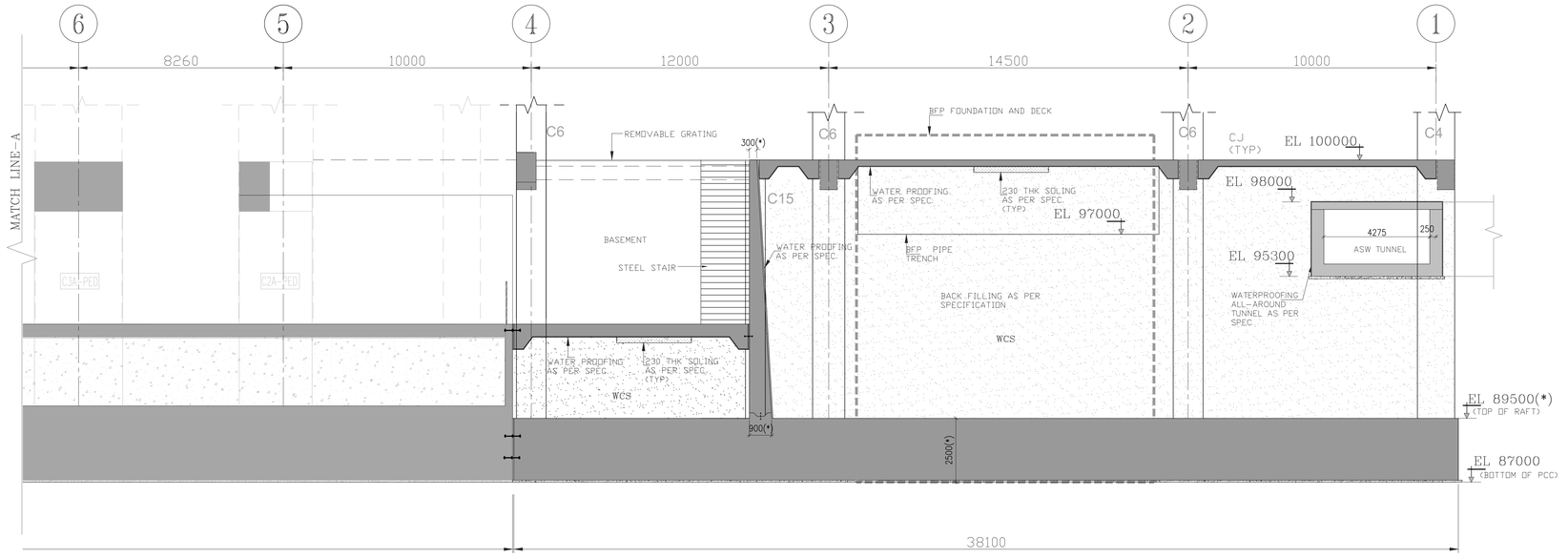
Sl. No.	DCPL Comments dated 15.12.2023	BHEL Reply	Remarks
1	PLEASE CHECK WITH KAIGA_5_22000_8035_GA	50mm gap revised in KAIGA_5_22000_8035_GA.	
2	ALL COLUMNS I.E. C7A, C6A, C5A, C4A, C3A, C2A, C1A SHALL BE SHOWN	Noted & Incorporated.	
3	PLEASE CHECK WITH KAIGA_5_22000_8036_GA.REVISE ACCORDINGLY	Noted & Incorporated.	
4	SHALL BE FINALIZED DURING DETAIL ENGINEERING	Noted & Incorporated.	
5	CHECK THE APPLICABILITY OF USAGE OF FILLCRETE FILLING W.R.T. TECHNICAL SECIFICATION	Noted & checked.	
6	FURNISH PROPER PLAN VIEWS	Refer Plan views already submitted in KAIGA_5_22000_8016/8019/8020 for clarity.	
7	TOP OF FOUNDATION	Noted & Incorporated.	
8	PROVIDE PLAN VIEWS AT VARIOUS LEVELS FOR CLARITY	Refer Plan views already submitted in KAIGA_5_22000_8016/8019/8020 for clarity.	



SECTION 1-1

(REFER GA DRG NO. 8016)

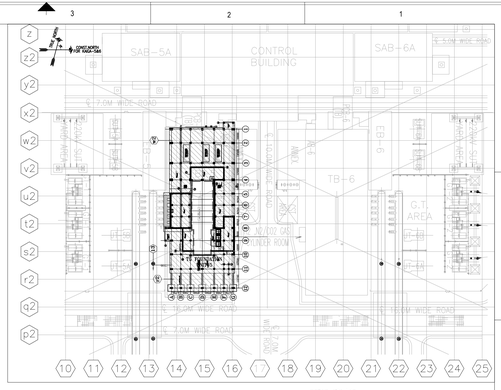
(*) DIMENSIONS/LEVELS SHALL BE FINALIZED DURING DETAIL ENGINEERING



SECTION 1-1

(REFER GA DRG NO. 8016)

(*) DIMENSIONS/LEVELS SHALL BE FINALIZED DURING DETAIL ENGINEERING



KEY PLAN

LEGENDS:

DWG - DRAWING
EL - ELEVATION
FFL - FINISHED FLOOR LEVEL
GA - GENERAL ARRANGEMENT
H - HIGH
TB - TURBINE BUILDING
THK. - THIKNESS
TOC - TOP OF CONCRETE
TYP. - TYPICAL
○ - BUILDING GRID
⬡ - PLANT GRID

PG - PLANT GRID
UN - UNLESS NOTED
TOR - TOP OF RAFT
COL. - COLUMN
TP - TERMINAL POINT
TIP - TURBINE ISLAND PACKAGE
TOT - TOP OF TUNNEL
BOT - BOTTOM OF TUNNEL
W - WIDE
BXXXX - BEAM NUMBER
CXX - COLUMN NUMBER
℄ - CENTER LINE
EJ - EXPANSION JOINT
CJ - CONSTRUCTION JOINT

- CHEQUERED PLATE PLATEFORM
- REMOVABLE CHEQUERED PLATE
- GRATED FLOORING
- REMOVABLE GRATED FLOORING
- LAY DOWN AREA
- REMOVABLE CONCRETE COVER
- FILCREATE
- WCS (WELL COMPACTED SOIL)

NOTES:

FOR NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

IMP. NOTES:

FOR IMP. NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

TABLE -A

ENGINEERING REFERENCE DRAWINGS (TITLE)	DRAWING NOs.
GENERAL NOTES & STANDARD DETAILS FOR STRUCTURAL STEEL WORKS (UNIT#5 & 6)	KAIGA-5&6/22400/8001/DD
GENERAL NOTES & STANDARD DETAILS FOR CIVIL WORKS (UNIT#5 & 6)	KAIGA-5&6/22210/8001/DD
TURBINE BUILDING - GA OF TRANSVERSE SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8018/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8019/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8020/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8021/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8022/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8023/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8024/GA
TURBINE BUILDING -GA OF FLOOR AT EL 127.0M GRID 1 TO 12 (UNIT#5)	KAIGA-5/22000/8025/GA
TURBINE BUILDING -GA OF ROOF (UNIT#5)	KAIGA-5/22000/8026/GA
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 1 (UNIT#5)	KAIGA-5/22222/8033/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#5)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#5)	GHAVP-2/22222/8035/DD
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN BELOW 100.0M FOR TB-5	KAIGA-5/22000/8001/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN AT 100.0M FOR TB-5	KAIGA-5/22000/8002/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 111.0M FOR TB-5	KAIGA-5/22000/8003/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 118.0M FOR TB-5	KAIGA-5/22000/8004/GA
GENERAL ARRANGEMENT DRAWING -TURBINE BUILDING PLAN VIEW AT 127.0M FOR TB-5	KAIGA-5/22000/8005/GA
CROSS SECTION OF TB-5	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&6/10000/2001/GA

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DEVELOPMENT CONSULTANTS PVT. LIMITED

Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.

ACTION	1
✓	APPROVED
2	COMMENTED
3	FOR INFORMATION

REVIEWED BY : ANIRBAN SARKAR
SIGNATURE:
DATE : 18.12.2023

PROPOSED/CONSTRUCTION STAMP

REV. No.	DESCRIPTION	BHEL	NPCIL
R0	FOR NPCIL APPROVAL	15.12.2023	SIGNATURE WITH DATE

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DESD.	CHKD.	REVD.	APPD.

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG (LAND) PACKAGE
TURBINE BUILDING
GA OF RAFT FOUNDATION AT EL 89500 AND EL 93300 (TOC) (UNIT#5)

DESD. DATE	A.KAPOOR 28.11.2023	DRN. DATE	S.MAN 01.12.2023	REVD. DATE	S.MISHRA 01.12.2023
DES. CHK'D. DATE	V.SHARMA 01.12.2023	DRG. CHK'D. DATE	A.KAPOOR 01.12.2023	APP'D. DATE	A.KUMAR 01.12.2023

PROJECT: 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS
PROJECTION

NPCIL DRG. No. KAIGA-5/22000/8017/GA
SHEET 1 OF 1
REV. No. R0
BHEL DRG NO: PE-DC-488-611-C1003_(RA) FILE NAME: KAIGA-5-22000-8017-GA

DRG. TO BE READ IN CONJUNCTION WITH DON'FCN/ECN, IF ANY.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER 12 / SURFACE FINISH TO BE 3.2 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO 0.15 / 0.40 X 45°
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.15 / 0.40
TOLERANCES ON RADII AND CHAMFERS (IS :2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	120 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

TOLERANCES ON ANGULAR DIMENSIONS : 0°30'

REV. No.	REF. LOCATION	DESCRIPTION	DRN.	DES'D.	DES.CHK'D.	REVD.	APP'D.	DES'D.	CHK'D.	REVD.	APP'D.
REVISIONS			SIGNATURE WITH DATE (CONSULTANT)					SIGNATURE (NPCIL)			

REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

DRG. No. KAIGA-5/22000/8016/GA (SH 1 OF 2)

A0

COMPLIANCE REPORT

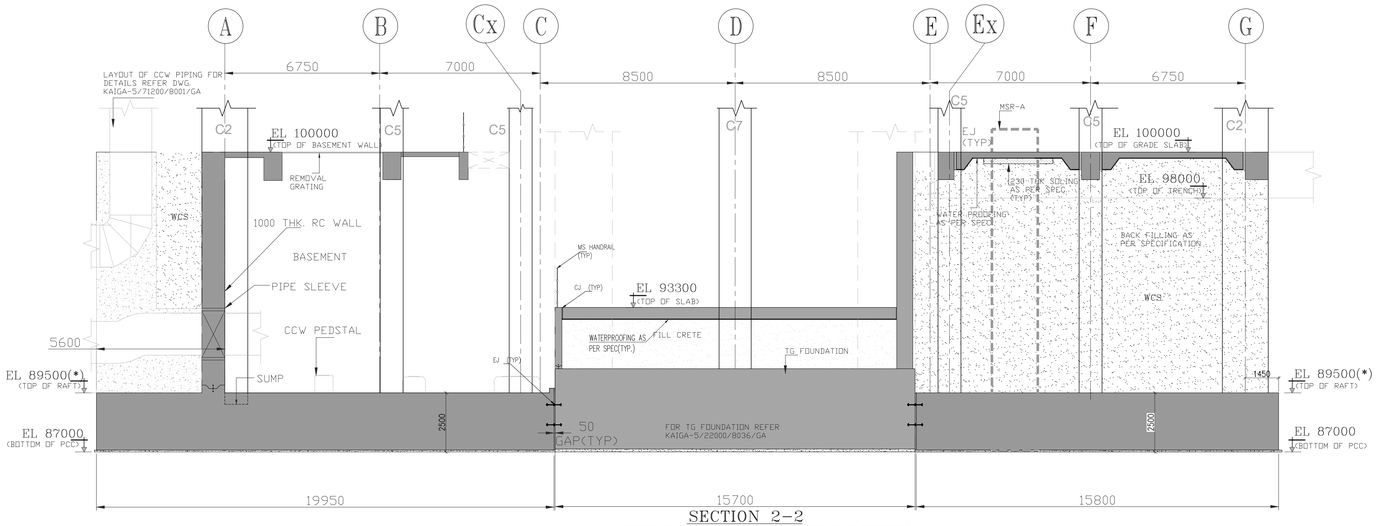
NUCLEAR POWER CORPORATION OF INDIA LTD

KAIGA ATOMIC POWER PROJECT - UNITS 5&6

(2 X 700 MWe)

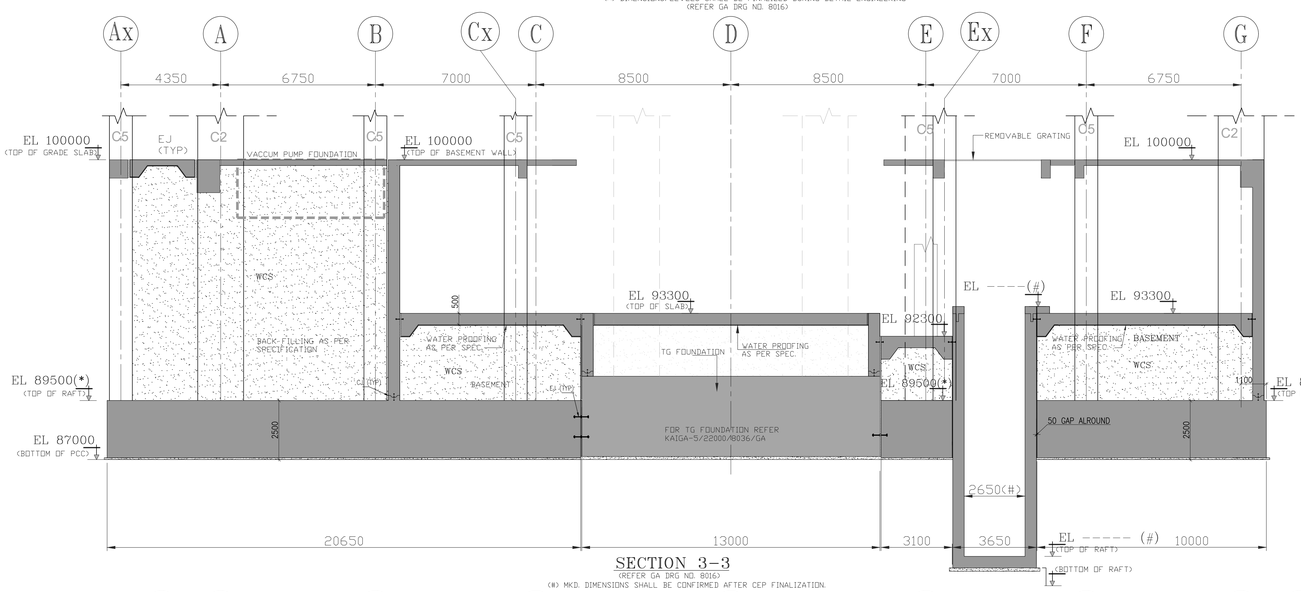
DRAWING/DOC TITLE	TURBINE BUILDING - GA OF RAFT FOUNDATION (UNIT 5)
CUSTOMER DRG/DOC No.	Kaiga-5/22000/8018/GA
BHEL DRG/DOC No.	PE-DG-488-611-C1004
COMMENTS ON REV. No.	RA

Sl. No.	DCPL Comments dated 15.12.2023	BHEL Reply	Remarks
1	COLUMN AND PEDESTALS OF TG FOUNDATION TO BE SHOWN	Noted & Incorporated.	
2	PLEASE CHECK WITH KAIGA_5_22000_8035_GA	50mm gap revised in KAIGA_5_22000_8035_GA.	
3	CHECK THE APPLICABILITY OF USAGE OF FILLCRETE FILLING W.R.T. TECHNICAL SECIFICATION	Noted & checked.	
4	SHALL BE FINALIZED DURING DETAIL ENGINEERING	Noted & Incorporated.	
5	RELEASE OF ALL HOLDS TO BE CHECKED	Marked dimensions shall be confirmed after CEP finalisation.	
6	PROVIDE FRAMING PLAN AT 97.0 M LEVEL FOR CLARITY (TYP.)	Plan already furnished in approved drawing KAIGA_5_22000_8019/8020 where beams are below trenches/tunnels.	



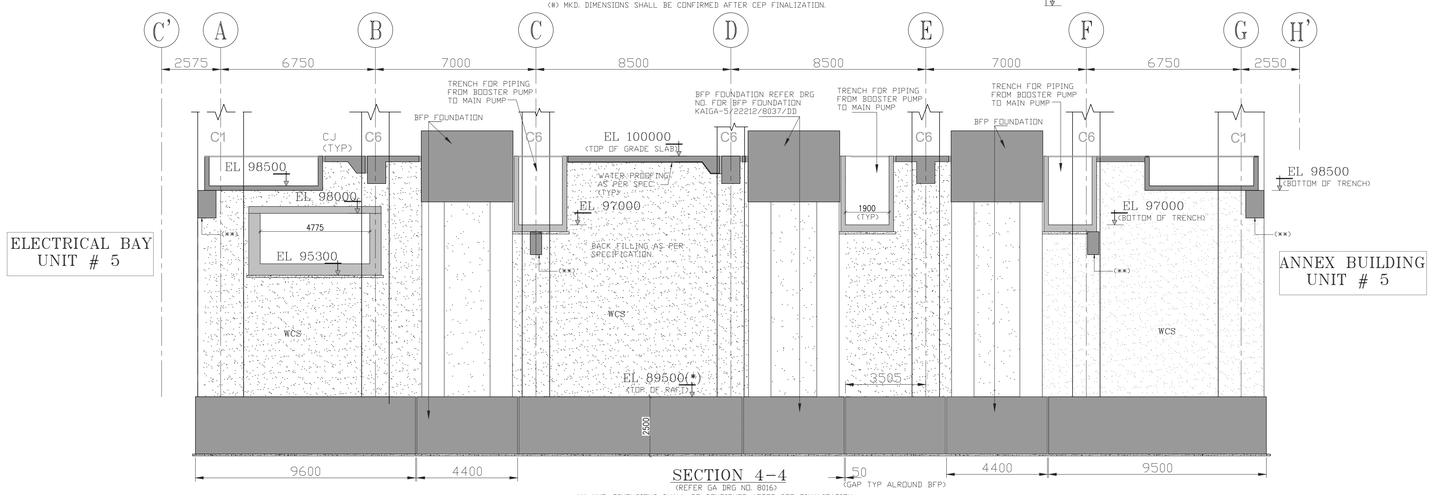
SECTION 2-2

(*) DIMENSIONS/LEVELS SHALL BE FINALIZED DURING DETAIL ENGINEERING (REFER GA DRG NO. 8016)



SECTION 3-3

(REFER GA DRG NO. 8016)
(#) MKD. DIMENSIONS SHALL BE CONFIRMED AFTER CEP FINALIZATION.

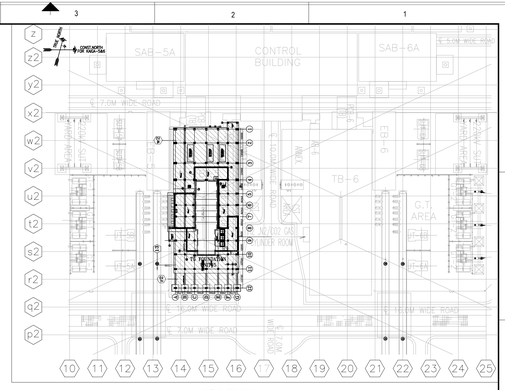


SECTION 4-4

(REFER GA DRG NO. 8016)
(#) MKD. DIMENSIONS SHALL BE CONFIRMED AFTER CEP FINALIZATION.
(**) REFER KAIGA-5-22000-8019-20-GA_RA

ELECTRICAL BAY UNIT # 5

ANNEX BUILDING UNIT # 5



KEY PLAN

LEGENDS:

DWG - DRAWING
EL - ELEVATION
FFL - FINISHED FLOOR LEVEL
GA - GENERAL ARRANGEMENT
H - HIGH
TB - TURBINE BUILDING
THK. - THIKNESS
TOC - TOP OF CONCRETE
TYP. - TYPICAL
◯ - BUILDING GRID
⬡ - PLANT GRID
▨ - BASEMENT AREA

MSR - MOISTURE SEPARATOR AND REHEATER
PG - PLANT GRID
UN - UNLESS NOTED
TOR - TOP OF RAFT
COL. - COLUMN
TP - TERMINAL POINT
TIP - TURBINE ISLAND PACKAGE
TOT - TOP OF TUNNEL
BOT - BOTTOM OF TUNNEL
W - WIDE
BXXXX - BEAM NUMBER
CXX - COLUMN NUMBER
℄ - CENTER LINE
EJ - EXPANSION JOINT
CJ - CONSTRUCTION JOINT

▨ - CHEQUERED PLATE PLATEFORM
R - REMOVABLE CHEQUERED PLATE
▦ - GRATED FLOORING
IR - REMOVABLE GRATED FLOORING
⨯ - LAY DOWN AREA
1 1 - REMOVABLE CONCRETE COVER
⋰ - FILCREATE
⋰ - WCS (WELL COMPACTED SOIL)

NOTES:

FOR NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

IMP. NOTES:

FOR IMP. NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

TABLE -A

ENGINEERING REFERENCE DRAWINGS (TITLE)	DRAWING NOs.
GENERAL NOTES & STANDARD DETAILS FOR STRUCTURAL STEEL WORKS (UNIT#5 & 6)	KAIGA-5&6/22400/8001/DD
GENERAL NOTES & STANDARD DETAILS FOR CIVIL WORKS (UNIT#5 & 6)	KAIGA-5&6/22210/8001/DD
TURBINE BUILDING - GA OF TRANSVERSE SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8017/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8019/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8020/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8021/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8022/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8023/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8024/GA
TURBINE BUILDING -GA OF FLOOR AT EL 127.0M GRID 1 TO 12 (UNIT#5)	KAIGA-5/22000/8025/GA
TURBINE BUILDING -GA OF ROOF (UNIT#5)	KAIGA-5/22000/8026/GA
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 1 (UNIT#5)	KAIGA-5/22222/8033/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#5)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#5)	KAIGA-6/22222/8035/DD
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN BELOW 100.0M FOR TB-5	KAIGA-5/22000/8001/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN AT 100.0M FOR TB-5	KAIGA-5/22000/8002/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 111.0M FOR TB-5	KAIGA-5/22000/8003/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 118.0M FOR TB-5	KAIGA-5/22000/8004/GA
GENERAL ARRANGEMENT DRAWING -TURBINE BUILDING PLAN VIEW AT 127.0M FOR TB-5	KAIGA-5/22000/8005/GA
CROSS SECTION OF TB-5	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&2/10000/2001/GA

DEVELOPMENT CONSULTANTS PVT. LIMITED

Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.

ACTION	
✓	APPROVED
2	COMMENTED
3	FOR INFORMATION

REVIEWED BY : ANIRBAN SARKAR
SIGNATURE:
DATE : 18.12.2023

DESIGN STAMP / CONSULTANT STAMP

REV. No.	DESCRIPTION	
R0	FOR NPCIL APPROVAL	15.12.2023
REV. No.	DESCRIPTION	BHEL / NPCIL SIGNATURE WITH DATE

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DESD.		CHKD.		REVD.		APPD.	

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG &UND PACKAGE
TURBINE BUILDING
GA OF RAFT FOUNDATION AT EL 88500 AND EL 93300 (TOC) (UNIT#5)

DESD.	A.KAPOOR	DRN.	S.MAN	REVD.	S.MISHRA
DATE	28.11.2023	DATE	01.12.2023	DATE	01.12.2023
DES. CHKD.	V.SHARMA	DRG. CHKD.	A.KAPOOR	APPD.	A.KUMAR
DATE	01.12.2023	DATE	01.12.2023	DATE	01.12.2023

PROJECT: 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS
PROJECTION

NPCIL DRG. No. KAIGA-5/22000/8018/GA (SH 1 OF 2) | SHEET 1 OF 1 | REV. No. R0
BHEL DRG. NO: PE-DG-488-611-C1004 (RA) | FILE NAME: KAIGA-5-22000-8018-GA

DRG. No. KAIGA-5/22000/8016/GA (SH 1 OF 2)

TABLE-1

REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

REV. No.	REV. LOCATION	DESCRIPTION	DRN.	DESD.	DES.CHKD.	REVD.	APPD.	DESD.	CHKD.	REVD.	APPD.
		REVISIONS		SIGNATURE WITH DATE (CONSULTANT)				SIGNATURE (NPCIL)			

UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN MM.
MACHINE ALL OVER.
SURFACE FINISH TO BE 3.2/ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO 0.15 x 45° / 0.40
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.15 / 0.40.
TOLERANCES ON RADII AND CHAMFERS (IS-2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS-2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	315 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

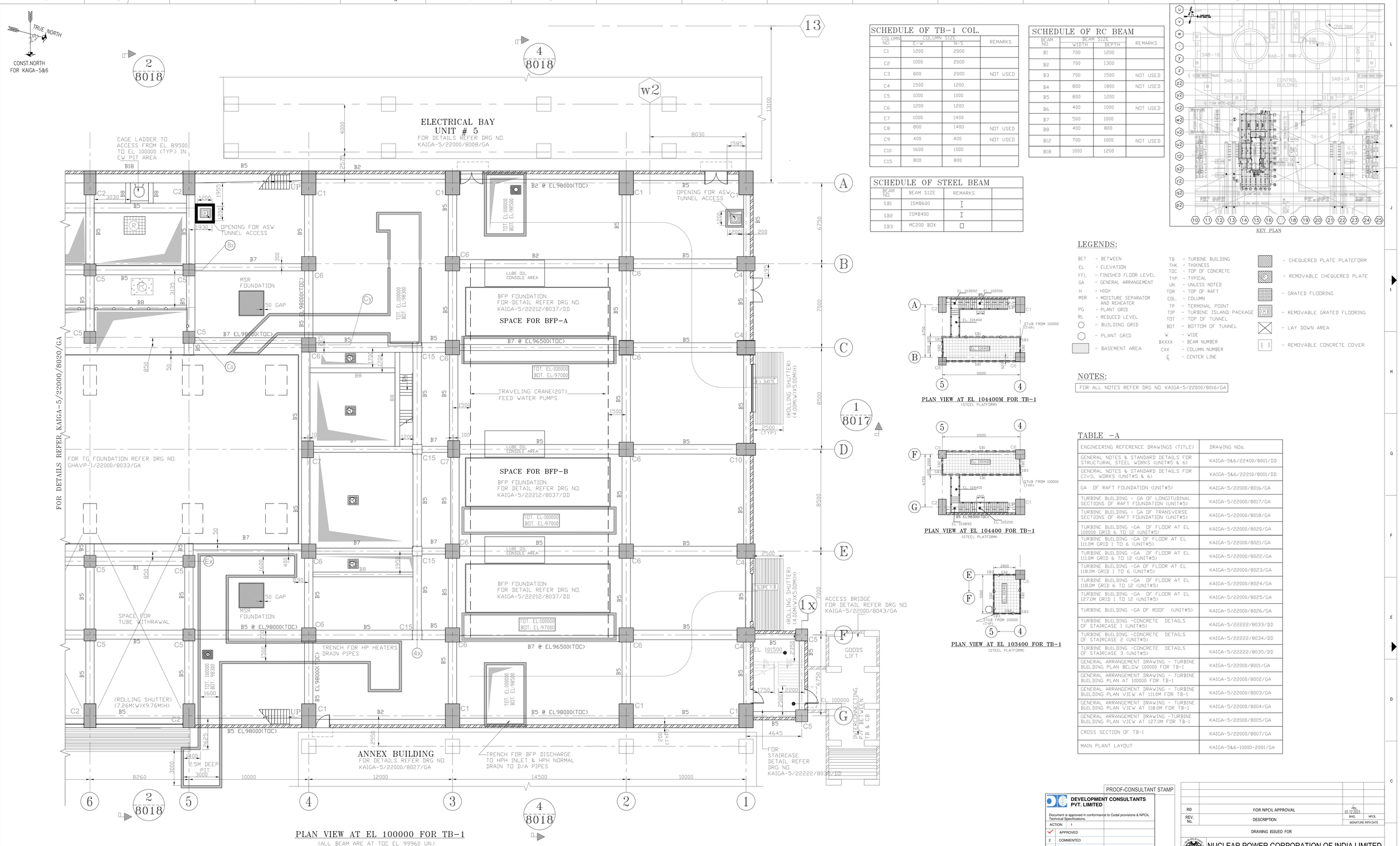
SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

TOLERANCES ON ANGULAR DIMENSIONS ± 0°30'

DRG. TO BE READ IN CONJUNCTION WITH DOM/FOM/SOW, IF ANY.

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A0



PLAN VIEW AT EL 100000 FOR TB-1

(ALL BEAM ARE AT TOC EL 99960 UN.)

200 THK. SLAB

SCHEDULE OF TB-1 COL.

COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	
C2	1000	2000	
C3	800	2000	NOT USED
C4	1500	1200	
C5	1000	1000	
C6	1200	1200	
C7	1000	1400	
C8	800	1400	NOT USED
C9	400	400	NOT USED
C10	1600	1000	
C15	800	800	

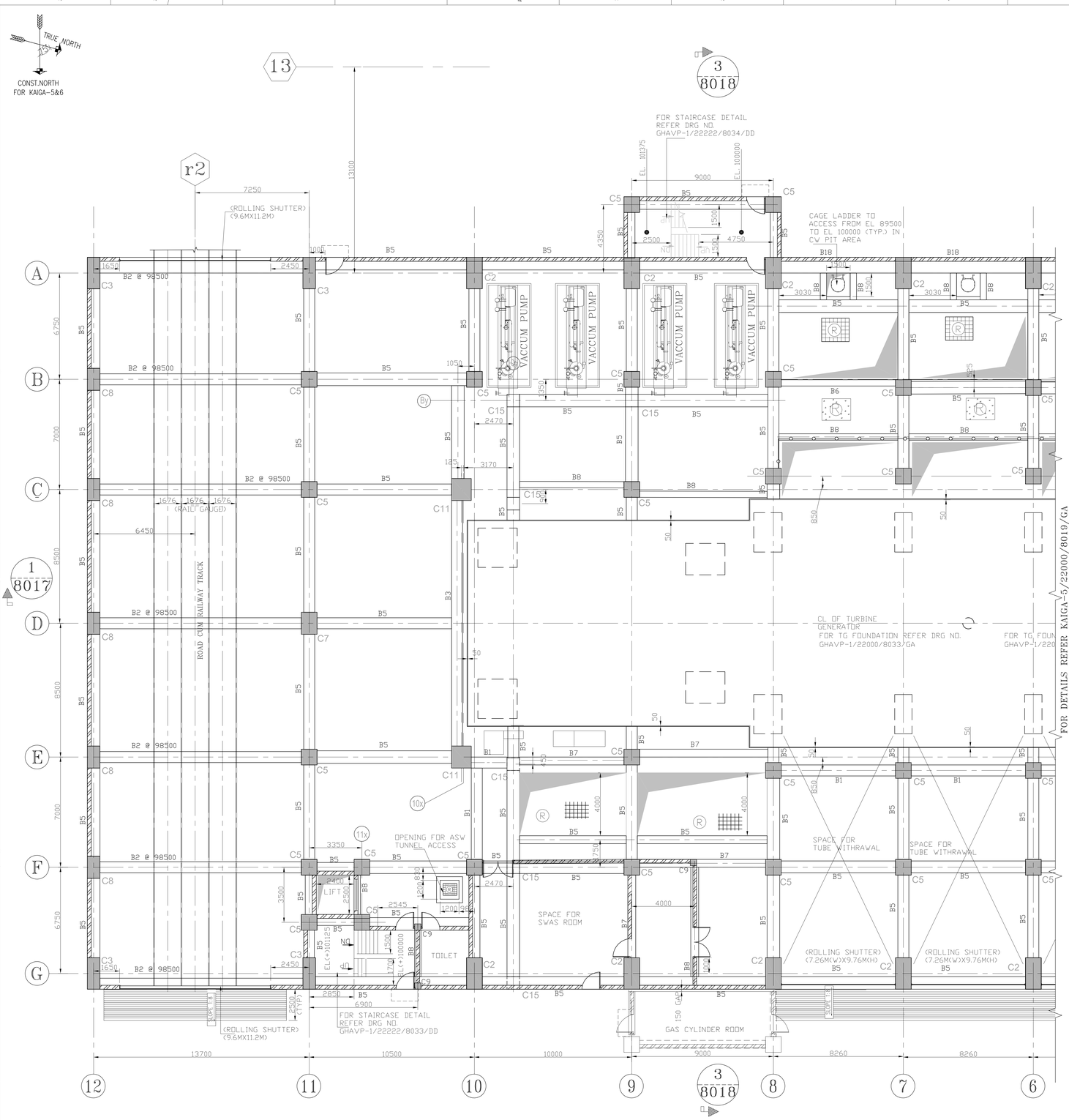
SCHEDULE OF RC BEAM

BEAM NO.	BEAM SIZE WIDTH	BEAM SIZE DEPTH	REMARKS
B1	700	1200	
B2	700	1300	
B3	700	1500	NOT USED
B4	800	1800	NOT USED
B5	800	1200	
B6	400	1000	NOT USED
B7	500	1000	
B8	400	800	
B12	700	1000	NOT USED
B18	1000	1200	

SCHEDULE OF STEEL BEAM

BEAM NO.	BEAM SIZE	REMARKS	
SB1	ISMB600	I	
SB2	ISMB400	I	
SB3	MC200 BOX	□	

CCWS TANK
SAB-1E
RAB-1
RAB-2
SAB-1A
CONTROL BUILDING
SAB-2A
TB-6
G.T. AREA
SAB-2B
SAB-2C
SAB-2D
SAB-2E
SAB-2F
SAB-2G
SAB-2H
SAB-2J
SAB-2K
SAB-2L
SAB-2M
SAB-2N
SAB-2P
SAB-2Q
SAB-2R
SAB-2S
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SAB-3SV
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SAB-4Z



PLAN VIEW AT EL 100000 FOR TB-1

(ALL BEAM ARE AT TOC EL 99960 UN.)

200 THK. SLAB

SCHEDULE OF TB-1 COL.

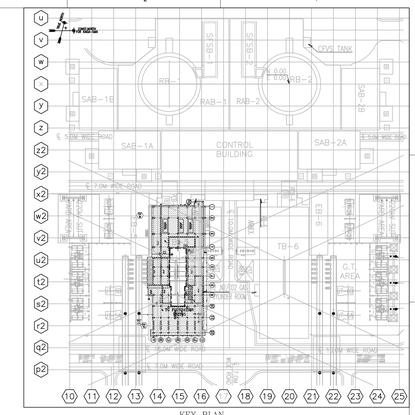
COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	
C2	1000	2000	
C3	800	2000	
C4	1500	1200	NOT USED
C5	1000	1000	
C6	1200	1200	NOT USED
C7	1000	1400	
C8	800	1400	
C9	400	400	
C11	1250	1400	
C15	800	800	

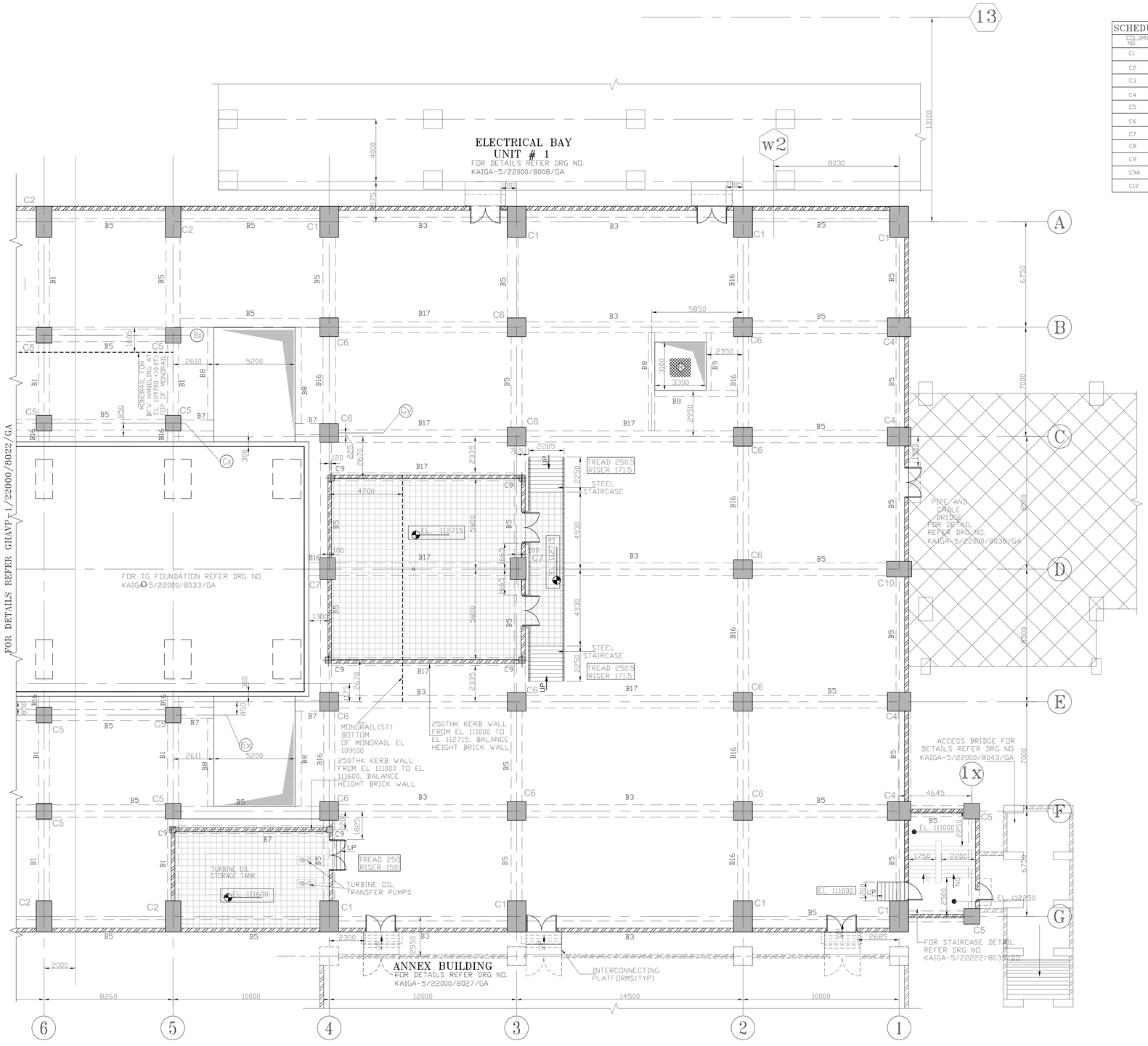
SCHEDULE OF BEAM

BEAM NO.	BEAM SIZE WIDTH	BEAM SIZE DEPTH	REMARKS
B1	700	1200	
B2	700	1300	
B3	700	1500	
B4	800	1800	NOT USED
B5	800	1200	
B6	400	1000	
B7	500	1000	
B8	400	800	
B9	300	600	
B18	1000	1200	

SCHEDULE OF STEEL BEAM

BEAM NO.	BEAM SIZE	REMARKS	
SB1	ISMB600	I	


CW& SW PUMP HOUSE
CW& SW PUMP HOUSE
CW& SW PUMP HOUSE



PLAN VIEW AT EL 111000 FOR TB-1

1. ALL BEAM ARE AT TOC EL 110960 UN.
200 THK. SLAB

SCHEDULE OF TB-1 COL.

COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	
C2	1000	2000	
C3	800	2000	NOT USED
C4	1500	1200	
C5	1000	1000	
C6	1200	1200	
C7	1000	1400	
C8	800	1400	NOT USED
C9	400	400	
C9A	2000	2000	NOT USED
C10	1600	1000	

SCHEDULE OF BEAM

BEAM NO.	BEAM SIZE WIDTH	BEAM SIZE DEPTH	REMARKS
B1	700	1200	
B2	700	1300	NOT USED
B3	700	1500	
B4	800	1800	NOT USED
B5	800	1200	
B6	400	1000	NOT USED
B7	500	1000	
B8	400	800	
B9	300	600	
B16	800	1000	
B17	700	1400	

LEGENDS:

EL - ELEVATION
FFL - FINISHED FLOOR LEVEL
GA - GENERAL ARRANGEMENT
H - HIGH
RL - REDUCED LEVEL
◯ - BUILDING GRID
⬡ - PLANT GRID
▨ - BASEMENT AREA

TB - TURBINE BUILDING
THK. - THIKNESS
TOC - TOP OF CONCRETE
TYP. - TYPICAL
UN - UNLESS NOTED
TOR - TOP OF RAFT
COL. - COLUMN
TP - TERMINAL POINT
TIP - TURBINE ISLAND PACKAGE
TOT - TOP OF TUNNEL
BOT - BOTTOM OF TUNNEL
W - WIDE
BXXXX - BEAM NUMBER
CXX - COLUMN NUMBER
℄ - CENTER LINE

▨ - CHEQUERED PLATE PLATEFORM
▨ - REMOVABLE CHEQUERED PLATE
▨ - GRATED FLOORING
▨ - REMOVABLE GRATED FLOORING
▨ - LAY DOWN AREA
▯▯ - REMOVABLE CONCRETE COVER

NOTES:

FOR ALL NOTES REFER DRG NO.KAIGA-5/22000/8016/GA

TABLE -A

ENGINEERING REFERENCE DRAWINGS (TITLE)	DRAWING NOs.
GENERAL NOTES & STANDARD DETAILS FOR STRUCTURAL STEEL WORKS (UNIT#5 & 6)	KAIGA-5&6/22400/8001/DD
GENERAL NOTES & STANDARD DETAILS FOR CIVIL WORKS (UNIT#5 & 6)	KAIGA-5&6/22210/8001/DD
GA OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8016/GA
TURBINE BUILDING - GA OF LONGITUDINAL SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8017/GA
TURBINE BUILDING - GA OF TRANSVERSE SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8018/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8019/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8020/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8022/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 1 TO 6 (UNIT#1)	KAIGA-5/22000/8023/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8024/GA
TURBINE BUILDING -GA OF FLOOR AT EL 127.0M GRID 1 TO 12 (UNIT#5)	KAIGA-5/22000/8025/GA
TURBINE BUILDING -GA OF ROOF (UNIT#1)	KAIGA-5/22000/8026/GA
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 1 (UNIT#5)	KAIGA-5/22222/8033/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#5)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#5)	KAIGA-5/22222/8035/DD
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN BELOW 100.0M FOR TB-1	KAIGA-5/22000/8001/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN AT 100.0M FOR TB-1	KAIGA-5/22000/8002/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 111.0M FOR TB-1	KAIGA-5/22000/8003/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 118.0M FOR TB-1	KAIGA-5/22000/8004/GA
GENERAL ARRANGEMENT DRAWING -TURBINE BUILDING PLAN VIEW AT 127.0M FOR TB-1	KAIGA-5/22000/8005/GA
CROSS SECTION OF TB-1	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&6-10000-2001/GA

PROOF CONSULTANT STAMP
DEVELOPMENT CONSULTANTS PVT. LIMITED
Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.
ACTION 1
✓ APPROVED
2 COMMENTED
3 FOR INFORMATION
REVIEWED BY : ANIRBAN SARKAR
SIGNATURE:
DATE : 05.12.2023

REV. No.	DESCRIPTION	DATE	BHEL	NPCIL
R0	FOR NPCIL APPROVAL	01.12.2023		

SIGNATURE WITH DATE

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DES'D.	CHK'D.	REV'D.	APP'D.

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG SUND PACKAGE
TURBINE BUILDING
GA OF FLOOR AT EL (+) 111.0M GRID 1 TO 6 (UNIT#5)

DES'D.	AKPOOR	DRN.	S.NAN	REV'D.	S.MISHRA
DATE	28.11.2023	DATE	01.12.2023	DATE	01.12.2023
DES. CHK'D.	V.SHARMA	DRG. CHK'D.	A.KAPOOR	APP'D.	A.KUMAR
DATE	01.12.2023	DATE	01.12.2023	DATE	01.12.2023

PROJECT 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS
PROJECTION

NPCIL DRG. No. KAIGA-5/22000/8021/GA
SHEET 1 OF 1
REV. No. R0
PE-DG-488-611-C1007 (RA)
FILE NAME: KAIGA-5-22000-8021-GA

DRG. TO BE READ IN CONJUNCTION WITH CONFIGN.IN IF ANY.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE 3.2 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO 0.15 / 0.40 x 45°.
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.15 / 0.40.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	240 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

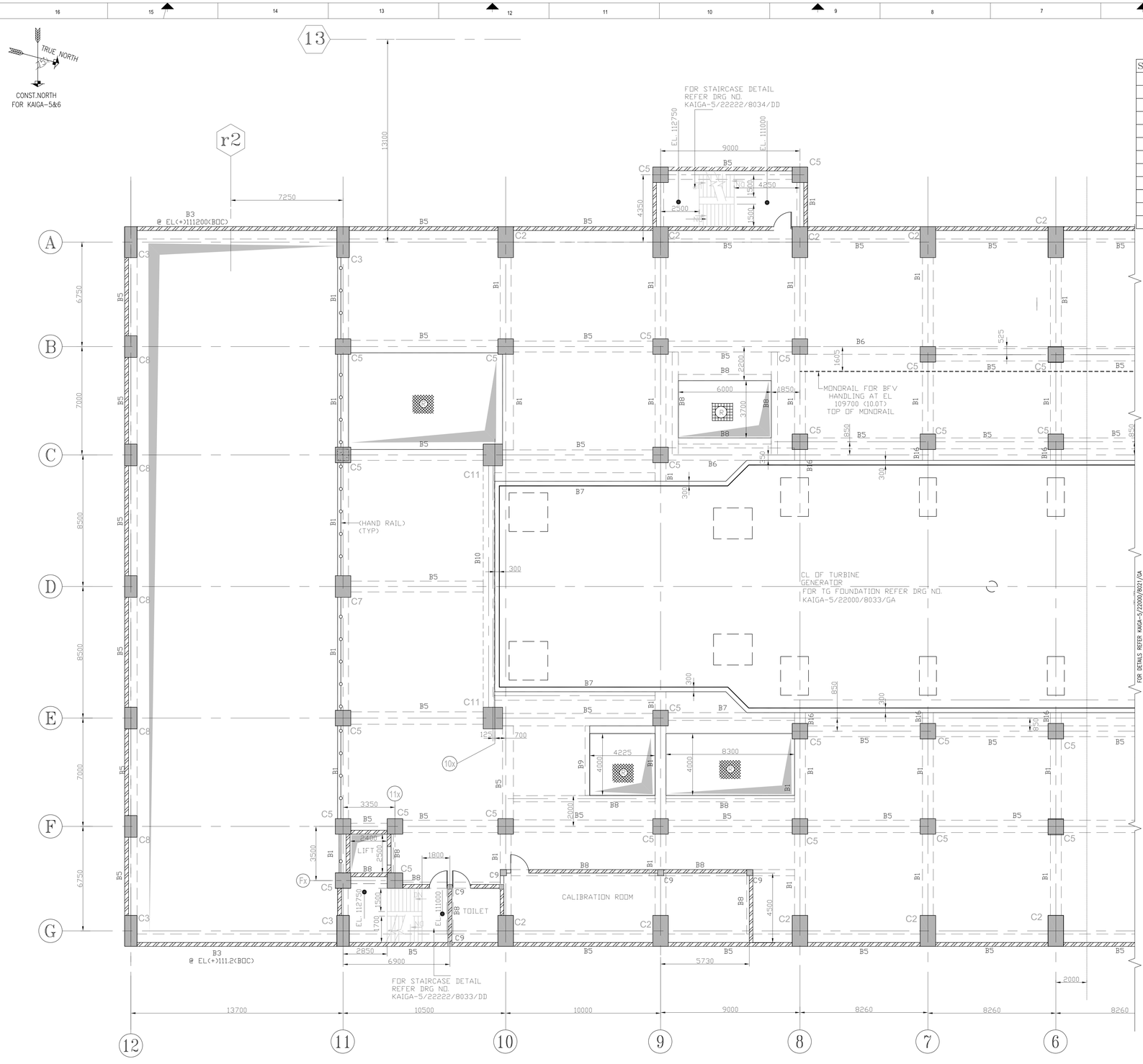
TOLERANCES ON ANGULAR DIMENSIONS : 0°-30'

THE DESIGNS, DRAWINGS AND SPECIFICATIONS CONTAINED IN THIS DOCUMENT ARE THE SOLE PROPERTY OF NUCLEAR POWER CORPORATION OF INDIA LIMITED (NPCIL). NO PART OF THIS DOCUMENT INCLUDING ANY PART THEREOF, RELATED DOCUMENTATION OR INFORMATION SHALL BE DISCLOSED TO OTHERS IN ANY FORM, STORED IN ANY MEDIUM, REPRODUCED OR TRANSMITTED IN ANY FORM AND/OR USED FOR ANY PURPOSE EXCEPT WITH THE PRIOR WRITTEN PERMISSION OF NPCIL. UNAUTHORISED USE OF THE DESIGNS, DRAWINGS AND SPECIFICATIONS CONTAINED IN THIS DOCUMENT SHALL BE UNLAWFUL AND WILL BE PROSECUTED. COPYING IS STRICTLY PROHIBITED AND MAY CONSTITUTE AN EMPYREAL ACT AND CAN ATTRACT LEGAL ACTION.

REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

REVISIONS: REV. No. | REV. LOCATION | DESCRIPTION | DRN. | DES'D. | DES.CHK'D. | REV'D. | APP'D.
SIGNATURE WITH DATE (CONSULTANT): DES'D. | CHK'D. | REV'D. | APP'D.
SIGNATURE (NPCIL)

A0 DRG. No. KAIGA-5/22000/8021/GA

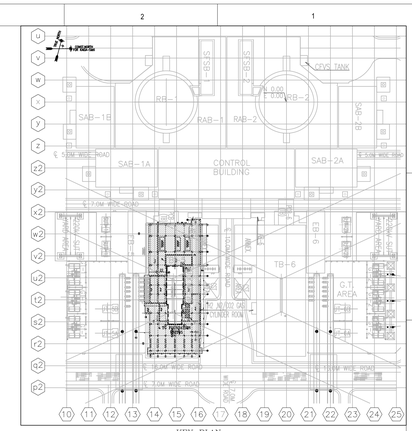


SCHEDULE OF TB-1 COL.

COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	NOT USED
C2	1000	2000	
C3	800	2000	
C4	1500	1200	NOT USED
C5	1000	1000	
C6	1200	1200	NOT USED
C7	1000	1400	
C8	800	1400	
C9	400	400	
C10	1600	1000	NOT USED
C11	1250	1400	

SCHEDULE OF BEAM

BEAM NO.	BEAM SIZE WIDTH	BEAM SIZE DEPTH	REMARKS
B1	700	1200	
B2	700	1300	NOT USED
B3	700	1500	
B4	800	1800	NOT USED
B5	800	1200	
B6	400	1000	
B7	500	1000	
B8	400	800	
B9	300	600	
B10	700	1800	
B16	800	1000	



KEY PLAN

LEGENDS:

EL - ELEVATION
FFL - FINISHED FLOOR LEVEL
GA - GENERAL ARRANGEMENT
H - HIGH
RL - REDUCED LEVEL
○ - BUILDING GRID
⬡ - PLANT GRID
▨ - BASEMENT AREA

TB - TURBINE BUILDING
THK. - THICKNESS
TOC - TOP OF CONCRETE
TYP. - TYPICAL
UN - UNLESS NOTED
TOR - TOP OF RAFT
COL. - COLUMN
TP - TERMINAL POINT
TIP - TURBINE ISLAND PACKAGE
TOT - TOP OF TUNNEL
BOT - BOTTOM OF TUNNEL
W - WIDE
BXXXX - BEAM NUMBER
CXX - COLUMN NUMBER
℄ - CENTER LINE

▨ - CHEQUERED PLATE PLATEFORM
▨ - REMOVABLE CHEQUERED PLATE
▨ - GRATED FLOORING
▨ - REMOVABLE GRATED FLOORING
▨ - LAY DOWN AREA
▨ - REMOVABLE CONCRETE COVER

NOTES:

1. FOR ALL NOTES REFER DRG NO.KAIGA-5/22000/8016/GA

TABLE -A

ENGINEERING REFERENCE DRAWINGS (TITLE)	DRAWING NOs.
GENERAL NOTES & STANDARD DETAILS FOR STRUCTURAL STEEL WORKS (UNIT#5 & 6)	KAIGA-5&6/22400/8001/DD
GENERAL NOTES & STANDARD DETAILS FOR CIVIL WORKS (UNIT#5 & 6)	KAIGA-5&6/22210/8001/DD
GA OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8016/GA
TURBINE BUILDING - GA OF LONGITUDINAL SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8017/GA
TURBINE BUILDING - GA OF TRANSVERSE SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8018/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8019/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8020/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8022/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 1 TO 6 (UNIT#1)	KAIGA-5/22000/8023/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8024/GA
TURBINE BUILDING -GA OF FLOOR AT EL 127.0M GRID 1 TO 12 (UNIT#5)	KAIGA-5/22000/8025/GA
TURBINE BUILDING -GA OF ROOF (UNIT#1)	KAIGA-5/22000/8026/GA
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 1 (UNIT#5)	KAIGA-5/22222/8033/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#5)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#5)	KAIGA-5/22222/8035/DD
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN BELOW 100.0M FOR TB-1	KAIGA-5/22000/8001/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN AT 100.0M FOR TB-1	KAIGA-5/22000/8002/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 111.0M FOR TB-1	KAIGA-5/22000/8003/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 118.0M FOR TB-1	KAIGA-5/22000/8004/GA
GENERAL ARRANGEMENT DRAWING -TURBINE BUILDING PLAN VIEW AT 127.0M FOR TB-1	KAIGA-5/22000/8005/GA
CROSS SECTION OF TB-1	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&6-10000-2001/GA

PLAN VIEW AT 111000 FOR TB-1

1. ALL BEAM ARE AT TOC EL 110960 UN.
2. 200 THK. SLAB

PROOF CONSULTANT STAMP
DEVELOPMENT CONSULTANTS PVT. LIMITED
Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.
ACTION 1
✓ APPROVED
2 COMMENTED
3 FOR INFORMATION
REVIEWED BY : ANIRBAN SARKAR
SIGNATURE:
DATE : 05.12.2023

REV. No.	DESCRIPTION	DATE	BHEL / NPCIL SIGNATURE WITH DATE
R0	FOR NPCIL APPROVAL	01.12.2023	

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DES'D.	CHK'D.	REV'D.	APP'D.

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG ISLAND PACKAGE
TURBINE BUILDING
GA OF FLOOR AT EL (+) 111.0M GRID 6 TO 12 (UNIT#5)

DES'D.	AKPOOR	DRN.	S.NAN	REV'D.	S.MISHRA
DATE	28.11.2023	DATE	01.12.2023	DATE	01.12.2023
DES. CHK'D.	V.SHARMA	DRG. CHK'D.	AKPOOR	APP'D.	A.KUMAR
DATE	01.12.2023	DATE	01.12.2023	DATE	01.12.2023

PROJECT 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS
PROJECTION

NPCIL DRG. No. KAIGA-5/22000/8022/GA
SHEET 1 OF 1
REV. No. R0
PE-DC-488-611-C1008_(RA)
FILE NAME: KAIGA-5-22000-8022-GA

DRG. TO BE READ IN CONJUNCTION WITH CONFIGURATION, IF ANY.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE 3.2 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO 0.15 to 0.40 X 45°
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.15 to 0.40.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	315 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

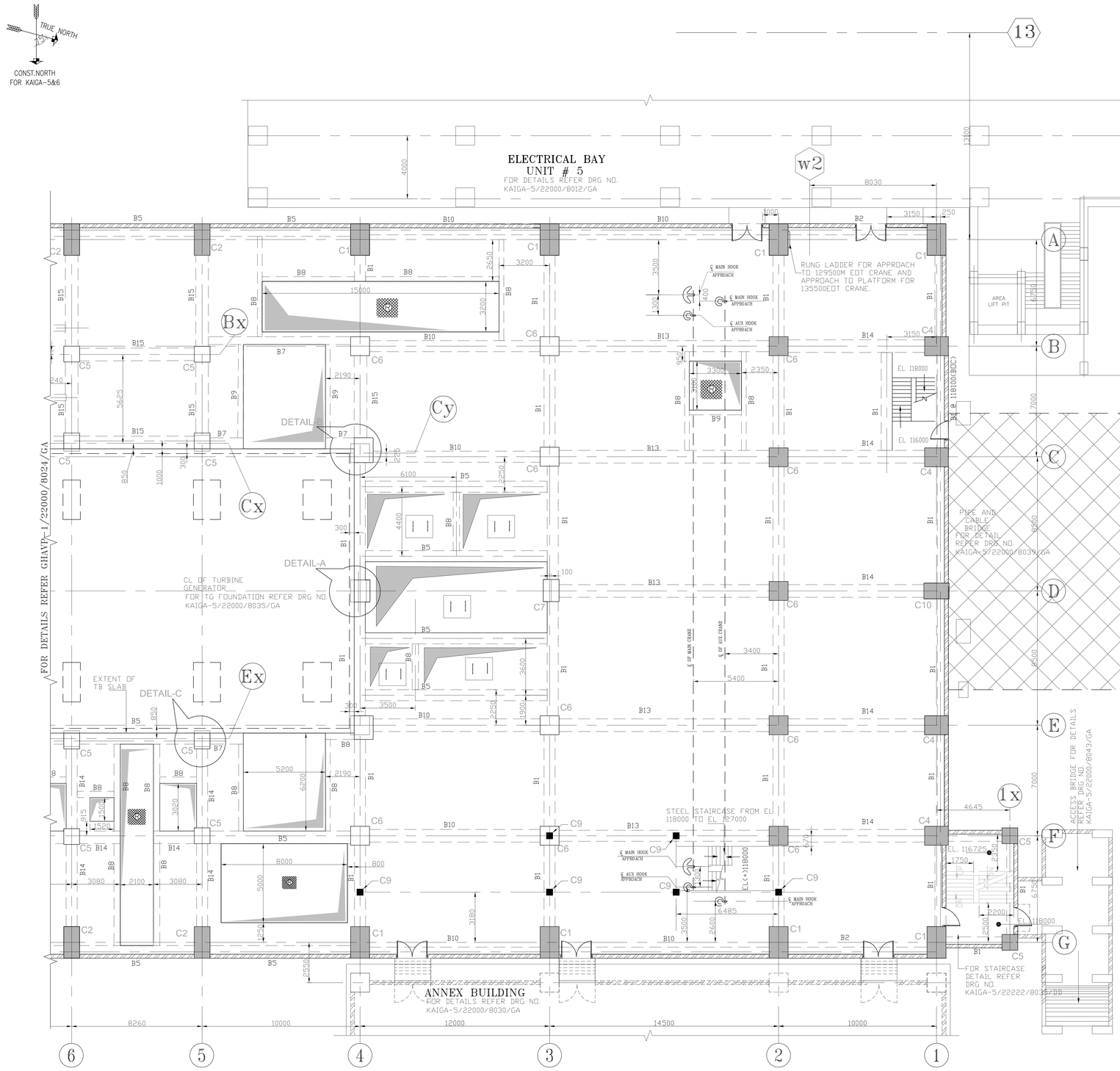
TOLERANCES ON ANGULAR DIMENSIONS : 0°-30'

REV. NO.	REC. LOCATION	DESCRIPTION	DRN.	DES'D.	DES.CHK'D.	REV'D.	APP'D.	DES'D.	CHK'D.	REV'D.	APP'D.
REVISIONS			SIGNATURE WITH DATE (CONSULTANT)					SIGNATURE (NPCIL)			

REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

A0 DRG. No. KAIGA-5/22000/8022/GA

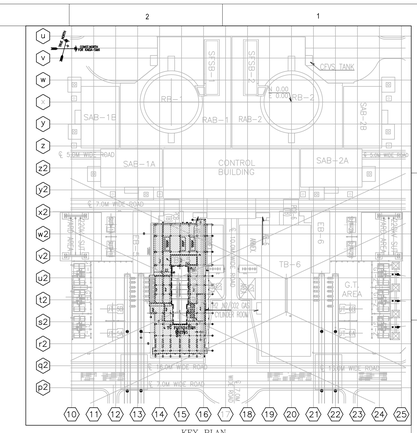
PROPRIETARY AND CONFIDENTIAL INFORMATION: THE INTELLECTUAL PROPERTY RIGHTS CONTAINED IN THIS DRAWING ARE OWNED BY BHEL. THIS DRAWING IS BEING PROVIDED TO YOU ON A CONFIDENTIAL BASIS AND YOU AGREE THAT YOU WILL NOT USE, DISCLOSE OR COPY THIS DRAWING OR ANY PART THEREOF WITHOUT THE PRIOR WRITTEN CONSENT OF BHEL. YOU ALSO AGREE THAT YOU WILL NOT USE, DISCLOSE OR COPY THIS DRAWING FOR THE BENEFIT OF ANY THIRD PARTY. IN THE EVENT OF ANY UNAUTHORISED USE, DISCLOSURE OR COPYING BY YOU OR ANY THIRD PARTY, BHEL RESERVES ITS RIGHTS TO TAKE ANY AND ALL LEGAL ACTION.



PLAN AT 118000 FOR TB-1
(ALL BEAM ARE AT TOC EL 117960(TYP)(UND)
(200 MM THK. SLAB)

SCHEDULE OF TB-1 COL.			
COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	
C2	1000	2000	
C3	800	2000	NOT USED
C4	1500	1200	
C5	1000	1000	
C6	1200	1200	
C7	1000	1400	
C8	800	1400	NOT USED
C9	400	400	
C9A	2000	2000	NOT USED
C10	1600	1000	
C11	1250	1400	NOT USED

SCHEDULE OF BEAM			
BEAM NO.	BEAM SIZE WIDTH	BEAM SIZE DEPTH	REMARKS
B1	700	1200	
B2	700	1300	
B3	700	1500	NOT USED
B4	800	1800	NOT USED
B5	800	1200	
B6	400	1000	NOT USED
B7	500	1000	
B8	400	800	
B9	300	600	
B10	700	1800	
B13	800	1500	
B14	800	1100	
B15	800	1000	



KEY PLAN

LEGENDS:

FFL - FINISHED FLOOR LEVEL
GA - GENERAL ARRANGEMENT
H - HIGH
RL - REDUCED LEVEL
◯ - BUILDING GRID
⬡ - PLANT GRID
BXXXX - BEAM NUMBER
CXX - COLUMN NUMBER
℄ - CENTER LINE

TB - TURBINE BUILDING
THK. - THIKNESS
TOC - TOP OF CONCRETE
TYP. - TYPICAL
UN - UNLESS NOTED
TOR - TOP OF RAFT
COL. - COLUMN
TP - TERMINAL POINT
TIP - TURBINE ISLAND PACKAGE
TOT - TOP OF TUNNEL
BOT - BOTTOM OF TUNNEL
W - WIDE

- CHEQUERED PLATE PLATEFORM
- REMOVABLE CHEQUERED PLATE
- GRATED FLOORING
- REMOVABLE GRATED FLOORING
- LAY DOWN AREA
- REMOVABLE CONCRETE COVER

NOTES:

FOR ALL NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

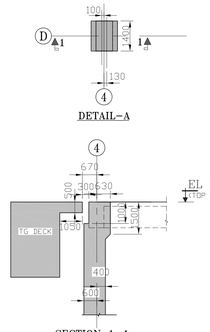


TABLE -A

ENGINEERING REFERENCE DRAWINGS (TITLE)	DRAWING NOs.
GENERAL NOTES & STANDARD DETAILS FOR STRUCTURAL STEEL WORKS (UNIT#5 & 6)	KAIGA-5&6/22400/8001/DD
GENERAL NOTES & STANDARD DETAILS FOR CIVIL WORKS (UNIT#5 & 6)	KAIGA-5&6/22210/8001/DD
GA OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8016/GA
TURBINE BUILDING - GA OF LONGITUDINAL SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8017/GA
TURBINE BUILDING - GA OF TRANSVERSE SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8018/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8019/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8020/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8021/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8022/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8024/GA
TURBINE BUILDING -GA OF FLOOR AT EL 127.0M GRID 1 TO 12 (UNIT#5)	KAIGA-5/22000/8025/GA
TURBINE BUILDING -GA OF ROOF (UNIT#5)	KAIGA-5/22000/8026/GA
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 1 (UNIT#5)	KAIGA-5/22222/8033/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#5)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#5)	KAIGA-5/22222/8035/DD
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN BELOW 100.0M FOR TB-1	KAIGA-5/22000/8001/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN AT 100.0M FOR TB-1	KAIGA-5/22000/8002/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 111.0M FOR TB-1	KAIGA-5/22000/8003/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 118.0M FOR TB-1	KAIGA-5/22000/8004/GA
GENERAL ARRANGEMENT DRAWING -TURBINE BUILDING PLAN VIEW AT 127.0M FOR TB-1	KAIGA-5/22000/8005/GA
CROSS SECTION OF TB-1	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&6-10000-2001/GA

PROOF-CONSULTANT STAMP

DEVELOPMENT CONSULTANTS PVT. LIMITED

Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.

ACTION	1
✓	APPROVED
2	COMMENTED
3	FOR INFORMATION

REVIEWED BY : ANIRBAN SARKAR
SIGNATURE: /s/-
DATE : 05.12.2023

DO NOT SCALE THE DRAWING.

UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER 3.2
SURFACE FINISH TO BE 6.3 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO 0.15 - 0.40 x 45°.
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.15 - 0.40.

TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	240 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

TOLERANCES ON ANGULAR DIMENSIONS : 0°-30'

REV. No.	DESCRIPTION									
R0	FOR NPCIL APPROVAL								01.12.2023	
REV. No.	DESCRIPTION								BHEL SIGNATURE WITH DATE	NPCIL

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DES'D.	CHK'D.	REV'D.	APP'D.

MAIN TIP CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG SUNO PACKAGE
TURBINE BUILDING
GA OF FLOOR AT EL (+) 118.0M GRID 1 TO 6 (UNIT#5)

DES'D. DATE	AKKPOOR 28.11.2023	DRN. DATE	S.NAIN 01.12.2023	REV'D. DATE	S.MISHRA 01.12.2023
DES. CHK'D. DATE	V.SHARMA 01.12.2023	DRG. CHK'D. DATE	AKKPOOR 01.12.2023	APP'D. DATE	A.KUMAR 01.12.2023

PROJECT 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS
PROJECTION

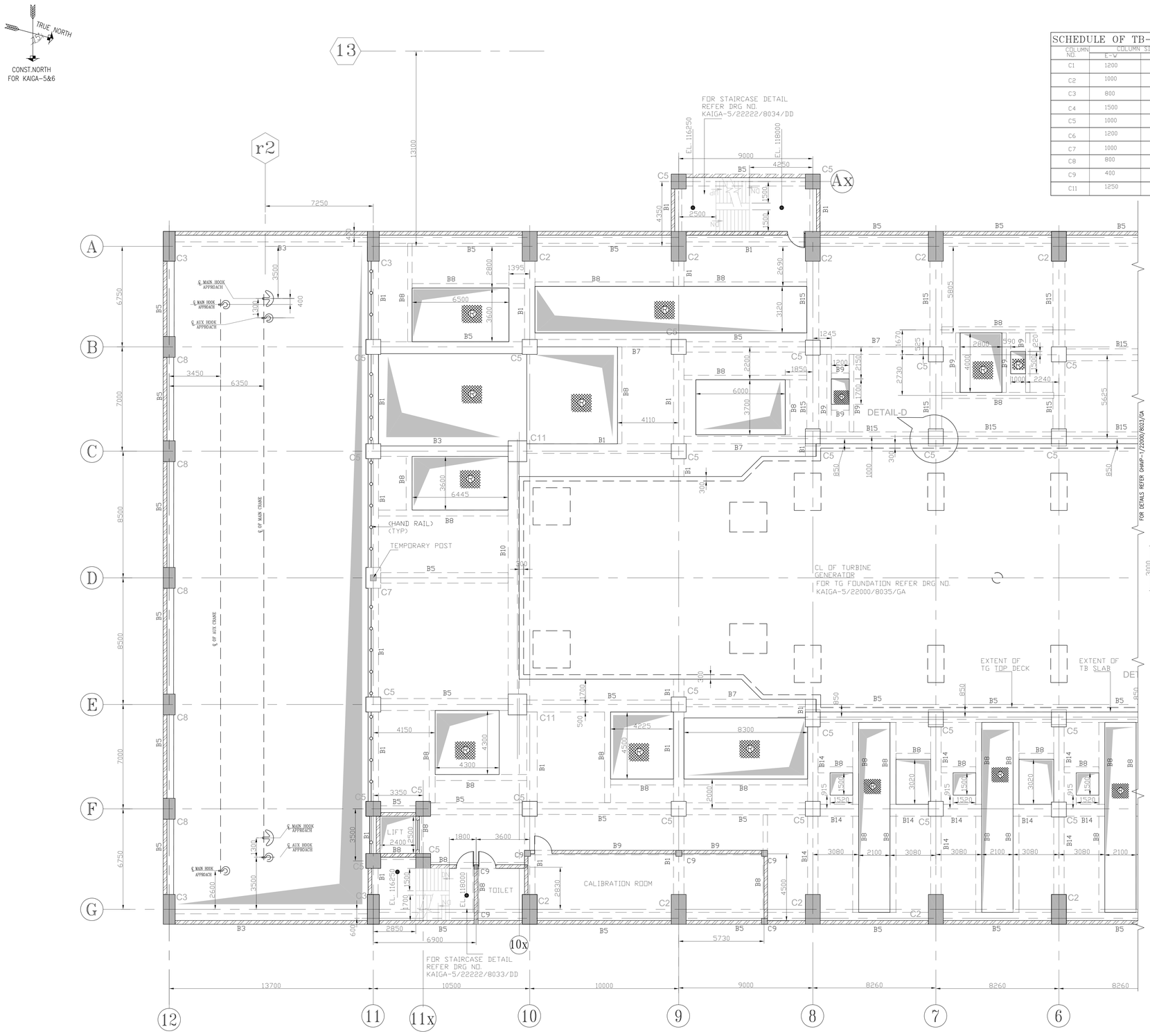
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SHEET 1 OF 1
REV. No. R0

PE-DG-488-611-C1009...(RA) FILE NAME: KAIGA-5-22000-8023-GA

DRG. TO BE READ IN CONJUNCTION WITH DOWFONEICN, IF ANY.

DRG. No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.
KAIGA-5/22000/8023/GA						

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PLAN AT 118000 FOR TB-1

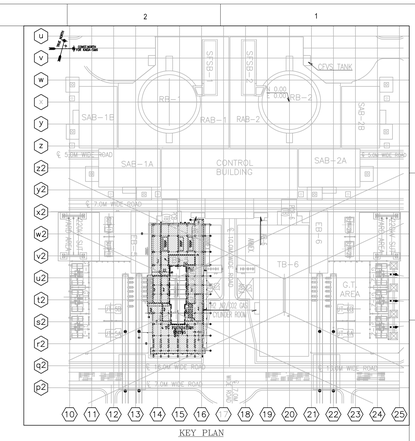
(ALL BEAM ARE AT TOC EL 117960(TYP)(UNO)
(200 MM THK. SLAB)

SCHEDULE OF TB-1 COL.

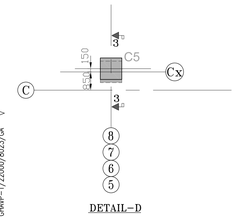
COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	NOT USED
C2	1000	2000	
C3	800	2000	
C4	1500	1200	NOT USED
C5	1000	1000	
C6	1200	1200	NOT USED
C7	1000	1400	
C8	800	1400	
C9	400	400	
C11	1250	1400	

SCHEDULE OF BEAM

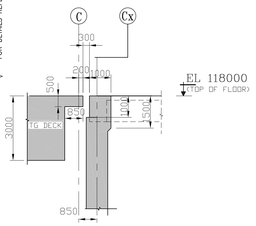
BEAM NO.	BEAM SIZE WIDTH	BEAM SIZE DEPTH	REMARKS
B1	700	1200	
B2	700	1300	NOT USED
B3	700	1500	
B4	800	1800	NOT USED
B5	800	1200	
B6	400	1000	NOT USED
B7	500	1000	
B8	400	800	
B9	300	600	
B10	700	1800	
B13	800	1500	NOT USED
B14	800	1100	
B15	800	1000	



KEY PLAN



DETAIL-D



SECTION 3-3

LEGENDS:

FFL	- FINISHED FLOOR LEVEL	TB	- TURBINE BUILDING
GA	- GENERAL ARRANGEMENT	THK.	- THIKNESS
H	- HIGH	TOC	- TOP OF CONCRETE
RL	- REDUCED LEVEL	TYP.	- TYPICAL
○	- BUILDING GRID	UN	- UNLESS NOTED
⬡	- PLANT GRID	TOR	- TOP OF RAFT
BXXXX	- BEAM NUMBER	COL.	- COLUMN
CXX	- COLUMN NUMBER	TP	- TERMINAL POINT
℄	- CENTER LINE	TIP	- TURBINE ISLAND PACKAGE
		TOT	- TOP OF TUNNEL
		BOT	- BOTTOM OF TUNNEL
		W	- WIDE

- CHEQUERED PLATE PLATEFORM
- REMOVABLE CHEQUERED PLATE
- GRATED FLOORING
- REMOVABLE GRATED FLOORING
- LAY DOWN AREA
- REMOVABLE CONCRETE COVER

NOTES:

FOR ALL NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

TABLE -A

ENGINEERING REFERENCE DRAWINGS (TITLE)	DRAWING NOs.
GENERAL NOTES & STANDARD DETAILS FOR STRUCTURAL STEEL WORKS (UNIT#5 & 6)	KAIGA-5&6/22400/8001/DD
GENERAL NOTES & STANDARD DETAILS FOR CIVIL WORKS (UNIT#5 & 6)	KAIGA-5&6/22210/8001/DD
GA OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8016/GA
TURBINE BUILDING - GA OF LONGITUDINAL SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8017/GA
TURBINE BUILDING - GA OF TRANSVERSE SECTIONS OF RAFT FOUNDATION (UNIT#5)	KAIGA-5/22000/8018/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8019/GA
TURBINE BUILDING -GA OF FLOOR AT EL 100.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8020/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 1 TO 6 (UNIT#5)	KAIGA-5/22000/8021/GA
TURBINE BUILDING -GA OF FLOOR AT EL 111.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8022/GA
TURBINE BUILDING -GA OF FLOOR AT EL 118.0M GRID 6 TO 12 (UNIT#5)	KAIGA-5/22000/8024/GA
TURBINE BUILDING -GA OF FLOOR AT EL 127.0M GRID 1 TO 12 (UNIT#5)	KAIGA-5/22000/8025/GA
TURBINE BUILDING -GA OF ROOF (UNIT#5)	KAIGA-5/22000/8026/GA
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 1 (UNIT#5)	KAIGA-5/22222/8033/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#5)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#5)	KAIGA-5/22222/8035/DD
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN BELOW 100.0M FOR TB-1	KAIGA-5/22000/8001/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN AT 100.0M FOR TB-1	KAIGA-5/22000/8002/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 111.0M FOR TB-1	KAIGA-5/22000/8003/GA
GENERAL ARRANGEMENT DRAWING - TURBINE BUILDING PLAN VIEW AT 118.0M FOR TB-1	KAIGA-5/22000/8004/GA
GENERAL ARRANGEMENT DRAWING -TURBINE BUILDING PLAN VIEW AT 127.0M FOR TB-1	KAIGA-5/22000/8005/GA
CROSS SECTION OF TB-1	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&6-10000-2001/GA

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DEVELOPMENT CONSULTANTS PVT. LIMITED

Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.

ACTION	1
✓	APPROVED
2	COMMENTED
3	FOR INFORMATION

REVIEWED BY : ANIRBAN SARKAR
SIGNATURE:
DATE : 05.12.2023

REV. No.	DESCRIPTION	DATE / BHEL	SIGNATURE WITH DATE
R0	FOR NPCIL APPROVAL	01.12.2023	NPCIL

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DES'D.	CHK'D.	REV'D.	APP'D.

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG ISLAND PACKAGE
TURBINE BUILDING
GA OF FLOOR AT EL (+) 118.0M GRID 6 TO 12 (UNIT#5)

DES'D. AKKPOOR DATE 28.11.2023		DRN. S.NAN DATE 01.12.2023	REV'D. S.MISHRA DATE 01.12.2023
DES. CHK'D. V.SHIVANA DATE 01.12.2023		DRG. CHK'D. A.KKPOOR DATE 01.12.2023	APP'D. A.KUMAR DATE 01.12.2023

PROJECT 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS

PROJECTION

NPCIL DRG. No. KAIGA-5/22000/8024/GA

SHEET 1 OF 1

REV. No. R0

P/E-DG-486-611-C1010_(RA) | FILE NAME: KAIGA-5-22000-8024-GA

ORG. TO BE READ IN CONJUNCTION WITH CONFIGNEON, IF ANY.

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER. 3.2
SURFACE FINISH TO BE 3.2 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO 0.15 X 45°, 0.40
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.15, 0.40.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	120 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

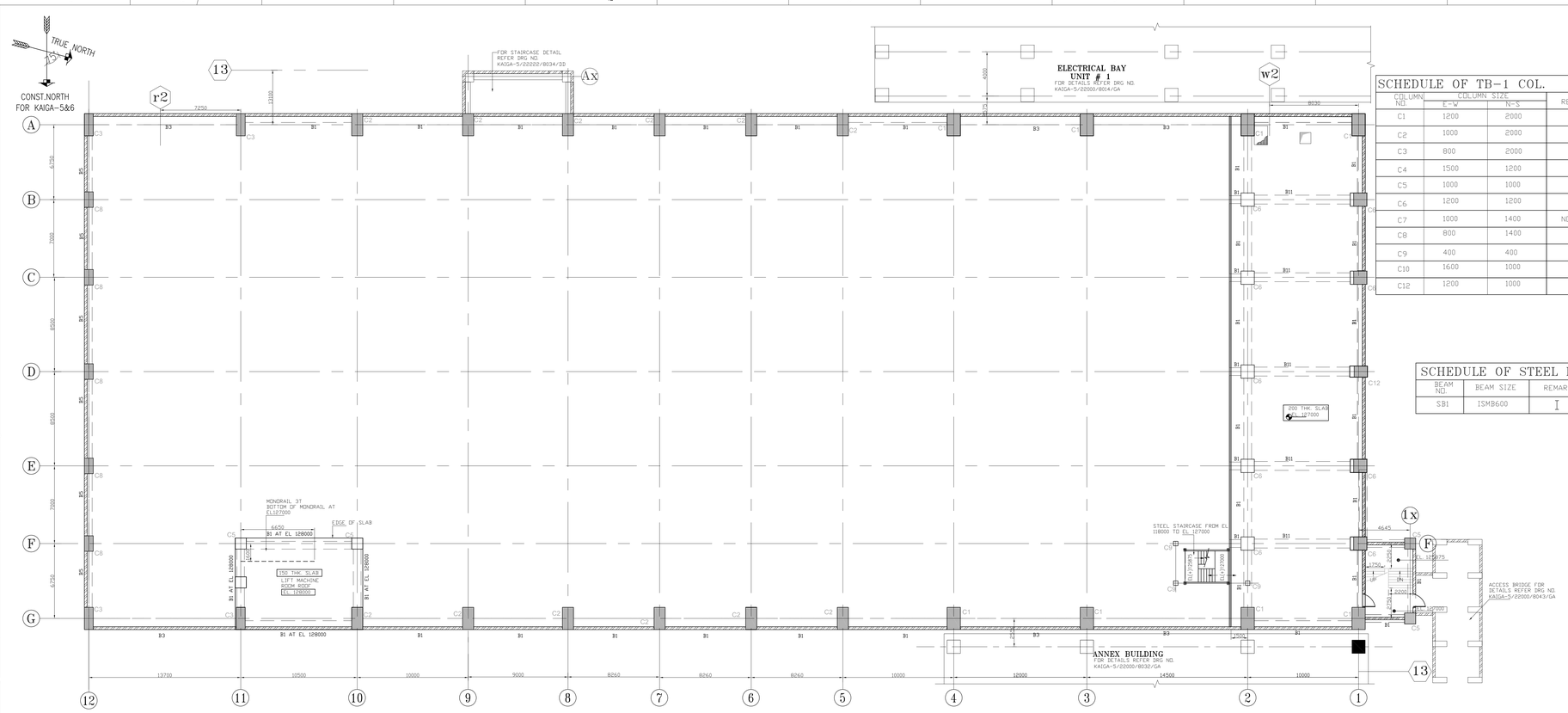
SPECIFIED DIMENSIONS	TOLERANCE
XX	± 0.5
XX.X	± 0.2
XX.XX	± 0.1

TOLERANCES ON ANGULAR DIMENSIONS : 0° 30'

REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

REV. No.	REV. LOCATION	DESCRIPTION	DRN.	DES'D.	DES.CHK'D.	REV'D.	APP'D.	DES'D.	CHK'D.	REV'D.	APP'D.
REVISIONS			SIGNATURE WITH DATE (CONSULTANT)					SIGNATURE (NPCIL)			

A0 DRG. No. KAIGA-5/22000/8024/GA

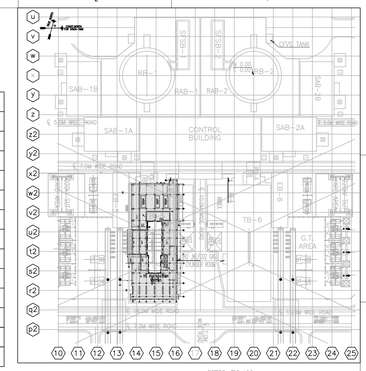


PLAN AT EL 127000 FOR TB-1
NOTE:-(ALL BEAM ARE @ TOC EL 1207600

PLAN AT EL 122500M/ EL 123000 FOR TB-1
NOTE:-(ALL BEAM ARE @ TOC EL 1207600

PLAN AT EL 121000
NOTE:-(ALL BEAM ARE @ TOC EL 1207960M)

KEY PLAN



SCHEDULE OF TB-1 COL.

COLUMN NO.	COLUMN SIZE E-W	COLUMN SIZE N-S	REMARKS
C1	1200	2000	
C2	1000	2000	
C3	800	2000	
C4	1500	1200	
C5	1000	1000	
C6	1200	1200	
C7	1000	1400	NOT USED
C8	800	1400	
C9	400	400	
C10	1600	1000	
C12	1200	1000	

SCHEDULE OF BEAM

BEAM NO.	BEAM SIZE WIDTH	BEAM SIZE DEPTH	REMARKS
B1	700	1200	
B2	700	1300	NOT USED
B3	700	1500	
B4	800	1800	NOT USED
B5	800	1200	
B6	400	1000	NOT USED
B7	500	1000	
B8	400	800	
B9	300	600	
B10	700	1800	NOT USED
B11	700	2000	
B12	250	500	

SCHEDULE OF STEEL BEAM

BEAM NO.	BEAM SIZE	REMARKS	
SB1	ISMB600		

LEGENDS:

EL - ELEVATION
FFL - FINISHED FLOOR LEVEL
GA - GENERAL ARRANGEMENT
H - HIGH
RL - REDUCED LEVEL
◯ - BUILDING GRID
⬡ - PLANT GRID
BXXXX - BEAM NUMBER
CXX - COLUMN NUMBER
℄ - CENTER LINE

TB - TURBINE BUILDING
THK. - THIKNESS
TOC - TOP OF CONCRETE
TYP. - TYPICAL
UN - UNLESS NOTED
TOR - TOP OF RAFT
COL. - COLUMN
TP - TERMINAL POINT
TIP - TURBINE ISLAND PACKAGE
TOT - TOP OF TUNNEL
BOT - BOTTOM OF TUNNEL
W - WIDE

- CHEQUERED PLATE PLATEFORM
- REMOVABLE CHEQUERED PLATE
- GRATED FLOORING
- REMOVABLE GRATED FLOORING
- LAY DOWN AREA
- REMOVABLE CONCRETE COVER

NOTES:

FOR ALL NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

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CROSS SECTION OF TB-1	KAIGA-5/22000/8007/GA
MAIN PLANT LAYOUT	KAIGA-5&6/10000/2001/GA

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DEVELOPMENT CONSULTANTS PVT. LIMITED

Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.

ACTION	!
✓	APPROVED
2	COMMENTED
3	FOR INFORMATION

REVIEWED BY : ANIRBAN SARKAR
SIGNATURE:
DATE : 05.12.2023

CONSULTANT STAMP

DO NOT SCALE THE DRAWING.

UNLESS OTHERWISE STATED :-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE $\sqrt{3.2}$ OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO 0.15 X 45° / 0.40
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TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	315 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

TOLERANCES ON ANGULAR DIMENSIONS : 0°-30'

REV. No.	REV. LOCATION	DESCRIPTION	DRN.	DES'D.	DES.CHK'D.	REV'D.	APP'D.	DES'D.	CHK'D.	REV'D.	APP'D.
		REVISIONS	SIGNATURE WITH DATE (CONSULTANT)					SIGNATURE (NPCIL)			
R0		FOR NPCIL APPROVAL									

01.12.2023 — BHEL — NPCIL — SIGNATURE WITH DATE

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)

DES'D. | CHK'D. | REV'D. | APP'D.

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG ISLND PACKAGE
TURBINE BUILDING
GA OF FLOOR AT EL(+)121.0M/EL(+)122.5M/EL (+)123.0M/EL (+)127.0M (UNIT#5)

DES'D.	AXAPPOR	DRN.	S.NAN	REV'D.	S.MISHRA
DATE	28.11.2023	DATE	01.12.2023	DATE	01.12.2023
DES. CHK'D.	V.SHARMA	DRG. CHK'D.	AXAPPOR	APP'D.	A.KUMAR
DATE	01.12.2023	DATE	01.12.2023	DATE	01.12.2023

PROJECT: 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS
PROJECTION

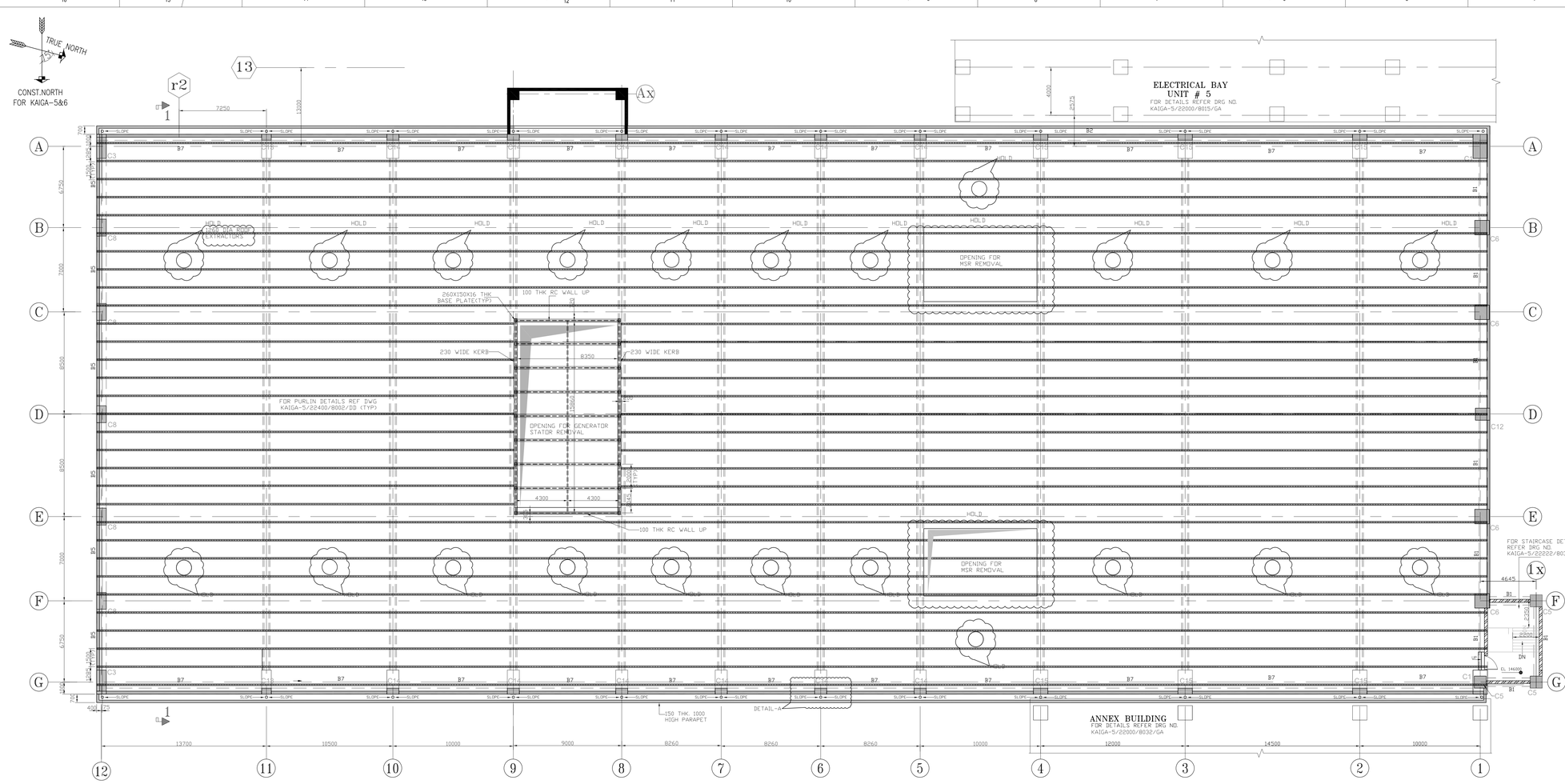
NPCIL DRG. No. KAIGA-5/22000/8025/GA — SHEET 1 OF 1 — REV. No. R0

BHEL DRG NO: PE-DG-488-611-C1011 (RA) — FILE NAME: KAIGA-5-22000-8025-GA

DRG. TO BE READ IN CONJUNCTION WITH CONFIGNTECH, IF ANY.

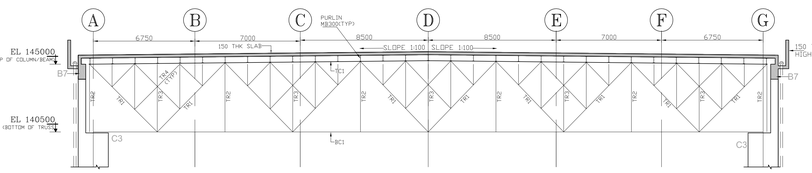
DRG. No. KAIGA-5/22000/8025/GA — A0

REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

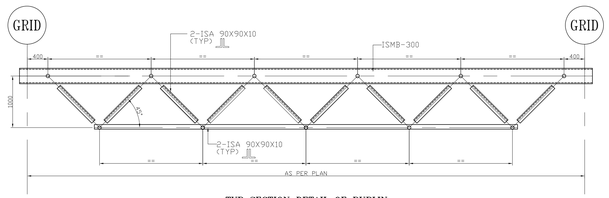


PLAN AT EL 145000 FOR TB-1

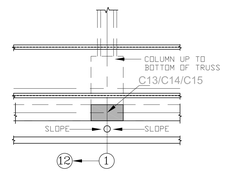
NOTE:-(ALL BEAM ARE AT TOC EL 145000)



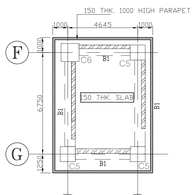
SECTION 1-1



TYP SECTION DETAIL OF PURLIN

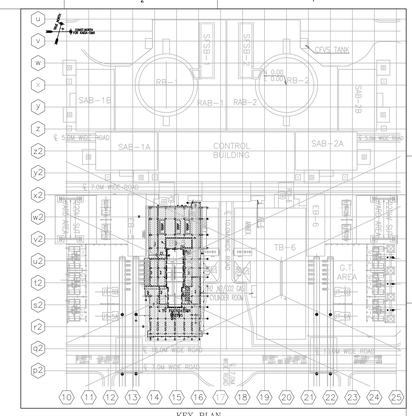


DETAIL-A



PLAN AT EL 148000M

STAIRCASE MUMTY



KEY PLAN

LEGENDS:

DWG	- DRAWING	UN	- UNLESS NOTED
EL	- ELEVATION	COL	- COLUMN
FFL	- FINISHED FLOOR LEVEL	TP	- TERMINAL POINT
GA	- GENERAL ARRANGEMENT	TIP	- TURBINE ISLAND PACKAGE
H	- HIGH	TOT	- TOP OF TUNNEL
TB	- TURBINE BUILDING	BOT	- BOTTOM OF TUNNEL
THK	- THIKNESS	W	- WIDE
TOC	- TOP OF CONCRETE	BXXXX	- BEAM NUMBER
TYP	- TYPICAL	CXX	- COLUMN NUMBER
◯	- BUILDING GRID	℄	- CENTER LINE
⬡	- PLANT GRID		

- CHEQUERED PLATE PLATEFORM
- REMOVABLE CHEQUERED PLATE
- GRATED FLOORING
- REMOVABLE GRATED FLOORING
- LAY DOWN AREA
- REMOVABLE CONCRETE COVER

NOTES:

FOR ALL NOTES REFER DRG NO. KAIGA-5/22000/8016/GA

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TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 2 (UNIT#5)	KAIGA-5/22222/8034/DD
TURBINE BUILDING -CONCRETE DETAILS OF STAIRCASE 3 (UNIT#5)	KAIGA-5/22222/8035/DD
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CROSS SECTION OF TB-1	KAIGA-5/22000/8007/GA
TURBINE BUILDING - DETAILS OF ROOF TRUSS (UNIT#5)	KAIGA-5/22400/8001/DD
TURBINE BUILDING - DETAILS OF PURLINS (UNIT#5)	KAIGA-5/22400/8002/DD
TURBINE BUILDING -CONCRETE DETAILS OF ROOF (UNIT#6)	KAIGA-5&6/22222/8051/DD
MAIN PLANT LAYOUT	KAIGA-5&6/10000/2001/GA

SCHEDULE OF TB-1 COLUMN

COLUMN NO.	COLUMN SIZE	
	E-W	N-S
C1	1200	2000
C3	800	2000
C5	1000	1000
C6	1200	1200
C8	800	1400
C12	1200	1000
C13	800	500
C14	1000	500
C15	1200	500

SCHEDULE OF BEAM

BEAM NO.	BEAM SIZE	
	WIDTH	DEPTH
B1	700	1200
B5	800	1200
B7	500	1000

SCHEDULE OF TRUSS MEMBER

TC1	625X12 THK. PLATE; 4 ISA 200X200X20 (TYP)	APPLICABLE FOR TRUSS ALONG GRID 2 TO 11
BC1	4 ISA 200X200X20 (TYP); 625X12 THK. PLATE	APPLICABLE FOR TRUSS ALONG GRID 2 TO 11
TR1	2-ISA 200X200X20 (TYP)	APPLICABLE FOR TRUSS ALONG GRID 2 TO 11
TR2	2-ISA 150X150X16 (TYP)	APPLICABLE FOR TRUSS ALONG GRID 2 TO 11
TR3	2-ISA 150X150X16 (TYP)	APPLICABLE FOR TRUSS ALONG GRID 2 TO 11
TR4	2-ISA 90X90X8 (TYP)	APPLICABLE FOR TRUSS ALONG GRID 2 TO 11

DESCRIPTION OF HOLD

1. ROOF EXTRACTORS
2. OPENING FOR MSR REMOVAL

PROOF-CONSULTANT STAMP

DEVELOPMENT CONSULTANTS PVT. LIMITED

Document is approved in conformance to Codal provisions & NPCIL Technical Specifications.

ACTION	
1	APPROVED
2	COMMENTED
3	FOR INFORMATION

REVIEWED BY : ANIRBAN SARKAR
SIGNATURE :
DATE : 05.12.2023

REV. No.	DESCRIPTION		
R0	FOR NPCIL APPROVAL	01.12.2023	
		BHEL	NPCIL
		SIGNATURE WITH DATE	

DRAWING ISSUED FOR

NUCLEAR POWER CORPORATION OF INDIA LIMITED

(A GOVERNMENT OF INDIA ENTERPRISE)

DES'D.	CHK'D.	REVD.	APPD.

MAIN T/P CONTRACTOR: BHARAT HEAVY ELECTRICALS LTD

POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA
JOB REF. No. 488

TITLE :- KAIGA ATOMIC POWER PROJECT-5&6 (2 X 700 MWe PHWR)
TG BLND PKAGE
TURBINE BUILDING
GA OF ROOF AT EL (+) 145.0M (UNIT#5)

DES'D. DATE	A.KAPOOR 28.11.2023	DRN. DATE	S.NAN 01.12.2023	REVD. DATE	S.MISHRA 01.12.2023
DES. CHK'D. DATE	V.SHARMA 01.12.2023	DRG. CHK'D. DATE	A.KAPOOR 01.12.2023	APPD. DATE	A.KUMAR 01.12.2023

PROJECT: 2x700 MWe PHWR
KAIGA- ATOMIC POWER PROJECT UNITS NO. 5 & 6

SCALE - NTS

PROJECTION

NPCIL DRG. No. KAIGA-5/22000/8026/GA

SHEET 1 OF 1

REV. No. R0

BHEL DRG NO. PE-DC-488-611-C1012_(RA) FILE NAME: GHAVP-5-22000-8026-GA

DRG. TO BE READ IN CONJUNCTION WITH DCN/FCN/ECN, IF ANY.

DO NOT SCALE THE DRAWING.

UNLESS OTHERWISE STATED :-

ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER. 3.2
SURFACE FINISH TO BE 12.5 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO 0.15 X 45° / 0.40
ROUND ALL INTERNAL CORNERS AND EDGES TO R 0.13 / 0.40.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

RADII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	± 0.2	± 0.5	± 1.0

TOLERANCES ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UPTO 6	± 0.1	120 - 1000	± 0.8
6 - 30	± 0.2	1000 - 2000	± 1.2
30 - 120	± 0.3	2000 - 4000	± 2.0
120 - 315	± 0.5	4000 - 8000	± 3.0

TOLERANCES ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	±
XX.X	±
XX.XX	±

TOLERANCES ON ANGULAR DIMENSIONS : ± 0° 30'

REV. No.	REV. LOCATION	DESCRIPTION	DRN.	DES'D.	DES.CHK'D.	REVD.	APPD.	DES'D.	CHK'D.	REVD.	APPD.
		REVISIONS		SIGNATURE WITH DATE (CONSULTANT)				SIGNATURE (NPCIL)			

A0	DRG. No. KAIGA-5/22000/8026/GA	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.	REFERENCE DRAWINGS	DRAWING No.

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NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A Government of India Enterprise)

KAIGA-5&6/40000/PROCUREMENT SPECIFICATION/MS-1

PROCUREMENT SPECIFICATION
FOR
TURBINE ISLAND PACKAGE
(ENGINEERING, PROCUREMENT AND CONSTRUCTION)

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KAIGA-5&6/40000/PROCUREMENT SPECIFICATION/MS-1

PROCUREMENT SPECIFICATION
FOR
TURBINE ISLAND PACKAGE
(ENGINEERING, PROCUREMENT AND CONSTRUCTION)

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PROCUREMENT SPECIFICATION NUMBER: KAIGA-5&6/40000/PROCUREMENT SPECIFICATION/MS-1,
PROCUREMENT SPECIFICATION
FOR TURBINE ISLAND

VOLUME-II- Section-C, PART-2

CONTENTS

SUB SECTION NO.	TITLE	PAGE NO.
C	TECHNICAL REQUIREMENTS	**5**
C-1	GENERAL TECHNICAL REQUIREMENTS	**5**
C-1-1	PROJECT INFORMATION	**6**
C-2	SPECIFIC TECHNICAL REQUIREMENTS	**9**
C-2-1	TECHNICAL REQUIREMENTS OF CIVIL STRUCTURES	**10**
	SUPPLEMENT REQUIREMENTS FOR KAIGA-5&6	**359**
	INPUTS	**361**
	GHAVP-1&2 PROCUREMENT SPECIFICATION	**1369**

KAIGA-5&6/40000/PROCUREMENT SPECIFICATION/MS-1

REVISION No. – R0, JANUARY-2019

VOLUME-II
Section-C (TECHNICAL REQUIREMENTS)
PART-1

C-1: GENERAL TECHNICAL REQUIREMENTS

1.0 PROJECT INFORMATION

1.1	OWNER / PURCHASER	:	NUCLEAR POWER CORPORATION OF INDIA LTD. (NPCIL)
1.2	ENGINEER	:	EXECUTIVE DIRECTOR (PROCUREMENT)
1.3	Project Title	:	2x700 MWe PHWR – KAIGA-5&6 ATOMIC POWER PROJECT
1.5	Location	:	KAIGA, UTTARA KANNADA DISDRICT, KARNATAKA
1.6	Elevation (RL)	:	RL +32m to +46m
1.7	Nearest Railway Stations	:	KARWAR (Konkan Railway)
1.8	Name of Railway Stations	:	KARWAR (Konkan Railway)
1.9	Ambient Air Temperatures	:	
	a) Maximum dry bulb temperature	:	+41.6 deg C,
	b) Minimum dry bulb temperature	:	10.9 deg C,
	c) Design temperature for electrical equipment / devices	:	+50 deg C
1.10	Relative Humidity		
	a) Maximum during monsoon	:	99.9%
	b) Minimum (design)	:	3%
1.11	Air Quality	:	Air quality is clean and free from chemical pollutants.
1.12	Rainfall	:	
	a) Annual Average	:	3649.31 mm
	b) Highest annual rainfall	:	4695.1 mm in 1988
	c) Lowest annual rainfall	:	2345.3 mm in 2016
	d) Period	:	Year 1987-2017

1.13 Tropicalisation : _____

1.14 a) Wind Pressures :

Height above mean ground level, m	Design Wind Speed m/sec
@ 10 M	5.0
@ 100 M	13.8

The assessment of wind loads based on the above basic wind speed shall be done as specified in IS: 875.

b) Wind direction : Predominantly W,SW,NE & E with respect to true North

1.15 Transport : Rail & Road

1.16 Rail / Road access : About 53 km from Karwar (Konkan Railway) Station and NH 10 passes through Karwar

1.17 SEISMOLOGY : Zone III as per IS1893-2002 part I

1.18 Auxiliary Power : Auxiliary electrical equipment to be supplied against this specification shall be suitable for operation on the following supply systems

a) For AC motors 200 kW and above : 6600 Volts, 3 phase, 50 Hz, non-effectively earthed with following supply variations*

b) For AC motors below 200 kW : 415 V, 3 phase, 3 wire, 50Hz effectively earthed with following supply variations*

c) Construction supply : 415 V, 3 phase, 4 wire, 50 Hz, AC supply effectively earthed, one feeder supplied to the VENDOR at one point, as determined by the PURCHASER near the Sub-station, with

following supply variations *

d)	Panel Lighting fixtures, Space heaters	:	240 V, 1 phase, 2 wire, 50 Hz, AC supply with neutral lead earthed, with following supply variations*
e)	DC motors control and protective devices	:	220 V, 2 wire, unearthed DC supply from Station Battery / Battery Charger, with a supply variation of (-) 20% to (+) 10% of rated voltage.
f)	Instrumentation controls & annunciation	:	i) (+) 24V DC centre tap grounded supply for general control purpose. ii) 240V AC, 1 phase, 2 wire, 50 Hz, un-interruptible power supply source (UPS).

NOTES:

1.0 *Supply Variations

i) Variation of supply voltage : (±) 10%

ii) Variation in supply frequency : (±) 5%

iii) Combined voltage and frequency variation : (±) 10%

VOLUME-II-
Section-C
PART-2

C-2: SPECIFIC TECHNICAL REQUIREMENTS FOR KAIGA 5-6

VOLUME-II-
Section-C-
PART-2
C-2: SPECIFIC TECHNICAL REQUIREMENTS
CONTENTS

SPECIFICATION NO.	TITLE	PAGE NO.
C-2-1	TECHNICAL REQUIREMENTS OF CIVIL STRUCTURES	353

VOLUME – II-
Section-C
PART -2
C-2: SPECIFIC TECHNICAL REQUIREMENTS
C-2-1: C-2: SPECIFIC TECHNICAL REQUIREMENTS OF CIVIL STRUCTURES FOR-KAIGA 5&6

NUCLEAR POWER CORPORATION OF INDIA LIMITED

(A Government of India Enterprises)

PROCUREMENT SPECIFICATION NUMBER : KAIGA- 5&6/40000/ PROCUREMENT SPECIFICATION/ MS-1
PROCUREMENT SPECIFICATION
FOR
TURBINE ISLAND PACKAGE

SECTION C -2-1: SPECIFIC TECHNICAL REQUIREMENTS OF CIVIL STRUCTURES FOR KAIGA 5&6

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Approved By	**ARVIND SHRIVASTAVA AD (Civil) & Head (Civil Engineering Group)**	21/XII/2018	**21/12/2018**
	(Name & Designation)	**(Signature)**	**(Date)**

REVISION CONTROL SHEET
PROCUREMENT SPECIFICATION NUMBER : KAIGA5&6/40000/
PROCUREMENT SPECIFICATION/ MS-1
PROCUREMENT SPECIFICATION
FOR
TURBINE ISLAND
SECTION C -2-1: SPECIFIC TECHNICAL REQUIREMENTS OF CIVIL STRUCTURES

REV. NO. / DATE	DESCRIPTION	PREPARED BY	CHECKED BY	REVIEWED BY	APPROVED BY

1. GENERAL

1.0.1 PROJECT

The proposed project of KAIGA 5-6 consists of two units of 700 MWe PHWR type Nuclear Reactors.

1.0.2 LOCATION

The site is located in Kaiga Village, Karwar Taluka, Uttara Kannada District, Karnataka state. Kaiga Site bounded between the Latitude 140 50' 29" - 140 52' 59' and Longitude 740 24' 30"-740 27' 40"at East-West and North-South sides respectively. Kaiga Site is at about 13 km upstream of Kadra Dam and associated hydro-electric power house on the left bank of Kali River on the banks of the Kadra reservoir. Geographically the site surrounded with hills covered with thick ever green forest at three sides and one side Kadra reservoir. The site receives an average rainfall of 3900 mm during the four months of monsoon (June to September).

1.0.3 ACCESSIBILITY

Access (Road, Rail and Air Connectivity)
Kaiga site is accessible from Karwar through State Highway 06 (SH-06) by taking 3 km diversion from SH06 at Hartuga. SH-06 is interconnected with SH-34 at Kadra and NH-66 at Karwar. Hence the nearby towns like Dharward, Hubballi, Belgaum, Goa etc. is connected. The nearest Broad gauge rail connectivity exists at Karwar on Konkan Railway and Londa on Belgaum-Goa broad gauge of South Western Railway Division. Air connectivity exists with Goa, Hubballi and Belagavi at 140, 150 and 175 kilometre respectively from Kaiga Site.

1.1 GENERAL GEOLOGY OF THE SITE

The plant site forms a part of the Peninsular Gneissic Complex of Uttar Kannada District. These tonalitic gneisses (plagioclase or sodalime feldspars are greatly in excess of orthoclase or K feldspars) with age > 3000 million years form basement rock and are overlain by metasedimentary rocks (Quartz schists, Qtz-sericite schist and Banded Magnetite quartzite) and Metavolcanics. The contact between the granite gneiss and metavolcanics is about 1 km south of Kaiga village. Granite gneisses are traversed by few basic dykes (delerites) and bodies of ultrabasic rock (pyroxenite, peridotite, gabbro and diorite). One such body also occurs within 4 to 5 km South East of the site area. The relevant borelogs in TI area (BH-110 & BH -113) are attached with the tender. It is observed that in one of the boreholes (BH-113) rock with low core recovery and RQD exists upto 58M depth from the existing ground level. ***In such situation contractor may require to use Pile- Raft foundation for the structures and the provision for the same shall be included by the contractor in his bid without any extra cost to NPCIL.***

1.2 METEOROLOGICAL DATA

The other meteorological parameters at Kaiga are as follows:

		Max.	Min.
1.	Air temperature	43.21	8.25

The annual maximum rainfall of 5708.2 mm and minimum rainfall of 2308.2 mm and average annual average rainfall is 3645mm. The maximum daily rainfall of 469.3 mm on 12/06/1999 (data from 1901 to 2010).

1.3 SEISMOLOGY

The site falls in zone III as per IS: 1893 and corresponds to an earthquake intensity of VII or less, as per Modified Mercalli Intensity Scale. The digital values of Response Spectra for safe shut down earthquake condition shall be given at a later stage.

1.4 SITE INSPECTION

The contractor is deemed to have visited the site and familiarized themselves thoroughly with the site conditions before submitted their tender. Non-familiarity with site conditions will not be considered a reason either for extra claims or for not carrying out the work in strict conformity with drawings and specifications. For any information on site visit, the tenderers may contact the office of CCE, Kaiga 5&6, Post Kaiga, Karwar, Karnataka State, Pin-581400.

1.5 SITE CONDITIONS

The bore hole location Drawing No. KAIGA-5&6/10120/2001/DD-R1 is enclosed along with the tender document. Typical details of a relevant Bore log data BH-110 & BH 113 are given at the end of this section in Annexure-1 for general guidance to the Bidders. All the geotechnical investigations as indicated (within the TI Package) in the drawings will be performed by the Purchaser and report of same will be made available subsequently for guidance. Any additional geo-technical investigation required for satisfactory analysis and design considering typical foundation pattern adopted by the bidder shall be carried out by him at no additional cost to NPCIL.

The bidders are advised to study the bore log data for information. The details of other bore log data in balance area of plant will be available in the office of the Engineer for reference of the bidders, if needed.

The finished grade level of EL 99.7m corresponds to RL 41.300.

For detailed geology around Turbine Building & other structures, para 2.1.1 may be referred.

1.6 BUILDING DESCRIPTION

Description of Main structures covered in the scope of this tender are as follows:

1.6.1 TURBINE BUILDING :

The Turbine buildings are located to the East of Control building. The Structure of the Turbine building shall be of reinforced concrete and shall be supported on Raft Foundation resting on competent rock. If required, piles shall also be provided below Turbine Building raft without any extra cost to Purchaser. For wall/cladding , Concrete Block Masonry is to be provided unless approved otherwise by the engineer. The RCC roof shall be made without any internal support, in order to avoid any interference in work being carried out below the roof. The roof shall be provided with water proofing with thermal insulation as per specifications. All the fire rating & other technical requirements shall be considered while selection of material & sizing of the members. Each turbine building shall be accommodated within the allocated maximum plan size as shown in the main plant layout drawing. The location of buildings in the main plant lay out is shown in Drg. No. KAIGA 5&6/10000/2001/GA enclosed along with the tender. A portion below condenser shall be lowered appropriately for cooling water inlet and outlet pipes.

The turbine building shall have floors and mezzanine floors at various elevations, housing the turbo generator and other components like HP Turbine, LP Turbine, Generator, Moisture Separator & Reheater, Deaerator, HP and LP feed water heaters, Condensate Extraction Pumps, Boiler Feed Pumps, Storage tanks, Vacuum pumps, Generator Circuit Breaker, Bus Ducts etc. The description given above is brief only . For detailed description relevant chapters of the tender may be followed.

For industrial & fire safety requirements relevant AERB & other statutory guidelines as applicable shall be strictly adhered.(Refer C-1-3)

The Turbine Generator(TG) shall be supported on a separate RCC pedestal and Reinforcing Concrete Raft foundation resting on competent rock. If required, piles shall also be provided below TG raft without any extra cost to Purchaser . The TG foundation shall be isolated from the main turbine building, so as to avoid transmission of vibrations or any other kind of forces to the main building.

Inside the building, EOT cranes with other suitable crane girders shall be provided, to handle the heaviest load within the building for maintenance & erection of Turbo Generator & other equipment except Turbo Generator Stator. During maintenance provision of removable leak-tight opening shall be made in the roof of Turbine Building for removal of Turbo Generator Stator. The building shall have necessary cable & Pipe trenches / tunnels, racks, pipes, hangers & anchor supports. The lifts as well as stair cases shall be provided to access from one floor to another floor of the building.

The access to Turbine building from Control Building at various floors shall also be

provided through proper connecting walkways, landing, Staircase etc. Floor levels & entry location from control building , are at similar locations as given for GHAVP project in drawing GHAVP 1&2/24200/ 2011 TO 2018/ GA. The connecting structure (Access Bridge) shall be planned & designed in such a way that it does not transfer any load to control building as the same is not considered in the design of control building.

In addition to above, condensate storage area & ventilation buildings, are to be provided by the side of Turbine buildings as indicated in the Drawing No. KAIGA 5&6/10000/2001/GA enclosed along-with the tender.

Annex Buildings are located by the side of both the Turbine Buildings. One of the Annex Building houses the Workshop alongwith other facilities, whereas other Annex Building houses the Laboratory with other facilities. For details of various facilities in the Annex Buildings Chapter C-1-3 of the Tender may be referred. The Annex building may be designed by the bidder as standalone structure or could be a part of the Turbine Building.

The construction of a local Control center inside turbine building with noise barrier/acoustic insulation as specified is also included in the scope of bidder, The detailed requirements of same which are indicated C&I specifications in chapter C-2-4 are also to be met .

1.6.2 **Pipe Cable Bridge (PCB):**

The Pipe and Cable Bridge (PCB) connecting Control building to Turbine Building shall have RCC Structure with suitable foundation resting on competent rock and the same is included in the scope of this tender . If required, piles shall also be provided below raft without any extra cost to Purchaser . The intermediate floors & roof of PCB shall be of RCC. The roof shall be provided with water proofing with insulation as per specifications. ***The structure of PCB shall be planned in such a manner that it does not interfere with the vehicular and equipment movement on 10 m wide (7m carriage bay and 1.5m wide shoulder on either side of road) road , as well as tunnels & trenches laid under the road***. *The tunnel & trenches in this area are similar to the one given in GHAVP 1&2 and as indicated in drawing no GHAVP 1&2-29700-5002-GA.*The PCB foundations should not transfer any load on tunnels & trenches.

The floor elevations of Turbine Building shall preferably match with Control building floor levels. (Floor levels of control building are similar to GHAVP project and as given in drawing Nos. GHAVP 1&2/24200/ 2011 TO 2018/ GA, along with this tender). The width of PCB shall match with the PCB opening at control building end as shown in above mentioned drawings ,however the length of PCB will depend on the size of Turbine building as finalized by the bidder and approved by the purchaser. ***The PCB structure shall be planned & designed in such a way that it does not transfer any load to control building.***

1.6.3 **Electrical Bays:**

The electrical bays shall be provided adjoining to main turbine buildings. The electrical

bay houses Switchgears and Motor Control Centers. The size , layout & equipment arrangement of electrical bay shall be as specified in section C-2-3 of the Tender. The Structure of the Electrical bay shall be of RCC with Raft Foundation resting on competent rock. If required, piles shall also be provided below raft without any extra cost to Purchaser . The roof shall be provided with water proofing with thermal insulation as per specifications. All the fire rating & other technical requirements shall be considered while selection of material & sizing of the members. ***The engineering of the Electrical Bay shall be carried out on the basis of equipment layout and other input as finalized by the Purchaser & given in the electrical specifications in section C-2-3.***

The present layout of Electrical bays is finalized based on the structural configuration and sizing of various columns, beams etc. as per drawings attached in section C-2-3. It is expected that bidder shall maintain the same, while design of Electrical Bay Buildings . In case, it is found to be essential to change the given dimension and same is approved by Engineer, the Purchaser may modify the equipment layout, opening arrangement etc, to meet the design, construction and maintenance requirements. In such situation, Bidder shall carry out the necessary design changes based on modified layout by the purchaser without any extra cost to Purchaser.

1.6.4 **Access Bridge:**

The Access bridge for both the units needs to be provided to connect the turbine building from control building from each floor of Control building. This structure shall have landing at each floor of Turbine Building connected to nearest available Control building floor. It shall also have provision of lift, to access the Turbine Building & Control building. The floor elevations of Control building at which turbine building to be connected with control building are similar to GHAVP project and as given in drawing Nos. GHAVP 1&2/24200/ 2011 TO 2018/ GA . The Access Bridge structure shall be RCC. The roof shall be provided with water proofing with insulation as per specifications. Lift shall open at all floor levels of CB & TB.

1.6.5 **CCW Inlet & Outlet Pipes / Conduit**

The detailed requirement for CCW Inlet & Outlet Pipes/ Conduits given in Section C-2-5 shall be met. Suitable arrangement viz. culvert etc. shall be made to ensure that no loads are transferred by other Structures & Systems under this package on CCW Pipes/ Conduits.

1.6.6 **Transformer Yard:**

All the civil works for transformer yard (adjoining to turbine buildings & electrical bay) to accommodate SUT, UT, GT, Oil Separation Pit, Bus Duct, Rail Track (including rails) for maintenance upto Turbine building, spare GT area, fire barrier walls etc. are included in the scope of the bidder as shown in the relevant tender drawing. **The supply and erection of rail on road towards western side of grid X-2 is also included in the scope of bidder**. For detailed scope Section C-2-3 shall be referred. The transformer yard is open to sky. An area reserved for Transformer Yard

is shown in main plant layout drawing attached with the tender. ***The engineering of this area shall be done on the basis of input data and equipment layout provided by the Purchaser as given in the electrical specifications in Section C-2-3.The foundation for all the equipment & structures shall be Raft or Pile- Raft foundation, unless approved otherwise by the Purchaser. In case of raft foundation, the foundation shall rest on competent rock for SUTs, UTs, GTs, Burnt Oil Pit and Fire wall etc. (unless specifically approved by the engineer).*** The equipment foundations shall be structurally isolated from the grade slab to avoid any transfer of load.

1.6.7 **Tunnels & Trenches around Turbine Building & Transformer Yard (Other than CCW Pipes/conduits) & other area:**

The engineering & construction of all the tunnel trenches within the road edges between grid (8&9), Grid (26-27), grid (r2- q2) & grid (x2-y2)is included in the scope of bidder. The terminal points are similar to GHAVP project and as given in Sketch No. GHAVP 1&2/29700/2001/SK. The end of the RCC tunnels shall be provided with proper construction joint & dowels of adequate length which can be used by other agency for further construction. (The load being transferred, if any, at terminal point and is to be accounted for, during design by TI package contractor to be specified.) The tunnels / trenches shall be aligned & engineered properly considering the road crossing etc, if any, as per overall layout of the plant. The Tunnel trenches included in the scope are similar to GHAVP 1&2 (Ref: GHAVP 1&2/29700/2001/SK):

- PTL 26, 33(upto terminal point),53,96,97
- PTR 26A , 26B & 68
- CTR 72,74, 74A,75, 77,78,79, 80
- CTL 73, 73A(upto terminal point), 73B, 94 (upto terminal point), 95, 95A
- ASW tunnels upto terminal points in East & West direction.
- Any additional tunnel / trenches / pipes required within the terminal of this contract, are also included in the scope of bidder. The portion of the tunnels/ trenches which is excluded from the scope of this package are similar to the one specifically mentioned in the Sketch No . GHAVP 1&2/29700/2001/SK given with the tender.
- The layout of Major Surface drain will be provided by the purchaser to the bidder on its finalization . Design and construction of down comer pipes & additional internal drains connecting to the Surface drains is in the scope of bidder. Construction of Surface drains within the terminal boundaries as specified in para 1.6.7 is in the scope of bidder. The relevant sectional details & Layout, given in construction *drawings supplied by the Purchaser (at a later stage)* shall be followed, in order to meet the continuity of flow as these are part of overall drain network of plant.
- The layout of Plant drain will be provided by the purchaser to the bidder on its finalization . Design and construction of additional internal plant drains connecting to the nearest available plant drains shown in above drawing is in the scope of bidder. Design (wherever not supplied by the bidder) & Construction of plant drains within the terminal boundaries as specified in para 1.6.7 is in the scope of bidder. The relevant sectional details & Layout, given in construction *drawings supplied by the Purchaser (at a later stage)* shall be followed, in order to meet the continuity of flow as these are part of overall drain network of plant. In case the manholes for above services are not

available, close to terminal boundaries, then these lines are to be connected by the bidder at his own cost to the nearby Man Hole/ nearest connecting point at the boundary limit.

- The layout of Roof drain will be provided by the purchaser to the bidder on its finalization. Design (wherever not supplied by the bidder) & Construction of Roof Down Comers & Drains within the terminal boundaries as specified in para 1.6.7, is in the scope of bidder. The relevant sectional details & Layout, given in construction *drawings supplied by the Purchaser (at a later stage)* shall be followed, in order to meet the continuity of flow as these are part of overall drain network of plant. In case the manholes for above services are not available, close to terminal boundaries, then these lines are to be connected by the bidder at his own cost to the nearby Man Hole/ nearest connecting point at the battery limit.
- The layout of Sewer drain will be provided by the purchaser to the bidder on its finalization. Design (wherever not supplied by the bidder) & Construction of sewer line from building to the nearest manhole outside the terminal boundaries as specified in para 1.6.7 is in the scope of bidder. The relevant sectional details & Layout, given in construction *drawings supplied by the Purchaser (at a later stage)* shall be followed, in order to meet the continuity of flow as these are part of overall drain network of plant. In case the manholes for above services are not available, close to terminal boundaries, then these lines are to be connected by the bidder at his own cost to the nearby Man Hole/ nearest connecting point at the boundary limit.
- The construction of 10 m wide road between grid 17- 18 within terminal point is excluded from the scope of the bidder. However the bidder shall fill the area up to subgrade i.e. EL 98.0m , with material as per specifications and/or as approved by the purchaser.

1.6.8 The construction of Hard Stand "C" is excluded from the scope of this tender. However, the area below the Hard stand within terminal point shall be graded upto EL 98.00 with material as per technical specifications and/or as specified by the Engineer suiting for operation of crane for handling the Turbine Building equipment like Deaerator, Tubo-generator, MSR, LP Turbine & HP Turbine .

1.6.9 **Area grading within the terminal points:**

The area grading within the terminal point within the road edges between grid (8-9), Grid (26-27), grid (r2- q2) & grid (x2-y2) , upto EL 99.7M (RL 219.3M) is within the scope of bidder. For area grading backfilling upto EL 99.7M shall be done using material as per the technical specifications and as approved by the Purchaser, unless specified in the approved drawing otherwise .

1.7 SCOPE OF CIVIL WORK

1.7.1 **General:**

The works proposed to be performed under this contract are for engineering, procurement, fabrication, construction, commissioning and handover of two 700 MWe units of Kaiga Atomic Power Project - 5&6 (KAIGA- 5&6) and shall include all the facilities required for power production utilizing the steam produced in secondary

cycle. ***The facilities shall be established within the allocated area satisfying all the statutory, technical and performance requirements specified in the tender.*** The work shall generally include but not limited to following:

Finalization of equipment layout, general arrangement, loading, analysis , design , drawings, procurement, fabrication, construction & commissioning of :

- Turbine Building including BFP, CEP and Vaccum Pumps.
- Turbo Generator Foundations
- Foundation of all other equipment's
- Annex Building ,Turbine Oil storage tank
- Condensate storage tank and its storage area
- Pipe and Cable Bridge (PCB) structure connecting Control building to Turbine Building
- Electrical bay (The engineering of the building is to be carried out on the basis of equipment layout and other input finalized by the Purchaser or his consultant as given in the Electrical Specification.).
- All other Tunnels , Trenches & pipes within the terminal boundaries except similar to those which are specifically mentioned as excluded in the sketch No. GHAVP 1&2/29700/2001/SK.
- Transformer yard accommodating SUT, UT, GT, Oil Separation Pit, Bus Duct, Rail yard for maintenance upto Turbine building including rails in transformer yard to & within the turbine building unloading bay, spare GT area . The supply and erection of rail on road towards western side of grid X-2 is also included in the scope of bidder.
- Embedded parts / Penetrations,
- Access bridge to connect the turbine building from control building from each floor of Control building (The floor elevations of Control building at which turbine building to be connected with control building are similar to GHAVP project and as given in drawing Nos. GHAVP 1&2/24200/ 2011 TO 2018/ GA) .
- Surface drains, Plant drains, Roof drains and Sewer lines (Based on the engineering input provided by the purchaser)within the terminal point as specified in Para 1.6.7.
- Internal & External Finishes, cladding , plastering , flooring & painting etc.
- Fabrication & erection of all structural steel works like trusses , crane girders etc.
- Dewatering of the area
- Area Grading & temporary access roads within the terminal point
- All the civil, structural & architectural works as necessary for completion of the system.

1.7.2 **Detailed:**

The scope of work shall include engineering, procurement, supply & construction necessary for functional requirements. The work shall generally include but not limited to the following :

(a) ***The excavation of site will be carried out within the terminal points of this package by the Purchaser as indicated in the drawing no*** KAIGA 5&6/16000/2003 /SK. ***However, additional excavation, if any required from functional reasons due to system requirements or due to geotechnical reasons , shall be carried out by the contractor at his own cost. Wherever, the founding levels are lower than the levels***

specified in above drawing the ground shall be lowered by bidder using appropriate cutting tool like , rock breaker, chisel etc. which does not disturb and damage the adjoining structure and also do not have any adverse effect on the existing works being executed by other contractors in adjoining areas. The excavation using controlled blasting may be resorted in specific cases with prior approval of Engineer. The over excavated / damaged ground, if any, shall be made good by the bidder at his own cost. Schedule of the additional excavation and backfilling shall be finalized in consultation with PURCHASER. Bidder must schedule his excavation and other activities considering the status of construction & schedule of construction of adjoining structure.

Back filling of areas, wherever required, shall be done using suitable backfill material as decided by the Engineer, and is included in the scope of this tender. The same shall be done by the bidder at his own cost. The area under the structures shall be raised, by filling PCC only unless approved otherwise by the Engineer

The bidder has to carry out at least following confirmatory geological tests for both the buildings independently, to demonstrate the suitability of geotechnical parameters considered, in his design within the area covered in the scope of the bidder unless approved otherwise by the Engineer.

- ***minimum one bore hole of nx size (As required, but not lesser than 60m depth from founding level),***
- ***analyzing & arriving at safe bearing capacity using RMR & Unconfined compressive strength of core (having a minimum factor of safety of 10) approach. and a lesser of these 2 values shall be considered in the design in case of rock.***
- ***cyclic plate load tests under TG foundation area &***
- ***Geological mapping at the founding level of foundation & its side area,***

The bidder shall also carry out the ground improvement by consolidation grouting as per IS 6066 & conduct the water loss test as per IS 5529(Part 2), unless approved otherwise by the Engineer. All the above activities shall be executed as per the relevant technical specifications detailed in subsequent clauses of this tender.

(b) Analysis ,Design and Detailed Engineering of all the structures i.e. covered in the scope of this tender and as detailed above.

(c) Preparation of Design Basis Reports (DBR), Static and dynamic analysis reports and other design reports as applicable and suggested by the engineer.

(d) Preparation of general arrangement, loading, Architectural , concrete forming, EP location, EP fabrication and Reinforcement drawings etc. The reinforcement detailing has to be as per Indian Standards/ ACI/ AERB code as directed by the engineer.

(e) Complete analysis , design, procurement ,fabrication and erection of structural /Miscellaneous Steel works & EP including preparation of all necessary drawings within the terminal points & within the scope of this tender.

(f) Preparation of composite drawings including details of Civil, Electrical, Mechanical, Instrumentation etc.

(g) Preparation of Bar bending schedule and Bill of materials.

(h) Design , fabrication and erection of formwork and supporting system required for concreting of the various elements of the structure.

(i) All Reinforced concrete work in pile (wherever applicable), raft, isolated footings, columns, equipment foundations, slabs, beams, underground tunnels/trenches, sumps, basement structures, ducts, precast covers and allied structures etc.

(j) All RCC work required for equipment machinery, tanks, tunnels , trenches etc., supply & installation of EPs.

(k) Supplying and Fixing water stops, expansion joint.

(l) Supplying & Construction of brick, concrete block walls along with plastering , glazed walls, Metal deck sheeting, cladding & roofing as per the drawings .

(m) Providing & fixing the Metal Doors/ Fire proof doors, Windows, Ventilators & Louvers with glass & glazing along with all the necessary fixtures wherever required or as specified by the Purchaser. Wherever required, suitable sound insulation measures shall be provided.

(n) Providing and laying of plant drain, storm water drains, sewer lines, roof drains, UPVC pipe down comers and different pipes and other plumbing and sanitary works and connecting the sewer lines to nearest manhole outside the area within this contract or as required.

(o) F3 & U3 finishes to the concrete.

(p) Hardonate flooring by vacuum de-watering method and other types of flooring as specified in the specifications, including specific requirements given in other sections of the tender.

(q) Painting over concrete , structural steel , wall, ceiling, Doors , Windows & Ventilators etc. wherever required as specified in the tender or else as directed by Purchaser.

(r) Water proofing work in basement, sump, wall and roof etc. as specified in the tender specifications or approved by the Purchaser.

(s) Providing facilities throughout the contract period for sampling and testing of various construction materials as specified and as directed by Purchaser.

(t) Providing proper storage facilities for construction materials such as cement, steel, aggregate, admixture, Structural Steel, water stop, paints etc.

(u) Construction of temporary Access Roads & storm water drains within the terminal points .

(v) General area grading and drainage within the terminal points upto EL 99.7M unless specified otherwise, with proper retaining walls / sheet piles (wherever required) .

(w) Providing suitable dewatering system in order to keep the excavation dry at all times during the construction period , the contractor shall provide adequate standby arrangement for pumping water in case of power failure.

(x) Finishing works for above mentioned structures, partition walls. plastering, flooring, painting, false ceiling wherever specified & approved in the drawings, erection of doors, windows & rolling shutters, P.H. Works, waterproofing, construction joints, fire proofing, painting of equipment, structures and piping etc.

(y) Preparation of quality assurance plan, quality assurance manual, testing methodologies Inspection and testing plan, and acceptance criteria for material qualification.

(z) Preparation of construction methodology, safety manual, job hazard analysis, work procedures, etc.

(aa) Submission & obtaining the purchaser approval on Construction Completion Certificate & system transfer docket containing necessary documents like Test Certificates, Pour Cards, As Built Drawings & Inspection reports etc.

(bb) Attending meetings with purchaser, AERB, wherever & whenever required, at own cost.

1.8 MATERIAL AND SERVICES BY NPC

Land, water and power etc. will be given by NPCIL on chargeable basis on conditions mentioned elsewhere in the relevant documents.

The supply of all the materials , required to execute the work covered under this contract, is in the scope of contractor.

1.9 DRAWINGS

Drawings being issued with bid are for ***guidance*** only. All the construction/ as-built drawings are to be prepared by bidder on suitable integrated engineering environment or AutoCAD (latest version) as per relevant standards and as specified by purchaser . Drawings in Compatible AutoCAD version shall also be provided to the purchaser. Contractor should have adequate knowledge of prevailing codes and practices for reinforcement detailing .

3 number of prints (full scale) of each drawing shall be submitted to Purchaser for every revision/correction. Drawings /Documents preparation, checking and Approval of drawings shall be done by the EPC contractor as well as design consultant (if

appointed) and same shall also be approved by Proof consultant. Before submission to Purchaser all documents should bear the signatures and names of persons preparing, checking and approving the documents/drawings as well as of Proof consultant .After the approval from Proof consultant the Drawings /Documents shall be submitted for final acceptance of Purchaser. Purchaser comments if any shall be incorporated in the relevant final drawings/ documents prior to execution.

Supporting design calculations (wherever applicable) shall also be submitted by EPC contractor prior to submission of related drawings. Two copies of the approved prints and one set soft copy shall be submitted to the Purchaser. The final soft copy of all the documents and drawings will be registered in Purchaser's document management system (PLM) in the format attached with the tender, progressively with the work progress. Execution shall be done only after proper registration of the documents/ drawings.

Submission of DVD/ CDs (2 copies) of all approved drawings, DBR, Mathematical model, software input and output files, post processors , static and dynamic analysis reports, Design Manual etc , along with soft copy of executable file of programme, excel sheets used in the process of analysis and design are also included in the scope of bidder.

The documents/drawings furnished by Purchaser and/or generated by the EPC contractor shall not be used by the contractor anywhere else without prior written approval of the purchaser. All the generated documents/ drawings will be property of the purchaser.

The bidder has to prepare the following drawings:

(a) General arrangement, Loading, Architectural , Concrete forming, EP location, EP fabrication, Reinforcement drawings etc. for all the structure covered in the scope of this contract. The reinforcement detailing has to be carried out as per Indian Standards/ ACI code as directed by the purchaser .

(b) Design of Joints, preparation & issue of fabrication drawings for Structural Steel works & other Miscellaneous Steel Structures.

(c) Preparation of Bar bending schedule and Bill of materials (BOQ).

(d) Preparation of composite drawings including details of Civil, Electrical, Mechanical, Instrumentation etc.

(e) Preparation of EP list

The bidder has to prepare all the drawings/ Report as per the approved format of the Purchaser. A period of minimum 15 working days shall be considered for obtaining the Purchaser's comments after submission of drawing / Document by the Contractor.

1.10 SPECIFICATIONS

The specifications given in this document cover the general description, quality and workmanship of materials and finished work. They are not intended to cover minute details. The work shall be executed in accordance with best modern practices.

For all the Civil works these specifications shall have precedence in case anything contrary to this is stated anywhere in the contract document, unless specifically mentioned in this document or approved by the engineer. The Purchaser's decision shall be final, on any issue arising out of such discrepancies.

1.11 PARTICULARS OF THE MATERIALS TO BE USED BY THE BIDDER:

The bidder has to use the following materials for civil construction unless otherwise specified /approved by the Engineer in writing

- **Backfilling:**

A) AREA GRADING:
Upto EL 99.70m : As per technical specifications and as approved by the engineer

B) Within Foot Print of structure/ equipment Foundation:

PCC shall be used, unless specifically approved by the Engineer. The properties of the back fill material used shall be suitably accounted in the design.

- **CONCRETE : M 35 Grade**

- **PCC: M15 Grade**

- **STRUCTURE-**

Foundation Type : RCC Raft or RCC Raft with Piles (wherever required)

Structure above Raft: Reinforced Cement Concrete (RCC), unless approved otherwise by the Purchaser.

- **WALLS :**All external walls shall be of Concrete Block Masonry, unless approved otherwise by the Engineer . Wherever required, proper glass partitions shall also be provided.

- **ROOFING :**

The roof of Turbine buildings shall be cast in situ RCC (with water proofing and required thermal insulation as per specifications) over Steel Deck Span Sheets, unless specifically approved by the Engineer. The roof of Turbine Buildings shall be laid over steel roof trusses and purlins. The roof shall be made without any internal support from slab below in order to avoid any interference in work being carried below the roof.

The floors & roofs (Except for Turbine Building) shall be of cast in situ RCC (with water proofing and required thermal insulation on roofs) .

❖ **PLASTERING : On masonry works**

A)EXTERNAL: 20 mm thick rough cast plaster / sand faced plaster wherever masonry is used for cladding and as approved by purchaser.
B) INTERNAL: 15 mm thick cement mortar

❖ **FLOORING :**

40 mm thick Hardonate flooring in cement concrete 1: 1.5: 3 or alternative flooring or as functionally required & approved by the purchaser.

The areas used for handling the chemicals and battery rooms shall be provided with acid & alkali resistant lining .

In case, if specific flooring requirements are specified in other sections of the tender the same shall be followed unless otherwise agreed by the engineer.

❖ **WATER STOP :**

PVC type as required & approved by the purchaser.

❖ **WATER PROOFING:**

FOR ROOF :

Spray Applied 2 component Polyurethene Membrane as per specifications on all RCC roofs . Wherever required, proper thermal insulation shall also be provided .

FOR BASMENT / TUNNELS/ TRENCHES /SUMPS:.

PVC Membrane as per the technical specifications. PVC membrane shall also be provided all around CEP foundation external surfaces.

❖ **PAINTING**

A) INSIDE SURFACE :
On masanory walls upto 2 m height 250 micron thick epoxy paint & for balance height acrylic emulsion paint of shade to be approved by purchaser.

B) OUTSIDE SURFACE ABOVE GRADE LEVEL:
Anti-Carbonation, Anti-Corrosive and Waterproof Coating on plastered/ concrete surface of shade as approved by the purchaser.

C) STEEL STRUCTURE:
Epoxy paint as specified in clause 19.18.5.5, unless specified otherwise.

D) FLOOR :
1200micron thick Self-Leveling Epoxy coating on Turbine operating floor. On all other floors except for Turbine operating floor, 500 micron thick epoxy paint shall be used.

In areas where any other specific type of flooring like Acid Alkali Resistant Lining etc. (other than Hardonate flooring) is specified, epoxy coating need not be provided.

E) FIRE PROOFING OF STEEL STRUCTURE:
Using Intumescent Paint for desired fire rating or encasing in concrete as specified in the drawing and approved by the Engineer.

❖ **DOORS/ WINDOWS :**

Anodised aluminum doors / steel rolling shutters and anodised aluminum windows as approved by the purchaser .Wherever required, fireproof doors shall also be provided of adequate fire rating.

❖ The false ceiling shall be provided, wherever specified in the tender (inclusive of other sections).

1.12 GENERAL & ARCHITECTURAL REQUIREMENTS

1.12.1 *Grade of concrete*

All the cement concrete works involved in the Turbine Building& other associated structures shall meet the requirements for relevant IS standards.

Grade of concrete shall be M35 for sub-structure and for super-structure. The RCPT value of the concrete used for the construction shall not be more than 2000 columbs at 56 days.

1.12.2 *Types of cement*

The cement shall be OPC 43 grade confirming to IS 8112 or OPC 53grade confirming to IS 12269 as well as the additional requirements of technical specifications . To meet the durability requirement, mineral admixture like flyash may be used with proper mix proportioning . The quality of fly ash shall meet the relevant technical specifications.

1.12.3 *Reinforcement*

The reinforcement shall be HYSD TMT bars of grade Fe 500 as well as the additional requirements of relevant technical specifications shall be used.

1.12.4 *General Architectural Requirements*

Powder coated aluminum panel of minimum 0.5mm thick lined ceiling (closed type pattern) fixed to R.C. beams shall be provided for all air-conditioned areas. The illumination and duct grills in these areas shall match the overall aesthetics.

All the buildings shall be provided with minimum 1.0m wide concrete paving all round as plinth protection. Paving shall be slopped outward to provide a rapid run off rainwater away from building.

Doors, windows and rolling shutters on external walls of buildings shall be provided with sunshade with side projections .Sunshade from walls shall be minimum 750 mm over windows & doors and 1500 mm over rolling shutters.

All stairs shall have a maximum riser height of 175mm and a minimum thread width of 250mm with Aluminum nosing. Minimum width of stairs of in all building shall be 1200mm.

Stairway in a single run shall have the same slope. The vertical rise of the stairways shall not exceed 3.0m and number of riser shall not exceed 12 for a single flight.

Hand railing minimum 1100mm high shall be provided around all floors/roof openings, projections, balconies, walkways, platforms, etc. ***All hand rails, toe guard, balustrades, vertical posts& horizontal rails of RCC staircases connecting the floors& railings around openings in RCC floors shall be of Stainless steel*** . Other hand rails shall be 32mm nominal bores MS medium quality pipes and shall be coated with 2 coats of high build epoxy paints with suitable primer. Vertical spacing of landings shall not exceed 1.5m center to center. Minimum 2 numbers 32NB GI pipe shall be provided for horizontal rails and toe guard shall be provided. All rungs for ladder shall also be coated with 2 coats of high build epoxy paints with suitable primer as per specifications.

All steel platforms above grade shall be constructed with 150 wide kick plates at edge of platform to prevent tools or materials from falling off platform.

Doors shall be provided at appropriate location to prevent dust ingress from outside.

Rolling shutter size and its operating system shall be decided based on the equipment handling for erection and maintenance with a side clearance.

All windows/louvers shall be of anodized aluminum .

External cage ladder shall be provided for access to Turbine building roof. Internal cage ladder 2 nos. shall be provided to access crane walkway .

All the edge protection angles shall be coated with 2 coats of high build epoxy paints with suitable primer.

1.12.5 *Glazing*

Glazing partition wall shall be provided in areas wherever required and as approved by the Engineer.

Glazing shall be in double toughened glass with glass of minimum 6mm thickness for effective thermal insulation. Vision panel shall be minimum 4mm thick.

Windows & ventilators located on external walls above operating floors levels and those located in fire prone areas shall be provided with wired glass of minimum 6mm thickness. Windows in other areas shall be finished with 6mm thick clear glass.

1.12.6 *Flooring*

The nominal total thickness of floor finish shall be 40mm. The areas used for handing of chemicals shall be provided with Acid & Alkali resistant Lining. Wherever, special type of flooring is required due to functional requirements or mentioned in other sections, the same shall be provided.

Skirting shall match with floor finish.

1.12.7 *Roof Drainage System*

A system shall be provided for removal of water from roof surface to avoid damage to the roof structure of all buildings and shall consist of the following:

Roof Drain Heads
Rainwater down comers
Fixtures

IS:1742 code of practice for buildings drainage shall be followed for this purpose.

Multiple drains (min.2nos.) shall be provided for all roof areas. System will be designed to handle rainfall at a rate of 160 mm per hour and in accordance with stipulations of IS:1742.

1.12.8 *Plant Drain, Surface Drain & Sewer Line:*

Construction shall be done as per the system engineered by Purchaser as specified in clause 1.6.7 above . Wherever additional lines are to be laid to connect the system engineered by Purchaser, shall be designed and constructed by Bidder.

1.12.9 *External Painting*

The building shall be provided with paint on external surface matching with the plant aesthetics as specified in clause 1.11 above.

1.13 LAYOUT

Only two main centre lines and one permanent bench mark would be furnished and all other lay out, fixing levels etc. shall be done by the Contractor at his own cost. The Contractor shall protect and maintain, during the course of execution of the work, the main centre lines and bench marks, so that they are left undisturbed even after completion of his work.

1.14 ACTIVITY SCHEDULE

The successful bidder has to prepare the detailed schedule and construction procedures for all major activities and submit the same for approval before commencement of work.

The work shall commence and completed in accordance with the Construction Schedule specified elsewhere. The various phases of work shall be completed within the periods as specified in the approved construction schedule, to be submitted by the bidder. The total completion period for this contract will be as given in the tender notice attached with this tender document.

2. DESIGN SPECIFICATIONS

2.1 PROJECT SITE FEATURES

2.1.1. LOCAL GEOLOGY

Seven Boreholes BH103, RBH-104,RBH-109, BH-110, RBH-111, BH-115 and BH-116 covers Turbine Building-5.

Seven Boreholes BH105, RBH-112, BH-113, BH-106, RBH-114, BH-117 and RBH-118 exists covers Turbine Building-6.

Boreholes RBH-107 & RBH -108 covers Transformer Yard of both the units.

The representative borehole data BH-110 & BH-113 are attached as Annexure-1 for guidance. The soil/ rock samples from boreholes will be tested & relevant data will be provided to bidder subsequently.

Subsurface profile at Turbine building -5 & 6 areas generally consists of top soil followed by laterite, boulders/sand and rock as indicated in representative borehole data BH-110 & BH-113.

2.1.2. SITE GRADING

The site selected for general layout of Turbine Building and other associated structure are located in a slightly sloped terrain. This area will be excavated by the Purchaser up to the levels as indicated in drawing No KAIGA 5&6/16000/2003 /SK. However, on completion of construction, this area will have to be graded to Finished Grade Level of RL 41.300 M.

i.e. EL 99.7 M and the same is included within the scope of this tender.

The finished floor level of all the structures is fixed at EL 100 000 i.e RL 41.600 M . The site will be graded to EL 99.700 M.

2.1.3. SEISMIC, SAFETY, QUALITY & DESIGN CLASSIFICATION

The site lies in Zone-III, as per the zoning map of India [IS-1893-2002, Part-1]. The structures within the scope of this tender are seismically classified category 3, safety class NINS (Not important from Nuclear Safety) & Design Class DC-4(Non Safety class structure.

2.1.4. METEOROLOGICAL CONDITIONS

Following meteorological data should be considered for design.

a) Annual average Rainfall: 3645 mm
Maximum Intensity /Hr for 1 Hr duration: 160 mm/hr
(for design of roof drainage)

b) Wind pressures : Following 3 sec averaged extreme wind speed for different return periods upto 10m height: shall be followed in the design.

i) 100 years return period: 44.07 m/sec
ii) 1000 years return period: 62.01 m/sec
iii) 10000 years return period: 79.95 m/sec

Height (m)	Vb (m/s)	k1 values for different return periods									
		50	100	1000	10000	k2	k3	50	100	1000	10000
10.00	39.00	0.99	1.13	1.59	2.05	1.00	1.00	38.61	44.07	62.01	79.95
20.00	39.00	0.99	1.13	1.59	2.05	1.07	1.00	41.31	47.15	66.35	85.55
30.00	39.00	0.99	1.13	1.59	2.05	1.12	1.00	43.24	49.36	69.45	89.54
40.00	39.00	0.99	1.13	1.59	2.05	1.15	1.00	44.21	50.46	71.00	91.54
50.00	39.00	0.99	1.13	1.59	2.05	1.17	1.00	45.17	51.56	72.55	93.54
60.00	39.00	0.99	1.13	1.59	2.05	1.18	1.00	45.71	52.18	73.42	94.66
70.00	39.00	0.99	1.13	1.59	2.05	1.20	1.00	46.25	52.80	74.29	95.78
80.00	39.00	0.99	1.13	1.59	2.05	1.21	1.00	46.80	53.41	75.16	96.90
90.00	39.00	0.99	1.13	1.59	2.05	1.23	1.00	47.34	54.03	76.02	98.02
100.00	39.00	0.99	1.13	1.59	2.05	1.24	1.00	47.88	54.65	76.89	99.14

c) Max Dry Bulb Temp : 43.21 ^{0} C (100 year return period)
d) Minimum Dry Bulb temp : 8.25 ^{0} C (100 year return period)

e) Relative Humidity

i) Max. during monsoon : 99.9%

ii) Min. during Dec to Jan : 3%

2.2 DESIGN

The design of the structures (unless specified otherwise) given in clause 1.6 &1.7 is in the scope of the Bidder. The design of the structures shall be done by the Bidder or his design consultant as approved by the purchaser .**The designer should have experience to design of similar structures i.e minimum one Turbine Building with Turbo generator Foundation of a power plant of minimum 500 MWe capacity of any Nuclear or Thermal Power Plant in rocky site (applicable for KAIGA 5-6 only, For GHAVP experience of TG design in Soil site is essential)**. ***The designer shall be acceptable & approved by the purchaser. The credentials of Designer shall also be provided along with technical bid.***

2.2.1 PROOF CONSULTANT

The successful bidder shall appoint a proof consultant(s) with the approval of the purchaser for independent checking of the analysis, design and drawing works carried out by the bidder or his design consultant. The bidder shall provide the names of his prospective design consultants (if appointed) and proof consultants along with his bid.

It is preferred that proof checking consultants are from institutions like IIT's or any other premier organizations or experienced professionals. The proof consultant shall have experience of analysis & design of machine foundation & framed structures. The proof consultant shall be acceptable & approved by the purchaser. The credentials of Consultant (if appointed) & Proof consultant shall also be provided along with technical bid.

All design related deliverables by bidder shall bear the certification by proof check consultant regarding the documents and drawings are in conformance to codal provisions and technical specifications.

2.2.2 GUARANTEE FOR DESIGN

The bidder shall furnish guarantee against fault in the design (even though it might have been accepted by the Purchaser)of the structures covered under his scope of work. Further he shall also carry out at his cost all necessary rectification/improvements in the design of structures covered under the contract so as to make good any inadequacy arising out of above factors. The approval of Purchaser does not absolve the bidder from the overall responsibility of satisfactory performance of design & construction of the works within his scope.

2.3 DESIGN PARAMETERS AND METHODOLOGY

The following design parameters and methodology shall be followed for structural/civil engineering design of Turbine building and other structures within this contract. ***The***

fundamental principle controlling the design and construction of all the structures is to ensure that functional performance is maintained at all times upto earthquake level of zone III of IS 1893 and structural integrity against collapse is also to be maintained under the extreme loading including Safe Shutdown Earthquake condition to ensure safety of the adjacent safety related buildings viz. Control Building, SAB etc.

In principle this shall be achieved through a combination of using the best quality control standards for material and workmanship during construction and designing for all severe load combinations, whilst imparting a high level of redundancy within the structural system.

2.3.1 DESIGN PARAMETERS

2.3.1.1 SAFE BEARING CAPACITY, FOUNDING LEVEL & OTHER GEOTECHNICAL PARAMETERS:

The safe bearing capacity at founding level of any structure shall be computed based on standard codal approach/ practices considering the geotechnical parameters of the influence zone, based on dimension of structure and maximum intensity of pressure. For finalization of influence zone, the foundation profile up to a depth, where net increase in vertical pressure becomes less than 10% of the initial overburden pressure from founding level of the structure shall be considered in the analysis.

The geotechnical parameters shall be evaluated based on bore hole data obtained on ground and required field test.

The foundation of all structures and major equipment of transformer yard (SUT, UT, GT etc.) & oil separation pit, CCW Inlet & hot water tunnel, PCB & Electrical bay, Turbine Building and Turbo-generator etc. shall be taken from competent rock or supported on pile unless specifically approved otherwise by the engineer and as approved by the engineer. All other tunnel / trenches may be engineered & founded on PCC / fillcrete, unless approved otherwise and as approved by the Engineer.

2.3.1.2 MODULUS OF SUBGRADE REACTION :

Based on the preliminary investigation, the modulus of subgrade reaction shall be determined from established theories under static & dynamic condition for all the structures, considering fck of concrete as 35 Mpa.

2.3.1.3 GROUND WATER

From the recording of ground water table observed in various bore holes during site investigation, it has been established that the bore holes and trial pit water level variation within the main plant area is quite erratic. And in most of the cases it is found within 2-4 m below existing Ground level.

As the foundations are below the ground water table, de-watering will be required during construction. Suitable de-watering system shall be adopted by the bidder during construction stage to maintain the water level 1 m below the founding level. All the foundations, retaining walls etc. will be designed taking into account worst conditions of ground water hydrostatic pressure. *As per the current practice for design and stability check purpose, ground water level will be taken upto finished grade level.*

2.3.1.4 EARTHQUAKE INDUCED LIQUEFACTION

The phenomena of Landslides, Collapse, Subsidence and Liquefaction depends on the nature of ground and prevailing sub-soil water conditions. The site is not found susceptible for Liquefaction hence not to be considered.

2.3.1.5 LOADS & LOAD COMBINATIONS

The following loads shall be considered in their worse combinations as appropriate for the design of the Turbine Buildings, Ventilation Buildings, Electrical Bay, Pipe & Cable Bridge , Transformer Yard area & CCW Tunnels etc.

a) Dead Loads

Dead loads comprise of the self-weight of all permanent construction, including walls, floors, roofs, ceilings, columns, stairways, cable shafts and fixed service equipment. While estimating dead loads for the purpose of design, the unit weight specified in IS: 875 Part-1 shall be used.

b) Equipment Loads

The buildings shall house a number of equipment on various floors. The loads from these equipments shall be specified as per vendor details.

c) Live Loads

Live loads on floors shall be considered as per the following sub-sections:

d) Uniformly distributed loads

The uniformly distributed live loads assumed shall be the highest values likely to be produced. The uniformly distributed loads are static loads on the plan area and provide for normal effects of impact but do not take into consideration special concentrated loads, which are been dealt below.

e) Concentrated loads

Except for offices, toilet blocks etc. all floor slabs, secondary beams and girders etc. (other than the operating platforms near the equipment) shall be designed for a concentrated load of 10000 N acting simultaneously with the uniform live load as given

in (i) to take care of any unforeseen exigent loads. This load shall be assumed to act at points so as to result in maximum moment and/or maximum shear. However, this load shall not be considered concurrently along with any actual concentrated load given to be carried over to the main beams, columns and foundations. For floor slabs, unless otherwise specified, this load shall be assumed to act as distributed uniformly over an area of 750mm square and shall be located so as to produce the maximum stress condition in the floor slab.

f) Live load on roof

Live load on roof shall be considered, as the roof is provided with access. The following provisions as per BIS 875 Part-2 shall be followed. The minimum live load on roof that shall be considered for design is 1500 N/sq m. but not less than 3750N uniformly distributed over any span of one meter width of roof slab or 9000N uniformly distributed over the span in the case of beams or truss or wall.

g) Loads on purlins supporting the RCC roof

Every purlin shall be designed to carry the more severe of the two loads indicated below:

- The loads transmitted to the member RCC roof in accordance with (f) and
- An incidental concentrated load of 10000N placed at the most unfavorable position on the member.

h) Loading on handrails, parapets etc

Stairway railings, hand rails, parapets and balustrades, both exterior and interior shall be designed to resist horizontal thrust of 750 N/m applied at the top of the railing.

i) Loads due to impact and vibration

Structures carrying live loads, which induce impact or vibration, shall be designed for minimum increased live load as follows:

Structures	**Min. Impact Factor**	**R e f e r e n c e**
a) For light machinery, shaft or motor units.	20%	BIS:875
b) For reciprocating machinery or power units.	50%	BIS:875
c)Transformer roller loads	10%	Assumed
d)Truck wheel load	30%	Assumed

Impact and vibration load for gantry girders, monorails etc.

For crane gantry girders and supporting columns, the following allowances shall be deemed to cover all forces set up by vibration, shock from slipping of slings, kinetic action of acceleration and retardation and impact of wheel loads –

Type of load	Additional load
a) Vertical loads for electrical overhead crane (EOT)/monorails	25% of maximum static wheel loads.
b) Vertical loads for hand operated cranes/monorails (HOT)	10% of maximum wheel loads.
c) Horizontal forces transverse to the rails for electric overhead cranes.	5% of weight of the crab and the weight lifted on the crane.
d) Horizontal forces along the rails for EOT cranes.	5% of the static wheel loads.

The horizontal forces specified in (c) & (d) shall be considered as acting at the rail level.

For monorails no horizontal surge shall be considered.

j) Construction Live Load

These are the superimposed loads, which may come on a member during construction or after construction as erection loads.

k) Soil/Earth Pressure

Turbine building with C.W. Pit basement walls shall be subjected to lateral earth pressure for the portion where sides of the wall are back-filled. The walls shall be subjected to earth pressure at rest derived as per standard formulae.

l) Hydrostatic Pressure

The basement walls shall be designed considering the subsurface water pressure rising up to finished grade level, as approved by the engineer, under normal and severe environmental load combinations including Earthquake. Computation shall be based on the buoyant unit weight of the soil plus full hydrostatic pressure. The value of δ shall be taken as half the value of δ for dry backfill. The full upward pressure of water below basement floors shall be taken over the entire area.

m) Rain Loads

Design maximum intensity of rainfall for the roof is 160 mm/hr. The flat roofs shall be designed to sustain the load of rainwater that could accumulate on it during any unlikely event of roof drain blockage. The maximum accumulated height of water shall be assumed as 300mm over roof drain and 150mm over roof slab. Rain load and live load on roof shall not be considered to act simultaneously and more critical of the two shall

be adopted in the design.

n) Wind Loads

The design wind speed (Vz) shall be computed in accordance with BIS:875 (Part-3).

The relevant normal loadings to be considered in combination with wind load as stated above shall comprise of the full dead load and the reduced percentage of live loads as applicable, together with live loads on roof. For structural design 100 year return period of wind shall be considered.

o) Seismic Loads

Since no safety related systems are located in turbine building and other associated structures, but due to provision of MSIV on PCB, the seismic classification has been kept as NINS and structure design is to be done as per codal provisions of IS 1893.However, the structural integrity against collapse is also to be maintained for all the structures under the extreme loading (SSE) condition to ensure safety of the adjacent safety related buildings viz. Control Building, SAB etc.

The elements of the structures shall be checked considering the SRSS values of responses due to all the three ground motions acting concurrently.

At KAIGA 5&6 site, for SSE condition the digital value of Response spectra shall be given at a later stage.

The relevant normal loadings to be considered in combination with seismic load (SSE) shall comprise of the full dead load and the following percentages of live loads:

Load Class	Percentage of Design Live Load
Staircase & balconies	25%
Uniformly distributed live loads 4000 N/sq.m. and above	50%

Under earthquake conditions the structure shall be assumed as loaded with the above-reduced percentages of live loads and the roof with no live load . Self wt. of EOT cranes shall be considered without any lift load.

Active earth pressure distribution due to submerged backfill on the basement walls during an earthquake shall be as per the provisions of BIS:1893. Also active pressure due to uniform surcharge over backfill behind basement walls shall be obtained as per BIS:1893. For saturated earthfill, the saturated unit weight of the backfilled soil shall be adopted. For submerged earthfill, the dynamic increment in active earth pressure during earthquakes shall be found using Mononobe-Okabe formulae which has been furnished in of BIS:1893and also recommended in ASCE 4-16.

p) Crane Load:

The maximum load while lifting the test load shall be considered . However this shall not be considered during the seismic condition.

q) Surcharge:

Unless specified otherwise, a surcharge (Minimum 2 T/SQM) shall be considered in the design on account of movement of equipment, traffic, stacking of material , crane etc. on the ground adjacent to structures .

r) Internal Pressure (In case of Pressure Tunnels)

The internal water pressure in the tunnels including the surge & shut off condition shall be considered in the design appropriately as specified in Section C-2-5.

s) **Any Other Load:**

As applicable the load due to temperature, creep, shrinkage etc shall be considered in the design following the relevant codal provisions.

t) Combination Of Loads

The turbine buildings and other structures shall be designed for worst combination of the loads specified above and any other loads as applicable. The suitability of the design shall be checked for load combinations to satisfy the Limit state of serviceability & Limit state of strength / Collapse as defined below:

i) Limit state of Serviceability :

Load combinations under this category are unfactored (or as given in Table-18 , BIS:456 for Limit State of Serviceability) and shall be used to ensure the requirements of limit state of serviceability of the structure. For CCW Tunnels relevant requirements specified in the AWWA standards and requirements specified in C-2-5 shall be met.

ii) Limit State of strength/ Collapse:

Load combinations for design under this category are factored and shall be used to ensure that no applicable limit state of failure is exceeded and stresses in the structure are well within its permissible limits . The structural elements to grouped into a number of groups and the basic loading combinations applicable to each of these groups shall be applied . The load factors applicable for the various load combinations shall be based on the combination philosophy of BIS:456, except for the Extreme Environmental load combination. No load factors for extreme environmental load (SSE) combination has to be considered.

All loads with appropriate load combinations shall be considered to act with the corresponding load factor. The most unfavorable effect on the structural element shall

be considered for design. In the load combinations, under Severe Environmental and Extreme Environmental condition, the earthquake and the wind loads are considered not to act concurrently. Moving loads such as those of monorail hoists, EOT crane together with the loads lifted are considered only for normal load combinations. In other combinations their static load effects without the loads being lifted are to be considered. Loading effects due to truck or transformer movement are to be considered under normal load combination. Construction load shall be combined with dead load only.

For CCW Tunnels relevant requirements specified in the AWWA standards and requirements specified in C-2-5 shall be met.

2.4 Submission of design report

The analysis shall be carried out using NISA, ANSYS, ABAQUS, SAP, which has been validated. The bidder shall make copies of all the analysis & design documents available to the owner in required numbers as desired by the purchaser.

2.5 ANALYSIS AND DESIGN

Prior to carrying out actual analysis, the structural analysis software needs to be validated by solving some benchmark problems.

2.5.1 F.E. Modelling & Design of Turbine Building, Electrical Bay, PCB, Access Bridge &Transformer Yard

The structures should be idealised as a 3D framed system. Raft, Pile(if applicable) Columns, beams and slabs should be modeled using suitable finite elements available in the structural analysis software to be used. Commercially available software for structural analysis like NISA, ANSYS, ABAQUS, SAP etc.

3D static analysis has to be done to obtain the member forces due to the static load conditions.

To obtain the member forces due to earthquake, response spectrum analysis with 3-D model of the structure has to be performed using the response spectra as per IS 1893. For collapse study under SSE, the response spectra shall be given at a later stage.

2.5.2 TG BLOCK

The TG block consists of top deck, columns, intermediate platforms and TG mat. Top deck supports the turbine, generator and the exciter. The columns of TG pedestal, independent columns supporting the platforms, some internal columns and pit walls are supported on the TG mat.

The design of TG block shall be based on working stress method. The permissible stresses in concrete and reinforcement shall be based on IS: 456 and IS: 2974 (part-3). In addition to functional requirement mentioned above codal requirements of IS: 2974 (Part-3) shall be satisfied. Some of the important requirements are listed below:

- The base mat shall be so dimensioned that the resultant force due to weight of the machine, the top deck, intermediate floors/platforms, columns supporting the TG deck, equipments and supporting structures resting on mat, basement walls resting on the mat etc., shall not have eccentricity with respect to the centre of gravity of the base area more than 3% of the base dimensions in the direction of the eccentricity.
- Adequate haunches shall be provided at intersections of the beams and the columns to avoid large concentration of stresses and to increase general rigidity of the frame.
- Fundamental natural frequency of the TG block in horizontal direction shall be separated by a minimum of 20% of the operating speed and fundamental natural frequency in vertical direction shall be separated by 50%.
- Minimum reinforcement for the deck beams shall be 0.25% of the sectional area at top and bottom and 0.1% of sectional area at sides.
- Allowable bearing pressure on soil/rock shall be 80% of allowable safe bearing pressure on soil
- For grouting of machine bed plates and pockets for anchor bolts, non-shrink grout shall be used.
- TG block should have adequate strength to withstand the worst combination of static, dynamic and seismic loads.
- Raft should be rigid enough to ensure fixed end conditions for the columns and prevent non-uniform settlement. If required , the Piles shall be provided under the raft.
- The natural frequency of the machine foundation system to be such as to avoid resonance at operating speed of the turbo-generator and the amplitude of displacements or any other specific criterion specified by the Turbine / Equipment Manufacturer.

2.5.3 Tunnel Trenches

The Tunnels are to be designed for the worst combination of loads considering Internal water pressure , wherever applicable (Considering Surge both positive & negative pressure & Shutoff Pressure), Earth Pressure (considering fully saturated soil conditions) , Surcharge, Seismic Loads, Loads from vehicular movement over tunnels and any other additional loads etc. as applicable. The support for tunnel shall be properly modeled considering the springs or any other elements as the case may be. The suitability of design shall be checked for completely filled as well as in its empty condition etc. also.

The tunnels are to be designed meeting requirements specified in IS 3370 .

2.5.4 SPECIFIC REQUIREMENTS

2.5.4.1 FIRE RATING & CORROSION

The Turbine building& other associated structures in the scope of this tender will have to cater the fire rating specified in Section C-1-3, unless approved otherwise. The following minimum dimensions and clear covers shall be provided.

Element	Parameter	Minimum Dimension (mm) for Resistance Period			
		1 hour	2 hour	3 hour	4 hour
Column	Side	200	300	400	450
	Cover	25	35	35	35
Load	Thickness	125	150	200	250
bearing	Cover	15	25	25	25
wall					
Slab	Thickness	100	125	150	175
	Cover	15	25	35	45
Beam	Width	125	200	250	275
	Cover	30	60	70	80

Note: Covers indicated relate to main reinforcing bars. Floor finishes shall be taken as part of clear cover for top reinforcement in beams and slabs . Fire rating requirements will not govern for secondary structural elements like lintels, transoms, mullions and canopies. Weld mesh shall be provided wherever cover is more than 40 mm.

2.5.4.2 EMBEDDED PARTS (EP)

These shall be designed for maximum forces arising out of Operating condition and Earthquake (codal) condition**.** It may be noted that the usage of Cinch anchors for anchoring any equipment is prohibited unless specifically permitted by the engineer. Therefore the bidder should provide adequate number of EPs for fixing the equipment and services. However, anchors less than 6 mm dia may be used to provide electrical fixtures etc.

3. CLEARING AND EXCAVATION

3.1 GENERAL

SCOPE OF WORK :

The excavation of site will be carried out within the terminal points of this package by the Purchaser as indicated in the drawing no KAIGA 5&6/16000/2003 /SK. However, additional excavation, if any required from functional reasons due to system requirements or due to geotechnical reasons , shall be carried out by the contractor at his own cost. Wherever, the founding levels are lower than the levels specified in above drawing the ground shall be lowered by bidder using appropriate cutting tool like , rock breaker, chisel etc. which does not disturb and damage the adjoining structure and also do not have any adverse effect on the existing works being executed by other contractors in adjoining areas. The excavation using controlled blasting may be resorted in specific cases with prior approval of Engineer. The over excavated / damaged improved ground, if any, shall be made good by the bidder at his own cost. Schedule of the additional excavation and backfilling shall be finalized in consultation with PURCHASER. Bidder must schedule his excavation and other activities considering the status of construction & schedule of construction of adjoining structure. Contractor shall make necessary arrangement for Dewatering alongwith stand by arrangement at his own cost. The contractor has also to make necessary arrangements for side protection to avoid any slippage of rock/ soil etc. at his own cost. No extra payment will be made to remove any of slipped rock/earth etc in the excavated area. The contractor is also requested to visit the site prior to quoting & satisfy himself with the actual site conditions. In case further excavation is required, the same shall be carried out as per following specifications.

A) This section covers all the excavation works to be performed under this contract which shall consist of clearing of site and excavation of all existing material of whatever nature, to the lines and grades shown on the construction drawing or as otherwise directed by the engineer. The work shall also include drilling and blasting, loading, hauling and disposal of materials in designated spoil, stockpile areas or directly as construction materials.

B) The contractor shall also be responsible for excavation which is not specifically required for the construction of permanent structures, but incidental to the installation of temporary facilities such as site roads, approach ramps etc.

C) Slope protection and stabilization measures, which may be needed in conjunction with surface excavation work, shall be carried out as defined in other sections of these specifications.

D) The approval given by the Engineer during the course of execution, to the contractor's methods and equipment shall not relieve the contractor of his full responsibility for the proper and safe execution of excavations, or of liability for injuries to, or death of persons, or any other obligations under this contract. It shall also not relieve his

responsibilities for the accuracy or adequacy of the plan for obtaining the desired results in the stipulated time schedule.

3.2 SUBMITTALS

A) The contractor will be required to submit along with the bid, a detailed method statement, drawings and work programme for the excavation. The method statement has to give the details on the plant and equipment proposed to be used by the contractor for excavation and haulage, blasting methods, drainage and safety precautions, disposal of material, procedures for installation of rock supporting and stabilization works, and for construction of temporary site facilities such as roads, temporary drainage lines etc.

B) After the award of work and at least 15 days prior to commencement of the actual excavation, the contractor shall submit to the Engineer an updated method statement and programme for the activities set out in (A) above giving refined and full details of the proposed excavation methods in soil as well in rock and sequences including necessary plans for site drainage and safety precaution. Any and all variations from the corresponding data submitted with the tender will be explained and justified in the updated document to the satisfaction of the Engineer. The data shall include the following:

i) Method for excavation in soil & soft rock
ii) Location and area of blast
iii) Diameter, spacing, depth, pattern and orientation of blasting holes
iv) Type, strength, amount, column load and distribution of explosives to be used per hole, per delay and per blast.
v) The type of detonators, powder factor and sequence and pattern of delays to be used for blast.
vi) Description and purpose of any special methods of equipment to be adopted by the contractor.
vii) Type & No. of PPV measuring equipments along with methodology of measurements.
viii) No. of blast per day.
ix) Method of mucking & disposal of excavated material.
x) Details of the equipment to be deployed with proper justification.

C) Within 7 days of receipt of the above updated excavation method statement and programme, the Engineer will advise the contractor in writing, of his acceptance of, or comments on the submitted documents. The Engineer reserves the right to reject the proposed plan, if, in his opinion, undesirable damage to permanent rock surfaces or existing structures would result from the proposed blasting action. If acceptance is withheld, a new plan in whole or in part shall be submitted. Excavation shall only be carried out in areas for which the Engineer has accepted the plan.

D) At least 15 days prior to dumping and stock piling any excavation material, the contractor shall submit the layout of spoil or stock pile areas which will be within the areas designated on the tender drawings or as approved by the Engineer. All pertinent data of working methods and provisions for stability and temporary and permanent

drainage of the areas shall be included. Details of volume proposed to be stored, material types, heights of storage and grades shall be provided.

E) The Contractor shall submit and agree with the Engineer a monitoring plan for the progress of the excavation as well as to observe potential or actual movement of the slopes of the excavated pit. This plan shall also give details of the procedure and equipment to be employed by the contractor to stabilize or to protect as quickly as possible any areas in which untoward movement or slope deformation is likely to occur or has occurred.

3.3 CLEARING THE SITE

All the areas upon which the construction is to be carried out and over which excavation is to be done and areas which are required by the Contractor for his construction facilities are to be cleared of all rubbish, stumps, roots, bush, vegetation etc. and any other objectionable matter. Stumps, roots shall be removed to the full depth wherever possible but at least 450 mm below original ground level. Trees, if any, shall not be uprooted or cut without the prior approval of the Engineer. All spoils and unserviceable materials and rubbish shall be disposed of at locations away from the work site in a manner directed by the Engineer. Care shall be taken to see that unsuitable waste materials are disposed off in such a manner that there is no likelihood of these getting mixed up with the materials meant for construction. Useful materials, saleable timber, firewood etc., shall be stacked properly at the work site in a manner directed by the Engineer and finally handed over to NPCIL.

3.4 LAYOUTS AND LEVELS

Under no circumstances shall the contractor remove or disturb any permanent benchmarks / reference pillars installed by NPCIL. The contractor shall carefully maintain and protect all benchmarks and reference pillars and shall layout all his works by accurate reference thereto. The layout and levels of all structures shall be made by the Contractor from the general grid of the plot and bench marks given by the Engineer. The Contractor shall make his own surveying arrangements for laying out and establishing the reduced levels based on two reference grid lines and one bench mark as furnished by the Engineer and shall be responsible for the accuracy of layout and levels.

The theodolite and leveling instruments to be used by the Contractor shall be of digital type (total station). He shall also render necessary assistance to the Engineer by way of surveying instruments, materials and men for checking the layout and levels.

The ground level shall generally be taken at spacing at a grid of 5m x 5m.Where local mounds or abrupt undulations are met with or when so directed by the Engineer, the grid spacing may be at closer interval not exceeding 2m. The ground levels shall be properly recorded and plotted on plans, which shall be signed by the Contractor and the Engineer before the earthwork actually commences.

3.5 EXTENT OF EXCAVATION, LINES AND GRADES

The contractor shall perform excavation in all types of soils, murrum, soft and hard rock, boulders etc. in foundation, over areas and in trenches to widths, lines, levels, grades and curves as shown in the drawing or to lesser widths, lines and levels as directed by the Engineer. The Contractor shall clear the following work areas required for the performance of the work:

- Area of buildings / structures covered under the scope of this contract.
- All areas where backfill or grading as specified, including stacking yard and disposal areas as well as road formations within the points as specified in the drawings.
- Areas proposed to be occupied by Contractor for his plant and machinery, offices and camps.
- Any other area specified by the Engineer.

3.6 APPLICABLE CODES

The following Indian Standard Codes, unless otherwise specified herein, shall be applicable. In all cases, the latest revision of the codes shall be referred to:

a) IS-3764 - Safety Code for Excavation Work.

b) IS:9758 - Guidelines for de-watering during construction.

c) IS:10379 - Code of practice for field control of moistures and compaction of soils

d) Indian Explosives Act 1940 (Latest Version)

e) IS-2720 - Part-II - Determination of water content.

Part-VII - Determination of water content. - Dry Density Relation Using Light Compaction.

Part-VIII - Determination of Moisture content - Dry Density Relation Using Heavy Compaction.

Part-XXVIII - Determination of Dry Density of Soils, In-place, by the Sand Replacement Method.

Part XXIX - Determination of Dry density of Soils, In place, by core cutter method.

f) IS-4081 - Safety Code for Blasting and Related Drilling Operation.

g) IS-1200 - Method of Measurement of Building Works.

3.7 EARTHWORK EXCAVATION -GENERAL

Excavation shall be done to lines and levels defined in the drawings or as directed by the Engineer. *A drawing indicating the bore logs is attached in the tender.* The earthwork shall also include, where required temporary sheet piling or sheeting, bracing and shoring, to maintain the excavated pits, without interruptions to service lines, cables, duct banks, etc., encountered within the area of excavation or within reasonable distance of excavation.

3.7.1 LIMITS OF EXCAVATION

All excavation shall be carried out very carefully using methods and techniques that will produce smooth and sound rock surfaces with minimum over-break and fracturing beyond the lines and grades/ limit of excavation shown in the construction drawings and will preserve the structural integrity of the excavated area. The contractor shall take all precaution to preserve in the soundest possible and undisturbed condition all materials beyond the limits of excavation. Special care shall be exercised where vertical or near vertical faces are required. The excavation of final 150 mm thick layer shall be carried out with special care as directed by the Engineer, to ensure that the there are no major protrusions and major over cuts. In rock excavation, an over break limit of 150 mm in local spots may be allowed only on sides. Any extra excavation shall be made good by the contractor at his own cost with the class of material proposed to be laid over it or any other material approved by the Engineer.

Soft pockets, if any, shall be removed even below the final level and extra excavation shall be filled up by material which is proposed to be laid over it or any other material approved by the Engineer.

3.7.2 CLASSIFICATION OF EARTH WORK

For purposes of work to be executed in accordance with this specification, the following classification shall apply.

A) All types of soils, murrum, loose boulders of size with volume up to 1 cum, intrusions and soft rock
B) All types of rock and boulders with volume beyond 1 cum.
C) Dental Excavation

The excavation work shall further be categorized in the following 3 categories:

A) Excavation in General Areas & grading work up to grade level.
B) Excavation for buildings /structures foundations below grade level.
C) Excavation for Tunnel & trenches etc., below grade level

3.7.3 EXCAVATION IN SOIL

This includes earth, murrum, top deposits of agricultural soil, reclaimed soil, clay, sand or any combination thereof, soft and hard murrum, shingle etc. which is loose enough to be removed with spades, shovel, pick axes, poclain & poclain mounted rippers. Boulders in all volumes up to 1 cu.m, found during the course of excavation shall also fall under this classification. This shall also include all materials, hard conglomerate, all decomposed weathered rock, highly fissured rock and other varieties of soft rock, which can be removed with pick axes, crowbars, wedging and hammering & other mechanical equipment with some difficulty. The mere fact that the contractor, for reason of his own, resorts to blasting and/or wedging and chiseling for excavation shall not mean the rock is classifiable as hard rock.

When the bottom of the excavated pit as indicated in the construction drawing is disturbed or loosened by the excavation process, the contractor shall improve it at his own cost with the class of material proposed to be laid over it or any other material approved by the Engineer.

3.7.4 EXCAVATION IN HARD ROCK

This includes all rock other than materials mentioned above, occurring in masses, boulders having approximate volume more than 1 cum., which can best be removed only by blasting, hydraulic splitting, chiseling and wedging (where blasting cannot be permitted owing to any restriction at site). The total excavation work in hard rock shall be categorized in the following 4 categories:

a) Excavation in hard rock using general and free blasting
b) Excavation in hard rock using controlled blasting
c) Excavation in hard rock by blasting using mufflers (muffled blasting).
d) Excavation in hard rock without blasting i.e. by wedging / barring / hydraulic splitter.

3.7.5 STRIPPING BLUFFS AND LOOSE ROCK

All loose boulders, semi-detached rocks not directly in the excavation but close to the area to be excavated as to be liable, (in the opinion of the Engineer), to fall or otherwise endanger the workmen, equipment, or the work etc. shall be stripped off and removed away from the areas of excavation. The method used shall be such as not to shatter or render unstable or unsafe the portion, which was originally sound and safe. Any materials not requiring removal as contemplated in the work, but which, in the opinion of the Engineer, is likely to later become loose or unstable shall also be promptly and satisfactorily removed as directed by the Engineer.

3.7.6 APPROACH RAMPS/ROADS

The contractor shall adopt method of mucking by clamshell, dragline or conveyors. However only under exceptional circumstances where ramps are unavoidable, the Contractor may provide the same with the prior approval of the Engineer. Berms, if

required at intermediate levels may be provided beyond 6-m depth with the prior approval of the Engineer. Such ramps shall be excavated later and the excavation shall be finished to the lines and grades shown on the approved drawings and to the satisfaction of the Engineer. No extra payment shall be made for formation of such berms , ramps etc. The berms , ramps falling outside the line of excavation shall be made good after the completion of work as directed by the Engineer.

3.8 STABILITY OF EXCAVATION

The methods of excavation shall, in every case be subject to the approval of the Engineer. The Contractor shall ensure the stability and safety of the excavations, adjacent structures, services and the works. The Contractor shall ascertain himself the nature of materials to be excavated and difficulties likely to be encountered in executing the excavation. Coffer dams, sheeting and shoring, bracing and maintaining suitable slopes, draining etc. shall be provided and installed by the contractor. The contractor shall submit drawings to the Engineer showing the proposed arrangement with detailed design calculations and shall obtain written approval from the Engineer. Irrespective of the approval of the Engineer, the responsibility for adequacy of such measures shall rest fully with the contractor.

If any slip occurs, the Contractor shall remove all the slipped material from the excavated pit, at his own cost. Also, if any damage to the built up structure occurs because of the slip, the Contractor shall make good the same at his own cost & to the satisfaction of the Engineer.

3.8.1 TIMBER SHORING

Timber shoring shall be as specified in IS: 3764-Safety Code for Excavation Work. Wherever the shoring is required for deep excavations, the same shall be designed by the Contractor and got approved by the Engineer prior to its use in the work

Timber shoring shall be 'Close' or 'Open' type, depending on the nature of soil and the depth of pit or trench. The type of shoring shall be as approved by the Engineer.

3.8.2 OPEN TIMBERING

In the case of open timbering, the entire surfaces of the side of trench or pit are not required to be covered. The vertical boards of minimum 25 cm x 4 cm sections shall be spaced sufficiently apart to leave unsupported strips of maximum 50 cm average width. The detailed arrangements, sizes of the timber and the spacing shall be subject to the approval of the Engineer.

3.8.3 CLOSE TIMBERING

Wherever so directed by the Engineer the contractor shall provide close timbering

3.8.4 LEFT IN SHORING

If the Engineer directs any timbering to be left in for the safety of the structure or otherwise for reasons commensurate with the type of construction, necessitating such decision, the same shall be provided by the contractor.

3.8.5 REMOVAL OF SHORING

The removal of shoring timber shall be done very carefully to prevent the collapse of the pit or trench. It shall start at one end and proceed systematically to the other end. No part of the work should be damaged during the removal of the shoring. No claim shall be entertained for any shoring, which cannot be withdrawn and is lost and buried.

3.9 EXCAVATION IN HARD ROCK

Excavation in hard rock shall generally be carried out by blasting. If, due to proximity of structures or due to other reasons, blasting is not possible or permission for blasting is refused by the Engineer, the excavation shall be carried out by chiseling, wedging, picking, barring, hydraulic splitting, burning & sudden quenching or by other approved methods.

3.10 LINE DRILLING

Where shown on the drawings or specified by the Engineer, vertical faces of excavations shall be formed by line drilling. Line drilling is defined as a single row of unloaded holes drilled along the excavation line, spaced no more than 2 to 4 times the hole diameter on the centers.

The diameter of the holes for line drilling shall be 50 mm or more. The maximum spacing of the holes shall be 150 mm when the diameter of the hole is 60 mm or less. When the line-drilled holes are greater than 60 mm in diameter, the spacing of the holes may be increased suitably by conducting suitable mock-ups wherein the diameter of the hole and spacing may be varied to arrive at suitable spacing. No additional payment shall be made for such mock-ups.

All vertical faces shall be line drilled to prevent damage to the rock beyond the limits of the excavation. The blast holes directly adjacent to the line drilled holes shall generally be loaded with less amount of blasting material and shall be closely spaced than other holes in the primary pattern. The distance between the lines drilled holes and the directly adjacent blast holes shall be 50 to 75 per cent of the normal burden..

3.11 PERIMETER DRILLING AND PRE-SHEARING

Where shown on the drawings or specified by the Engineer, vertical faces of excavation shall be formed by perimeter drilling and pre-shearing to the dimensions shown on the drawings. Within 1 m of corners, the hole spacing shall be reduced by drilling intermediate holes so that satisfactory and high quality excavation lines are maintained at corners. These intermediate guide holes may or may not be loaded.

The Contractor shall carry out trials prior to commencing actual perimeter drilling and pre-shearing to determine the correct spacing of the drill holes and amount of explosives required per hole to permit the rock to shear cleanly between the holes.

The spacing of holes may vary from 300 mm to 750 mm depending on the rock characteristics and the amount and type of explosives placed in the holes, so that the rock will break cleanly between the holes with a minimum of shattering of rock on the exterior faces of the excavation. Such experimental blasting shall not be separately paid for.

All pre-shearing of vertical faces shall be carried out by the Contractor prior to blasting the interior pattern holes of the excavation so that a sheared line will be established on all vertical faces around the perimeter of the excavation. Perimeter drilling and pre-shearing shall be carried out to the full depth of the vertical faces of the excavation.. If, the depth of excavation exceeds 6m, the pre-shearing may be done in stages subject to the approval of engineer & without any extra cost.

3.12 DENTAL EXCAVATION

A) Dental excavation shall include the removal of unsuitable materials from shear zones, clay seams, pockets, joints or from spaces between boulders beyond the lines of excavation shown on the construction joints which are too small to be excavated by common earth moving equipment.

B) Dental excavation, depending upon its extent will require the use of back-hoe or other small excavating equipment as well the use of high velocity air water jet. The methods deployed shall be such as to avoid fracturing of the adjacent rock.

Where directed by the Engineer, the contractor as stipulated above shall carry out dental excavation. The extent to which such materials shall be removed including depth, direction and other dimensions will be determined by the Engineer. In general, depth shall be more than the width of the seam. Dental excavation shall not be carried out by blasting. Such excavated pits shall be backfilled with concrete or shotcrete as decided by the Engineer..

3.13 BLASTING

A valid blasting license shall be obtained by the Contractor from authorities concerned for starting any blasting work. The Contractor shall employ a competent and experienced supervisor (called Man-in-Charge) preferably having experience in mining operation and licensed blaster. They shall be held personally responsible to ensure that all safety regulations are followed.

Before any blasting is carried out, the Contractor shall intimate the Engineer and obtain the written approval of the Engineer & safety officer of NPCIL for resorting to blasting operations. Contractor shall intimate the hours of firing charges, the nature and quantum of explosives proposed to be used. Blasting shall generally be carried out at

certain specified hours preferably early morning, during mid-day lunch time and/or at the close of work before sunset. The hours when blasting will be carried out shall be made known to people in the vicinity. In general, the contractor shall resort only to electric blasting and shall use dynamite or gelatin sticks.

Before starting blasting, the area shall also be encircled by red flags planted 200 m from the zone of blasting. All persons including workman shall be evacuated from the encircled flagged area at least 10 minutes before firing. A warning whistle/ siren shall be sounded for this purpose. The Contractor shall be responsible for any accident to workmen, public or property due to unsafe blasting operation.

3.13.1 EXPLOSIVES

The Contractor shall acquaint himself with all the laws, and regulations concerning, purchasing, transporting, storing, handling and use of explosives. All such laws, regulations, rules and safety codes, etc. as are prevailing from time to time shall be binding on the Contractor.

The provisions detailed in this specification are supplementary to the above laws, rules and regulations. Further, the Engineer may issue modifications, alterations and new instructions from time to time.

All materials such as explosives, detonators, fuses, tamping materials etc. that are proposed to be used in the blasting operations shall have the prior approval of the Engineer.

The Engineer may render necessary help to the Contractor to obtain license for explosives. However, it is the Contractor's responsibility to obtain the license, paying the necessary fees etc.

Gelatin, Dynamite, ANFO and such other safe explosives shall only be used wherever possible. Explosives with nitroglycerine shall be used only under exceptional circumstances with prior approval of the Engineer.

The Contractor shall clearly indicate the type and grades of explosive, he proposes to use for blasting for different type of work under different conditions and the same shall be approved by the Engineer before commencement of work. Special gelatin 80% and open cast gelignite are the explosives recommended for most type of excavation. In damp rock, high explosives like special gelatin shall be used. Where especially hard rock is encountered or exceptionally good fragmentation is required, special Gelatin 90% may be used.

For initiation, electric detonators (instantaneous and short delay), 'Cordtex' Detonating Fuse and detonating relays may be used. Electric short firing is preferred.

The detonators used shall be capable of giving effective blasting of the explosives. All the damaged detonators shall be discarded.

The explosives shall be exploded by means of a primer, which shall be fired by a fuse instantaneous detonator (FID) or other approved cables. The detonators with FID shall be connected by special nippers.

3.13.2 STORAGE OF EXPLOSIVES

The Contractor shall have to make necessary storage facilities for the explosives as per rules of the local authorities and the Govt. of India.

The Contractor shall build a magazine for storing the explosives. The site of the magazine, its capacity and design shall be subject to the approval of the Engineer and the Inspector of Explosives before the construction is taken up. As a rule, the explosives shall be stored in a clean dry, well ventilated, bullet-proof and fire-proof building at an isolated site as approved by the Engineer / Inspector of explosives.

The explosives, detonators and fuses shall each be separately stored in accordance with relevant Govt. rules.

3.14 MAINTENANCE OF EXPLOSIVE MAGAZINE

The Contractor shall keep a careful and day-to-day account of the use of explosives in an approved register and in an approved manner. The register shall be produced by the Contractor for inspection of the Engineer whenever so required by the latter. The Engineer may also pay surprise visits to the storage magazine. In case of any unaccountable shortage of the explosives or if the account is not found to have been maintained in a manner prescribed by the Engineer, the Contractor shall be liable to be penalized. The action taken under this clause shall be in addition to that, which might be taken by the competent civil authorities in a court of law.

The magazine shall, when not in use by authorised person, be kept well and securely locked and guarded.

The magazine shall at all times be kept scrupulously clean. No unauthorised person should at any time be admitted inside the magazine.

The magazine shall not be opened during or on the approach of thunderstorm and no person shall remain in the vicinity of the magazine during such periods. Magazine shoes without nails shall, at all times be kept in the magazine and a cement trough 30 cm high and 45 cm. in diameter, filled with water shall be kept near the door of the magazine. Persons entering the magazine must put on magazine shoes, which shall be provided by the Contractor for the purpose. They will also:

1. Not put their feet on the clean floor unless they have the magazine shoes on.

2. Not allow the magazine shoes to touch the ground outside the clean floor.

3. Not allow any dirt or grit to fall on the clean floor.

Person with bare feet shall, before entering the magazine, dip their feet in water and then step direct from the tub over the barrier (if there be one) on the clean floor. A brush or broom shall be kept in the lobby of the magazine, for cleaning out the magazine on each occasion it is opened, for the receipt, delivery or inspection of explosives.

Matches, lighters or inflammable material shall not be allowed inside the magazine. Light shall be obtained from an electric storage battery lantern

No person having articles of steel or iron on him shall be allowed to enter the magazine.

Oily cotton rags waste and articles liable for spontaneous ignition shall not be allowed inside the magazine.

Workmen shall be examined before they enter the magazine to see that they have none of the prohibited articles.

No tools or implements other than those of copper, brass, gunmetal, or wood shall be allowed inside the magazine. All tools shall be used with extreme gentleness and care.

Boxes of explosives shall not be thrown down or dragged along the floor, and shall be stacked on wooden trestles. Where there are white ants, the legs of the trestles should rest in shallow copper, lead or brass bowls containing water. Open boxes of dynamite shall never be exposed to the direct sun rays.

Empty boxes or loose packing material shall not be kept inside the magazine.

The magazine shall have a lightning conductor, which shall be got tested at least once in six months by an officer authorised by the Engineer. The Contractor shall, within 15 days, comply with all recommendations made by the officer testing the lightning conductor.

A notice shall be hung in the lobby of the magazine, prohibiting entrance of unauthorised people.

The following shall be hung in the lobby of the magazine:

a) A copy of rules both in English, Hindi & in the language which the workers concerned is familiar with.

b) A statement showing the stock in the magazine at the particular time.

c) The certificate showing the last date of testing of the lightning conductor, and

d) A notice that smoking is strictly prohibited.

The magazine shall be inspected at least twice a year by an officer representing the engineer, who shall see that all the rules are strictly complied with. He shall notify all

the omissions to the Contractor who shall rectify the defects within a period of 15 days from the date of receipt of the notice.

3.15 TRANSPORT OF EXPLOSIVES

For the transport of the explosives and detonators between the store and the site, approved mobile explosive van shall be used.

3.16 DISPOSAL OF DETERIORATED EXPLOSIVES

All deteriorated explosives shall be disposed of in an approved manner. The quantity of the deteriorated explosives to be disposed off shall be intimated to the Engineer, prior to its disposal and record thereof shall be maintained.

3.17 PERSONNEL

Excavation by blasting will be permitted only under the personal supervision of approved competent person and licensed blasters having minimum five years of mining experience and trained workmen.

All supervisors and workmen in charge of make up, handling, storage and blasting work shall be adequately insured by the Contractor.

Storage shall be, handled by a very reliable person approved by the Engineer. The Engineer may, if necessary conduct police inquiries as to his reliability, antecedents etc. The Contractor shall have to produce a security for the person in-charge of the explosives, if and when required by the Engineer, or to the civil authorities of the district.

The Contractor shall make sure that his supervisors and workmen are fully conversant with all the rules to be observed in storing, handling and use of the explosives. It shall be ensured that the supervisor in charge is thoroughly acquainted with the details of handling of explosives and blasting operations.

3.18 PREPARATION OF PRIMER

The primers shall not be prepared near open flames or fires. The work of preparation of primers shall always be entrusted to the same personnel involved in blasting and shall be supervised by the respective shift supervisor. Primers shall be used as soon as possible after they are ready.

3.19 CHARGING OF HOLES

Holes for charging explosive shall be drilled with pneumatic drills, the drilling pattern being so planned that rock muck produced due to blasting can be handled without necessity of secondary blasting. Pattern of drill holes shall be got approved by the

Engineer. The work of charging shall not commence before all the drilling work at the site is completed, and the supervisor has satisfied himself to that effect by actual inspection.

While charging, open/naked lamps shall be kept away.

Only wooden tamping rods, without any kind of metal on them, shall be allowed to be used. The tamping rods shall have cylindrical ends. Bore holes must be of such a size that the cartridge can easily pass down the hole.

Only one cartridge shall be inserted at a time and gently pressed home with tamping rod - sand or clay or other tamping material used for filling the rest of the hole shall not be tamped too hard.

3.20 BLASTING OPERATIONS

Under all conditions of excavation, explosives like gelatin with detonator shall be used. In under-water or excavation with substantial seepage causing accumulation, an electric detonation shall be used.

Holes for charging explosives shall be drilled with pneumatic drills, the drilling pattern being so planned that rock pieces after blasting will be suitable for handling without secondary blasting. The pattern and orientation of drilled holes shall be such as to prevent flying of rock pieces. The inclination of the holes shall be towards the non-developed/ unpopulated area of the site. The pattern of drilled holes shall be approved by the Engineer.

The blast material shall be of best make and as approved by the Engineer before actual use. Quantity of charge, spacing of holes, depth of holes etc. shall be determined based on suitable mock ups. The depth of hole may generally be 1.5 m but shall not exceed 6 m. The diameter of the hole may vary from 30 to 100 mm and the spacing of holes may vary from 1.2 m to 1.8 m in both directions.

When the drilled hole encounters water, the charge shall be fed into a steel tube or a plastic tube and inserted to the bottom of the hole.

3.21 CONTROLLED BLASTING

Where shown on the drawing or specified by the Engineer as a part of controlled blasting line drilling and or pre-shearing, may also have to be adopted for reducing over break and for preventing damage to rock beyond the limits of excavation. As a part of control blasting the PPV limitations given in clause 3.23 & 3.24 shall be followed. Wherever specified or directed by Engineer, to avoid the flying of stones, following protective measures must be followed while blasting.

3.22 PROTECTIVE MEASURES

Wherever specified and as directed by the Engineer, the following protective measures shall be adopted while carrying out blasting operations (under muffled blasting) to avoid flying of stones :

a) The hole shall be covered with 0.6 to 1.0 sq.m., mild steel plate of minimum 6 mm thick.

b) Reinforcement rod mesh not less than 20 mm dia. at 150 mm centers in both directions shall be placed over the steel plates.

c) Steel plate and reinforcement shall be inspected after every blasting operation and all twists shall be removed to the satisfaction of the Engineer before reuse.

d) Sand filled bags shall be placed over the mesh suitably covering the whole region under blasting operation.

e) The thickness of covering plate and the kind of dead weight is to be duly approved by the Engineer.

3.23 CONTROL IN BLASTING

In order to safeguard the existing civil structures and the operating power stations / units of DAE, the following limitations shall be taken note of by the Contractor while planning for excavation in hard rock. Measurement of ground vibration is required during the experimental blasting as well as actual excavation to ensure that the prescribed safe vibration level is not exceeded through out the excavation work.

a) The contractor shall arrange to provide engineering seismographs (such as seismograph model VS1600 or equivalent), sensors and such electronic devices to record the induced blast vibration in three mutually perpendicular directions to assess and monitor the impact of the blast on the adjacent structures and for carrying out suitable adjustment in the quantum of charge to prevent any damage to existing structures. The type/ model and quantum of seismographs proposed to be deployed shall be got approved by the Engineer. This shall be at no extra cost to NPCIL.

b) Delay detonators of 500 Millie second are recommended to be used for excavation.

3.23.1 CHARGE LIMITATIONS : GENERAL

Within 20 meters from existing structures, no blasting shall be done without prior written approval of the Engineer. It is generally recommended that where the blasting is to be done, within 20 meters of the nearest point of permanent building, the area shall be line drilled on periphery before blasting.

The peak particle velocity on any structure of nearby operating power plant shall be limited to the following values:

a) 10 mm per second, for normal cases.

b) In critical cases, peak particle velocity of 3 mm per second is prescribed as a safe vibration level for buildings where electrical and electronic equipment are installed.

Note: *The following tables are the results of the test conducted by M/S CWPRS .The contractor shall carry out an Independent similar study at his own cost for KAIGA site , unless approved otherwise by the Engineer. No extra claim in this regard will be entertained.*

Table A : Site specific safe charge weight, distance and PPV data for KAPP site.(for guidance only)

Distance (m)	**Safe charge weights/ delay (kg) for PPV of**	
	10 mm/s	**3 mm/s**
20	0.6	0.1
30	1.3	0.3
40	2.4	0.5
50	3.7	0.7
60	5.3	1.0
70	7.2	1.4
80	9.4	1.8
90	11.9	2.3
100	14.7	2.9
150	33.0	6.4
200	58.8	11.4
250	91.9	17.9
300	132.3	25.7
350	180.0	35.0
400	235.0	45.7
450	297.7	57.8
500	367.5	71.4

** The peak particle velocity limitations on structure of project under construction are as follows:

a) The PPV limits of above clause 3.23.1 b) shall be followed, for the structure where construction is completed & equipment are commissioned.

b) The PPV limits for the structures, which are under construction, shall depend as per the age of concrete. The charges given in 3.23.2 may be followed for the same after prior approval.

Contractor shall submit his scheme with charges and delays he proposes to use for blasting for approval of the engineer. Contractor has to make experiments for the above delay in the presence of engineer to verify whether the charges and delays, he proposes to use are suitable for the type of work. When blasting is necessary adjacent to partially or completely built structures, the contractor shall take all the precautions necessary to prevent damage to structures from the flying rock pieces. The contractor shall be responsible for all damages caused by blasting and shall replace or repair the structures at his own cost. All major blasting shall be completed prior to starting concrete work on site.

3.23.2 CHARGE LIMITATIONS : FOR GREEN CONCRETE

a) No blasting shall be allowed for any of the structure excavation until freshly placed concrete has reached a minimum strength of 7N/Sq.mm

b) Normally, blasting should be resorted to only after 7 days of concreting work in case of O.P.C. (10 days in case of PPC/fly ash concrete) in adjacent structures.

c) In no case, shall blasting be allowed closer than 20 m to any structure after concrete placing has started. When minor blasting is necessary after concrete placing has started in any structure, the maximum size of charge for distance from 20 meter and above shall be limited as per approved values.

d) The excavation of bottom-most 150mm thick layer shall be done by hand trimming, barring, chiseling, hydraulic splitting etc.

In case, barring, chiseling or hydraulic splitting cannot be resorted to for the last layer, Contractor, with the permission of Engineer may resort to controlled blasting with low charges. However, in case of over-break beyond the specified limits Contractor shall fill up the over excavated portions with same class of concrete as is proposed to be laid over the excavated portions or any other material approved by the Engineer, at his own cost. The choice of the filling material shall be at the discretion of the Engineer.

3.24 ELECTRIC BLASTING

Unless otherwise specifically approved by the Engineer, the Contractor shall resort only to electric blasting. Only approved make firing apparatus can be used on the job. The Supervisor in- charge shall only possess the key of the firing apparatus and he shall keep it always with himself. Special apparatus such as capacitor discharge blasting machine shall be used as a source of current for the blasting operations and power lines shall not be tapped for this purpose.

Before use, all the detonators shall be checked to ensure that they are not damaged. For blasting in series only detonators of the same manufacture and of the same group of electrical resistance shall be used. Such of the electrical lines as could constitute danger for work of charging, shall be removed from the site or shall be switched off. The firing shall be done with a proper insulating cover so as to avoid short-circuiting due to

contact with water, metallic parts or rock etc. The use of earth as a return line shall not be permitted. The firing cable shall be connected to the source of power only when nobody is in the area of blasting. Before blasting, the circuit shall be checked by suitable apparatus such as a blasting multi-meter of low output. After firing, whether with or without an actual blast, the contact between the firing cable and the source of current shall be cut-off before people are allowed to leave the shelter.

During storms, charging with electrical detonators shall be suspended. The charges already placed in the holes shall be blasted as soon as possible, but taking all safety precautions, and giving necessary warning signals. If this is not possible, the site shall be evacuated till the storm has passed.

3.25 PRECAUTIONS AFTER BLASTING

The name of the day & night shift Supervisors must be noted daily in the Contractor's office. After the blast, the supervisor must carefully inspect the work and satisfy himself that all the charges have exploded. After the blast takes place in underground works, the workman shall not be allowed to go to the place till all toxic gases have disappeared from the place.

If it is suspected that part of the blast has failed to fire or is delayed, sufficient time shall be allowed to elapse before entering the danger zone. When fuse and blasting caps are used, a safe time should be allowed and then the supervisor alone shall leave the shelter to inspect the blasting zone. None of the drillers are to work near the misfired hole until one of the two following operations have been carried out by the Supervisor and no drilling in such holes of misfire shall be permitted

(i) The Supervisor should very carefully (when the tamping is of damp clay) extract the tamping with a wooden scraper or jet of water or compressed air (using a pipe of soft material), and withdraw the fuse with primer and a fresh detonator with fuse should be placed in this holes and fired out, or

(ii) The hole may be cleared of 30 cm of tamping and the direction then be ascertained by placing a stick in the hole. Another hole may then be drilled at least 60 cms. Away and parallel to it and about 30 cms. Less in depth. This hole shall than be charged and fired. The balance of the cartridges and detonators found in the muck shall be removed.

(iii) Before leaving his work, the Supervisor from the previous shift shall inform the Supervisor of the relieving shift of any case of misfires and should point out the position with a red cross denoting the same and also stating what action, if any, he has already taken in the matter. The Supervisor should also at once report at the office of the Contractor and the Engineer, all cases of misfire, the cause of the same and what steps were taken in connection with the same.

(iv) If a misfire has been found to be due to a defective detonator or dynamite the whole quantity or box from which the defective article was taken, must be thoroughly inspected by the Contractor and if needed isolated.

3.26 ACCEPTANCE OF EXCAVATED AREA

Excavated area shall be cleaned, trimmed to exact shape and size. All disturbed material and other debris shall be removed and the surface shall be thoroughly cleaned to the satisfaction of the Engineer. A joint survey of the excavated pit shall be carried out at various stages of excavation such as soil and soft rocks and hard rock before acceptance of the excavated area. The joint survey report duly signed by NPCIL and the contractor. Before any further work with concrete or backfill is commenced, the Contractor shall inform the Engineer and get the area approved by him.

3.27 DISPOSAL OF SURPLUS MATERIAL

All surplus materials shall be carried away from the site and disposed at dumping site/ stock piles, in separate heaps as per the utility of the material, as directed by the Engineer. The Engineer may ask the contractor to dump the excavated materials in low lying areas, regular heaps, bunds, blankets riprap with regular slopes and level so as to provide natural drainage. As a rule, all softer material shall be laid towards the centre of heaps, the harder and more weather resisting materials forming the casing on the sides and the top. All such works as mentioned above are deemed to have been taken into account while quoting .

All excavated material from the pits shall be the property of the Corporation and if the Contractor wants to use it, he shall have to obtain it from the Engineer at a rate fixed by the Purchaser, until unless specified otherwise.

In no case, the excavated soil shall be stacked within a distance of 1.5 m from the edge of the excavation or 1/3rd of the excavation depth, whichever is more.

3.28 PRECIOUS OBJECT, RELICS, OBJECTS OF ANTIQUITY ETC.

All gold, silver, oil, minerals, archaeological and other findings of importance, trees cut or other materials of any description and all precious stones, coins, treasures, relics, antiquities and other similar things which may be found in or on the site shall be the property of the Corporation and contractor shall duly preserve the same to the satisfaction of the Engineer and from time to time deliver the same to such person or persons as the Engineer may from time to time authorize or appoint to receive the same.

3.29 DEWATERING ARRANGEMENTS

Wherever ground water table is met with, during excavation and also to take care of surface water running into the excavated areas, the contractor shall immediately bring it to the notice of the Engineer. The contractor shall adopt a detailed dewatering system and maintain dry working conditions by lowering the water table at least 1 m below the bottom of the excavation. The dewatering systems may be well point dewatering, open dewatering systems, deep well dewatering system or any other method suitable for the type of sub-soil/ strata. The Contractor shall prepare the detailed scheme for

dewatering in line with IS 9758 and submit the same to the Engineer for approval. The scheme proposed by the Contractor should take into account the disposal of water at a suitable location as directed by the Engineer so that the wastewater does not return back to the pit. The Contractor shall continue dewatering i.e. maintain dry working condition till the entire excavation is completed and until such time as directed by the Engineer. The Contractor shall remove all slush/ muck from the excavated area to keep the work area dry. The contractor may employ sludge pumps for this purpose.

3.30 USE OF EXCAVATED MATERIAL:

The Contractor may note that useful rock excavated from the structures shall be used for the production of fine & coarse aggregates & backfilling. All the rock excavated from the structure foundation suitable for aggregate production shall be subject to the approval of the Engineer and shall be stacked in the stockpiles at the locations directed by the Engineer. Similarly the material suitable for backfilling shall also be stacked suitably. The rock suitable for production of aggregates for concrete, if available shall be given to the Contractor at a rate fixed by KAIGA site. *However, the excavated material used for backfilling will be available free of charge, if required the contractor has to break the bigger sized available material to the suitable size as specified in the specification, for backfilling at his own cost* **.**

4. BACKFILLING

4.1 SCOPE

This specification covers the Backfilling around foundations in pits, trenches, plinth under floors & grade areas.

4.2 MATERIALS

a) Excavated soil & other suitable filling material obtained from site grading excavation and excavation for basements and foundations for various plant buildings is proposed to be used for filling, to bring the plant site to the designed finished grade level. Such filling material will be available to the contractor free of cost within the plant area, to the extent its availability and suitability for backfilling as decided by the Engineer.

b) Soils such as black cotton soil, clay and mixtures having swelling characteristics shall not be used for backfilling in plinth, the areas where structure are likely to be located, roads & below grade slab etc. However, such materials may be used in rest of the areas to make the same up to finished ground level (FGL) with the prior approval of the Engineer.

c) All clods of earth shall be broken or removed. Selected material from borrow pits, which shall be approved by the Engineer, can also be used for backfill.

d) The material from outside the plant boundary may also be used, after obtaining necessary approval of the source from the Engineer. Royalty, Taxes, Quarry fees etc, if any, shall be borne by the contractor and proof of payment thereof shall be submitted to the Engineer for record purpose.

e) No filling shall commence until dewatering upto a depth of 1 m below excavated level so as to enable the backfilling works to be carried in the dry condition as per the direction of the Engineer

4.3 BACKFILLING OF DIFFERENT AREAS

Backfilling of different areas shall be carried out as defined below:

a) **General area grading**: Backfilling shall be done using excavated material/ borrowed earth compacted in layers, with a limiting layer thickness of 300 mm.

b) **Area around trenches:** Backfilling shall be done using excavated material/ borrowed earth with a limiting layer thickness of 200 mm compacted to a thickness not more than 150 mm or by using Fill-crete as approved by the engineer.

c) **Plinth area and area around structure with available working space lesser than 3 m:** Where due to space constraint required compaction is not possible, backfilling shall be done with Fill-crete of minimum grade M-5 using cement, fly ash & sand mix (except for top 300 mm, which has to be filled with earth).

d) Under the foundation: Using PCC or Fill-crete as specified in the drawing

4.4 GENERAL AREA GRADING

a) Soil obtained from excavation shall be used for filling after breaking/crushing the clods of the soil. The water shall be added to bring the soil mass to optimum moisture content (derived from modified proctor density tests with varying moisture contents), rolled & compacted.

b) The lower layers of the fill shall be spread in uniform horizontal layers not exceeding the thickness specified in above clause in loose thickness and each layer shall be compacted with a minimum of 8 to 10 passes of a 10 Ton smooth wheeled vibratory roller. In this clause and all subsequent clauses, the 'Number of passes' shall mean the number of times that each point on the surface of the layer being compacted has been traversed by the roller. During rolling, the roller shall uniformly overlap not less than one third of the roller track width made in the preceding travel. Each layer of fill shall meet the specified compaction requirements given in the drawings, before any succeeding layer is placed. The top layer of finished thickness of 300 mm shall also be spread in one uniform horizontal layer and

compacted as above.

4.5 FINISHED COMPACTED SURFACE

The finished compacted surface of the top course shall be dressed to the slopes and cross falls indicated in the construction drawings and the finished surface shall not vary more than +/- 50 mm from the true elevation at any point.

4.6 PROTECTION OF FILLING

The contractor shall protect all fill and in the event of its being washed away by rainwater or damaged in any other way, he shall, at his own cost, restore and make it good. Should any slip occur, the contractor should remove the affected material and make good the slip with sound material without any extra cost to NPCIL and to the satisfaction of the Engineer.

4.7 FILLING OF TRENCHES

Filling in trenches for pipes and drains shall commence as soon as the joints of pipes and drains have been tested and accepted.

The filling on the sides of the pipe & up to 300 mm or diameter of the pipe, whichever is more, above the crown of the pipe shall be carefully filled with fine material such as selected earth / murrum etc. according to availability at site, in layers not exceeding 150 mm size watered, rammed & consolidated, taking care that no damage is caused to the pipes. In areas where mechanical compaction is not possible, fill crete shall be used as filling material.

4.8 FILLING IN PITS, PLINTH AND AROUND STRUCTURES

As soon as the area is cleared & approved, the space around the foundation structures in pits shall be cleared of all debris, brick bats, mortar droppings & waste concrete etc and shall be filled with earth, if the available working space is more than 3m, the earth filling shall be done in layers of thickness not exceeding the limits as specified above. Each layer shall be watered, rammed and properly consolidated to meet 90% of modified proctor density, before the succeeding layer is laid. Earth shall be rammed preferably with approved compaction machine. Usually no manual compaction shall be allowed unless specifically permitted by the Engineer. The final surface shall be trimmed and leveled to proper profile as directed by the Engineer. At least one field density test by sand replacement method, as per IS: 2720 Part XXVIII shall be conducted on every third layer per 100 sq. meters to check the effectiveness of compaction. at no extra cost to Purchaser. The location for taking samples shall be randomly selected by the Engineer. Wherever compaction is not possible through mechanical means the same shall be filled using fill Crete/ fly ash or crusher dust /sand as directed by the Engineer.

4.9 SAND FILLING IN PLINTH AND OTHER PLACES

When directed by the Engineer, backfilling shall be carried out using selected coarse sand. The filled sand shall be flooded with water for sufficient time to ensure optimum consolidation. The surface of the consolidated sand shall be dressed to the required level or slope. Construction of floors or other structures shall not be started until the Engineer has inspected and approved the fill. Compaction of sand will be determined as per IS: 2720.

4.10 GENERAL SITE FILLING BY BORROWED MURRUM

Murrum for general site filling shall be from approved source, which could be from outside the plant boundary limits. The approval for same shall be obtained from the Engineer.

4.11 USEFUL EXCAVATED MATERIAL

The Contractor may note that useful soil, excavated from the structures & foundations may be used for the backfilling or other suitable purposes if, permitted by the engineer. All the material excavated from the structure foundation suitable for use shall be subject to the approval of the Engineer and shall be stacked in the stockpiles at the locations directed by the Engineer. Similarly the material suitable for backfilling shall also be stacked suitably. The excavated material used for backfilling will be available free of charge, but if required the contractor has to break the bigger size material to the suitable size as detailed in the specification, suitable for backfilling without any extra cost. If adequate quantity of backfilling material is not available at construction site (through excavated material) the Contractor shall arrange the same from outside after prior approval of the source.

5. CONSOLIDATION GROUTING:

The structures shall be founded on competent strata. The consolidation grouting wherever required shall be carried out as per the following specifications.

5.1 APPLICABLE CODES

Unless otherwise specified, the following Indian Standard codes shall be applicable. In all cases, the latest revision of the Codes shall be referred to.

IS- 6066 -Recommendations for pressure grouting of rock foundations in River Valley Projects.

IS- 5529 Part-2- Code of practice for In- situ- Permeability Test –Part 2 Test in Bedrock

5.2 GENERAL PROGRAMME OF GROUTING

The number and pattern of grout holes (it includes primary, secondary and tertiary holes), spacing and depth of grout holes shall be as shown in the drawings or as directed by the Engineer. The pressure and proportion of grout mixes to be used for injection shall be based on water pressure test and the results of trial grouting operations. If the foundation conditions, as revealed by such tests, indicate that grouting to greater depth is necessary, the Contractor is required to drill to a greater depth and grout these holes at relatively higher pressure. If on the other hand, the drilling and grouting of primary holes indicate that the number and or the depth of secondary holes could be curtailed, the scope of work would get reduced. The holes, which absorb water greater than *3 lugeons*, shall invariably be grouted. (1Lugeon is water loss of 1 lit/m/min at a pressure of 10 kg/sq.cm.)

5.3 EQUIPMENT

5.3.1 DRILLING EQUIPMENT

All grouting holes shall be drilled at the locations and spacing, to the size & depths shown on the drawing or as desired by the Engineer. Percussion type drills, rotary type Tungsten Carbide/Diamond drills and if necessary large size drills, wagon drill etc., shall be used for drilling as appropriate for type of rock. For speedy drilling operation percussion drilling equipment, similar to Atlas Copco's standard O.D.Unit, may be used.

5.3.2 GROUTING EQUIPMENT

All equipment used for mixing and injecting grout shall be furnished by the Contractor. They shall be maintained in operating condition at all time.

The equipment for grouting purpose shall include, but not be limited to:

- Two air driven, double acting slush pumps of long stroke type capable of operating at a maximum discharge pressure of 10.55 kg/cm^2 (150 psi) with adequate bypass arrangement for circulating the grout.

- Pumping equipment of any other type, which is equivalent or better, may be used, with specific approval of the Engineer. The equipment shall be specially designed for grouting services including mixing, agitating, pumping and injection of a cement grout.

- Compressor with adequate capacity to deliver air at minimum pressure of 6.33 kg/cm^2 (90 psi).

- A mechanically operated colloidal (high speed) type mixer for preparing the grout.

- A mechanically agitated sump or hold over tank with provision for suitable screens to keep the mixed grout in suspension and remove hardened grout or foreign materials not passing through IS sieve with 1.18 mm standard screen. The

arrangement of these facilities shall be such that the gravity flow is ensured from the mixer to the agitator.

- A tank of sufficient capacity and with adequate by pass pipe and fittings for auxiliary water supply, to be used in pressure testing, flushing and pressure washing operations.

- Accurate water meter graduated in cubic meters and each cubic meter divided in five hundred parts with bypass so that water can be measured directly into the auxiliary water supply tank.

- Valves, pressure gauges including gauge savers, pressure hose pipes, fittings and such other small tools as may be necessary to provide a continuous supply of grout and also accurate pressure control. Pressure gauges shall be provided at grout pump outlet and at the grout hole manifold with a grout meter to measure the quantum of grout.

- The inside diameter of the pressure hose and grout supply line should be capable of withstanding maximum water or grout pressure to be used. The inside diameter of packer supply pipe shall be suitable for the diameter of the hole drilled.

- Arrangement for measuring the upheaval of rock/ overburden with necessary dial gauges as per IS 6066.

5.4 GROUTING MATERIAL

5.4.1 GENERAL

Grout composition shall be mixture of cement and water with possible addition of mineral fillers and fluidifiers, and or other admixtures. The grout mixes will be varied to meet the characteristics of each hole as determined by conditions encountered.

5.4.2 SAND

The sand shall consist of hard dense, durable uncoated rock fragments or natural sand with less than 3% of any deleterious substances and fineness will be such that 100% shall pass a standard IS sieve of 1.18 mm size and 50% shall pass IS sieve of 300 micron size.

5.4.3 LOCATION OF GROUT HOLES

The grout holes shall be laid out in lines, as indicated on approved drawings with secondary holes staggered with reference to the primary holes on the adjacent lines. Spacing between holes initially shall be 5 m centre to centre or as specified in the drawing. After completing the grouting through these primary holes intermediate holes will be taken in between primary holes. The number of holes for further grouting (tertiary grouting - which will be determined based on results of drilling and grouting of intermediate holes) will be such that a continuous consolidated area of satisfactory water tightness is achieved.

5.4.3.1 DEFINITIONS

- A "zone" is a series of adjacent rock strata within a predetermined depth or grout curtain.
- A "Section" is a horizontal reach along the grout curtain.
- A "Stage" is a partial or complete depth of hole for drilling and grouting purposes within any zone.
- The "Closure Method" is the procedure of locating an additional grout hole midway between two previously drilled and grouted holes.
- "Packer" grouting consists of drilling a hole to full depth and grouting from bottom of the hole upward at different depths, settings of stages by means of a packer set at required depths.
- "Stage grouting" consists of drilling a hole to a limited depth within a zone, grouting at this depth cleaning the hole and letting the grout set, re-drilling the hole to another limited depth and grouting and thus continuing in as many stages of drilling and grouting as may be necessary to secure a satisfactory job of grouting within any zone.

5.5 CASING AND DRILLING

Each hole drilled shall be protected from caving and/or being clogged or obstructed. The hole drilled in the overburden shall have a casing keyed into the rock sufficiently to exclude collapse of overburden and the joints to be water tight. The Contractor may adopt mud drilling in overburden to facilitate fixing of casing pipe in rock. This casing shall be capped and furnished with fittings for water testing or grouting. Any hole clogged or obstructed shall be cleaned out in a satisfactory manner. All metal pipes and fittings required for casing and grouting holes shall be furnished, handled, installed and removed by the Contractor. No extra payment will be made for drill bits , casing pipes or any other fittings left in or could not be removed.

5.5.1 DRILLING

After drilling through overburden and installing the casing pipe, further drilling shall be continued with the percussion drilling if the rock does not produce mud slurries. The percussion drilling shall be continued up to the required depth in the hard rock. If at any instance the rock conditions dictate use of rotary drilling then drilling shall be carried out accordingly.

In case of overburden drilling equipment (similar to Atlas Copco's Standard O.D. Unit) which has rotary action combined with percussion, the same equipment shall be continued up to the required depth. The holes should be thoroughly washed immediately before grouting with alternate jets of air and water under continuous

pressure in a manner permitting free outflow by inserting a smaller pipe and introducing air and water at the bottom of the hole. The use of grease or other lubricants on the drill rods or in the drill holes will not be permitted. The holes shall be drilled vertically or at inclinations from vertical as shown in the drawing or as directed by the Engineer. Whenever the drill water is lost or large artesian flow is encountered in any hole the Drilling operation shall be stopped and the hole shall be grouted before drilling operation is resumed. Upon completion of drilling or at any stage of hole, it shall be temporarily capped or otherwise protected from entry of foreign materials until grouting operation require it to be opened. Re-drilling required because of the Contractor's failure to clean out a hole before grouting shall be performed by the Contractor at his own expenses and no additional payment shall be made on account of the same.

5.5.2 WASHING AND PRESSURE TESTING

It will be necessary that during the drilling of grout holes in rock, or after drilling is over, the holes be completely pressure tested to a pressure equivalent to 0.23 to 0.46 kg/cm^2 per meter depth. When abnormal gain or loss of drill water is observed, caving of the hole or binding of the bit occurs during drilling or falling of the bits and drill rods as through open cavity, it will be necessary to discontinue drilling and the hole pressure tested either with or without the use of packers.

It may be necessary that upon completion of any hole, to pressure test the same using (special double seal) packers set at intervals of 3 M or less starting at the bottom and going upwards in the hole. The quantity of water taken in by the hole during testing under pressure shall be carefully observed and recorded in order to enable the Engineer to assess the type of rock and decide on the grouting procedure. Immediately before the pressure grouting of each stage of any hole is taken up, it will be necessary to thoroughly wash the hole under pressure and then pressure test it. At least the nearest two holes in advance of each hole to be washed shall be completely drilled for the same stage and the adjacent holes completely washed to allow washing and flushing out of any intervening clay-filled seams, fractures or solution channels. All the washable materials shall be washed with water and air under pressure not exceeding grout pressure. The pressure testing shall be done as per Clause 10.3 of IS: 6066.

5.5.3 GROUTING - GENERAL

Grouting mixes, pressures, pumping rates and the sequence of drilling and grouting of holes will be determined in the field by the Engineer. In no case shall the deepening of any hole preparatory to grouting be commenced before a minimum period of 16 hrs has elapsed since completion of the previous stage grouting in that hole. No Second Stage grouting shall be conducted within approximately 12.5 meters radius of any hole in which a previous stage of grouting has been completed, until the grout in such previous hole has set for a period of twenty four (24) hours. The w/c ratio by volume will be varied to meet the characteristics of each hole as revealed by the grouting operation. In general, if pressure tests indicate a relatively tight hole, grouting shall be started with thin mix. If an open hole condition exists, as determined by loss of drill water or inability to build up pressure during washing, then grouting shall be started

with a thicker mix, and with the grout pump operating as nearly as possible at constant speed at all time. The water cement ratio will be decreased, if required, till the required pressure is reached.

Pressures as high as practicable but safe against rock displacement, shall be used in the grouting. Periodic application of water under pressure shall be made to avoid premature stoppage. The rate of pumping or pumping pressure shall not be increased suddenly. The grouting shall not be considered complete till the hole takes grout at the rate of less than 2 liters per minute averaged over a period of 10 min. If due to size and continuity of fractures it is found impossible to reach the required pressure after pumping a reasonable volume of grout at minimum workable w/c ratio, the speed of pumping shall be reduced. Following this reduction, if the desired result is still not achieved the grouting in the hole shall be stopped. Then the grout shall be allowed to attain initial set, the hole shall be cleaned and after the final set of the grout additional drilling and grouting shall be taken up in this hole or in adjacent area till desired resistance is built up. The arrangement of the grouting equipment shall be such as to provide a constant circulation of grout throughout the system and to permit accurate pressure control by operation of a valve on the grout return line. Pressure gauge and adequate valves are required at the pump at each hole to control, bypass and shut off, as required by the Engineer. The equipment and lines shall be prevented from chocking by the constant circulation of grout and by the periodic flushing out of the system with water. Flushing shall be done with grout intake valve closed, water valve open and pump running at full speed.

5.5.4 GROUTING WITH PACKERS

Different grouting pressures will be required for grouting different sections of most of the holes. The grouting shall be performed by attaching a rubber packer to the end of grout supply pipe, lowering the grout supply pipe into the hole to the top of the section which is required to be grouted. The packer shall be so designed that it shall be able to expand to seal the drill hole at the specified elevation and when expanded shall be capable of withstanding pressure without leakage, for a period of 5 minutes.

After fixing the packer at required elevation, the bottom portion of the hole shall be grouted at specified pressure allowing the packer to remain in place till the grouting is completed and grout pipe shall then be withdrawn to the next higher section required to be grouted at the specified pressure and thus successively grouting the hole in stages at the specified grouting pressures until the entire hole is completely grouted.

5.5.4.1 Whenever rock lifting is anticipated the pressure shall be suitably modified. It is always better to begin with a low initial pressure say 0.1 to 0.25 kg/sq.cm per meter of overburden and build up pressure gradually. It is advisable to ensure that the pressure shall not be raised until the rate of intake falls below a lower limiting value of say 5 liters/min. The limiting value of pressure for each zone and depth of stage shall be established from the result of trial grouting along with observations of upheaval by uplift. Control of pressures shall be as per clause 12.1.4 of IS:6066.

5.5.4.2 In case different grouting pressures are required for grouting different sections & the top layers are susceptible to up-heaving the grouting can be done with double packer system also, as specified in IS: 6066.

6. CONCRETE:

6.1 SCOPE

a) This specification covers all the aspects of concrete production like procurement of ingredients, storing, proportioning, mixing, placing, vibrating and curing of plain, reinforced, pre-stressed and pre-cast concrete etc. This specification broadly covers: -

i) Requirements for source-qualification, procurement, batch qualification testing and storage of concrete ingredients.

ii) Requirements for proportioning of concrete mix, batching, mixing, Transportation, sampling, testing and acceptance of concrete of specified grades.

iii) Requirements for preparation and placement of concrete including chilling, conveying, depositing, compaction, curing, finishing, inspection, testing and preparation of construction joints and repairing, if needed.

b) Wherever information shown is in contradiction to the contents of this specification, all information pertaining to plain, reinforced, pre-stressed and pre-cast concrete shown and noted on the drawings shall be considered part of this specification and shall supersede this specification.

c) During concrete mix proportioning, it may be required, in consultation with the Engineer, to include pozzolanic material (fly ash, micro silica, GGBS etc.) either individually or in combination, to meet the specified requirement of strength and durability. Special provisions with regard to allowable limits of these pozzolanic materials, effect on properties of concrete, durability requirements of concrete have been highlighted. To achieve high level of mechanization in concrete production and placement, special requirements for batching plant, concrete pumping equipment, field practices etc. have also been highlighted.

6.2 QUALIFICATIONS AND APPROVAL OF SOURCES

All materials required for the manufacture of concrete and used for curing of concrete shall be procured only from approved sources. Such approvals shall be given by the Engineer only after due evaluation of tests and test certificates and also after further sampling and testing the materials as per relevant specifications by the contractor. It is the responsibility of the contractor to carry out investigations and evaluation of sources of material for pre-qualification. The contractor shall also ensure that at least two sources of each material are pre-qualified for ensuring uninterrupted supply of material. Bulk procurement of the ingredients of the concrete shall be made only after the contractor has completed the process of pre-qualification and the Engineer has duly approved the sources/ products. The approval of the Engineer does not, however,

absolve the contractor of his responsibility for the quality and consistent supply of the materials.

6.3 STANDARDS AND SPECIFICATIONS

The provisions of the latest revisions with amendments, if any, of the following Indian Standards and other relevant codes shall form part of this specification to the extent they are relevant. Where the provisions of these Standards/Codes are in conflict with the stipulations of this specification, the specification supersedes the respective Standard or Codes.

6.3.1 BUREAU OF INDIAN STANDARDS

IS – 383	Specification for coarse and fine Aggregates from natural sources for concrete.
IS – 456	Plain and reinforced concrete – code of practice
IS – 460	Specification for Test Sieves (Part I, II & III).
IS – 516	Methods of Tests for strength of concrete.
IS – 1199	Methods of sampling and Analysis of concrete.
IS – 1343	Pre-stressed Concrete - Code of practice
IS – 1727	Methods of test for pozzolanic materials.
IS – 1791	General requirements for batch type concrete mixers
IS – 2386	Methods of Test for Aggregates for concrete. (Part I to VIII)
IS – 2395 Part I & II	Painting of concrete, masonry and plaster surfaces - Code of practice.
IS – 2430	Methods of sampling of aggregates for concrete.
IS – 2505	Concrete vibrators – immersion type. - General requirements
IS – 2506	General requirements for concrete vibrators, screed board type.
IS – 2514	Specification for Concrete vibrating Tables.
IS – 2645	Integral Waterproofing Compounds for Cement Mortar and Concrete – Specification.
IS – 2722	Specification for portable swing weigh batchers for concrete. (Single & Double bucket type).
IS –3025	Methods of sampling and test (Physical and Chemical) for water and waste water (Part 1 to63)
IS – 3085	Method of test for permeability of cement mortar & concrete.
IS – 3558	Code of practice for use of immersion vibrators for consolidating concrete.
IS-3812 (Part-I)	Pulverized Fuel Ash – Specification: For use as Pozzolana in Cement, Cement Mortar and Concrete.
IS – 4031	Methods of physical tests for hydraulic cement (Part 1 to 15).

IS – 4032	Method of chemical analysis of hydraulic cement.
IS – 4082	Stacking and storage of construction materials and components at Site - Recommendations.

IS – 4634	Batch type concrete mixers - method of test performance of.
IS – 4845	Definitions and terminology relating to hydraulic cement.
IS – 4925	Concrete batching and mixing plant: specification
IS – 5816	Splitting Tensile Strength of Concrete – Method of Test.
IS – 5892	Concrete transit mixers - specification
IS – 6461	Glossary of terms relating to cement concrete (Part-1 to 12)
IS – 7320	Specification for Concrete slump test apparatus.
IS – 7325	Specification for Apparatus for determining constituents of fresh concrete.
IS – 7861	Code of practice for Extreme weather concreting (Part 1 & Part 2).
IS – 8112	Specification for 43-grade ordinary Portland cement.
IS – 8142	Method of test for determining setting time of concrete by penetration resistance.
IS - 9013	Method of making, curing and determining compressive strength of accelerated cured concrete test specimens.
IS – 9103	Concrete Admixtures – Specification
IS – 10262	Concrete mix proportioning - Guidelines.
IS – 12089	Specification for granulated slag for manufacture of Portland slag cement.
IS – 12269	Ordinary Portland cement 53-grade - Specification.
IS – 12600	Portland cement low heat - Specification.
IS – 14687	Falsework for concrete structures – guidelines.
IS –14959 (Part-I)	Determination of Water Soluble and Acid Soluble Chlorides in Mortar and Concrete (Fresh mortar and concrete).
IS- 15388	Silica fume- Specification
SP-23	Handbook on Concrete Mixes.

6.3.2 ASTM STANDARDS

ASTM C-33	Standard Specification for Concrete Aggregates.
ASTM C-94	Standard Specification for Ready Mixed Concrete
ASTM C-295	Standard Guide for Petrographic Examination of Aggregates for Concrete
ASTM C-494	Standard Specification for chemical admixtures for concrete.
ASTM C–1202	Standard Test method for electrical indication of concrete's ability to resist chloride ion penetration.
ASTM C-1240	Standard Specification for silica fume used in cementitious mixtures.
ASTM C–1260	Standard test method for Potential Alkali Reactivity of

	Aggregates (Mortar - Bar Method)
ASTM D–75	Standard practice for Sampling Aggregates
ASTM D–1411	Standard Test methods for Water - Soluble chlorides present as admixtures in graded aggregate road mixes.

6.3.3 ACI / ASME CODES AND SPECIFICATIONS

ACI 211.1	Standard Practice for selecting proportions for normal, Heavy Weight and mass concrete.
ACI 304.1R.	Guide for the use of Preplaced Aggregate Concrete for Structural and Mass concrete Applications.
ACI 304.2R	Placing Concrete by Pumping Methods.
ACI 318	Building code requirements for structural concrete and commentary.
ACI 349	Code requirements for Nuclear safety - related concrete structures
ASME Sec-III Division-2	Code for Concrete Containments

6.3.4 OTHER STANDARDS

a) Railway Specifications – Tests for chloride and sulphate content of aggregates.

b) The European guidelines for Self-Compacting Concrete – Specification, Production and Use (EFNARC Publication).

c) DIN-1048 Specification for water permeability of concrete.

d) Concrete library of JSCE No. 36 – Recommendations for construction of concrete containing ash as a mineral admixture

e) JSCE Concrete engineering series 31- Recommendation for self-compacting concrete

f) BS6699- Specifications for Ground Granulated Blast Furnace Slag for use with Portland cement

6.4 STORAGE OF MATERIALS

a) The contractor shall make necessary arrangements, for safe storage and ensure prevention against deterioration of the materials. Cement, fly ash, GGBS, micro silica, super plasticizers, admixtures, retarders etc. shall, invariably, be stored in weather proof sheds of adequate capacity for storage of the material for at least 3 weeks' of work. However, the contractor shall ensure that sufficient quantities of all materials are available for uninterrupted progress of the work. Cement and other construction materials shall be stored as per recommendations of Indian Standards and as per manufacturer's recommendation. Storage silos shall be watertight. In the storage area, proper access and lighting shall be provided for inspection, identification and drawl of

material. The material shall be stored batch wise with proper identification tag, indicating the quantity received, batch number and the date of receipt and issue. The consignments shall be used in the order of receipt at site, unless otherwise directed. In case of large concrete pours, the material to be used shall be identified and procured well in advance, taking the quantity required for a particular concrete pour into consideration. The cement shall be used within three months from the date of manufacture. However, in exceptional circumstances, if approved by the Engineer, the above stipulation may be relaxed subject to the condition that the material shall be retested to ensure the conformity with the technical specifications. Normally, materials of different type or grade shall not be stored in the same godown. If materials of different type or different grade are stored in the same place, it shall be clearly demarcated and separated to avoid intermixing.

b) The contractor shall prepare an elaborate procedure for the periodic inspection and testing of the materials to detect any deterioration and also for segregation of the deteriorated material. The above procedure shall be approved by the Engineer and implemented by the contractor. It is the responsibility of the contractor to provide all samples and other facilities to the Engineer for carrying out inspection and testing of materials both at the source and at the site of work at his own cost. The rejected materials shall be removed from the site within 48 hours. If the contractor fails to remove the rejected material within 48 hours, the right to get the materials removed from the site rests with the Engineer and all the expenditure incurred by the Engineer for such removal shall be borne by the Contractor.

c) Coarse and fine aggregate (both normal and heavy) shall be stacked on concrete/masonry platforms separately in a manner to prevent their intermixing and to avoid contamination by foreign materials. Each size of aggregate shall be kept separately with wooden, steel, concrete or masonry bulkheads in such a way, to prevent intermixing. If necessary, rock ladders, reclamation tunnels etc. may be provided so that the grading of the material is not affected.

d) All storage arrangements, handling schemes shall be subject to the approval of the Engineer. If the storage arrangement is not to the satisfaction of the Engineer, he may direct the contractor to make such arrangements as he considers necessary and in the event of non-compliance, the Engineer reserves the right to make such arrangements as may be needed at the contractor's risk and cost.

e) A detailed record of receipt and issue of all materials with the associated test certificates shall be maintained by the contractor and shall at all times be available to the Engineer for his scrutiny.

6.5 CONCRETE INGREDIENTS

6.5.1 CEMENT

6.5.1.1 SOURCE QUALIFICATION

a) In no case, cement shall be purchased from agents/ distributors. A minimum of two cement plants shall be pre-qualified well before the start of the concreting works.

b) In general, Ordinary Portland cement (OPC) of 43 grade conforming to IS 8112 and 53 grade conforming to IS 12269 shall be used. In addition to the requirements specified in these standards, following additional requirements shall also be met with:

i) Chloride content shall not be more than 0.05% by mass of cement.
ii) C_3A content shall be between 5% and 8%.
iii) In case of alkali reactive aggregate, alkali content, as Na_2O equivalent shall not be more than 0.6% by mass of cement.

c) Any other special type of cements i.e. Portland Pozzolana Cement (IS 1489 – Part 1 and 2), Portland Slag Cement (IS 455), Sulphate Resisting Cement (IS 12330), Low Heat Portland Cement (IS 12600), Rapid Hardening Portland Cement (IS 8041) may be used in works only with the written permission of the Engineer and only if the design of structures demands the usage of the same.

6.5.1.2 PRE-DISPATCH TESTS

All the consignments of cement shall be accompanied by the manufacturer's test certificate for individual batches, ensuring that cement meets all the requirements of the specification.

6.5.1.3 TEST AT SITE (BATCH QUALIFICATION)

a) In addition to the manufacturer's test certificate, the Contractor shall arrange for testing of the cement either at site laboratory or at any other outside laboratory approved by the Engineer. Cement samples, for such tests, shall be drawn, in the presence of the Engineer or his authorized representative. A composite sample shall be collected representing 250 MT (or such smaller quantity as may be decided by the Engineer) of cement from each grade / brand with proper batch identification. At least 10 grab samples shall be taken representing the entire batch. When cement is supplied in bowser / bulker and directly fed to the silo, grab sample shall be taken from each bowser / bulker. Composite sample shall be prepared by thorough mixing of the grab samples to represent the entire batch.

b) The tests and their frequency shall be as given in Table 6.1.

TABLE 6.1

FREQUENCY OF TESTING OF CEMENT

Sl. .No	Description of Test	Frequency
1	Normal consistency	250 MT or lesser
2	Compressive strength 3 days, 7 days, 28 days	250 MT
3	Initial and final setting time	250 MT
4	Specific gravity	2000 MT
5	Soundness	
a	Le Chatelier's method	2000 MT
b	Auto clave method	2000 MT
6	Specific surface	2000 MT

c) All the chemical tests specified in the relevant standards shall be conducted at an independent laboratory for every 20000 MT of cement supplied or at every 6 months whichever is earlier for each brand/grade. All the chemical compounds shall be reported separately. Bogue's compounds shall also be calculated and furnished.

d) The Engineer shall be able to witness sampling, testing and inspection of cement at the site laboratory or at independent laboratory. Cement shall be released for use, only after ensuring that it meets the requirements of initial and final setting time as well as 3 days compressive strength results. If required, necessary co-relation shall be established between accelerated 1-day strength with 3, 7 and 28-day strengths. Based on this co-relation, cement may be inducted into the work with the prior approval of Engineer in exceptional cases only.

e) Cost of above testing shall be borne by the Contractor. Contractor shall ensure that the construction schedule is not affected because of testing of material at outside laboratory.

f) Test results either from the site laboratory or from an approved outside laboratory shall be taken as final for acceptance or rejection criteria.

6.5.2 FLY ASH

a) Fly Ash conforming to IS 3812 (Part 1) shall only be used. Bottom ash, Ash from Air pre-heater and pond ash shall not be used for mortar as well as for concrete production. Fly ash shall be collected in dry condition from the source with proper moisture proof packing arrangement. Fly ash can also be supplied in bulk containers. For source qualification, three samples from a particular source shall be collected and tested for physical and chemical properties. If all the three samples pass the requirements given in IS 3812 (Part-1) then the source shall be considered as acceptable. However, loss on ignition shall not be more than 2% and particles retained on 45-micron sieve shall not exceed 20%. This requirement is in variance with IS 3812 (Part-1). Bidder will have

to meet the requirements given in the specification. In case the quality of fly ash collected from the source does not meet the requirements the contractor will have to use the processed flyash or install a classifier at his own cost.

b) All the physical and chemical tests specified in IS 3812 (Part-1) shall be conducted at every 2,000 MT of fly ash or at every 1-month intervals whichever is earlier. However for fineness only percentage retention on 45-micron sieve shall be the criteria for acceptance or rejection. The discretion to change this frequency rests with the Engineer depending upon the consistent performance of the previous batches. The fly ash, if stored for more than 3 months, it shall be re-qualified before its use.

c) The contractor shall get the test certificate for each batch of supply from the fly ash supplier. The contractor at his own cost shall undertake the following tests either at field laboratory or at outside approved laboratory for each batch of 100 T or part thereof:

i) Percentage retained on 45 micron sieve
ii) Loss on ignition
iii) Moisture content

6.5.3 MICRO SILICA

a) Though micro silica is available in three forms i.e. un-densified, densified and slurry form, only densified form of silica fume shall be used and shall conform to the requirements of IS: 15388.

b) Test requirements of micro silica for source qualification as well as batch qualification shall be as per Table 6.2. For batch qualification tests specified under serial No. 2, 3,5 and 6 of following table (Table 6.2) shall be conducted for every 100 Tons and all other tests shall be carried out at every 2000 Tons.

TABLE 6.2

TEST REQUIREMENTS OF MICRO SILICA

Sl. No.	Description of test	Test method	Requirements
1	SiO_2,(%), min	IS 1727	85.0
2	Maximum Moisture content (%)	See Note 1	3.0
3	Loss on ignition (%), max	IS 1727	4.0
4	Alkalies as Na_2O (%), max	See Note 2 and 3	1.5
5	Oversize percent retained on 45 micron IS sieve (%), Max	IS 1727	10.0
6	Compressive strength at 7 days as percent of control samples	IS 1727 See Note 3	85.0

7	Specific surface (m^2/g), min	IS 15388 Annexure A	15.0
8	Specific gravity*	IS 1727	-

NOTE:

1. For determination of moisture content, dry a weighed sample as received in an oven at 105^0C to 110^0C. Express the percentage loss in mass and record as moisture content.

2. For determination of alkalis, method of test used for determination of alkali in cement may be adopted.

3. In the test method for determination of compressive strength of silica fume cement mortar in accordance with IS: 1727, the value of factor N may be taken as 1.

4. Specific surface test is optional.

5. Tests specified above shall be carried out by the contractor at his own cost.

(*) For batch qualification the specific gravity value shall not deviate by ±0.2 from the values obtained during mix qualification

6.5.4 GROUND GRANULATED BLAST FURNACE SLAG (GGBS)

a) The GGBS shall conform to BS 6699. The GGBS may be used with OPC (Ordinary Portland Cement) 43 grade conforming to IS: 8112 or 53 grade conforming to IS: 12269.

b) Test requirements of GGBS for source qualification as well as batch qualification shall be as per Table 6.3. Cost of testing shall be borne by the Contractor.

TABLE 6.3

TEST REQUIREMENTS OF GGBS AS PER BS 6699

Sl. No	Description of test	Test method	Requirements
1	Fineness (M^2/Kg)	EN-196-6	275 (minimum)
2	Soundness (Le Chatelier Expansion) in mm	EN-196-3	10.0 (maximum)
3	Loss on ignition (%), max	EN-196-2	3.0 %
4	Insoluble Residue (%)	EN-196-2	1.5 (max)
5	Initial Setting Time (IST)	EN-196-3	Not less than IST of OPC
6	Magnesia content (%)	EN-196-2	14.00 (max)
7	Sulphide Sulphur (%)	EN-196-2	2.00 (max)
8	Sulphite Content (%)	EN-196-2	2.50 (max)

Sl. No	Description of test	Test method	Requirements
9	Magnese Content (%)	EN-196-2	2.00 (max)
10	Chloride Content (%)	EN-196-21	0.10 (max)
11	Moisture Content (%)	BS 6699-APPN-E	1.00 (max)
12	Glass Content (%)	BS 6699-APPN-D	85 (min)
13	Compressive strength in (N/mm^2) After 7 days After 28 days	EN-196-1	 12.0 (min) 32.5 (min)
14 a b c	Chemical Moduli $CaO + MgO + SiO_2$ $CaO + MgO / SiO_2$ CaO / SiO_2	EN-196-2	66.66(Min) > 1.0 < 1.4

In case of use of Portland Slag Cement the cement shall meet all the requirements given in IS 455.

c) All the physical and chemical tests shall be conducted at every 500 MT of GGBS or at every 6 months intervals whichever is earlier. The discretion to change this frequency rests with the Engineer depending upon the consistent performance of the previous batches. The contractor shall also get the test certificate for each batch of supply from the GGBS supplier.

6.5.5 AGGREGATE

a) The samples of coarse and fine aggregate shall be tested by the contractor at his own cost as per Table-6.4 while qualifying the source and thereafter at regular intervals as mentioned therein. The regular supply of coarse and fine aggregates shall commence only after approval of the source. The layout of the crushing, washing and batching plant shall be subject to the approval of the Engineer. The crushing plant shall include vertical shaft impactor in the system, so as to obtain cubical aggregate as well as crushed fine material for use as manufactured sand. ***Contractor shall note that crushing of aggregate at GHAVP site is prohibited.*** Direct purchasing of crushed aggregate from outside suppliers may be allowed subject to the condition that the material so procured meets this specification. The contractor, however, is advised to procure the boulder and crush the same at a place convenient to him. Alternatively, he may establish crushing machinery at the quarry and transport the crushed aggregates/ crushed sand. All efforts should be made by the contractor to contain the dust level to the minimum so as to meet environmental standards by incorporating suitable filters and/ or any such arrangements.

TABLE 6.4

AGGREGATE TESTING SCHEDULE AND REQUIREMENTS

Sl. No.	Activity/Test	Frequency	Applicable Code	Requirement
1(*)	Petrographic strained quartz analysis by weight	One sample for new source or change in source of aggregates	IS: 383 / ASTM C-295	<20%
2(*)	Alkali reactivity			
a)	Mortar bar method	One sample fornew source or change in source of aggregates.	ASTM C-1260	Expansion shall be less than 0.10% at 16days
b)	Chemical method	One sample for new source or change in source of aggregate and Subsequently once in 6 months during progress of work.	IS: 2386 / IS: 383	Shall fall in innocuous zone
3	Chloride content	-do-	IS 14959(P-I) / Railway Spec	0.04% by wt. max.
4	Sulphate content	-do-	IS 3025(P-24) /Railway Spec.	0.40% by wt. max.
5	Iron content for heavy density aggregates	One sample for every 5000 MT for new source or change in source	NPC Spec.	Shall not be less than 60% 4.65 (for HA)
6	Specific gravity (SSD condition)	-do-	IS: 2386	2.6 (for C.A.) 2.55(for F.A.)
7	Deleterious material	-do-	IS: 2386 / IS: 383	Refer Table No.6 and 8
8	Size and Gradation	One sample for every 1000 Cum of concrete (minimum one sample per week)	IS: 2386 / IS: 383	Refer Table No. 5 and 7
9	Absorption/. Moisture content	One sample daily	IS: 2386	3% max.
109	Silt content (for natural sand only)	Once in a week	IS: 383	8% max. By volume
10	Organic impurity (for natural sand only)	Once in six months	IS: 2386 / IS: 383	No impurity
11	Flakiness and	Once in a month	IS: 2386	Individual-15%

Sl. No.	Activity/Test	Frequency	Applicable Code	Requirement
	elongation index (for C.A. only)			max.
12	Crushing value (for C.A. only)	Once in six months	IS: 2386	45%** max.
13.	Abrasion value (for C.A. only)	Once in six months	IS: 2386	
14.	Impact valve (for C.A. only)	Once in six months	IS: 2386	

(*) Based on the test results of Petrographic examination and /or alkali aggregate reaction test, if aggregate is found alkali reactive, remedial measures like restricting the alkali content of cement, admixture and/or addition of pozzolanic material shall be resorted to with the approval of the Engineer. As a normal rule, such aggregate shall not be used into work and efforts shall be made to obtain non-reactive aggregate.

(**) These limits shall be 30% (maximum) for aggregate to be used in road construction.

6.5.5.1 WASHING OF AGGREGATE

The impurity level in both coarse aggregate and fine aggregate shall be controlled. If impurities are beyond acceptable limits, the contractor shall at his own cost make necessary arrangements to wash the river sand/ aggregate before inducting the same into concrete. Silt content of sand shall be checked for each truckload and shall be brought within acceptable limits by washing. Both coarse aggregate and fine aggregate shall be washed thoroughly to remove all vegetation, perishable substances, and objectionable amounts of foreign matter, quarry dust, clay lumps, silt and such other deleterious materials. A suitable washing mechanism shall be provided as per scheme approved by the Engineer. The contractor shall prepare a detailed procedure for washing indicating the washing arrangement and get approval of the same from the Engineer. The washing arrangement shall be such as to remove the wastewater along with the unwanted materials and drain the same away from the site. It shall also not be directly let into the river/ nallah or such other existing water bodies.

6.5.5.2 FINE AGGREGATE

Fine aggregate shall consist of natural sand, manufactured sand, or a combination thereof. Fine aggregate having a specific gravity of less than 2.55 (saturated surface dry condition) shall not be used. Fine aggregate shall be graded within the limits specified in Table 6.5. The sand shall be of siliceous material, sharp, hard, strong and durable and shall be free from adherent coating, clay, dust, alkali, organic material, deleterious matter, lumps, etc. Sampling of fine aggregate shall be in accordance with IS: 2430. Fine aggregate shall be so graded that concrete of required workability, density and strength could be produced using the specified water binder ratio. The method of determination of gradation shall be as per IS: 2386.

TABLE 6.5

GRADING LIMITS FOR FINE AGGREGATES

IS Sieve designation	Percentage passing by weight		
	Zone-I	Zone-II	Zone-III
10 mm	100	100	100
4.75 mm	90-100	90-100	90-100
2.36 mm	60-95	75-100	85-100
1.18 mm	30-75	55-90	95-100
600 micron	15-34	35-59	60-79
300 micron	5-20	8-30	12-40
150 micron	0-10	0-10	0-10

NOTE :

1. For crushed sand, the permissible limit on 150 micron IS sieve shall not exceed 20%. This shall not affect 5% allowance permitted on clause 1.3 of IS – 383 applying to other sieve size.

2. Fine aggregate complying with the requirement of both grading Zone-I and II of Table–1.5 are only suitable for concrete production. However, in exceptional cases, with the specific permission of Engineer the Zone –III sand may also be used.

3. In addition to above, the fine aggregate shall be so graded that the concrete of the required workability, density and strength can be produced. The method of determining gradation by sieve analysis shall be in accordance with IS: 2386.

6.5.5.2.1 FOREIGN MATERIALS LIMITATIONS IN FINE AGGREGATE

The fine aggregate shall be free from injurious amounts of dust, clay lumps, pyrites, coal, lignite, soft, elongated or flaky particles, shale, alkali, organic matter, loam, mica and other deleterious substances. The percentage of deleterious substances in the fine aggregates, as delivered to the mixer, shall not exceed the values given in Table 6.6, when tested in accordance with IS: 2386.

TABLE 6.6

LIMIT OF DELETERIOUS MATERIALS IN FINE AGGREGATE

Description of test	% By weight	
	River sand	Crushed Sand
a) Material passing 75 micron	3.0 (max)	15.0 (max)
b) Shale	1.0 (max)	Nil
c) Coal and Lignite	1.0 (max)	Nil

d) Clay lumps	1.0 (max)	1.0 (max)
e) Total of other deleterious substances such as alkali, Mica coated grains, soft and flaky particles and loam	2.0 (max)	2.0 (max)
f) Total of all above substances	5.0 (max) *	2.0 (max) *

* Excluding (a)

6.5.5.2.2 ORGANIC IMPURITIES

Aggregate, when tested in accordance with IS: 2386 (Part-2), "The method of test for aggregate for concrete – Estimation of deleterious materials and organic impurities", producing a colour darker than the standard shall be rejected. However, such sand, when tested for mortar-making properties and the mortar develops a compressive strength at 7 and 28 days of not less than 95% of that developed by a similar mortar made from another portion of same sample which has been washed in 3% solution of sodium hydroxide followed by thorough rinsing in water, then the Engineer may permit use of such sand on works.

For sand that is used after washing, the washed water from the sand shall be free from water-soluble chloride and sulphate content. The presence of chloride and sulphate content can be checked with silver nitrate and barium chloride respectively. Prior approval of the Engineer shall be taken for bringing sand from new sand quarry or change in quarry.

6.5.5.2.3 USE OF CRUSHED SAND

If the contractor desires to replace sand partially or completely, with crushed sand, he may do so only if the quality of final product meets all the requirements of these specifications. It shall be noted that crushed sand shall be manufactured by specially crushing it from the aggregate by deploying proper machinery for the same. Crusher dust obtained while producing aggregate shall not be directly used for replacing sand unless it meets the technical specifications/ grading limits specified in Table Nos.6.4, 6.5 and 6.6.

6.5.5.2.4 FREQUENCY OF TESTING AND OTHER CHARACTERISTICS

The fine aggregate shall be tested for physical, chemical & mechanical properties and impurities content as per schedule given in Table Nos. 6.4, 6.5 and 6.6.

6.5.5.2.5 COARSE AGGREGATE

Coarse aggregate for normal concrete shall consist of hard, strong, durable particles of crushed stone and shall be free from thin elongated soft pieces, vegetation or other deleterious matter. It shall have no adherent coating. Coarse aggregate shall have an average specific gravity (saturated surface dry condition) 2.6 or more and no individual value shall be less than 2.55.

6.5.5.3.1 GRADING

The size of normal aggregate shall be selected from the standard sizes given in Table 6.7. The method of determining grading by sieve analysis shall be according to IS: 383. The stones required for making aggregates shall be transported to the crushing plant, preferably to be installed near the site of work and shall be crushed by the Contractor in primary and secondary crushers to yield the aggregates to the required sizes and specification as described under various items of schedule of quantities in Section-VIII of the document. In areas, where there is congestion of reinforcement and embedment, the Engineer may direct the contractor to use smaller size of aggregate without any additional cost for screening off the higher sizes.

TABLE 6.7

GRADING REQUIREMENTS OF COARSE AGGREGATES

Sl. No.	Nominal size	Amounts finer than each sieve (square openings)							
		50 mm	40 mm	20 mm	12.5 mm	10 mm	4.75 mm	2.36 mm	1.18 mm
1	40 to 4.75 mm	100	95 -0	30-70	-	10-35	0-5	-	-
2	20 to 4.75 mm	-	100	95-100	-	25-55	0-10	-	-
3	12.5 to 4.75 mm	-	-	100	90-100	40-85	0-10	-	-
4	10 to 2.36 mm	-	-	-	100	85-100	0-20	0-5	-
5	20 to 10 mm	-	100	85-100	-	0-20	0-5	-	-
6	40 to 20 mm	100	85-100	0-20	-	0-5	-	-	-

6.5.5.3.2 FOREIGN MATERIALS LIMITATION

The amount of deleterious substances in coarse aggregate shall not exceed the limits given in Table 6.8.

TABLE 6.8

LIMIT OF DELETERIOUS MATERIALS IN COARSE AGGREGATE

Sl. No.	**Deleterious substances**	**Maximum percent by weight of total sample**
1	Coal and Lignite	1.00
2	Shale	NIL

3	Clay Lumps	1.00
4	Soft fragments	NIL
5	Material finer than 75 micron	3.00
6	Sum of percentage of all Deleterious materials	5.00

6.5.6 WATER

a) Water used for both mixing of concrete and curing shall be clean and free from injurious amounts of oil, acids, alkalis, salt, sugar, organic materials or other substances that may be deleterious to the concrete or steel. Potable water is generally considered satisfactory for mixing and curing of concrete. The pH value of water shall generally be not less than 6. The sources of water shall have approval of the Engineer. The quality of water shall meet the provisions of IS: 3025 particularly Parts 22 and 23. The sample of water taken for testing shall represent the water proposed to be used for concreting, due attention being paid to seasonal variation. The quality of water shall be tested at every 6 months. The sample shall not receive any treatment before testing other than that envisaged in the regular supply of water proposed for use in concrete or curing. The sample shall be stored in a clean container previously rinsed out with similar water. ***The exploitation of Ground Water for construction work is prohibited at GHAVP site*** .

a) Permissible limits of solids, when tested in accordance with IS: 3025 are given in Table 6.9.

TABLE 6.9

PERMISSIBLE LIMIT FOR SOLIDS

Sl. No.	**Description of test**	**Tested as per**	**Permissible limits (max.)**
1	Organic	IS3025 (Part 18)	200 mg/l
2	Inorganic	IS3025 (Part 18)	3000 mg/l
3	Sulphates (as SO_3)	IS3025 (Part 24)	400 mg/l
4	Chlorides (as Cl)	IS3025 (Part 32)	2000 mg/l for concrete not containing embedded steel and 500 mg/l for reinforced concrete work
5	Suspended matter	IS3025 (Part 17)	2000 mg/l

c) In case of doubt regarding development of strength, the suitability of water for making concrete shall be ascertained by the compressive strength and initial setting time tests of concrete.

d) Average 28-day compressive strength of at least three 15 cm size concrete cubes, prepared with water proposed to be used, shall not be less than 90 percent of the average strength of three similar concrete cubes prepared with distilled water. The cubes shall be prepared, cured and tested in accordance with IS: 516.

e) The initial setting time of test block made with the appropriate cement and the water proposed to be used shall not be less than 30 minutes. The initial setting time shall also not differ by more than +30 minutes from the initial setting time of control test block prepared with the same cement and distilled water. The test blocks shall be prepared and tested in accordance with IS: 4031 (Part 5).

6.5.6.1 USE OF ICE AND CHILLED WATER

a) The Contractor shall study the placement temperature requirement, the ambient conditions and work out the refrigeration plant capacity to meet the construction schedule. It shall be noted that the temperature of the concrete indicated in the drawings/ specifications is at the placing point. The contractor shall submit his scheme of temperature control of concrete with detailed calculations before the actual commencement of work. The temperature control may be achieved either by mixing chilled water or by addition of ice flakes depending upon the ambient conditions and transportation time.

b) Mixing water shall be kept cool by storing it under cover. Storage tank shall always be kept clean. Water shall be transported to the mixing plant in such a way that there is no rise in temperature. If chilled water or crushed ice is used as a part of mixing water to achieve the specified temperature of water, the Contractor shall install and maintain in good working condition a refrigeration plant to produce chilled water at temperature not exceeding $8^{o}C$. The Contractor shall also build and maintain well-insulated adequate capacity storage tanks for cold water with insulated piping. To supplement this refrigeration facility, the Contractor may establish ice plant of suitable capacity. The full quantity of crushed ice shall be stored in cold storage 24 hours in advance of start of concreting. The temperature in the cold storage shall not be higher than ($-2^{\circ}C$).

c) Ice, if used as replacement for a portion or all of the mixing water, shall be produced from water, which meets the requirements of this specification. Ice shall be in flaky condition and such ice flakes shall have thickness less than 3 mm. The ice plant should be capable of producing flaked ice. The Contractor shall make his own arrangement for storing adequate quantity of ice. Commercial ice shall not be used. In case of large pours, where the existing refrigeration capacity is not adequate, the contractor may use commercial ice, subject to the approval of the Engineer, after ensuring that the quality standards of this specification are met with.

6.5.7 CHEMICAL ADMIXTURES

a) The Contractor shall procure all chemical admixtures required in the specification. The Contractor shall ensure consistent behavior of proposed admixtures in concrete mixes and at all ambient temperatures likely to be experienced at project site throughout the year, and especially at the recommended placement temperatures. Contractor shall

arrange for pre-qualification of such admixtures to fulfill the requirements specified in ASTM C-494 at his own cost. Qualification of chemical admixtures shall be carried out as per the guidelines given in ASTM C 494, using concrete with a cement content of 307 kg/m^3. Setting time of concrete with admixtures shall be decided by casting specimens and keeping the same in a temperature controlled room at a temperature of 23 (+/-) 2^0C. Base material of admixture shall be either sulphonated naphthalene formaldehyde based or poly carboxylic ether based only. High range water reducing and retarding admixture conforming to type G of ASTM C-494 shall be used.

b) Generically high range water reducing and retarding admixture shall be of either Sulphonated Naphthalene Formaldehyde condensate (SNF), Sulphonated Melamine Formaldehyde condensate (SMF) or Poly Carboxylate and conform to type G of ASTM C-494 depending on the fines content and limitation of chlorides, sulphates and other alkali contents.

c) The admixture to be used for Viscosity Modifying Agent (VMA) shall generically be either of Modified Cellulose or Poly-ethylene Glycol.

d) Admixture samples, when tested, shall meet the requirements given in Table 6.10.

TABLE 6.10

ADMIXTURE QUALIFICATION TEST

Sl. No	**Description of Test**	**Acceptance values for Type G**
1	Water Reduction as % of Control Mix	18 % minimum (*)
2	Air entrainment	± 1 % of control mix
3	Initial Setting Time Deviation from control At least Not more than	 1:00 hour later 3:30 hours later
4	Final Setting Time Deviation from control At least Not more than	 -- 3:30 hours later
5	Compressive strength As % of Control Mix 1 day 3 day 7 day 28 day	 125 % min 125 % min 115 % min 110 % min
6	Flexural Strength as % of Control Mix 3 day 7 day 28 day	 110 % min 100 % min 100 % min

Sl. No	Description of Test	Acceptance values for Type G
7	Specific gravity at 25^0C	Within ±0.02 of the value stated by manufacturer
8	Solid content	With ± 3% of the value stated by the manufacturer
9	Ph	7-8
10	Chloride content	0.2 % max
11	Infrared Spectrograph	Identification of base material of the admixture

(*) This value is at variance with the ASTM C 494.

6.5.7.1 SAMPLING

a) The manufacturer's tests certificates shall accompany all individual batches of admixtures. Batches of admixture, not accompanied with correlating test certificates, shall not be inducted into the work till the tests are completed and the material found meeting the standards. The batches/lots of admixture, accepted for testing, shall be identified with the unique sample number. Location of the product containers shall be distinctly identified and cordoned off to prevent mix-up with other products and brands and unacceptable materials.

b) Admixture shall be thoroughly agitated by using mechanical agitator, prior to sampling and a composite sample shall be collected representing 25.0 MT of admixture with proper batch identification. Grab sample shall be taken from each batch. Even if number of batches are less than 4, minimum 4 such grab samples shall be taken representing 25 MT of admixture and composite sample shall be prepared by thoroughly mixing the grab samples. Volume of each grab sample and composite sample shall be as decided by the Engineer.

c) It may also be noted that the admixture shall be thoroughly stirred before actual use. Mechanical stirring is mandatory and manual stirring shall not be permitted.

6.5.7.2 BATCH QUALIFICATION

Each batch of 25 MT (or lesser) of admixture shall be tested and qualified before use. All the tests, as given in Table-6.10, except 1-day compressive strength and flexural strength, shall be conducted. Admixture shall be released only after meeting the specified requirements. Infrared spectrograph of each batch shall be compared with the signature infrared spectrograph of that brand taken at the time of brand qualification to ensure consistent quality. In the event of tests failing to meet the specified requirements during batch qualification, the particular batch shall be rejected and removed from site.

Once accepted by the Engineer, one representative sample of 5 litres (approx.) shall be preserved from each batch upto 1 month from its expiry date. Such representative samples shall be identified, tagged and sealed indicating the sample identification

number, brand name, batch number, date of manufacture, date of collection and expiry date.

6.5.7.3 STORAGE

The admixture shall be accompanied by manufacturer's certificate indicating the expiry date. The product shall not be used after this date. Admixture shall be used as per manufacturer's instruction and with the control specified by the Engineer.

Utilization and storage conditions shall conform to in the corresponding technical documentation given by the manufacturer.

Contractor shall make adequate arrangement for procurement of admixture at least 45 days prior to use, as testing time for batch qualification takes minimum 30 days. Adequate quantity of tested material shall be stored to meet the construction schedule.

6.5.7.4 OTHER TYPE OF ADMIXTURES

The Engineer may, at his discretion, instruct the contractor to use any other type of admixture in concrete i.e. admixture conforming to ASTM C-494 Type A to F, water proofing admixture conforming to IS 2645 etc. These admixtures, if used, shall be qualified, on the same lines before use.

6.5.7.5 VISCOSITY MODIFYING AGENT (VMA)

a) Viscosity modifying agent shall be used in self-compacting concrete (SCC) to increase the segregation resistance of concrete. VMA shall be added in SCC as per the recommendations of the manufacture and it shall be ensured through trials that it does not have any adverse effect on any of the properties of green and hardened concrete.

b) The VMA shall generically be of water-soluble polymers, Modified Cellulose or Poly-ethylene Glycol, which are adsorbed on to the surface of the cement granules causing changes in the viscosity and the rheological properties of the mix. It shall be chloride free and compatible with all cements envisaged by IS standards.

c) Sulphonated Naphthalene based superplasticizer SNF is avoided, as it is not compatible with VMA. Other type of VMA can also be used if it meets the desired parameters of SCC, and compatible with the superpasticizer. It may be noted that there is no specific testing for qualification of VMA, other than its meeting desired properties of SCC for each batch of material (VMA).

d) Super plasticizers containing VMA may also be used for the production of self-compacting concrete subject to meeting all the desired properties of SCC.

6.6 CONCRETE MIXING PLANT

A numbers of modern concrete batching and mixing plant capable of producing concrete of specified quality and at the required output rate shall be established by the

Contractor at site. For mixing fly ash at site, Pan type mixer is preferred. A balanced complement of mixing, transporting, handling and placing equipment shall be deployed. Prior to use, the concrete mixing plants shall be completely installed and operated for a sufficient length of time to enable the Engineer to make the necessary physical tests (to assess the performance). Batching plants shall be fully automatic with computerized control along with the facility of automatic moisture correction.

Contractor shall provide, along with the tender proposal, full details of the batching plants to be deployed at site. After the award of the work, the layout of the plants, the full technical data and other details shall be submitted to the Engineer well before the actual setting of the plant.

6.6.1 TYPE OF PLANT

a) The type of plant to be deployed shall be automatic. The term 'automatic' is used to define a plant in which:

i) Batch weights are set on a mix selector manually,

ii) Mixes are batched in weigh hopper by operation of electric switch in one operation automatically,

iii) Ingredients are charged in the mixer, concrete is mixed and unloaded in a hopper in one operation by selecting mix number and operating a push button or through operation by computer.

b) Batching plant shall be capable of producing concrete according to the proportion set and controlled by the computer within the desired accuracy and tolerances specified for each of the ingredients, with different combinations of mixing sequences to produce concrete of different grades with the help of a single command. Plant software shall be capable of giving the batch weight records for each batch along with mixing cycle time in a format approved by the Engineer.

c) Each batching and mixing plant shall preferably comprise offour or five overhead storage bins for coarse and fine aggregate and cylindrical silos for cement, fly ash, GGBS and / or micro silica of adequate capacity, arrangement of adding water and admixture, to meet uninterrupted supply of concrete for placement in different pours. If cement is brought to the site in browsers / bulkers and directly loaded to the silos, then it is preferable to have minimum 3 silos for each batching plant for storage of cement. Alternatively, the silos can be kept connected to all the batching plants by providing interchangeable facility. Separate silos of adequate capacities are to be provided for fly ash, GGBS and micro silica, as the case may be, with suitable arrangement for direct loading and charging into the mixer. For loading fly ash, GGBS and micro silica, pneumatic conveyer shall be used, as screw type conveyers get choked frequently.

d) Storage bin of sufficient capacity for ice flakes shall be installed and fixed in such a way that water from melting ice shall not flow in the mixer through batcher but shall be collected in a conical vessel and drained outside.

e) The least count of weighing dials for 1 cu.m batch size plant shall be as per Table 6.11

TABLE 6.11

CAPACITY AND LEAST COUNT OF WEIGHING MECHANISM

Si.No.	Item	Capacity of dial (Kg.)	Least Count (Kg.)
1.	Cement	600	1
2.	Fly ash	600	1
3.	GGBS	600	1
4.	Microsilica	100	0.2
5.	Aggregate	2500	5
6.	Water	250	1
7.	Ice	250	1
8.	Admixture	25	0.1

f) If the batch size is different from 1 cu.m, then the capacity and least count of dials shall be modified accordingly. However, considering the demand rate of concrete, batching plant mixer of 2 cu.m. Capacity is preferred for all major concrete works.

g) Control room of the batching plant housing the instrumentation shall be free from vibrations and dust and shall be arranged as per the specification of the manufacturer. Indicators shall be fixed in such a way that operator is able to see batching of aggregate, mixing of concrete etc. directly and also all the dial indicators are clearly visible from one point.

h) All operations from charging the mixer to unloading of mix shall be interlocked so that unless mixer is empty, no new batch of ingredients is charged into the mixer.

6.6.2 WEIGHING AND BATCHING

6.6.2.1 WEIGHING UNITS

Every delivery point of aggregate, cement, fly ash, GGBS and/or micro silica into the mixer charging hopper shall have a weighing unit and each weighing unit shall include a visible, spring-less direct reading dial which shall indicate the scale load at all stages of the weighing operation from zero to full capacity. As far as practicable, the scale dials and the weighing equipment shall be in full view of the operator, so that he may conveniently observe the operation of the batcher gates and the discharge of the materials. Provision shall be made for adjustment and change in weights of materials being charged into the hopper.

Bins with adequate compartments shall be provided in the batching plant for fine aggregate and for each required size of coarse aggregate. Each bin compartment shall

be designed and operated so as to discharge efficiently and freely into the weighing hopper with minimum segregation. Means of control shall be provided such that, when quantity desired in the weighing hopper is approached, the gate shall shut off with precision. Weighing hoppers shall be so constructed that it will eliminate accumulations of tare materials and material is discharged fully.

6.6.2.2 MEASURING WATER AND ICE

Water and Ice shall be measured by weight. The mechanism for measuring and delivering water to the mixers shall not permit leakage when the valves are closed. The filling and discharge valves for the water tank shall be so interlocked that the discharge valves cannot be opened before the filling valve is fully closed.

6.6.2.3 MOISTURE CORRECTION

The batching plant shall be provided with at least one moisture probe attached to the fine aggregate bin. This probe shall sense the moisture in the fine aggregate at the time of batching and send the appropriate signal to the computer of batching plant so that adjustment in water quantity and fine aggregate quantity is made.

6.6.2.4 DISPENSER FOR ADMIXTURE

The concrete plant shall include dispensing device to accurately measure and deposit the full quantity of admixture into each mix at one time. The dispenser shall be interlocked with the batching and discharging controls of the water so that the batching and discharge of the admixtures will be automatic. The device shall be capable of ready adjustment to permit varying the quantity of the admixtures to be batched. The equipment shall be kept in a clean and fully operable condition.

6.6.2.5 TOLERANCE IN BATCHING WEIGHMENT ERRORS

The accuracy of weighing devices shall be as per Table 6.12:

TABLE 6.12

ACCURACY OF WEIGHING MECHANISM

Material	Percent of accuracy
Cement / Fly ash/GGBS	± 1 (by weight)
Water/Ice	± 1 (by weight)
Aggregate	± 2 (by weight)
Admixture	± 1 (by weight)
Micro silica	± 1 (by weight)

At least once in a month, the contractor shall check that the quantities of materials leaving the scales comply with the specified quantity within the tolerances. If

discrepancies are noticed, he shall immediately make necessary required corrections and shall undertake re-calibration.

6.6.3 MIXING TIME

a) The mixing time required should be based upon the ability of mixer to produce uniform concrete throughout the entire manufacturing process and for this; the manufacturer's specifications shall be followed. However, final mixing time should be based on the result of mixer performance test (uniformity test) made at frequent intervals throughout the duration of job. The mixing time shall be measured from the time all ingredients are in the mixer. Batch time with audible indicators used in combination with interlocks, to prevent under or over mixing of the batch and premature discharge, should be provided. The mixer shall be design for starting and stopping under full load.

b) In case of concrete with micro-silica, to ensure that agglomerates of densified micro silica break fully, mixing time required would generally be 1.5 times the time required for normal concrete and the same shall be established by conducting trials. Micro silica concrete needs additional mixing time. It is preferable to charge micro silica into the mixer along with coarse and fine aggregate, premix it for 10 seconds followed by charging of remaining ingredient i.e. cement, fly ash, water, ice and admixture into the mixer and final mixing of around 30 to 60 seconds. The time and sequence of loading shall be established by conducting trials.

c) Mixer is considered to pass the uniformity test if two samples taken after discharge of approximately 15% and 85% of the load meet the requirement given in Table 6.13**.**

TABLE 6.13

MIXER PERFORMANCE REQUIREMENTS

Sl. No.	Test	Requirement, expressed as maximum permissible difference in result of tests of samples taken from two locations in the concrete batch
1	Air entrainment	1.0 %
2 a) b)	Slump Average slump is less than 100mm Average slump is more than 100mm	 25 mm 40 mm
3	Average compressive strength at 7 days for each sample, based on the average strength of all compressive test specimens	7.5 %

d) Once the batching plant passes the performance test, for further compliance only slump test will be conducted at the frequency specified in Table 6.13.

6.6.4 RECORDS AND CHARTS

a) The Contractor shall maintain accurate records of the following at the batching plant for each batch:

i) The weight of cement, fly ash, GGBS, micro silica, water and admixture.
ii) The weight of coarse aggregate for each size recorded separately.
iii) The weight of fine aggregate for each size separately.
iv) The concrete Temperature immediately after mixing.
v) Mixing time of each batch, after all the materials are loaded into the mixer.
vi) Time of delivered of the concrete is from the mixer.
vii) Ambient temperature

b) The record shall be maintained by automatic recording and printout. Computer printouts shall also indicate the preset quantity of each ingredient, actual quantity discharged and error in it. The limits specified in the Table 6.12 shall be met (as an average) at the end of loading cycle of each transit mixer.

6.6.5 MAINTENANCE

The mixers shall be maintained in satisfactory operating condition, and mixer drums shall be kept free from hardened concrete. Mixer blades shall be replaced when worn down more than 10 percent of their depth. Should any mixer at any time produce unsatisfactory results or mortar leakage is observed, its use shall be promptly discontinued, till it is repaired.

6.6.6 PROVISION FOR INSPECTION

The complete plant assembly shall include provisions to facilitate the inspection of all operations at all times.

6.6.7 SAMPLING FACILITIES

Suitable facilities shall be provided for readily obtaining representative samples of concrete ingredients from any of the batchers and suitable devices for obtaining representative samples of concrete for determination of properties of fresh and hardened concrete to be made by the Contractor. All necessary platforms, tools and equipment for obtaining samples shall be made available at the start of work and shall be maintained throughout contract period.

6.6.8 CONCRETE SPECIMEN

Concrete specimen shall be prepared from the mixes used in the work and tested to determine the adequacy and accuracy of control for the materials entering into the concrete mix. The Contractor shall perform preparation, storage and testing of the specimen in presence of the Engineer to his entire satisfaction.

6.6.9 TEST WEIGHTS AND CALIBRATION

The Contractor shall provide standard test weights and any other auxiliary equipment, required for checking the operating performance of each scale or other measuring device. All the weighing scales shall be calibrated every month or whenever doubts arise or before any major pour, as directed by Engineer. Batching plant shall be allowed to use for production of concrete only if it meets the specified requirements.

6.7 PRE-REQUISITIES OF CONCRETE

6.7.1 CLASSES OF CONCRETE

Unless otherwise specifically stated as Nominal Mix, all concrete, contemplated under this specification, shall be taken to mean as "**Controlled Concrete**".

6.7.2 CONTROLLED CONCRETE

Controlled concrete is a concrete where the mix proportions are determined by mix design, preliminary mix proportioning and laboratory tests. These shall be carried out at specified intervals and also whenever the Engineer has reasons to believe that there has been a change in the quality, properties, or grading etc of any of the constituents of concrete, which, in his opinion, would impair the strength and /or durability.

Each class of concrete shall be identified by designation consisting of a prefix and two numbers like N/25/40. Prefix 'N', 'H' and 'SH' signifies Normal concrete, Heavy concrete made with hematite aggregates and Super Heavy concrete with a combination of hematite aggregates and chilled iron shots or steel punching respectively. Next two numbers e.g. 25 and 40 would denote the Uniaxial characteristic compressive strength at 28 days in MPa (25 MPa and maximum size of coarse aggregate in mm (40 mm) respectively.

6.7.3 NORMAL CONCRETE

Class designation of concrete shall be as specified on the drawing. Maximum size of aggregate shall be 20 mm unless specified otherwise. However, when concreting has to be carried out in congested areas, maximum size of aggregate may be suitably reduced, with the approval of the Engineer.

Unless otherwise specified on drawings or called for in the schedule of Quantities, the class designation of normal concrete to be used shall, generally, be selected from Table 6.14.

TABLE 6.14

GRADES OF NORMAL CONCRETE

Class	Characteristic Compressive Strength of 15 cm cubes at 28 days in MPa	Maximum size of aggregate in mm
N/10/20	10	20
N/20/20	20	20

N/30/20	30	20
N/35/20	35	20
N/40/20	40	20
N/45/20	45	20
N/50/20	50	20
N/60/20	60	20
Normal Grout	30*	Fine Aggregate

Normal concrete shall have a net unit weight of not less than 2400 Kg/cu.m.
* The compressive strength for grout shall be on cubes having area of face 50 cm^2.

6.7.4 MIX PROPORTIONING CRITERIA

The mix proportioning, in case of OPC concrete shall be based on 28-day characteristic strength. For concrete containing fly ash, GGBS or any other mineral admixture, the concrete acceptance criteria shall be based on 56- day strength. Any other specific requirement, if any, will be as indicated on the construction drawings.

6.7.5 DURABILITY OF CONCRETE

To meet the requirement of durability, the water content as well as water to binder ratio shall be as low as practicable. In addition, there shall be adequate compaction and immediate curing as well as curing for longer period is necessary.

6.7.6 EXPOSURE CONDITIONS

Various conditions for which the concrete will be exposed during its service life are given in the Table 6.15.

TABLE – 6.15

ENVIRONMENTAL EXPOSURE CONDITIONS

Sl. No	Environment	Exposure Condition
1	Mild	Concrete surface protected against weather or aggressive conditions except those situated in coastal area.
2	Moderate	Concrete surface sheltered from severe rain or freezing whilst wet Concrete exposed to condensation and rain. Concrete continuously under water. Concrete in contact or buried under non-aggressive soil / ground water. Concrete surfaces sheltered from saturated salt air in coastal area.
3	Severe	Concrete surface exposed to severe rain, alternate wetting and drying or occasional freezing whilst

		wet or severe condensation. Concrete completely immersed in seawater. Concrete exposed to coastal environment.
4	Very Severe	Concrete surface exposed to seawater spray, corrosive fumes or severe freezing conditions whist wet. Concrete in contact with or buried under aggressive subsoil / ground water.
5	Extreme	Surface of members in tidal zone Members in direct contact with liquid/solid aggressive chemicals

Unless otherwise specified in the drawing, **'Severe' and 'Moderate'** exposure conditions shall be considered for Coastal and inland sites of NPP respectively and mix proportioning of all types of concrete shall be carried out accordingly.

6.7.7 MINIMUM CEMENT CONTENT, MAXIMUM W/C

Unless specifically mentioned in the drawings, the values for minimum cement content and the maximum free water-cement ratio given in the Table 6.16 for different exposure conditions and for 20 mm maximum size aggregate may be used in the mix design.

TABLE 6.16

MINIMUM CEMENT CONTENT, MAXIMUM WATER-CEMENT RATIO AND MINIMUM GRADE OF CONCRETE FOR DIFFERENT EXPOSURES WITH NORMAL WEIGHT AGGREGATE OF 20MM NOMINAL MAXIMUM SIZE

Exposure	Plain Concrete			Reinforced Concrete		
	Minimum Cement Content kg/m^3	Maximum Free water-Cement Ratio	Minimum Grade of Concrete	Minimum Cement Content kg/m^3	Maximum Free water-Cement Ratio	Minimum Grade of Concrete
Mild	220	0.60	-	300	0.55	M 20
Moderate	240	0.60	M 15	300	0.50	M 25
Severe	250	0.50	M 20	320	0.45	M 30
Very Severe	260	0.45	M 20	340	0.45	M 35
Extreme	280	0.40	M 25	360	0.40	M 40

Notes:

a) Cement content prescribed in this table is irrespective of grade of cement and is inclusive of mineral admixture like fly ash, micro silica, GGBS etc

b) Maximum quantity of fly ash that shall be taken into account in the concrete composition for minimum cement content computation specified above shall be 35 % of Minimum cementitious material specified in above table, which is in line with IS 1489 requirements. However, 35% is not a maximum limit on fly ash content of concrete mix proportion.

c) Maximum quantity of GGBS that shall be taken into account in the concrete composition with respect to minimum cement content requirement specified above shall be 65 % of Minimum cementitious material specified in above table, which is in line with IS 455 requirements. However, 65% is not a maximum limit on GGBS content of concrete mix proportion.

d) Minimum cement content shall be increased by 40 kg/m^3 for 10 mm maximum size of aggregate and shall be reduced by 30 kg/m^3 for 40 mm maximum aggregate size.

6.7.8 EXPOSURE TO SULPHATE ATTACK

Requirements for concrete exposed to sulphate attack shall be as per relevant provisions of IS 456. All the recommendations for the type of cement, maximum free water/cement ratio and minimum cement content, which are required at different sulphate concentrations in near-neutral ground water having pH 6 to 9, given in the Table 6.17, shall be followed.

For the very high sulphate concentrations in Class 5 conditions, some form of lining such as polyethylene or polychloroprene sheet; or surface coating based on asphalt, chlorinated rubber, epoxy, or polyurethane materials should also be used to prevent access by the sulphate solution.

The decision of Engineer shall be followed in this regard. Such liner shall be measured and paid separately.

TABLE 6.17

REQUIREMENTS FOR CONCRETE EXPOSED TO SULPHATE ATTACK

Class	Concentration of sulphates expressed as SO_3			Type of Cement	Dense fully compacted concrete made with 20mm nominal Max. Size of Aggregate complying with IS 383	
	In soil		In ground water (g/l)		Minimum cement content kg/ m^3	Maximum W/C ratio
	Total SO_3 (%)	SO_3 in 2:1 water soil extract(g/l)				
1	Traces	< 1	< 0.3	OPC, PPC or Portland Slag cement	280	0.55

	<0.2					
2	0.2 to 0.5	1 to 1.9	0.3 to 1.2	OPC, PPC or Portland Slag cement Super sulphated cement or Sulphate resisting Portland Cement	330 310	0.50 0.50
3	0.5to1	1.9 to 3.1	1.2 to 2.5	Super sulphated cement or Sulphate resisting Portland Cement PPC or Portland Slag cement	330 350	0.50 0.45
4	1 to 2	3.1 to 5	2.5 to 5	Super sulphated cement or Sulphate resisting Portland Cement	370	0.45
5	More than 2	> 5	> 5	Sulphate resisting Portland Cement or Super sulphated cement with protective coatings	400	0.40

Notes:

a) Cement content given in this table is irrespective of the grade of cement.

b) Use of Super sulphated cement is generally restricted where the prevailing temperature is above 40°C.

c) Supersulphated cement gives an acceptable life provided that the concrete is dense and prepared with a W/C ratio of 0.4 or less in mineral acids, down to pH 3.5.

d) The cement content given in above table is the minimum recommended. For SO_3 contents near the upper limit of any class, cement content above these minimums are advised.

e) For severe conditions, such as thin sections under hydrostatic pressure on one side only and sections partly immersed, consideration should be given to a further reduction of W/C ratio.

f) Portland Slag Cement conforming to IS: 455 with slag content more than 50% exhibits better sulphate resisting properties.

g) Where chloride is encountered along with sulphate in soil or ground water, ordinary Portland cement with C_3A content from 5 to 8% shall be desirable to be used in concrete, instead of sulphate resisting cement. Alternatively, Portland slag cement conforming to IS: 455 having more than 50% slag or a blend of ordinary Portland cement and slag may be used provided

sufficient information is available on performance of such blended cements in these conditions.

6.8 PROPERTIES OF CONCRETE

6.8.1 CONCRETE MIX PROPORTIONING

Concrete shall be proportioned to obtain workable mixes for intended purpose and to meet the strength and finish requirements.

Preliminary mix proportioning shall be established by conducting trials by the contractor, well in advance, so as to meet the time schedule. Mix proportion adopted shall meet the specified properties of green as well as hardened concrete.

While conducting trials, contractor shall use the ingredients that are qualified for actual work. All efforts shall be made to carry out the trials in laboratory and after the mix is finalized, final trials shall be done at batching plant for final qualification of the mix proportion.

6.8.2 TARGET MEAN STRENGTH

The target mean strength of concrete mix shall be equal to the characteristic strength plus 1.65 times standard deviation. The standard deviation for each grade of concrete shall be calculated separately. When sufficient test results for a particular grade of concrete are not available, the value of standard deviation given in Table 6.18 may be assumed for mix proportioning in the first instance. As soon as the test results on sufficient number of samples are available, actual standard deviation shall be calculated and used in mix proportioning. However, when adequate past record for a similar grade exists the same may be used for deciding target mean strength.

TABLE 6.18

ASSUMED STANDARD DEVIATION

Grade of Concrete	Assumed Standard Deviation MPa
M 10 M 15	3.5
M 20 M 25	4.0
M 30 M 35 M 40 M 45 M 50 M 60	5.0

Note:

a) The above values correspond to the site control having proper storage of cement; weight batching of all materials; controlled addition of water; regular checking of all materials, aggregate grading and moisture content; and periodical checking of workability and strength. In case there is deviation in the control measures at site, the value of standard deviation given in the Table-6.18 shall be increased by 1 MPa.

6.8.3 MIX PROPORTIONING METHOD

Concrete mix proportioning may be done by methods given in IS 10262, SP-23, ACI 211.1, or on the basis of past experience or by any other suitable method so that the final product meets the specified requirements for green as well as hardened concrete. Efforts shall be made to keep cement content as well as unit water content as minimum as possible, with the use of suitable quality of chemical admixture.

6.8.4 POZZOLANIC MATERIAL

Fly ash, micro silica or ground granulated blast furnace slag (GGBS), individually or in combination, may be used in concrete along with OPC of 43 or 53 grade with the approval of Engineer. The upper limit for use of these pozzolanic materials is as given below:

a) Fly ash - 50% (max.) of total cementitious material for RCC and Prestressed concrete and 70%(max) for PCC
b) Micro silica - 7.5% (max.) of total cementitious material
c) GGBS - 65% (max.) of total cementitious material for RCC and Prestressed concrete and 80%(max) for PCC

However, minimum cement content requirement specified in 6.7.7 above shall be fulfilled. It has to be ensured that desired concrete characteristics are met with. In case of self-compacting concrete, fly ash quantity in excess of 50% can be used to meet the requirement of higher fines content.

6.8.5 WORKABILITY AND SLUMP

The workability measured in terms of slump shall be determined by slump tests as per IS 1199. As majority of concrete is desired to be placed using pumps, the workability of concrete shall be such that mix is pumpable. As a general guideline, slump of 125 mm at placement point is suitable for pumping of concrete. The requirement of slump for various pours, based on the placement methods and reinforcement congestion shall be decided at site with the concurrence of the Engineer.

6.8.6 UNIT WEIGHT

Normal concrete should have a net dry theoretical unit weight of 2400 kg/m^3, when tested as per IS 1199. The unit weight of concrete of any grade shall not be lower than 2375 kg/m^3.

6.8.7 AIR CONTENT

Air content of the concrete shall be tested as per IS 1199. While deciding on mix proportioning, air content for different aggregate sizes shall be as per Table 6.19

TABLE 6.19

AIR CONTENT OF CONCRETE FOR DIFFERENT MAXIMUM AGGREGATE SIZE

Maximum Aggregate Size	Max Air Content
40 mm	1%
20 mm	2%
10 mm	3%

The actual air content of concrete mix shall not exceed by more than 1% of the values given in Table 6.19.

6.8.8 SETTING TIME

Setting time of concrete shall be determined as per IS 8142. As the setting time depends on the temperature of concrete at the time of production as well as ambient conditions, it is required to check the setting time of concrete under same temperature and ambient conditions, as envisaged in the work.

Final setting time of concrete may be kept around 10 hours during summer and around 12 hours during winter. This parameter is required to be established for different ambient conditions for deciding time at which green cutting at construction joints is to be carried out.

6.8.9 BLEEDING

Bleeding of concrete shall not exceed 5% of the water content of the concrete, when tested as per IS 9103.

6.8.10 CHLORIDE CONTENT IN CONCRETE

The total acid soluble chloride in fresh concrete determined as per IS 14959 Part-1 shall not exceed 0.6 kg/m^3 and 0.4 kg/m^3 for reinforced and pre stressed concrete respectively.

6.8.11 CUBE COMPRESSIVE STRENGTH

Uniaxial Compressive cube strength shall be determined on 150 mm size cubes, as per IS 516.

6.8.12 CYLINDER COMPRESSIVE STRENGTH

Uniaxial Compressive cylinder strength shall also be determined on 150 mm diameter 300 mm long size cylinder, as per IS 516.

Uniaxial characteristic compressive cylinder strength shall not be less than 80% of characteristic compressive cube strength.

6.8.13 Deleted

6.8.14 FLEXURAL STRENGTH

Flexural strength of concrete shall be determined as per IS 516. Flexural strength shall not be less than $0.7\sqrt{f_{ck}}$ MPa where f_{ck} is the characteristic compressive cube strength of concrete in MPa.

6.8.15 MODULUS OF ELASTICITY

The modulus of elasticity of concrete shall be determined as per IS 516. The modulus of elasticity shall not be less than $5000\sqrt{f_{ck}}$ MPa, where f_{ck} is the characteristic compressive cube strength of concrete in MPa.

If the actual measured value differs by more than ± 20% from the value obtained from the above expression then it shall be reported to the Engineer.

6.8.16 PERMEABILITY

Permeability shall be determined by conducting Rapid Chloride Penetration Test (RCPT) as per ASTM C-1202. RCPT value shall not exceed 2000 Coulombs at 56 days.

6.8.17 TRIAL MIX AT LABORATORY

Based on the guidelines given above concrete mix design and proportioning shall be carried out so that it meets the requirements of strength, workability and durability.

Preliminary trials shall be carried out to optimize the quantity of cement, pozzolanic materials and other ingredients of concrete. To qualify a mix proportion, at least 4 trials shall be carried out in the laboratory using the preliminary mix design. Following tests shall be carried out on these mixes.

(a) Slump at 0 min, 30 min and 60 min.

(b) Unit weight

(c) Air content

(d) Initial and final setting time

(e) Compressive cube strength at 7, 28 and 56 *days

(f) Split tensile strength**

(g) RCPT at 56 days

* Only for concrete containing fly ash, GGBS or other pozzolana
** Only for containment structure or specified elsewhere

The concrete shall meet the specified values for all the above properties. The mean of 28 days cube compressive strength of all the four sets shall be more than or equal to fck + 4.0 MPa and individual test value shall be greater than or equal to fck, where fck is the characteristic cube strength of the concrete in MPa.

6.8.18 ACCEPTANCE TEST AT BATCHING PLANT

To ensure that laboratory proportioned concrete mix meets all the requirements when produced using the actual batching plant and other equipment, at least 4 trials shall be conducted at batching plant. It has to be ensured that all the requirements specified in above clause are met with. At least one test shall be conducted to check the yield of the concrete. In case of significant difference from the theoretical yield and the observed yield, it shall be investigated and rectification measures shall be taken.

Contractor shall submit a detailed report on the concrete mix proportioning to the Engineer for his approval. This report shall include the test results on concrete ingredients, laboratory trial results and batching plant trial results.

6.9 TESTS ON CONCRETE

Samples from fresh concrete shall be taken as per IS 1199 at the placement point or pumping point. Frequency of testing shall be as given in Table 6.20

TABLE 6.20

FREQUENCY FOR DETERMINATION OF PROPERTIES OF FRESH AND HARDENED CONCRETE

Sl. No.	Description of test	Frequency of testing
1	Slump	First 3 transit mixers and then from every 5th transit mixer
2	Temperature	First 3 transit mixers and then from every 5th transit mixer
3	Unit weight	At the time of casting of cubes one sample per day for each grade
4	Air content	One sample per week for each grade
5	Initial and final setting time	One sample per week for each grade
6	Bleeding	Whenever required
7	Cube compressive strength 7, 28 and 56* days	One sample per 50 cum up to 100 m^3 of concrete, there after one sample for each 100 m^3 or part

Sl. No.	Description of test	Frequency of testing
		thereof. At least one sample on each day of concreting for each grade.
8	RCPT	One sample per week for each grade
9	Chlorides and sulphate content test	One sample for each grade of concrete per six monthly

- Only for fly ash concrete/GGBS concrete.
- One sample for strength test means sufficient number of cubes to determine average of at least 3 cubes at specified time

6.9.1 ACCEPTANCE CRITERIA

Concrete of each grade shall be analyzed separately. The concrete shall be deemed to comply with the compressive strength requirements when both the following criteria are met with:

a) The mean strength determined from any group of four consecutive test results compiles with the value given in column (2) of Table 6.21

b) Any individual test result complies with the value given in column (3) of Table 6.21

TABLE 6.21

COMPRESSIVE STRENGTH COMPLIANCE REQUIREMENT

Specified Grade	Mean of the Group of 4 Non-Overlapping Consecutive Test Results in MPa	Individual Test Result in MPa
(1)	(2)	(3)
M 15	$\geq (f_{ck} + 0.825$ X established standard deviation (rounded off to nearest 0.5 MPa) or $(f_{ck} + 3)$ MPa Whichever is greater	$\geq f_{ck} - 3$ MPa
M 20 or Above	$\geq (f_{ck} + 0.825$ X established standard deviation (rounded off to nearest 0.5 MPa) or $(f_{ck} + 4)$ MPa Whichever is greater	$\geq f_{ck} - 4$ MPa

NOTE:

a. In the absence of established value of standard deviation, the value given in Table 6.18 may be assumed, and attempt should be made to obtain result of 30 samples as early as possible to establish the value of standard deviation.

b. Concrete is liable for rejection, if criteria mentioned in Table 6.21 is not met with.

c. If the concrete, after opening the shutter, is found to be porous or honeycombed, or concrete placing is interrupted without providing a proper construction joint or the reinforcement has been displaced beyond the tolerances specified, or construction tolerances have not been met with, it is liable to be rejected.

d. However, the same may be accepted if remedial measures are feasible and if the same are carried out to the satisfaction of the Engineer-in-charge.

6.9.2 USE OF 7 DAYS TEST

For any mix, a correlation between 7 day and 28 day strengths may be established in the laboratory. Soon after a job starts, a similar correlation shall be established during actual progress of the work. After the correlation has been established, the results of the 7 day test may be used as the precursor for the expected compressive strength at 28-days. If 7-day test indicates low compressive strength, corrective measures shall be taken without waiting for 28-day strength results. Similarly for concrete with fly ash, GGBS and micro silica, co-relation shall be established between 7, 28 and 56-day compressive strength.

6.9.3 FAILURE TO MEET STRENGTH REQUIREMENT

In the event of concrete, tested in accordance with the relevant standards, fails to meet the acceptance criteria specified in Table 6.21 above with the approval of Engineer, any or all of the following measures shall be taken by the contractor, with no extra cost to the owner.

1. Taking cores from the structural element, where the test has failed, (IS: 456).
2. Extended curing of the concrete represented by the specimen.
3. Load tests on part of structures as per IS: 456.
4. Non -destructive test on structure.
5. Replacement of affected part / parts of the structure.

6.9.4 NON DESTRUCTIVE TESTS

In case of doubts about the quality of concrete in the construction, non -destructive tests shall be conducted as directed by the Engineer. The tests shall be carried out by a specialized agency as per the provisions of IS 456. Based on the NDT evaluation, decision on acceptance of structure or otherwise shall be taken by the Engineer.

6.9.5 CORE TEST

Three cores shall be extracted from the structure for determination of compressive strength represented by that structural element. The diameters of core shall be at least 3 times the maximum size of aggregate used in the concrete and height to diameter ratio shall be 2.0. Core shall be tested as per IS 516. Concrete in the member, represented by a core, shall be considered acceptable, if the average equivalent cube strength of the

core (computed as 125% of the core cylinder strength) is equal to at least 85 percent of the specified characteristic strength and no individual average equivalent cube strength of core has strength less than 75% of the specified characteristic strength.

6.10 CONCRETE PRODUCTION, TRANSPORTATION & PLACEMENT

6.10.1 TEMPERATURE CONTROL

a) The concrete placement temperature shall be specified in the construction drawing. Normally, four different placement temperatures i. e. not exceeding 19^0C, 23^0C, 29^0C & 38^0C may be specified in the drawings. Generally, concrete temperature at the production point shall be maintained lower than the specified placement temperature so as to meet the criteria of specified placement temperature. Required temperature shall be achieved by reducing the temperature of water, replacement of part of mixing water with ice flakes and also by controlling the temperature of coarse and fine aggregate.

b) The stockpiles of the aggregate shall be protected from direct sunlight to avoid heating of aggregate. Wherever water is sprayed, suitable correction shall be applied so that the mix proportioning is not altered. Water shall be sprayed on the aggregate stockpile at every 300 mm or 450 mm height as the stockpiles are built up. The stockpiles, thereafter, shall be kept cool by water sprays. Fine aggregate may be stored under shed / in covered area, if the contractor so chooses.

c) If necessary, the coarse aggregate shall be taken into the bins and chilled water at temperature not more than 8^0C shall be sprayed on it through perforated pipe and allowed to be drained through screen fixed at the bottom. Draining screen shall remove excess water from the aggregate. The capacity and arrangement of the bins shall be such as to supply moisture free cooled aggregate to the top of the batching plant so that continuous supply of temperature controlled concrete is maintained.

6.10.2 TRANSPORTATION

a) The concrete shall be transported from the batching plant to the placement point as rapidly as possible by using insulated transit mixers for preventing segregation and loss of any of the ingredients. During hot weather, transit mixer shall be insulated to reduce loss of water by evaporation and heating of concrete from the ambient heat.

b) Once the concrete is mixed in the batching plant, no further water shall be added.

c) Concrete shall be placed and compacted in its final position within the forms within 90 (Ninety) minutes after the addition of water to the mixer or initial setting time of the concrete whichever is less.

d) The Concrete that has been left standing and has become stiff, such that it cannot be placed in satisfactory condition, shall be removed from the place of work immediately.

e) All equipment, used for transporting and placing of concrete shall be maintained in clean condition. All buckets, hoppers, chutes, transit mixers and other equipment shall be thoroughly cleaned periodically during placement and after completion of concreting.

6.10.3 RE-DOSING OF ADMIXTURES

a) In case, when transit mixer reaches placement point, the loss of slump is observed, re-dosing of admixture may be carried out, to get required consistency for getting pumpable mix. However, basis for re-dosing shall be established by conducting trials in advance to establish re-dosing requirement for getting required slump. The total quantum of admixture established at the trial stages shall, however, not be exceeded during re-dosing.

b) Suitable arrangements for re-dosing of admixture with dispensing unit shall be made to ensure accurate re-dosing and proper mixing.

c) Record shall be maintained for each such re-dosing and shall be incorporated in batch weight record of batching plant. Samples for determination of compressive strength and other parameters shall be taken only after re-dosing.

6.10.4 PLACING OF CONCRETE

a) The concrete shall be preferably placed to its final position in the structure using pumps and placer booms in such a manner that both quality and uniformity of concrete, in terms of W/B or W/C ratio, slump, air content and homogeneity is preserved.

b) Before any concrete is placed, the entire placing programme detailing equipment, layout, and proposed method shall be submitted to the Engineer for approval. No concrete shall be placed until the Engineer's approval is obtained. Such plan shall include all the standby arrangements and shall be submitted at least 48 hours prior to actual concreting.

c) Sufficient plant capacity and transportation equipment shall be available to ensure continuous delivery of concrete at the desired rate of pour. The rate of delivery of concrete shall be such as to ensure proper handling, placing, vibrating and finishing of the concrete and to ensure that the cold joint is avoided. No concrete shall be transported in open, while it rains. If there is any sign of washing of cement and sand, the concrete shall be removed immediately. If the concrete is to be placed at night, sufficient illumination shall be ensured. Safe working condition shall also be ensured.

d) The method of delivering and handling of concrete shall be such as to facilitate placing with minimum of re-handling and without damage to the structure or the concrete.

e) All items to be embedded in concrete shall be correctly positioned and securely held in position, well in advance of placing of concrete. However, shutter alignment shall be checked and cleared only after fixing and correctly aligning the embedded parts.

f) Concrete shall be deposited at or near its final position in the form. The concrete shall not be pushed laterally with the help of vibrator. Struts, stays and braces serving temporarily to hold the forms in correct shape and alignment during the placing of concrete, shall be removed only when the concrete placing has reached an elevation rendering their service unnecessary. These temporary members shall be entirely removed from forms and not buried in the concrete.

g) While preparing for placing of concrete, all sawdust, wood chips and other construction debris, shall be removed from the forms. Prior to placing of concrete on a rock surface, it shall be thoroughly cleaned and soaked with water for about 24 hours and surface shall be remain moist condition.

h) Concrete shall be placed in such a way that segregation is avoided and also the displacement of the reinforcement and embedment is avoided. Open troughs and chutes shall be of metal or metal lined. Where steep slopes are required, the chutes shall be equipped with baffles or be in short lengths to adjust the direction of movement. The addition of water, at any point in the system of transportation, to facilitate the movement of concrete shall not be permitted. All chutes, troughs and pipes, shall be kept clean and free from coatings of hardened concrete by thoroughly flushing them with water after each placement. Water used for flushing shall be discharged clear of the structure. Concrete shall neither be permitted to fall freely from a height of more than 1.50 m nor to strike the forms at an angle. Where drop chutes are used, a sufficient numbers must be provided so that the concrete discharged from the chutes are not required to flow laterally more than 10 m However, SCC can flow horizontally upto approx. 12 m to 15 m without segregation. Where a drop chute is swung from the vertical, the bottom two sections must be maintained in a vertical position to avoid segregation. Flushing water quality shall be same as that of the water, which is being used, for making concrete. Based on the work demand, if lift height is to be increased beyond 1.5 m proper arrangements for vibration shall be ensured. In locations, where direct placement is not possible and in narrow forms, suitable drop chutes or “elephant trunks” shall be provided to confine the concrete during placement.

i) Concrete shall not be placed into the forms, until the cleaning of concrete surfaces of previous pours and the placement of reinforcing steel and embedded parts have been inspected and cleared by the Engineer.

j) Storm water or water from curing of concrete, which may get accumulated on the surface of the bedding layer, shall be removed by suitable means before start of placement. No concrete shall be placed on a water-covered surface. However, the surface must be sufficiently soaked and shall be in saturated surface dry condition.

k) Concrete shall be placed in successive layers ranging in thickness not exceeding 500 mm or as directed by the Engineer. The bucket loads or other units of deposit shall be spread progressively along the face of the layer with such overlap as will facilitate spreading the layer of uniform depth and texture with a minimum hand shoveling. Any tendency to segregation shall be corrected by shoveling stones into mortar rather than mortar on to stones. If such condition arises, the cause or causes shall be investigated

and corrective action shall be planned. If required, mix proportion can be revised or method of placement can be modified.

l) When less than a complete layer is placed in one operation, it shall be terminated at a vertical bulkhead. Each layer of concrete shall be placed and compacted before initial setting of concrete of the previous layer takes place, to prevent injury to green concrete and to avoid separation between the consecutive layers.

m) During hot weather and rains, the concrete shall be covered with tarpaulins. Transportation, placement and consolidation of concrete shall be done in shortest possible time. Adequate precautions shall be taken to cover the transit mixer and chilled water may be sprayed over the transit mixer and the pipelines to maintain the temperature during the hot weather.

n) When concrete is to be placed in hot weather conditions, special provision shall be made for handling, placing and protecting the concrete, to ensure that concrete of full strength and free from damage, is obtained. For meeting the desired objective, means such as concreting during cooler hours of the day, use of chilled water, cooling of pipes etc., shall be resorted to. Commencement of concrete pour shall be avoided during heavy rains, storms and high winds.

6.10.5 COMPACTION

a) Vibrator should be inserted and withdrawn vertically at close intervals, using a systematic pattern of vibration to ensure that all concrete is adequately consolidated. As long as a vibrator needle sinks into the concrete by its own weight, it is not too late for the concrete to benefit from re-vibration, which improves compressive and bond strengths. Vibrators should not be used to move concrete laterally

b) On vertical surface, where air void holes are expected, voids can be reduced by the use of form vibrator or light tamping with wooden mallets.

c) Vibrators shall be manipulated so as to thoroughly work the concrete around the reinforcement and embedded fixtures, and into corners and angles of the forms.

d) Internal vibrators shall be inserted in a vertical position only, at intervals of about 450 mm depending upon the mix, the equipment used, the type of structure and experience gained on job. The vibrator needle shall be inserted by minimum 100mm in the previously laid layer. The zone of influence of needle vibrator is approximately 100 times cross sectional area of the needle being used. The vibrators shall be withdrawn slowly, approximately at the rate of 75 mm/sec. The spacing shall provide some overlapping of the area vibrated at each insertion. In no case shall vibrators be used to move concrete laterally inside the forms. Vibrator needle shall be kept clear of forms least by 100 mm. Over-vibration as well as under vibration shall not be done.

e) The internal-immersion type vibrators shall be high frequency vibrators with speed of not less than 7000 rpm when immersed in the concrete. Vibrators shall be used in sufficient numbers and power of each unit to properly consolidate all concrete in each

layer immediately after it has been placed in the forms. It shall be ensured that sufficient numbers of vibrators are available at site along with adequate standby units.

f) While placing concrete in layers, which are advancing horizontally as the work progresses, great care shall be taken to ensure adequate vibration, blending and melding of the concrete between the succeeding layers. The vibrator shall penetrate full in the layer being placed and also penetrate the layer below by about 50 mm while the under-layer is still plastic, to ensure good bond and homogeneity between two layers and prevent formation of cold joints.

6.10.5.1 USE OF FORM VIBRATORS

In case of the columns having congestion of reinforcement, supplemental form vibration may be used in addition to needle vibrators. Care should be taken to avoid excessive vibration, which would cause a weak paste on surface. However, this shall be preplanned activity and shutter as well as staging shall be designed for the additional loads form the vibrators.

6.10.5.2 USE OF SURFACE VIBRATORS

Surface vibrators may be used for horizontal elements like slabs. The vibrator operator shall be qualified before deploying on a job. Re-qualification shall be carried at suitable interval.

6.10.6 CONSTRUCTION JOINTS AND KEYS

When the work is to be interrupted, horizontal and vertical construction joints and bonding keys shall be located and shall conform to the details given on the drawings. In case of water retaining structure, containment structure and other structures, water stops as specified on the drawing shall be provided.

In case of columns, beams and slabs etc, the location of the joints shall be as indicated in the drawing or as directed by the Engineer. Concrete in a beam shall be placed throughout, without a horizontal joint. Before fresh concrete is placed, cement skin or any loose or porous material of partially hardened concrete shall be thoroughly removed and cut back until the solid face is exposed and surface made rough by hacking, or any other method. Rough surface shall be thoroughly wetted for about two hours and shall be in surface dry condition before new layer of concrete is placed over it.

6.10.7 TREATMENT ON SUSPENSION OF WORK

Whenever work is suspended on any section for more than two hours, the horizontal edges of the concrete next to the forms on surfaces that will be exposed shall be brought to a horizontal plane perpendicular to the plane of the forms and treated, so that the finished work will show smooth straight lines.

6.10.8 EXPANSION JOINTS AND SEPARATION JOINTS

These joints in concrete structures shall be provided, as specified in the drawing. The thickness of polythene sheet, if used, shall not be less than 500 microns. For Expansion joints relevant specification shall be followed.

6.10.9 WASH WATER

Wash water shall be removed in a manner to prevent running down and staining of concrete surfaces, exposed on completion of the job. Should unsightly wash-water streaks develop on the exposed surface, the same shall be removed to get a uniform colour and texture.

6.10.10 PLACEMENT INTERVAL

Placement interval between two subsequent or adjacent pours shall be as specified in the drawing.

6.10.11 CONSTRUCTION JOINT TREATMENT

Green cutting shall be made to treat the entire construction joint. Suitable surface retarder shall be used to retard the setting of concrete to a depth of 5 to 7 mm from the exposed surface that is going to receive subsequent concrete.

Green cutting shall be done by using air water jet at a suitable pressure to remove laitance from concrete surface at construction joint, exposing aggregate matrix, and shall be done only after the concrete is in final set condition. The water from the air water jet, used for green cutting of the concrete surface, shall be properly drained so as not to harm the quality of the concrete already placed. It shall also be ensured that this water does not get stagnated on the surface of concrete, depositing washed cement particles. As a pre-qualification, field mock-ups shall be conducted to check the adequacy of the material and method to be deployed on the job, before adopting in the field. In case of change in material source / type or methodology of green cutting, pre-qualification shall be redone. In areas where green cutting is not feasible, spraying of retarders followed by wire brushing immediately after final setting shall be adopted.
Approved brand of surface retarding (set retarding) agent shall be used for preparation of construction joint by green cutting of concrete. It shall be solvent free poly-hydroxyl compound and shall have a distinctive colour, which could be easily identifiable on its application over concrete. It shall be suitable for removing the cement-sand matrix between 5 to 7 mm depth after final setting time, when air water jet with a pressure of around 7 Kg/cm^2 from distance of approx. 500 mm is used. It may be noted that there is no specific testing for qualification of surface retarders other than its meeting desired performance specified above.

6.10.12 PLACEMENT OF CONCRETE AROUND LARGE OPENINGS

While placing concrete around large openings in walls, adequate care shall be taken to ensure proper flow and compaction of concrete on the underside of such openings. Adequate number of windows shall be provided in the formwork for air to escape and also for insertion of vibrators. Once the concrete reaches the level of such window, the same shall be properly closed before proceeding with further concreting.

6.10.13 PLACING CONCRETE BY PUMPING

a) As far as possible, concrete shall be placed using pumping. A steady supply of pump-able concrete is necessary for satisfactory pumping. Concrete pumps to be deployed on the work shall be able to deliver concrete at a desired rate up-to the placement point uninterruptedly.
b) Requisite numbers of concrete pumps, capable of pumping concrete at required rate, together with a complement of pipelines, accessories, spare parts, power controlled placer booms, experienced pump operators and maintenance staff shall be deployed.
c) The pumping plant shall be installed on each occasion, with preliminary mock operation for a sufficient length of time prior to scheduled placement of concrete, to enable conducting pump-ability tests and necessary adjustments for the mix proportioning, prior to use in actual work.

6.10.14 PUMPABILITY TRIALS

No mix shall be used in actual work until pump-ability trial is conducted. The actual field condition shall be simulated. The batching and conveying by transit mixers shall be in the same way as that will be in actual work. The pipe and hose layouts shall simulate the actual condition, as far as practicable. The system shall be able to meet uninterrupted desired supply of cohesive mix at the placement point. The samples shall be collected at batching plant, at pumping point and at placement point after pumping for slump and determination of compressive strength.

6.10.15 FIELD PRACTICES

a) Proper planning of concrete supply, pump location, line layout, placing sequence and the entire pumping operation shall be done by the Contractor, before commencement of concreting.

b) The pumps shall be as near to the placing area as practicable and proper access roads shall be available for movement of transit mixers and other equipment around the location.

c) Direct communications shall be maintained between the pump operator, concrete placing crew and the batching plant. As a final check, the pump shall be started and operated without concrete to assess that all moving parts are in operating conditions.

d) The mortar shall be pumped into the line to provide initial lubrication for the pump and pipeline. The mortar used for lubrication shall be collected in the bucket and disposed

off. This mortar shall not be placed in the forms. As soon as concrete is received, the pump shall be run slowly until the lines are completely filled and the concrete is slowly moved. Once the pumping starts, the operator shall ensure that the hopper of the pump is not emptied beyond a certain level, as air may enter the pipeline and cause choking.

e) Continuous pumping should be ensured. If delay occurs due to supply of concrete, form repairs, or any other reason, the pump shall be slowed down to maintain some movement of the concrete till normal supply is resumed. For longer delays, the concrete in the receiving hopper shall be kept moving in the line by giving one stroke of the pump at longer interval. In confined areas, attempt shall be made by the Contractor to run a return line back to the pump, so that the concrete can be re-circulated during such delays.

f) Minor blockages shall be cleared by operating a few strokes of the pump in reverse direction and then by returning to normal forward pumping. If this fails, a succession of reverse and forward strokes shall be carried out to remove the blockage. Should this fail, the blockage may be due to air lock and the entrapped air has to be removed.

g) Blockages in the pipe are usually assessed by the sound when the pipe is struck. To remove the obstruction, the concrete pipe shall be taken out at the assessed location and cleaned. The pumping process shall then be started again.

h) This method of checking the blockage and setting it right shall be done as early as possible, as excessive delay will cause setting of concrete in the pipeline downstream of the blockage. When the blockage is being found out and remedial measures taken, the pump shall periodically be given one or two strokes forward to keep the concrete in motion. If blockage occurs in the placer boom, a pipe joint near the base of the placer boom shall be opened and the boom made vertical to drain the concrete by gravity.

i) The termination of pumping operation shall be carefully planned to utilize the concrete dormant in the pipeline and the hopper, when the pump is stopped. However, concrete at placement point shall be kept green, avoiding cold joint, by operating standby pump or by any other standby arrangement.

j) When the form is nearly full, and there is enough concrete in the line to complete the placement, the pump shall be stopped and a go-devil be inserted and forced through the line to clear it out. Water under pressure shall be used to push the go-devil. The go-devil shall be stopped about one meter from the end of the line, so that the water in the line does not spill over into the placement area. After flushing, water in the pipe shall be removed by drain cock provided for this purpose, in the lowest part of the line. After all concrete has been removed from the line, pipes and equipment shall be immediately cleaned.

6.10.16 QUALITY CONTROL

Contractor shall ensure good workmanship and also the plant shall be maintained to meet peak demand. Degree of control on all the concrete operation, right from selection

of the ingredients to the final testing of specimen, shall be in line with the approved Quality Assurance Plan.

The Contractor shall engage experienced supervision at all levels. Complete crew, engaged in each of the concreting activity, shall be duly qualified for a particular activity and shall demonstrate their skills and capabilities to produce the final product meeting specified parameters.

6.10.17 CURING OF CONCRETE

a) Exposed surface of concrete shall be kept continuously in a damp or wet condition by ponding or by covering with a layer of sacking, canvas, hessian or similar materials and kept constantly wet for at least 7 days (10 days for hot weather condition) from the date of placing concrete in case of OPC Concrete and at least 10 days (14 days for hot weather condition) where mineral admixture or blended cement is used. The Quality of curing water shall be the same as that used for mixing concrete. Any type of the covering that would stain or damage the concrete during or after the curing period shall not be permitted. Covering shall be kept continuously wet during the curing period.

b) The structural elements with concrete having low water binder ratio and also when cement is partially replaced by pozzolanic material, the curing shall be done in two stages viz., initial curing and final curing.

c) **Initial Curing:** The initial curing shall start immediately after finishing. The concrete surface exposed to environment shall be kept covered by plastic sheet or other type of impermeable covers. The wet curing shall start immediately after the final set. This shall be carried out with the help of placing wet burlaps over the concrete surfaces.

d) **Final curing:** The final curing shall be done with water. It shall commence immediately after initial curing and continue upto a minimum period specified above. Hessian cloth can be wrapped on to columns and on vertical surfaces and the same shall be kept wet all the time by a suitable arrangement.

e) Contractor shall make suitable arrangement for continuous water supply, along with necessary equipment for getting a nozzle pressure of not less than 7 kg/cm^2, even at the highest elevation, for convenient and effective jetting on concrete surfaces for green cutting, for cooling aggregate, for curing and for other requirements. All necessary appliances such as hose, sprinklers, spraying devices etc. may be made available.

f) For curing of concrete in pavements, sidewalks, floors, flat roof or other level surfaces, the ponding method of curing is preferred. Special attention shall be given to edges and corners of the slab to ensure proper protection. The ponded area shall be kept continuously filled with water throughout the curing period.

g) **Membrane Curing:** Curing compound may be used in lieu of moist curing with due qualification of material and process, if permitted by the Engineer. Such compounds shall be applied to all exposed surfaces of the concrete as soon as possible after the concrete has set.

6.10.18 PROTECTING FRESH CONCRETE

Newly placed concrete shall be protected from rain, sun and wind. Concrete placed below the ground level shall be protected from falling earth during and after placing. Concrete placed in ground, containing deleterious substances, shall be kept free from contact with such ground or with water percolating from such ground during placing of concrete and for a period of at least 3 days. The ground water around newly poured concrete shall be maintained to a level lower than the fresh concrete layer by pumping or other means of drainage. Adequate steps shall be taken to prevent flooding. Fresh concrete shall be protected by, leaving the forms in place, prevention of disturbing shocks and vibrations and avoiding premature stressing until the concrete attains sufficient strength to sustain such loads or shocks.

6.11 REPAIR AND REPLACEMENT OF UNSATISFACTORY CONCRETE

A procedure shall be prepared by the contractor for carrying out inspection, repair and replacement of unsatisfactory concrete. Repair of unsatisfactory concrete shall be carried out by means of removing the unsatisfactory portion and replacing it with new concrete. Suitable keys, dovetail slots etc. may be provided to get proper bond between new concrete and old concrete. Prepared surface shall be kept wet for 24 hours immediately before the patching material is placed. However, surface shall be dry. Repair of concrete shall be carried out using skilled workmen. Repairs shall be undertaken as soon as practicable, after removal of forms, so as to meet the requirements of finish in that particular location. The portion of the concrete to be repaired may be reinforced with steel mesh, if directed by the Engineer. The contractor shall carry out all such repair with no extra cost to the owner.

The complete methodology for the repair shall have approval of the Engineer before undertaking such repair job. Proper curing shall be ensured for the repaired portion.

6.11.1 USE OF EPOXY

For bonding fresh concrete with old concrete epoxy shall be used if specifically directed by the Engineer. The type of epoxy and its application shall be as directed by the Engineer. Epoxy shall be applied in strict accordance with the instructions of the manufacturer. Approved material shall be arranged by the Contractor to undertake this activity.

The epoxy shall meet the requirements of ASTM C-881 and shall be used as per manufacturer's recommendations.

6.11.2 REPAIR WITH EPOXY MORTAR

The defects in concrete (within the acceptable limits, as decided by the Engineer) may be repaired using Epoxy mortar as per the instructions of the Engineer. No extra payment shall be made for such repairs.

6.11.3 MATCHING OF PATCH SURFACES

Filling material used in repair of surfaces, which will be exposed after completion of the project, shall be used with cement from the same source as that used in concrete and blended with a sufficient amount of white Portland cement to produce the same colour as in the adjoining concrete. Patched surface shall be given a final treatment to make the texture of the patch to match with the surrounding area.

6.11.4 CURING OF PATCH WORK

Immediately after any patchwork is completed, the area shall be covered with non-staining, water-saturated material and the same shall be kept wet and protected against sun and wind for a period of 12 hours. Thereafter, the area shall be kept continuously wet by a fine spray or sprinkling of water. The layers of patch may be reinforced with steel wire mesh, if directed so by the Engineer at no extra cost to the owner.

6.11.5 APPROVAL BY ENGINEER

All materials, procedures and activities for repair work as well as finishing work shall be subject to the approval of the Engineer.

6.12 FINISHING & OTHER GENERAL WORKS

6.12.1 FINISHING

a) Unless otherwise specified, concrete finishes shall conform to the following classifications and shall be provided as specified in the drawing.

b) Finish F1, F2 and F3 shall describe formed surfaces.

c) Finish U1, U2 and U3 shall describe unformed surfaces.

d) Offsets or fins caused by displaced or misplaced form panels, lining or form section or by defective form lumber shall be referred to as ‘abrupt irregularities’. All other irregularities shall be referred to as ‘Gradual irregularities’. Gradual irregularities shall be measured as deviation from a plane surface with a template 1.5 m long for formed surfaces and 3.0 m long for unformed surfaces.

6.12.2 FORMED SURFACE

a) Finish F1 shall apply to all formed surfaces for which finish F2, F3 or any other special finish is not specified.

b) Finish F1 shall include filling all form tie holes and localized air holes.

c) Finish F2 shall apply to all formed surfaces as shown on the drawings. Finish F2 shall include filling all form tie and localized air holes, repair of gradual irregularities exceeding 6 mm, removal of ridges and fins and abrupt irregularities by grinding.

d) Finish F3 shall apply to all formed surfaces exposed to view or where shown on the drawings. It shall include all measures specified for finish F2. In addition, filling air holes with mortar and treatment of the entire surface with sack rubbing shall include in F3 finish. It shall also include clean up of loose and adhering debris. The surfaces shall be prepared within two days after removal of the forms. The surfaces shall be wetted and allowed to dry slightly before mortar is applied by sack rubbing. The mortar used shall consist of one part cement to one and half part by volume of fine sand passing IS No. 16 sieve. Only sufficient mixing water, to give the mortar a workable consistency, shall be used. The mortar shall then be rubbed over the surface with a fine burlap or linen cloth so as to fill all the surface voids. The mortar in the voids shall be allowed to stiffen and solidify after which the whole surface shall be wiped clean with burlap so that the entire surface presents a uniform appearance without air holes and irregularities. The finished surface shall be cured for a period of 3 days.

6.12.3 UNFORMED SURFACES

a) Finish U1 shall apply to all unformed surfaces for which finish U2, U3 or any other special finish is not specified. Finish U1 shall include screeding the surface of the concrete to the required slope and grade, as specified on drawings.

b) Surfaces, to be covered with concrete topping, terrazzo etc., shall be smooth, screeded and leveled to produce an even surface and irregularities not exceeding 6 mm.

c) Finish U2 shall apply to all unformed surfaces, as shown on the drawings. Finish U2 shall include screeding and applying a wood float finish to the surface of the concrete to the required slopes and grade, repair of abrupt irregularities unless a roughened texture is specified and repair of gradual irregularities exceeding 6 mm.

d) Finish U3 shall apply to unformed surfaces for which a high degree of surface smoothness is required, where shown on the drawings. Finish U3 shall include screeding, floating and applying a steel trowel finish to the surface of the concrete to the required slope and grade, repair of gradual irregularities exceeding 6 mm, finishing joints and edges of concrete with edging tools.

6.12.4 FOUNDATION BEDDING, BONDING AND JOINTING

a) All surfaces or concrete beds shall be prepared by suitable shaping, thorough cleaning, washing and keeping the surface in SSD condition

b) All soil surfaces, upon which or against which concrete is to be placed, shall be well compacted and free from standing water, mud or debris. Soft or yielding soil shall be removed and replaced with lean concrete or with selected soil and compacted to the same density as the surrounding area. The surface of absorptive soil, against which concrete is to be placed, shall be moistened thoroughly so that moisture will not be drawn from the freshly placed concrete.

c) The concrete surfaces, upon which additional concrete is to be placed, shall be prepared by green cutting technique. Surface retarder shall be spread on the surface of newly laid concrete, just after finishing work is completed. After the concrete attains final set, high-pressure air water jet shall be used to remove cement matrix, exposing aggregate matrix. The water shall be drained properly along with cement particles. In case where green cutting is not adopted, with approval of the Engineer, scarifying and cleaning while the concrete is between its initial and final set shall be done. Great care shall be taken in performing this work to avoid removal of too much mortar and weakening of the surface by loosening of aggregate.

d) Concrete surfaces, upon which new concrete is to be placed, shall be cleaned and wetted, immediately before placement of the concrete. The bonding shall be with mortar having the same cement-sand ratio as that of the concrete being placed. Cost of the same will be deemed to have been included in the rate for concrete. However, no bonding mortar is required when green cutting technique is adopted for surface preparation.

Similar treatment shall be given at vertical construction joint.

6.12.5 WORKMANSHIP OF CONCRETE

Workmanship shall be conforming to relevant Indian Standards and good engineering practices. The mix proportioning shall have prior approval of the Engineer. Concrete shall be produced at fully automatic batching plants. In case, where the tilting drum mixer is used, adequate and accurate weight batching arrangement shall be provided. Tilting drum mixer shall be fully discharged before taking new batch. Partly set concrete shall be immediately removed. On completion of work the mixer as well as all other equipment shall be thoroughly cleaned.

6.13 SELF-COMPACTING CONCRETE (SCC)

Self-Compacting Concrete shall conform to European specification for Self-Compacting Concrete – Specification, Production and Use. All the ingredients of SCC are same as that of normal concrete, except Viscosity Modifying Agent (VMA) as an additional ingredient Quality of all the ingredients shall be the same as that for normal concrete. VMA shall be added to increase shear resistance of the concrete. All the test

equipment as well as desired parameters for fresh concrete shall be as detailed in European specification. After the mix proportion is finalized, adequate mock-ups shall be done, to ensure consistent quality of self-compaction. SCC may be used for casting all the structural elements of the plant buildings. It shall be kept in mind that formwork design shall be carefully done for SCC, as the SCC remains in liquid form for a longer period. As far as possible, pumping shall be resorted to. All other requirements for testing shall be the same as that of normal concrete, specified elsewhere in these specifications.

Properties of the fresh concrete are to be checked as per the provisions in the European specification. The desired parameters are given in Table 6.22. Testing methods and testing equipments like flow table, V-funnel, L-box, U-box, fill box and segregation resistance test shall be as per European specification. The tests to be carried out to establish various properties are given in Table 1.24. Once it is established that the mix proportion is meeting the desired parameters and after establishing the consistency of the results, the flow table test and V- funnel test are to be conducted at production point and placement point as a quality control measures. For hardened concrete, the tests specified in Table 6.20 are to be carried out. These Two (2) tests shall be conducted for first 3 transit mixers and subsequently one for every set of 5 transit mixers.

TABLE 6. 22
PARAMETERS FOR SCC

Sl. No.	Test	Unit	Minimum	Maximum
01	Slump flow	mm	650	800
02	T50 cm slump flow	Sec	2	5
03	"V" funnel	Sec	5	15
04	'L' box	h_2 / h_1	0.8	1.0
05	'U' box	$(h_2 - h_1)$ mm	0	30
06	Fill box	%	90	100
07	Segregation	%	-	20

TABLE 6.23
PROPERTIES TO BE ESTABLISHED BY TESTS

Slump flow test	Stability of mix (Cohesiveness)
T-50 cm time slump flow test	- do -
V-funnel test	Flow ability
L-Box test	Passing ability
U-Box test	- do -
Fill box test	Filling ability
Segregation Resistance test	Segregation

6.14 MATERIAL TESTING LABORATORY

The contractor shall establish a state of the art material-testing laboratory at site for testing of all the concrete ingredients, fresh concrete and hardened concrete. Fully automatic cube testing machines of adequate capacity and numbers shall be installed in the laboratory. Facilities for water permeability test as per DIN 1048 and Rapid Chloride Permeability Test (RCPT) as per ASTM-C-1202 shall also be available in the laboratory. Laboratory pan type mixer shall be available with the Contractor.

7. FORM WORK

7.1 SCOPE

The work covered under this section shall include the providing, erection and removal of formwork for all normal, and pre-cast concrete in walls, columns, foundations, slabs and beams, including its supporting members.

7.2 GENERAL

7.2.1 The formwork shall consist of but not limited to shores, bracings, sides of beams, columns, walls, rafts and bottom of slabs including ties, anchors, inserts, hangers, false work, wedges, etc. complete which shall be properly planned for the work. For the floors, supports can be taken from the floor down below with prior permission of the Engineer. Wherever required, provision shall be made to support the floor shuttering by means of trusses, which shall be spanned from the nearby walls/columns. Wherever specified, the left-in shuttering of adequate capacity shall be used.

7.2.2 The Contractor shall prepare, before commencement of actual shuttering work, design and drawing for formwork and centering and get them approved by the Engineer well in advance before fabrication and erection of formwork. Formwork shall be designed to fulfill the following requirements.

a) Sufficiently rigid and tight to prevent loss of grout or mortar from the concrete at all stages and appropriate to the methods of placing and compacting.

b) Made of suitable materials.

c) Capable of providing concrete of the correct shape and surface finish within the specified tolerance limits.

d) Capable of withstanding without deflection the worst combination of self-weight, reinforcement and concrete weight, all loads including lateral pressure on vertical surfaces and dynamic effects arising from construction and compacting activities, wind and weather forces.

e) Capable of easy striking without shock, disturbance or damage to the concrete.

f) Soffit forms capable of imparting a camber if required.

g) Capable of being cleaned and/or coated if necessary immediately prior to casting the concrete, design temporary openings where necessary for these purposes and to facilitate the preparation of construction joints.

7.2.3 Forms shall conform to the shapes, lines, grades and dimensions including camber of the concrete as called for on the drawings. Ample struts, walers, braces, etc. shall be used to hold the forms in proper position without any distortion whatsoever until the concrete has set sufficiently to permit removal of forms. Unless otherwise specified all forms in contact with concrete having F-3 finish shall be plywood panel formworks. Forms will be firmly bolted to previous pour of concrete. No through bolts embedded in concrete will be permitted in any underground structures. Threaded mild steel sleeves designed for holding in concrete and standard coil nuts/cone anchors shall be embedded in preceding concrete pours to anchor tie rods on lower end, while on the other end tie rods shall be provided beyond the lift under construction. Tie arrangement with baffle plate within the concrete may also be used as substitute for through tie with prior approval of the Engineer. The Contractor should finish all the coil nuts by dry packing. The recesses, if any, formed by removable timber wedges shall be filled with caulking compound or Epoxy mortar if depth is less at the Contractor's own cost. Formwork for removable hatchways and plugs shall be installed in place wherever possible. Back form for sloping concrete surfaces shall be provided as decided by the Engineer at no extra cost.

7.3 DESIGN AND FIXING OF FORMWORK

The formwork shall be designed and fixed to meet the tolerance in various areas as specified elsewhere in this specification. All floors and beam centering shall be crowned not less than 8 mm in all directions for every 5-meter span. Forms in contact with concrete shall be free from adhering grouts, projecting nails, splits or other defects. Formwork shall be so designed and erected with the forms for slab so that the sides of beams, columns and walls may be removed first, leaving the formwork to the soffits of beams and their supports in position. Where formwork for column is erected for its full height, one side shall be left open and built up in sections as placing of concrete proceeds, if so directed by the Engineer.

7.4 DESIGN LOADS

7.4.1 Unless prior approval in writing has been received from the Engineer all vertical wall forms shall be constructed for the minimum pressure as per CIRIA/ European Guidelines recommendations. The Contractor shall ensure that the constructions of the forms are adequate for all concrete placing condition and all the applicable CIRIA/European Guidelines recommendations are followed. However, in case of self-compacting concrete, the entire height of the pour shall be considered to be in fluid state and the lateral pressure shall be w x h, where "w" is the unit weight of green concrete and "h" is the height of pour.

7.4.2 All horizontal forms shall be constructed for pressures from the dead load of concrete including embedment and a minimum live load of 200 Kg/sq.m.

7.4.3 Forms constructed for retaining heavy concrete shall be built for pressures which have been increased by the ratio of the unit weight of heavy concrete to normal concrete.

7.4.4 Further, the formwork shall be designed to withstand all pressures arising out of placement of concrete using pumps, incidental loads if any and live load on the working platforms.

7.4.5 The form work shall be designed and fixed to meet the tolerances in various areas specified by the Turbine Manufacturer or as specified in the relevant drawings

7.5 TEMPORARY OPENINGS

Temporary openings, which can be conveniently closed, shall be provided at the base of the columns and wall forms and other places necessary to facilitate cleaning, inspection and vibration of concrete. Immediately before concrete is placed the forms shall be made sufficiently rigid and tight, thoroughly cleaned properly treated and free from foreign material. When forms appear to be unsatisfactory in any way, either before or during the placing of concrete, the Engineer shall order the work stopped until the defects have been corrected.

7.6 MATERIALS

7.6.1 Materials for the formwork shall be of plywood, formed steel plates, timber form covered with steel sheets, oil tempered hard board. Sliding forms and slip form shall be used for tall structures where specified and after approval by the Engineer. The supporting system shall be either adjustable props made of mild steel pipes for heights up to 6 meter or composite columns fabricated using M.S. Structural steel members.

7.6.2 Shuttering arrangement for concreting shall be of 12 mm/16 mm thick plywood backed with steel/DOKA framework and supports of horizontal and vertical walers connected to turn buckles. In case steel shuttering plates are used for formwork, the joints between the panels shall be sealed with suitable foam to make the formwork leak tight. Flat bar at top of soldier to be provided for maintaining thickness. Supports shall be rigid and strong enough to withstand effect of vibration without any deflection, bulging, distortion or loosening of its supports and shall be so as to prevent loss of slurry from the concrete. Plywood used shall be waterproof plywood conforming to IS: 4990. Test certificates from the manufacturers will be obtained and verified. Form strips or any other suitable sealing tapes will be used to prevent loss of slurry through the joints of formwork.

7.6.3 Suitable working platform will be provided for execution/ inspection of reinforcement, embedded parts and concreting.

7.7 CENTERING REQUIREMENTS

Centering using steel tubular props, H frames, built-up sections, with provisions to adjust heights of props shall be used and they shall be to true levels and rigid. They shall be adequately braced horizontally and vertically. For faster construction, quick strike decking system/ Acro/Doka systems shall also be used for shuttering supported

on floors below, vertical props shall be so supported on wedges or other measures shall be taken whereby the props can be gently lowered vertically while striking the shuttering. Bamboos or wooden poles shall not be used as props or cross bearers. Centering supported on structural steelwork shall also be designed for the conditions mentioned above.

7.8 TIE RODS

As far as possible MS tie rods left in type shall be used for supporting all forms. Retrievable type can also be used with prior approval of the Engineer. Tie rods shall have provisions for removal of a section of each rod at surface of the concrete to a depth of approximately 50 mm. All holes left by the removal of conical nuts or other removable fixtures embedded in the face of the concrete shall be filled and finished with sand-cement mortar in a manner specified in the finishing specification. Threaded inserts embedded on each face of the wall be cut for attaching the forms to previously placed concrete and when permitted shall be out off flush with the face of concrete or countersunk, filled and finished as required by the Engineer in the manner specified in the finishing specification. Measures shall be taken to prevent rust stains on concrete.. Through left-in Tie rods shall be permitted only upon approval of the Engineer.

7.9 FORM OIL

7.9.1 *Use of form oil shall not be permitted on the* surfaces, which require painting. If the Contractor desires to use form oil on the inside of the formwork of the other concrete structures, a non-staining mineral oil or other approved oil may be used provided it is applied before placing reinforcing steel and embedded parts. Such form oil shall be insoluble in water and not injurious to concrete and shall not become flaky or be removed by rain or wash water. Form oils that retard the setting of concrete shall not be used.

7.9.2 All excess oil on the form surface and any oil on metal or other parts to be embedded in the concrete shall be carefully removed. Before treatment with oil, forms shall be thoroughly cleaned of dried splatter of concrete from placement of previous lift.

7.9.3 The Contractor shall clean the concrete surfaces from any leftover form oil at his own cost if form oils are used.

7.10 SUSPENDED FORMWORK

7.10.1 In certain areas, as identified by the Engineer, metal decking/ and supported on structural steel framework shall be used as self-supporting shuttering as an alternative to the conventional shuttering in places where the area below has to kept free of scaffolding and centering works. The fixing of metal sheets to structural steel members shall be done by bolting / welding or any other alternative as advised by the Engineer .

7.10.2 Plate inserts may be embedded in the sidewalls during concreting, from which bracket supports can be obtained. Structural steel built-up sections or trusses shall be used for

supporting the formwork. The Contractor shall submit the design and detailed drawings for the above scheme for the approval of the Engineer. The scope of work shall include design, fabrication, erection and dismantling of the supporting structure.

7.11 CHAMFERS AND FILLETS

Unless shown on drawings or elsewhere to the contrary, all corners and angles shall be formed with 45 Degree mouldings to form chamfers or fillets on the finished concrete. The standard dimension of chamfers and fillets, unless otherwise detailed or specified shall be 25 mm by 25 mm. For heavier work, chamfers or fillets may be 40 mm to 50 mm. Care shall be exercised to ensure accurate mouldings. The diagonal face of the mouldings shall be planed or surfaced to the same texture as the forms to which it is attached. Unit rates quoted shall include providing the chamfers as specified or shown in the drawings.

Vertical construction joints on faces, which will be exposed at the completion of the project, shall be chamfered as above except where not permitted by the Engineer.

7.12 JOINTS

Joints in forms shall be truly horizontal or vertical unless otherwise specified and shall be sufficiently tight to prevent any leakage of cement slurry to avoid formation of fine or blemish. Faulty joints shall be sealed as directed by the Engineer. Suitable devices shall be used to hold adjacent edges together in accurate alignment. The Contractor shall use sealing tapes to avoid leakage of slurry through the formwork joints. On removal of forms the Contractor shall finish marks left by sealing tapes so as to merge with other concrete surface. The Contractor shall take care to maintain symmetry in formwork in slabs, walls, columns etc. so as to give a pleasant appearance to finished concrete surface. All forms shall be so made that they can be removed without hammering or prying against the concrete.

7.13 REUSE OF FORMS

Before reuse, all forms shall be thoroughly scrapped, cleaned, examined and when necessary, repaired or re-oiled before resetting. Formwork shall not be used/ reused, if declared unfit or unserviceable by the Engineer.

7.14 CLEANOUT PROVISIONS

Forms with limited working space within, shall be provided with temporary clean-out doors or openings for cleaning, washing, blowing and removal of water, wood chips, trash etc.

7.15 WORKING PLATFORM

The Contractor shall provide safe working platform for workmen, when working above ground level. Safe method of approach shall be provided to reach locations above ground level. Handrails shall be provided for all working platforms. Hanging platforms

shall have safety net provisions. All ladders shall have handrails and shall not be kept vertical. All platforms, ladders, handrails etc. shall be firmly secured to ground or on supports. No loosely supported ladders or platforms shall be used in the work. All ladders and platforms shall have a kick plate 150 mm high either MS or wooden board for safety of personnel. Ladders and platforms shall be periodically cleaned of loose debris etc.

7.16 REMOVALOF FORMS

7.16.1 In the determination of time for removal of forms, consideration shall be given to the location and character of the structure, the weather and other conditions including the setting and curing of the concrete and materials used in the mix.

7.16.2 Forms and their supports shall not be removed without approval of the Engineer. Improper methods of removal of formwork likely to cause overstressing or damage to the concrete shall not be used. Supports shall be removed in such a manner so as to permit the concrete to uniformly and gradually take the stress due to its own weight.

7.16.3 The supports can be reinstated in anticipation of abnormal conditions. Re-propping of beams shall not be done except with the approval of the Engineer.

7.16.4 The minimum period for removal of forms shall be as mentioned below. However, The seven-day test results shall be as per IS: 456 (latest revision). If the strength requirements are not met with, the formwork shall be removed as per the instructions of the Engineer.

TABLE 7.1

MINIMUM PERIOD FOR REMOVAL OF FORMWORK

Sl. No.	Class of Structures	Earliest Concrete age at stripping for placing Temperature above 20 deg. C	
		Where ordinary Portland cement is used	Where mineral admixture is used
1.	Walls, Columns & Vertical sides of Beams	24 to 48 hrs. as decided by the Engineer	48 to 96 hours
2.	Slabs (props left under)	3 days	7 days
3.	Beam soffits (props left under)	7 days	14 days
4.	Removal of props to slabs		
	For thickness above 300mm		
	a) Spanning upto 4.5M	14 days	21 days
	b) Spanning over 4.5M	21 days	28 days
	For thickness upto 300mm		

	a) Spanning upto 4.5M	7 days	14 days
	b) Spanning over 4.5M	14 days	21 days
5.	Removal of props to beams and arches		
	a) Spanning upto 6M	14 days	21 days
	b) Spanning over 6M	21 days	28 days
6.	Cantilever construction	Not until adequate fix-ity is developed subject to a min. of 10 days	Not until adequate fix-ity is developed subject to a min. of 21days

7.16.5 For rapid hardening Cement Concrete 3/7 th of the period specified for ordinary Portland Cement will be sufficient subject to the minimum period of 24 hours.

7.16.6 Striking shall be done with utmost care to avoid any damage to concrete surfaces or any projections on it and without shock and vibrations, by gently easing the wedges/jacks. If after removing the formwork, it is found that timber has been embedded in the concrete, it shall be removed and made good as approved.

7.16.7 Tie rods, clamp form bolts etc., which must be entirely removed from the walls or similar structure, shall be loosened not sooner than 24 hours after the concrete was deposited. Works damaged due to premature or careless removal/withdrawal/ loosening/striking of forms shall be reconstructed at Contractor's cost.

7.17 STOPPER FORMWORK

Stopper formwork (Bulkhead) shall be provided at all vertical construction joints. Such formwork shall be leak-tight and shall not allow leakage of cement slurry. Wherever specified in the drawings, gas barrier/water stopper shall be provided in the stopper shutter. In addition to the erected stopper, emergency stopper formwork shall be kept ready before starting large concrete pours, with provision for gas barrier/water stopper if required. All stopper formwork shall be measured and paid in the item of formwork only.

7.18 SLOPING FORMWORK

The bottom formwork shall be made out of plywood with wooden backing members. For slope above 15 Degree with the horizontal it is recommended to have plywood formwork for the top surface and supported on steel or wooden truss. These shall be divided into panels, which shall be fabricated in the shop to the required profile. The bottom of truss will be closed by plywood formwork at the time of concreting. Subsequently further closer formwork for the top surface will be extended after concreting and compaction of the lower portion The entire formwork shall be supported on structural steel/scaffolding supported on a firm base.

7.19 FORMWORK FOR SELF COMPACTING CONCRETE

The formwork shall be made out of plywood with wooden backing members. These

shall be divided into panels, which shall be fabricated in the shop to the required profile. Special care should be taken so that there is no gap in the formwork joints so as to ensure not leakage of slurry due to increased workability and slump achieved by using appropriate admixtures. The lateral green concrete pressure on the formwork shall be governed as per Para titled "DESIGN LOADS" of this specification.

7.20 POCKETS FOR FOUNDATION BOLTS

Pockets for foundation bolts shall be made out of plywood or timber. These shall be made slightly tapered for ease of removal. The bottom of such formwork shall be necessarily closed so as not to allow entry of concrete from bottom. The timber pocket may have to be broken to withdraw after concreting. Templates shall be provided wherever required or as directed by the Engineer.

7.21 CURVED FORMWORK

This shall cover all such formwork, which is curved in plan. The formwork shall be fabricated to the required curvature at shop before use. Mismatch if any at site, shall be rectified by cutting or replacing the panel/members.

7.22 FORMWORK FOR PRE-CAST CONCRETE WORKS

All pre-cast units shall be cast in a suitable yard, bed or platform with firm foundation and free from wind. The platform shall have a smooth plaster finish. The yard shall be fenced and shall have a curing tank of adequate size and capacity. The Contractor shall be responsible for the accuracy of the level and shape of the bed or platform. A suitable serial number and the date of casting shall be impressed or printed on each unit. Each unit shall be concreted in one operation. Reinforced concrete members shall be marked to indicate the upper surface.

The form shall be of steel sheets with only rigid steel frames. All components of formwork shall be so held that during casting there is no deformation of the form resulting in the concrete units not confirming to dimensions indicated in the drawings. The shuttering shall be made with a tolerance of (±) 3 mm in all directions.

The side shutters shall not be struck in less than 24 hours for ordinary Portland cement after concreting and no pre-cast unit shall be lifted during striking the form.

7.23 METAL DECK SHEETING WORKS AS LEFT IN SHUTTERING

7.23.1 GENERAL REQUIREMENT

This part of the specification covers the technical requirements for deck sheeting to be used as left in shuttering for floors & roofs. Supply and installation of the deck sheeting shall be done by same agency. During handling / stacking, if any damage is done to sheet like distortion of edges, scratches on sheet etc., then such damaged sheet shall stand rejected and shall be immediately replaced by the contractor.

7.23.2 MATERIAL

7.23.2.1 Troughed permanently metal decking sheet for Floor / roof decking shall be made by steel feed material of minimum 1.0 mm (bare metal thickness i.e. metal thickness excluding thickness for coating and galvanizing) galvanised to grade 275 as per as per IS 277, of minimum yield strength of 250 Mpa of drawing grade as per IS 513 of approved profile, sectional properties.

7.23.2.2 For metal decking the sectional modulus and moment of inertia of troughed profile per meter width shall be so as to limit the deflection of sheets to span/250 over a span of 1.5 m under total super imposed loading (DL +LL) of minimum 1000 kg per Sq.M.

7.23.2.3 The maximum spacing of the fasteners shall be 390 mm c/c along the length of purlins/runners. However exact spacing shall be as per the design done by the bidder for the fasteners considering the wind load, self-load and other associated loads. Minimum diameter of the fastener shall be 5.5 mm and at least 3 nos. of fasteners shall be used per sheet.

7.23.2.4 Percentage elongation of the mild steel sheet having minimum yield strength of 250 MPa, shall be 23% as per IS:2062.

7.23.3 INSTALLATION AND FIXING

a. The sheeting shall be fixed as per the approved drawings. Sheets shall be supplied in required sizes (based on supporting member spacing) according to the cutting schedule. Generally cutting of sheets to length shall not be permitted at site. Specific approval under exceptional circumstances shall be obtained before cutting of any sheet at site. Power tools shall be used for cutting. Cutting and trimming of small openings which were not finalised at the time of working drawings can be allowed at site. Wherever possible, site cut edges shall be concealed at laps or with flashings. Suitable steel members for stiffening shall be provided at the cut edges. No gas cutting shall be done on the sheet. If any sheet is found with gas cut mark, same shall stand rejected and shall be immediately replaced.

b. Distorted, blemished or water stained sheets shall not be used.

c. Before installing decking sheet, it shall be ensured that the purlins / supporting members are in true planes, correctly placed and securely fixed.

d. Side and end laps of the sheets shall be made weather proof by securing them with the fasteners not less than 4.0mm dia with 2.0 mm thick neoprene washer. Maximum spacing of the fasteners shall not to exceed 500 mm.

e. Precautions shall be taken during the erection of the sheets to ensure that partially erected decking sheets are protected during inclement weather and damage at all times.

f. Side and end of decking sheet shall be located and positioned in such a manner as to

provide the maximum weather protection taking into account the direction of the prevailing wind.

g. Length of the sheet shall be such as to cover minimum 3 span purlin/ supporting members spacing.

h. The roof decking sheets shall be fixed to the purlins/ supporting members with the help of self drilling and tapping type fasteners and neoprene washers.

i. Sheets shall be laid over the supporting members/ purlins with a minimum bearing of 50 mm and end projection of 75 mm at lap joints.

j. End and side laps between the sheets shall be sufficiently large to ensure the weather tightness. In no case, the end laps shall be less than 150 mm and side laps less than one trough length with proper weather tight arrangement.

k. As required the suitable shear connectors shall be provided on deck sheeting for proper shear transfer between sheet & floor/ roof concrete.

7.24 CONSTRUCTION JOINTS & GROOVE FOR CAULKING

These shall provided as shown in the approved drawings or as desired by the Engineer. A trapezoidal groove tapering from the face of the wall to inside will have to be provided on containment walls and roof at all construction joints. For construction joints in thin sections a steel cover plate exposed from one side of the surface will be provided replacing the water stop within the thickness and concrete will be cast against the plate. Suitable grooves will be provided at the junction of the plate and the concrete. Also embedded parts passing through the wall will be provided with grooves around its periphery on the containment walls. All such grooves shall be caulked by the flexible polysulphide compound or epoxy mortar as directed by the Engineer.

7.25 TOLERANCES

The following tolerances are permitted unless otherwise mentioned in the relevant drawings. The tolerances shall be taken as the departure from the true position at any point after completion of the structure.

Sectional dimensions	:	(±) 5 mm for cast-in-situ concrete.
Plumb	:	5 mm in 5 m but not cumulative. Tolerance in various sections should be compensatory and not cumulative
Levels	:	2 mm before any deflection has taken place for both cast-in-situ and pre-cast works.

Tolerances for climbing type of form work. Variation in walls: Not more than (+) 3 mm.

Total deviation at any point of climbing form / other formwork measured in horizontal plane with respect to the projection of a corresponding reference point at the base of the structure. (Total deviation consists of translational and rotational components.) : 3 mm per 6m height unless specifically required otherwise.

Latest computerised survey instruments shall be used for checking the verticality and alignment of the form works.

7.26 SUBMISSION OF CONTRACTOR'S SCHEME

Bidder shall submit along with his tender the scheme for shuttering, centering, scaffolding for important elements. These should be supported by preliminary drawing and design calculations. Final drawing shall be submitted before start of work.

The scheme submitted by the Contractor should be for all the different type of centering and shuttering schemes proposed and should be so elaborate keeping in mind the entire cross-section of the respective structures in general. The scheme should be such that the construction of one part of any building should not hinder the work on the other parts and keeping in mind the construction schedule.

For centering and shuttering of walls, columns, beams & slabs all the working drawings, details of erection methods calculation of stress and of deflections shall be supplied to the Engineer for approval at least six (6) months in advance of erection.

7.27 ALTERATIONS AND MAINTENANCE

Any modification that the Engineer may require shall be made by the Contractor. Notwithstanding the approval of or alteration suggested by the Engineer in the submitted design for any of the temporary work etc., the Contractor shall remain wholly and entirely responsible until the final acceptance of works, for the efficiency, security, safety and maintenance and for all obligations and risks in regard to such work specified or implied in the contract. The Contractor shall reinstate the same at their own cost, should any mishap or accident occur causing damage or injury thereto, subject however to such provisions of the conditions of contract as may be applicable in the case of such damage or injury.

8. WATERPROOFING OF UNDERGROUND CONCRETE STRUCTURES

8.1 SCOPE

This specification covers waterproofing of underground concrete structures viz. basement, sump, pit, tunnel and trenches against ground water.

The specification described here covers material description, physical and mechanical properties, testing, applicable codes and standards, acceptance criteria, surface preparation, placing in position, lapping and QA requirement etc of water proofing treatment of basement slab and walls.

8.2 GENERAL REQUIREMENTS

As a general guidance, the provisions contained in the contract shall be followed unless otherwise mentioned. Considering safety requirement, Nuclear Power Plant structures should meet special requirement regarding leak tightness.

The contractor shall do the proper concreting so that concrete is water tight in itself without waterproofing treatment. Quality control of concrete construction shall include inspection of preparations for concreting, mixing, transportation, placement, compaction, curing and protection.

The work of waterproofing of underground concrete structure shall be entrusted by the contractor to expert agency approved by NPCIL. The specifications of waterproofing mentioned here are generic in nature. The Contractor shall submit the detailed specification of waterproofing for NPCIL's approval.

8.3 MATERIAL

The plasticized PVC membrane shall be minimum 2.0 mm thick, single ply, twin colored preformed flexible membrane. The single ply plasticized PVC membrane shall be thermoplastic membrane manufactured by co-extrusion process. The membrane shall be of twin colour to provide visual indication of damage, due to any movement or any other reason. The sheet shall be minimum 2 meter wide and appropriate length to minimize the number of joints. The compartmentalization shall be done using specified size of water stop to confine any accidental damage within 100 square meters. All lap joints shall be tested for water tightness upto 2 Kg/sq cm pressure prior to concreting. The membrane shall be suitable for defect free installation on all type of surfaces viz. horizontal, vertical and overhead and it shall be loosely laid (unbounded) to act independent of structural movement. Adjacent sheets shall be laid with an overlap of at least 80 mm.

The PVC membrane used for waterproofing membranes shall exhibit the following properties.

PROPERTY	**TEST METHOD**	**UNIT**	**ACCEPTANCE VALUE**
Thickness	UNI EN 1849 -2	mm	Minimum 2.00 mm
Specific weight	UNI EN 1849 -2	kg/m2	2.600
Ultimate Tensile strength	UNI EN ISO 527-3 Transverse Machine direction	 N/mm2 N/mm2	 Minimum 14.9 N/mm2) Minimum 15.2N/mm2)
Ultimate Tensile Strength	UNI EN ISO 527-3 Transverse	 N/mm2	Minimum 14.9 N/mm2) Minimum 15.2N/mm2)

(Ageing by complete immersion in ground water for 16 months at 50 ^{0}C)	Machine direction	N/mm2	
Elongation	UNI EN ISO 527-3 Transverse Machine direction	 % %	 min 280 (-30%) min 280(-30%)
Mean Tensile Strength Variation	DIN 53455	%	3.5
Impact strength	DIN 16726 - 5.12	mm	> 600
Puncture resistance	DIN 16726 - 5.12	mm	> 1000 mm
Hydrostatic pressure resistance (6 hours at 5 bar)	UNI EN 1928 meth.B		Waterproof
Tear resistance	ISO 34 /ASTM D624	MPa	> 45
Resistance to static punching (CBR)	UNI EN ISO 12236	N	> 1700 N
Root resistance	DIN 4062		No penetration
Fire Behaviour	EN ISO 11925-2		Class E

For Sub-soil applications the chemical resistance of the PVC membranes shall be as fully resistant to the chemicals along with the respective compositions as listed below as per ASTM D 6943 (i.e. complete immersion of sample in respective solutions for 15 days).

CHEMICAL NAME	**NATURE OF CHEMICAL**	**% CONCENTRATION**
Sulphuric Acid	Inorganic Acids	≤ 25
Sulphurous Acid	Inorganic Acids	≤ 6
Nitric Acid	Inorganic Acids	≤ 5
Benzoic Acid	Organic Acid	≤10
Acetic Acid	Organic Acid	≤10
Oxallic Acid	Organic Acid	≤ 25
Phthalic Acid	Organic Acid	≤ 25
Tartaric Acid	Organic Acid	≤25
Citric Acid	Organic Acid	≤ 25
Ammonium Hydroxide	Inorganic Bases	≤ 5
Potassium Hydroxide	Inorganic Bases	≤ 5
Sodium Hydroxide	Inorganic Bases	≤ 10
Chlorides	Salt Solutions	≤ 25

Sulphates	Salt Solutions	≤ 25
Nitrates	Salt Solutions	≤ 25
Soap Solution	Salt Solutions	≤ 25
Drinking Water	Salt Solutions	Any Concentration

8.4 THICKNESS & SPECIFIC WEIGHT OF SHEET

The thickness of the single ply plasticized PVC membrane shall be 2.00 (minimum as per UNI EN 1849). The specific weight of 2.0 mm thick single ply plasticized PVC membrane test piece shall be determined in mass per unit area.

8.5 TENSILE STRENGTH & ELONGATION TEST

The tensile strength and elongation requirement shall be as per UNI EN ISO 527-3. In this test, dumbbell shaped single ply plasticized PVC test pieces are cut using the standard dumbbell die are stretched in a tensile testing machine at a constant rate of traverse of the driven grip. Readings of transverse loads and elongation are taken as required during the uninterrupted stretching of the test piece and when it breaks. For the tensile strength of the joints they are subjected to varying tensile stresses for the overlap joints as per ASTM D638.

8.6 PUNCTURE RESISTANCE

The puncture resistance requirement shall be as per DIN 16726 - 5.12. This is measured using the truncated cone test, in which truncated cones are used as puncture points. The heights of the truncated cones are varied to determine the critical cone height, which is the height at which the puncture occurs for a given pressure. The minimal permissible height for a 2.0 mm thick single ply plasticized PVC membrane used for waterproofing in case of basements is >800 mm.

8.7 HYDROSTATC PRESSURE RESISTANCE

The hydrostatc pressure resistance requirement shall be as per UNI EN 1928 meth.B. In this test the lateral hydrostatic pressure is exerted on below-grade foundations and slabs on grade by an elevated water table. Tests to quantify resistance to the passage of water should be specific as to the maximum pressure the membrane must be capable of withstanding. In case of single ply plasticized PVC membranes the minimum amount of pressure that the membrane can withstand is tested for a water table of 60mts as per the code. Subjected to these conditions there should be no penetration of water as per the specifying needs.

8.8 ROOT PENETRATION RESISTANCE

Root resistance is tested for single ply plasticized PVC waterproofing membrane through the composition of the membrane which provides an impenetrable barrier to root growth. Root resistant 2.0 mm thick single ply plasticized PVC membrane is quicker to install than separate waterproofing and root barrier layers.

8.9 TEAR RESISTANCE

This test method measures the force per unit thickness required to rupture, initiate, or propagate a tear through a sheet of 2.0 mm thick single ply plasticized PVC membrane. This testing is done so that the specified waterproofing membrane does not fail in service due to the generation and propagation of a special type of rupture called a tear. Tear strength is calculated as T= F/d, where T is the tear resistance, F is the load acting on the membrane and d is the thickness of the membrane. Tear strength of 2.0mm thick single ply plasticized PVC membrane should at least be 45MPa.

8.10 STATIC PUNCHING RESISTANCE

CBR Puncture is an index of puncture resistance that measures the force required to push a flat ended plunger through a 2.0 mm thick single ply plasticized PVC membrane. Instead of an 8 mm diameter probe with a beveled edge; this test utilizes a 50mm diameter, flat-ended probe (plunger) that is pushed slowly through the PVC membrane. The relatively large size of the plunger provides a multidirectional force on the PVC membrane and simulates big stones pressed onto the PVC membrane laying a relatively soft sub-base. The minimum value for a static punching resistance should be at the very least of 1700 N for subsoil applications.

8.11 FIRE RESISTANCE

This test determines the ignitability the specimen is subjected to direct impingement of a small flame at the edge or at the surface. The test specimen of size 250 mm × 90 mm is attached vertically on a U shaped specimen holder. A propane gas flame with a height of 20 mm is brought into contact with the specimen at an angle of 45 °. For subsoil applications of 2.0 mm thick single ply plasticized PVC they should belong to Class E as per the ISO 11925-2 (Reaction to fire tests-ignitability of products subjected to direct impingement of flame-Part 2:single flame source test).

8.12 TESTING

For acceptance of material listed in above table, Manufacturer Test Certificate (MTC) from manufacturer confirming to above specified properties shall be submitted to NPCIL. However, membrane supplied from each batch shall be got tested for Thickness, Ultimate Tensile Strength, Elongation & Puncture Resistance. Testing of the membrane shall be carried out by the contractor as per approved QAP in laboratories like IITs, ICT etc. or other Government approved/ NABL accredited laboratories as acceptable to NPCIL as per above mentioned relevant standards at no extra cost to NPCIL.

8.13 PACKAGING SHIPMENT AND STORAGE

Materials delivered at site shall be clearly marked with legible and intact labels with manufacturer's name, brand name, product identification and batch number. The products (adhesives etc.) shall be in original, unopened containers.

Materials shall be stored in areas where temperatures conform to manufacturer's recommendations and instructions. All materials shall be stored in covered clear away from reinforcements, coarse aggregates and heavy engineering activities at site. All the materials like membranes, sealants etc. shall be kept away from sources of ignition.

All empty containers of various chemicals employed, left over chemicals shall be disposed off; in a safe manner on a dumping site approved by the site authorities.

All personnel of the applicator should wear all safety gears like gloves, helmet, goggles etc during installation.

8.14 INSTALLATION AGENCY

The works shall be carried out only by trained and certified applicator of the specialized agency carrying water proofing treatment/ membrane supplier.

8.15 INSTALLATION OF MEMBRANE

The plasticized PVC membrane shall be fixed on PCC surfaces strictly as per the detailed application guidelines of the manufacturer. Broadly the installation steps shall include

- Removal of Sharp protrusions
- Installation of Geo textile made of needle-punched 100% pure polypropylene yarns, with a minimum weight of 300 gsm.
- In case of Vertical walls, installation of roundels with mechanical fixtures.
- Laying of plasticized PVC membrane with specified lap joints
- Welding of Joints and testing for water tightness up to 2 Kg/Sqcm
- Water tightening of Pile heads/ rock anchors etc as applicable
- Compartmentalization of the PVC membrane using PVC surface water stops
- Laying of Second layer of Geo textile.
- Laying of Protective screed on horizontal surfaces
- Laying of minimum 25mm thick Protective boards / 115 thick Brick wall protection (the protective board shall be used in case of back filling done with soil / crushed sand , having no boulder/aggregate bigger than 80mm size) for the vertical walls.

A detailed scheme shall be submitted by the contractor including the layout of PVC water stop arrangement and injection ports etc (if proposed) for NPCIL approval prior to its application.

The main contractor shall ensure that all areas of the finished basement waterproofing system shall be protected from site related work traffic and other trades until completion of all works.

Adequate temporary protection shall be provided over the installed membrane during the works program, particularly at temporary walkways, access points to the basement, concreting material stockpiles etc. in order to prevent damage.

8.16 PREPARATION OF THE SUBSTRATE

The substrate shall be PCC concrete of sufficient thickness (minimum 50 mm) to ensure a firm substrate that will not crack or deform under normal trafficable conditions during waterproofing installation, and structural concreting operations. It should be smooth, free from debris and other irregularities, which may puncture and damage the waterproof liner.

The surface will be made clean, dry, smooth and free of contaminants such as grease, animal fats, coal tar and oil based products. Accumulation/ ponding of water shall be removed from the work surface prior to installing the system.

All horizontal or vertical surfaces should be covered with a uniform adjustment layer using Non-Woven Geotextile. It has the purpose of ensuring the uniformity of the substructure in order to avoid irremovable debris or other roughness in the underlying layer which may cause damage, perforate or punch, the waterproof layer.

8.17 WATERPROOFING SYSTEM FOR BASEMENT RAFT SLAB

The 2.0mm thick single ply twin colored plasticized PVC loosely laid membrane waterproof system should be installed over the hardened well leveled surface of the PCC overlaid with first layer of Geotextile. The Geotextile shall be resistant to micro-organisms, needle-punched 100% pure polypropylene yarns, with a minimum weight of 300 gsm. The PVC membrane system shall be compartmentalized using PVC surface water-stop maximum size of compartmentalization shall be limited to 100 sq m). The PVC water stop used for compartmentalization shall be minimum 320mm wide, min thickness of 2.5mm and shall have minimum 4 ribs of 15 mm depth. These PVC water stops shall be welded with PVC membrane by hot air welding. The membrane shall be further covered with second layer of Geotextile ensuring no gaps in the Geotextile. The geotextile should be checked prior to laying of protection screed.

After checking all the joints & any visible damage, second layer of geotextile shall be laid over the member followed by laying of minimum 50mm thick layer of protection PCC (Minimum Grade M20) screed. The damage if any found, shall be recorded and the necessary patch repairs shall be conducted before laying of second layer of geotextile and protection layer.

8.18 WATERPROOFING SYTEM FOR VERTICAL/RETAINING WALL

The first layer of Geotextile Membrane shall be laid over the hardened well leveled surface. Over the Geotextile membrane 2.0mm thick single ply, twin colored, and plasticized PVC membrane waterproofing system shall be installed using rondels having maximum C/C spacing 1.0m .The rondels are provided to anchor & hold the Membrane at its position. The membrane is to be protected after installation with a 300gsm geotextile followed by protective layer of 25 mm thick expanded polystyrene boards (in case of back filling done with soil / crushed sand, having no boulder/aggregate bigger than 80mm size) or 115 mm thick brick wall. The PVC

membrane system shall be compartmentalized using PVC surface water-stop at required locations, based on the site requirements (maximum size of compartmentalization shall be limited to 100 sq m).

8.19 CHECK FOR MEMBRANE TO MEMBRANE JOINT

Two adjacent membranes shall be welded using hot air welding. It shall be a double seam weld to maximum clear length of the membrane installed; double seam weld shall allow pressure testing of every length of joint. The double seam joint shall be tested to a pneumatic pressure of maximum 2 bars kept for minimum duration of 8 minutes. The loss of pressure after holding for 8 minutes shall not exceed 20%.

Wherever the double seam welding machine cannot be used, the single seam welding shall be done after obtaining prior permission from engineer, in such case the weld width shall be preferable 40mm, but shall not be less than 20mm in any case. The single seam weld shall be tested using a seam probe hook to check for any opening in the weld. In addition to above if any destructive testing is found necessary shall also be performed.

8.20 PILE HEAD TREATMENT

The single ply plasticized PVC membrane is dressed up to the outer surface of the pile head or anchor or up stand. The membrane is then encapsulated in with a high strength flowable epoxy mortar having a minimum thickness of 10mm below the membrane and mini 20mm on top of it and extended to the edge of outer surface of the interface. The key properties of the high strength flow able epoxy mortar shall be as mentioned in the following table.

PROPERTY	**TEST METHOD**	**UNIT**	**ACCEPTANCE VALUE**
Solids Content	DIN 53213	%	100
Tensile Strength	BS 6319, Part 7	MPa	11
Compressive Strength	BS 6319, Part 2	MPa	100
Flexural Strength	BS 6319, Part 3	MPa	25

8.21 QUALITY ASSURANCE & SUPERVISION

A detailed work procedure and inspection and test plan (ITP) in line with this specification and manufacturer's specification with resources deployment shall be

prepared by the contractor and submitted to NPCIL for approval before proceeding with the work. Contractor shall carry out testing of materials as per direction of Engineer and shall submit testing reports and manufacturer's test certificates to the Engineer. A strict check on membrane properties and installation shall be exercised by Contractor's QA Engineer and necessary records in this regard shall be submitted to NPCIL. Contractor shall provide necessary assistance to NPCIL in supervision of water proofing work.

During the entire process of work under this specification, the Contractor shall arrange at his own cost the supervision of the work on water proofing by the manufacturer's/ specialized agency's representative to ensure that the work is being executed as per manufacturer's specifications and instructions.

8.22 GUARANTEE

The Contractor shall make periodical inspection and repair the waterproofing for any apparent defects to ensure complete waterproofing during the guarantee period. The Contractor shall submit a bank guarantee from a scheduled commercial bank (other than co-operative bank) for an amount of 10% of the cost of water proofing works carried out. The bank Guarantee shall be valid for a period of ten (10) years from the date of acceptance of the water proofing work by NPCIL.

9. DELETED

10. REINFORCEMENT

10.0 SCOPE

The work covered under this section shall include supplying, cleaning, cutting, bending, placing, binding and securing of reinforcement in position for all structures. For use of Fusion Bonded Epoxy Coated bars the relevant specification shall be followed.

10.1 STANDARDS AND SPECIFICATIONS

The provisions of the latest revisions with amendments, if any, of the following Indian Standards and other relevant codes shall form part of this specification to the extent they are relevant. Where the provisions of these Standards/Codes are in conflict with the stipulations of this specification, the specification supersedes the respective Standard or Codes.

10.1.1 BUREAU OF INDIAN STANDARDS

IS – 1786	High strength deformed steel bars and wire for concrete reinforcement-Specification.
IS – 456	Plain and reinforced concrete – code of practice
IS – 2502	Code of practice for bending and fixing of bars for concrete reinforcement.

IS – 9417	Welding cold worked steel bars for reinforced concrete construction – recommendation for welding.
IS – 2751	Code of practice for welding of mild steel plain and deformed bars for reinforced concrete construction.
IS – 822	Code of procedure for inspection of welds.

10.1.2 OTHER STANDARDS

1. ASME Section III DIVISION
2. Qualification of splicing system

10.2 MATERIAL

Material covered under this specification is a high yield strength deformed bar (HYSD) and TMT bars of grade Fe 500 conforming to IS: 1786, as specified in the drawing. For Fe 500 grade steel, the total elongation shall be more than 14.5 % and the ultimate tensile strength of the bar shall be 15 % more than the specified 0.2 % proof stress/ yield stress. This requirement is over and above the requirements specified in IS 1786. The Contractor shall submit the manufacturers test certificate for the material. Random tests i.e. minimum 1 sample per 150MT or at least one sample from each heat, for each diameter of bar shall be performed as required by the Engineer in his presence. All costs, incidentals to such tests shall be borne by the Contractor and shall be deemed to have been included in his quoted rates. Steel not conforming to the specifications shall be rejected. All reinforcement shall be clean, free from grease, oil, paint, dirt, loose mill scales, loose rust, dust, bituminous material or any other substance that will destroy/ reduce bond. All bars shall be thoroughly cleaned before fabrication and placement. Pitted and defective bars shall not be used.

The steel shall be supplied by main manufacturers like SAIL, TATA Steel & RINL etc., who manufacture the rebars using billet produced from ore itself and not by rerolling of steel.

10.3 STORAGE

10.3.1 The reinforcement steel shall not be kept in direct contact with ground but stacked on top of an arrangement of concrete pedestal or timber sleepers. Fabricated reinforcement shall be carefully stored to prevent damage, distortion, corrosion and deteriorations.

10.3.2 It shall be stored under cover, as desired by the Engineer without any extra cost. If necessary, the reinforcement steel, other than Fusion Bonded Epoxy Coated bars, shall be coated with cement wash before stacking, to prevent scale and rust. The stacks shall be easily measurable. Steel needed for immediate use shall only be removed from storage. Any reinforcement, which has deteriorated or has been damaged or is otherwise considered defective by the Engineer, shall not be used for the work.

10.4 FABRICATION

10.4.1 The reinforcement bars shall be straightened, cut to size using cutting machine & shall be cold bent using bar bending machine, without the use of heat, to the shapes mentioned in the Drawings, as per relevant Indian Standards. Bars having cracks or splits on the bends shall be rejected. The bar bending schedules shall be prepared by the contractor in general (except for critical structure as decided by the Engineer) according to the reinforcement drawings and shall get it approved by the Engineer. In any case, the details given in the drawings shall be final. The high strength deformed steel bars/ TMT Bars shall not be re-bent or straightened without the approval of the Engineer. Crossing bars shall not be tack welded. Bars shall be properly tagged for easy identifications.

10.4.2 Where reinforcement bars are bent aside at construction joints and afterwards bend back into their original position, care should be taken to ensure that at no time the radius of the bend is less than 6 times the dia for HYSD TMT bars.

10.5 FIXING / PLACING

10.5.1 Rough handling, shock loading (prior to embedment) and the dropping of reinforcement from a height shall be avoided. Reinforcement shall be accurately placed and fixed by any approved means to maintain the correct position of bars as shown on the drawings for this purpose. The contractor shall use cover blocks, spacers and chairs as per IS: 2502 to prevent displacement during placing & compaction of concrete. Concrete cover blocks as directed by the Engineer shall be used for providing specified cover to the rebars. Bars intended to be in contact at crossing joints shall be securely bound together at all such points with 1.6 mm dia soft annealed Iron wire (Binding wire). The vertical and horizontal distance required between successive layers of bars in beams, walls or similar members shall be maintained by the provisions of spacer bars at such intervals that the main bars do not perceptibly sag between adjacent spacer bar. The dia. of such spacer bar shall not be less than the dia. of the main bar. No reinforcement shall be bent when in position in the work, without the approval of the Engineer. In-situ bending of embedded bars using oxy-acetylene flame shall not be done. However, if it can be proved that cold bending is not possible the same may allowed at the discretion of the Engineer by taking due precautions. Erected and secured reinforcement shall be inspected and approved by Engineer prior to placement of concrete.

10.5.2 When reinforcement of the specified diameter is not available, Contractor may be allowed to replace with diameter higher than originally specified in the drawing on written approval of the Engineer at no extra cost to NPCIL. However, this option shall be used under exigency situations only and not as a general practice.

10.5.3 Exposed ends of dowel bars for underground structures shall be protected if necessary, by encasing the same in lean concrete, at no extra cost. Bars for the portion of structures above ground shall be given adequate coat of cement wash and if additional protection is needed as per the Engineer, shall be wrapped with plastic tape at no extra cost.

10.5.4 Wherever necessary/ as directed by the Engineer, before placing the reinforcement in the congested areas full-scale mock-ups shall be carried out and approval from Engineer shall be obtained. Such Mock-ups will be paid as per relevant items of BOQ.

10.5.5 For supporting the horizontal bars at height, supports drawings shall be prepared by the Contractor & shall be approved by the Engineer. Reinforcement chairs, spacers & support embedded in concrete as mentioned in the drawing or specified by the Engineer will be measured & paid separately.

10.6 TOLERANCE ON PLACING OF REINFORCEMENT

Unless otherwise specified in the drawings, reinforcement shall be placed in accordance with IS: 456.

10.7 LAP SPLICING OF REINFORCEMENT BARS

Lapping of reinforcement bars shall be done at locations shown in the drawings or as directed by the Engineer. The lap length shall not be less than that specified in the drawings and unless otherwise specified, the lap length shall be as per IS: 456. At locations where lap splice gives rise to congestion of reinforcement, such splice shall be replaced with welding/ mechanical splicing. For mechanical splicing of bar the relevant specification of mechanical splices (Threaded Coupler) shall be followed.

10.8 WELDING

10.8.1 Generally bars joints are to be made using mechanical splicing using threaded couplers or lapping. In exceptional cases only joints shall be made by welding or any equivalent splicing system like CADWELD etc. The splicing system shall be qualified as per ASME Section III DIVISION 2.

10.8.2 Field welding of reinforcement will not be permitted, without the written permission of the Engineer. Such approval will require identification of the type of steel used. Where welding is permitted, detailed welding procedure shall be submitted to the Engineer for approval. Welding of reinforcement to structural steel if required shall be done as per standard practice. Welding of reinforcement if required will be paid for as per relevant item of schedule. Welding of High Strength Cold Twisted deformed bars/TMT bars conforming to IS 1786 shall be made in accordance with the relevant Indian Standards (IS 9417).

10.8.3 The material shall be examined and compared with the manufacturer's test certificates, ISI certification marks and inspection stamps. Special attention shall be paid to the chemical composition of the material and its general weldability to meet the required standards for strength. The material shall be examined for surface defects, rust and corrosion products, presence of contaminants and any other factors, which may hamper the production of a satisfactory weld.

10.8.4 The qualifying tests for welders engaged in arc welding shall be in accordance with IS:

2751.

10.8.5 The Procedure to be adopted for the welding shall be arc welding with double V butt joints. Oxy-acetylene welding is not permissible.

In addition to the requirements specified in IS 9417, the requirements given below shall also be followed:

10.8.6 All welding operations shall be controlled to prevent a supply of more heat to the steel at a time than can be dissipated by the steel owing to its high thermal conductivity without adversely affecting the strength of the welded bars. The non-twisted portion of the deformed bar at weld junctions (25 to 50 mm) must always be cut off. Scraping of rust at joint- surfaces prior to welding is essential.

10.8.7 For edge preparation, the bar ends to be welded should be shaped by power shears and grinders. If oxyacetylene torches are used for shaping the edges (chisel edge) last 2-3 mm of the cut faces shall be removed by grinding. The amount to be ground off may be determined by tests, but should not be less than 2 mm. To avoid crookedness in bars after welding, their axes should be properly aligned prior to the welding operation. During the welding procedure, the bar may be supported to about 1 m. on each side of the joint over steel channels 2 m. to 3 m. long. Removal of slag after each alternate welding run is to be effected by brushing. The electrode shall never be lighted from the hot bar, to avoid notch effect.

10.8.8 Fusion faces and surfaces adjacent to the joint for a distance of at least 50 mm on either side shall be absolutely free from grease, loose scales, moisture or any other substance which may interfere with welding or adversely affect the quality of the weld.

10.8.9 Each layer of the multiple layer weld may be moderately peened with light blows from a blunt tool. Care must be taken to prevent scaling or flaking of weld.

10.8.10 Welded junctions of all reinforcing bars may be carried out at same section provided there are no bends, curved parts in reinforcement bars, or zones where variable loads predominate. It is recommended that all welds be located at least 50 dia away from bends.

10.8.11 Assessment after welding shall first be done to ascertain the correctness of the whole weldment by visual and dimensional inspection.

10.8.12 Mechanical testing in the form of tensile tests and 180-degree bend tests shall be carried out on prototype or sample welds. The choice of the samples will depend entirely on the Engineer, and will be made at random. Specimens for tension tests are to be chosen 1 out of every 100 joints prepared. The bend tests are to be conducted on 2 prototype specimens in 2 perpendicular directions, for every 200 joints. The specimen shall be bent by 180 degree for qualification.

10.8.13 The welded joint should be capable of resisting 90% of the actual bar strength and should not fail to develop at least 100% of the specified ultimate strength of the variety

of steel under use. The failure shall not occur at the joint location.

Weldments incapable of developing full strength shall not be used as reinforcement.

Apart from tensile testing of weldments, liquid penetrate flaw detection test as recommended in IS: 822 shall also be made on 10% of total joints on root & final pass.

10.9 FUSION BONDED EPOXY COATING BARS

10.9.1 SCOPE

These specifications cover coating of reinforcement bars with fusion bonded epoxy coating (FBEC) to be provided as corrosion protection measure, in construction of Nuclear Power plant. This coating shall be used, wherever specified so in the drawings.

10.9.2 REINFORCING BARS

The reinforcing bars to be provided with Fusion Bonded Epoxy Coating shall conform to I.S. 1786. In spite of producing test certificates by contractor for the proper quality of reinforcing bars, the quality of steel should also be tested by the FBE coating agency for bend test before undertaking coating and that if the reinforcing bar fails in bend test, it shall be rejected.

Reinforcing bars to be coated shall be fresh from rolling mills as far as possible. If the bars are rusted in quality before providing FBEC, the same shall be rejected.

10.9.3 Coating on Bars with FBEC

10.9.3.1 SURFACE PREPARATION

The surface of the steel bars to be coated shall be cleaned using shot blasting near to white metal .The surface profile shall be free from mill scale, rust and foreign matter.

10.9.3.2 The Coating shall be applied to the cleaned surface as soon as possible after cleaning. In no case the coating be delayed beyond 8 hours after cleaning.

10.9.3.3 The FBEC coating shall be done confirming to I.S. 13620 as well ASTM A775/775M.

10.9.3.4 The Fusion Bonded Epoxy Coating shall be carried out by an authorized FBE coating agency approved by Engineer.

10.9.3.5 Patch-up materials shall be procured in sealed containers with certificates from coating agency for supply of such patch-up material.

10.9.3.6 The Quoted rate for FBE coated bars shall include the use of PVC coated GI wire (Binding Wires) of 1.6 mm dia.

10.9.4 Tests for FBE Coating on Reinforcing Bars

10.9.4.1 The contractor shall produce certificate from the FBE coating agency that the quality of powder epoxy material and other components of FBEC conform to I.S. 13620 as well ASTM A775/775M. Such certificates shall accompany each delivery challan of coated bars. The Engineer may carry out such tests at plant to confirm use of proper quality of coating material.

10.9.4.2 The Coated reinforcement bars shall be tested for following properties at a specified frequency. Following tests on coated bars shall be as per I.S. 13620 at the specified frequency on routine basis and Test reports shall be jointly signed by authorized representatives of contractor and the coating agency:

Thickness of coating: One full-length bar for every twenty bars for each size of bars

Continuity of coating: One full-length bar for every twenty bars for each size of bars

Adhesion of coating: As per following frequency based on dia of bar
- Upto 16 mm dia: - 1 for every 1 tons
- Above 16mm and upto 25mm dia: - 1 for every 2 tons
- Above 25 dia: - 1 for every 4 tons

10.9.4.3 Inspite of conducting above tests and test certificates produced by the contractor and coating agency, Engineer reserves the right to carry out independent tests at coating plant for cross checking. The contractor's agreement with coating agency shall include the provision for Engineer's cross checking and that if the coating quality is not approved by the Engineer, the decision of the Engineer to reject or repair the coating shall be final and binding on all parties.

10.9.4.4 Thickness of Fusion Bonded Epoxy Coating shall be 250 (+/- 50) microns.

10.9.4.5 Holidays in coating shall not be more than two holidays per linear foot (six holidays per meter) of coated bar. All the damaged coating incurred during handling & fabrication, to the point of shipment to the job site shall be repaired. Damaged coating on a bar is permitted to be repaired if the amount of damaged coating does not exceed 1 % of the total surface area in each 0.3 m length of bar. The limit on the amount of repairable damaged coating does not include sheared & cut ends of the bars that are required to be coated with patching material. Repaired areas of damaged coating shall have a minimum coating thickness of 250 microns.

10.9.4.6 The Coating shall also meet all other requirements specified in IS 13612 as well ASTM A775/775M.

10.9.5 Handling

10.9.5.1 The coated bars shall be carefully handled in order not to drop them, not to rub them on hard surface or against another coated bar while conveying, stacking, placing or

stacking of fabricated bars. For this purpose, wooden packing batons shall be used at spacing of not more than 60 cms.

10.9.5.2 The Coated bars shall be tied to make bundles with PVC binding material to avoid damages to coating.

10.9.5.3 The cut ends of bars shall be touched up with special touch up material of the same specifications as provided by coating agency. There shall be minimum time gap to repair the cut ends and damaged portions with touch up materials and that failure to do so may cause complete rejection of the coated bars. The cut ends and damaged portions shall be touched up with repair patch-up material within four hours time gap. All damages to coating in handling etc. shall be repaired irrespective of their size. This stipulation supersedes provision of clause 13 of IS 13620.

10.9.5.4 The Contractor will be paid for the same quantity of reinforcement bars used in the work and paid under relevant item.

10.9.5.5 While bending the bars, the pins of workbenches shall be provided with PVC or plastic sleeves. It is preferable that contractor install bar bending machines suitable for FBE coated bars and that each bending operation is done in a time of not less than 90 secs.

10.9.5.6 The coated steel shall not be directly exposed to sun rays and rains and shall be protected with opaque polythene sheets or such other approved materials.

10.9.5.7 While Doing concreting, the workmen or trolleys shall not directly move on coated bars, wooden planks shall be placed on the bars for movement of workman & trolley of material, by the contractor.

10.9.5.8 In spite of all test certificates, if the coated bars are roughly handled by the contractor either during transport, fabrication, stacking, placing and concreting etc. or handled in such a manner as to damage the coating for area or portion more than reasonable, the Engineer reserve the right to reject the FBE coated bars and such rejected bars shall be removed by contractor from work site within three days. The decision of Engineer will be final as to reject the bars with damage coating or to allow repairing the coating, or to get it recoated entirely at the contractor's cost.

10.9.6 STORAGE

10.9.6.1 The Bars shall be stored as close as possible to the area of the structure where they will be placed (fixed) to keep handling operations to a minimum. Deliveries of the coated bars to the job site should be well coordinated to avoid any long term storage at site when stored in open. If circumstances or other conditions make it necessary to store FBE coated bars outdoors for an extended period of time, the coated bars should be protected from sunlight & salt spray, and sheltered from the weather.

10.9.6.2 FBE coated bars shall be stored above ground on protective timbers, supports shall be provided at regular interval to avoid sagging of the bundle. Such wooden or padded contact shall be at spacing of not more than 60 cms.

10.9.6.3 If a relatively large quantity of FBE coated bars is to be stored in a small area, bundles of straight bars shall be stacked with adequate blocking between the layers of bundles.

10.9.6.4 FBE bars shall be covered with opaque polythene sheets or other suitable protective material. The protective cover shall be draped over the sides of the bundles around the perimeter of the stack. The cover shall be properly secured with provision of air circulation to minimize the condensation under the covering.

11. REINFORCEMENT, SPLICING AND MECHANICAL FASTENERS & MECHANICAL COUPLERS

11.0 SCOPE

These specifications cover threaded couplers to be used for joining reinforcement bars, in lieu of laps/welding/mechanical splicing.

11.1 GENERAL

The couplers shall be of standard parallel square thread type. Ends of the reinforcement bars, which are to be joined, shall be enlarged by cold forging, threaded in such a way that thread diameter is not lesser than the parent bar to be joined. The material of the coupler shall be of same quality or of superior quality than the quality of material of the parent bars (i.e. reinforcement bars to be joined). The joint shall have guaranteed bar break i.e. when the joint is tested in universal tensile testing machine, the bar shall fail away from the coupler i.e. not within the coupler as well as within 2 times the diameter of bar from the ends of the coupler, which can be considered as affected zone. The Guaranteed Bar break condition is not mandatory, if the failure load of coupled specimen is higher than 1.15 times of its minimum specified yield stress. The coupler shall be qualified as per ASME, Section III, and Div.2. Additionally it shall meet all the requirements of "Class H" type coupler as specified in IS 16172. The safety margin in coupler design shall be such that guaranteed bar break is ensured even if 15% of the total threads length are out of coupler during installation.

The hand tightening of coupler shall be sufficient in the field and no mechanical means shall be essential for tightening. During testing, the coupler should only be hand tightened.

The process of manufacturing of the coupler, cold forging and threading including testing shall be carried out as per ASME approved quality assurance programme. The manufacturer of coupler shall hold a valid Quality System Certificate (QSC) from ASME. Installation of the coupler and supervision shall be done by the qualified personnel.

11.2 MANUFACTURING OF COUPLERS

All the couplers shall undergo quality checks on uniformity of threads, dimensional accuracy etc. Each coupler shall be clearly stamped indicating batch number, heat

number and diameter. This number shall be traceable to the original cast. The relevant material mill certificate shall be submitted with supply of a particular lot. The certificate shall give salient material properties.

11.3 THREADING OF ENDS OF THE REINFORCING BARS

This threading activity shall preferably be done at site. The various stages involved in threading are as given below

i. CUTTING

The ends of reinforcement bars shall be cut by mechanical means to get a perfect plain end surface, perpendicular to the axis of the bar.

ii. COLD FORGING & THREADING

After cutting, the ends of the bar shall be enlarged by cold forging such that the area of cross section after threading shall not be less than the area of cross section of the parent bar. The length of cold forging shall be adequate for proposed thread length as per manufacturer's design. Threading shall be done, preferably on lathe machine. The threads shall be square parallel type, to suit the couplers. The thread length and depth shall be as per manufacturer's design. After threading is completed, the threaded length of the bars shall be protected by providing plastic caps, before taking the bars out of the shop.

iii. QUALITY CONTROL IN MAKING OF THREADS

The work in shop shall be fully supervised by the Manufacturer representative. Double forging of bars is not permitted. In case of improper cold forging, the forged end of the bar shall be square cut and fresh cold forging shall be undertaken. The threading shall be checked with 'go' and 'no go' gauges.

For threaded coupler systems, every prepared bar end shall undergo a load test prior to actual use. The minimum test loading shall be equivalent to 80% of specified yield strength of bar. For this purpose contractor shall deploy the machine having facility of integrated load testing. The "Integrated" means that the testing operation is performed automatically by the same machine used to prepare the bar ends. A positive indication shall be punched on the rebar to indicate that this operation has been carried out and bar end has qualified for specified strength.

11.4 INSTALLATION OF COUPLERS IN THE FIELD

The installation of couplers in the field, for joining reinforcing bars, shall be undertaken by trained manpower and as per manufacturer's instructions. Threads of both the couplers and the bars shall be thoroughly cleaned with acetone or any other solvent, just before installation.

Where couplers are cast-in the concrete, but connection is not to be completed

immediately, the couplers shall be internally greased and plastic capped to a protection detail acceptable to the engineer. This cap shall be removed only when next bar is to be attached & then cleaned before joining the next bar.

11.4.1 The contractor shall arrange for a suitably qualified manufacturer's representative, experienced in mechanically connecting reinforcement, to be present at site before the start of work for initial training of personnel, and also to demonstrate the equipment and techniques as necessary.

11.4.2 The contractor shall submit to the Engineer, for his acceptance, a method statement for mechanically connecting the reinforcement and for the installation and verification in the field. This shall take into account any special requirements for horizontal, vertical and inclined couplers and shall include a rectification procedure, if the connection is incorrectly made. It shall also cover the correct methodology for handling of tools and equipment for mechanical connection on site. The following information shall also be included:

(a) requirements for cleanliness
(b) equipment for threading bars
(c) method of locking the connections on both rebars
(d) method of verification of final rebar alignment and coupler integrity.

11.4.3 Each coupler shall be visually examined prior to use to ensure the absence of rust and of any foreign material on the inside surface. All completed couplers shall be inspected and verified in accordance with the approved QAP. The Contractor shall ensure the acceptance of the Engineer for a procedure for documenting the inspection of the couplers. The contractor shall retain inspection records and shall submit copies to the engineer within 7 days. The Couplers that do not meet the acceptance standards shall be completely removed and the bars re-connected, as required.

11.5 QUALIFICATION TESTS

The splices shall be qualified as per ASME Section III Div-2, IS 16172 and by conducting following tests:

11.5.1 STATIC TENSILE TEST

Mechanical connections shall be tested in all reinforcing rebar sizes. All rebar transition connectors shall also be tested. For each rebar size, a minimum of six connections in each load direction shall be tested in accordance with ASTM A 370. A tensile test on an unspliced specimen from the same bar used for the spliced specimens shall be performed to establish actual tensile strength.

- The average tensile strength of the splices shall not be less than the followings:

a) 90% of the actual tensile strength of the reinforcing bar being tested.
b) 100% of the specified minimum tensile strength

- The tensile strength of an individual splice system shall not be less than the 115% of the specified minimum yield strength of the spliced bar.

11.5.2 CYCLIC TENSILE AND COMPRESSIVE TEST

Cyclic tensile and compressive test: Mechanical connections shall be tested in all reinforcing rebar sizes. For each rebar size, a minimum of three connections shall be tested for low cyclic tensile test. Each specimen shall withstand 100 cycles of stress variation from 5% to 90% of the specified minimum yield strength of the reinforcing bar. One cycle is defined as an increase from the lower load to the higher load & return. The test shall be performed as per Annexure D of IS 16172.

11.5.3 PERCENTAGE ELONGATION

The minimum uniform elongation (Elongation at maximum force) in the reinforcement bar outside the length of mechanical splice as measured as per Annexure B of IS 16172 shall be 3 % before failure of test piece.

11.5.4 SLIP TEST

The total slip value when measured in accordance to test procedure described in Annexure C of IS 16172 shall not exceed 0.10 mm.

11.5.5 TEST FOR AVOIDANCE OF STAGERRING

The strain measured over the full length of the splice at 90% of the specified minimum yield strength of the bar shall not exceed that of a bar that is not mechanically-spliced by more than 50%. The test shall be performed for all diameter of couplers.

11.5.6 LOW CYCLE FATIGUE TEST

The mechanical splice shall withstand 10000 cycles of alternating tension & compression load, when tested as per Annexure E of IS 16172.

11.5.7 HIGH CYCLE FATIGUE TEST

The mechanical splice when tested accordance to Annexure E of IS 16172 shall withstand 2 million cycles (2000000 Nos)of varying axial tensile load with a stress range of 60 MPa with upper stress in the test equal to 0.6fy.

11.5.8 PRODUCTION TESTS & ACCEPTANCE CRITERIA FOR A LOT

Static Tensile tests, as per ASTM A370, shall be conducted on each bar size & grade

for each lot as follows. The criteria mentioned below are in variance with the above referred codes.

Sr No	No of Coupler in the Lot	No of sample to be tested	Acceptable Defective couplers
1	Upto 500	14	NIL
2	501-1200	20	NIL
3	1201-3200	32	1
4	3201-10000	50	2
5	10001 and above	50+ 2 for each 1000 Nos beyond 10000	Not more than 4% of the samples tested

The lot is defined as the group of couplers which are of same size, type, class, material traceable to same cast and manufactured under similar conditions of production. All the tests shall ensure guaranteed bar break at a load not lower than the specified tensile strength of the bar. The quoted rate shall be inclusive of carrying out above tests and no separate payment shall be made for these tests.

11.5.9 The Contractor shall submit to the engineer for acceptance a report on these Proving Tests, within seven working days of the tests. The report shall provide full details including:

(a) Results of all tests
(b) Details of dimensions, geometry.
(c) Details of test procedures
(d) Description of test rig/load cell
(e) Description of load monitoring, strain measurements
(f) Calibration certificates.

11.5.10 From each test on the coupler and control bar specimens, the following information shall be provided:

(a) Stress-Strain (or Load Displacement) curves
(b) Yield Load & Yield Strength
(c) Elongation of the mechanical connection
(d) Ultimate load & Ultimate Tensile Strength
(e) Mode of failure
(f) Gauge length used for strain measurement and statement of how gauge length was determined.

12 PILING WORKS

12.0 SCOPE

This specification covers the works involved for bored cast in situ reinforced cement concrete (RCC) piles including all specific requirements for installation/casting of pile, testing (initial, routine and other NDT) and analysis of the various test results to assess

their vertical, horizontal and pull out load carrying capacities, confirm pile integrity, apportion skin friction and end bearing capacity of the pile and arrive at dynamic properties of soil-pile system. *All the piles within the scope of this tender needs be toe grouted. The procedure for Toe grouting shall be finalized by the contractor in consultation with Engineer.*

12.1 CODES, STANDARDS & SPECIFICATION

12.1.1 Latest Indian Standards on Piles

IS 2911 : Part 1: Sec 2 Code of practice for design and construction of pile Foundations: Part 1 Concrete piles, Section 2 Bored cast-in-situ piles
IS 2911 : Part 4: Load test on piles
IS 5121 : Safety code for piling and other deep foundations
IS 9716 : Guide for lateral dynamic load test on piles
IS 14362 : Pile boring equipment - General requirements
IS 14893 : Non Destructive integrity testing of piles-Guidelines

12.1.2 Latest ASTM

ASTM D 4945: Standard Method of test for High Strain Dynamic Testing of Piles
ASTM 6760: Standard Test Method for Integrity Testing of Concrete Deep Foundations by Ultrasonic Cross-hole Testing
ASTM D 5882: Standard Test Method for Low Strain Integrity Testing of Piles

Reference to any code shall always mean reference to the latest revised edition of the code including all its amendments up to date, unless otherwise specified. In the event of any conflict between the requirements of this specification and those of the referred codes, the former shall govern.

12.2 DESCRIPTION

12.2.1 GENERAL

Specifications to be followed for providing RCC bored cast in situ piles wherever required as per design . The scope in general consists of constructing the RCC bored cast in situ pile foundation .

The testing of piles shall be carried out by the contractor in line with relevant BIS codes, and / or ASTM codes, as specified above and procedures to be developed by the contractor/Vendor and approved by NPCIL. Initial and Routine (static and dynamic) tests shall be carried out on test piles and working piles, respectively as per provisions of BIS/ASTM and as approved by NPCIL.

The work involves but is not limited to the following:

1. Construction of Pile foundation .

2. Conducting Initial, Routine Load tests (Static and dynamic) on designated Test / working piles namely Vertical, Lateral, Pull out and Dynamic load tests.
3. Conducting Non-Destructive Testing (NDT) to assess pile integrity.
4. Toe grouting of pile

The contractor shall submit the work procedures for different items of piling works in line with IS/ASTM, Technical Specification herein under and get it approved from Engineer.

Upon completion of the piling work, all casing equipments, construction tools, protective covering and debris resulting from the piling operations shall be removed from the works site with the permission of the NPCIL.

12.2.2 MINIMUM REQUIREMENT OF PILING EQUIPMENT

The equipment & accessories should be compatible with the type of sub-soil, method of construction, type of founding strata & required penetration in the founding strata. The capacity of rig shall be adequate so as to bore up to required depth with specified diameter. Rig shall be equipped with suitable chisel to penetrate through any local obstruction/ hard strata.

Hydraulic self-propelled rotary piling rigs complete with adequate torque capacity and crowd value shall be deployed to complete the entire job as per the time schedule and specifications provided in this tender document. The Contractor shall mobilize adequate spares; cutting tools (e.g. flat teeth bits, round shank bits, holders, etc.) to avoid any stoppage of work.

The Contractor shall provide all the equipment, tools and plants required for the work.

12.2.3 SURVEYING AND LAYOUT

It is the sole responsibility of the contractor to bring to site all surveying instruments necessary for the marking out, fixation of levels, etc. and conduct these survey operations with utmost accuracy. The contractor shall put-up stable bench marks etc. as necessary for the work. NPCIL will provide benchmark location and elevation with respect to plant grid. The contractor shall be entirely responsible for accurate setting out of the work and he shall at his own expense make good any defects arising from errors in line and levels.

12.2.4 BORING

The boring shall be done as per specific requirements of soil strata and the procedure / methodology shall be approved by Engineer-In-Charge.

The Contractor, while boring the pile bores, shall constantly collect the bore spoils and these shall be compared with the layer wise soil classifications reported in the bore-log details of the location, reported in the soil investigation report. Should there be any variation between the two soil classifications, these shall be immediately reported to

the Engineer. Rig register and weekly report as per the format, approved by NPCIL shall be submitted to Engineer-In-charge of the project.

12.2.5 CLEANING OF PILE BORE

After completion the pile bore up to the required depth, the bottom of the pile bore shall be thoroughly cleaned. Cleaning shall ensure that the pile bore is completely free from sludge/bored material etc. Necessary checks shall be made to confirm the thorough cleaning of the pile bore as per the recommendations of IS 2911-Part1- section 2.

Pile bore spoil shall be disposed of from site within 1 Km. away as directed by the Engineer.

12.2.6 DEWATERING

The dewatering for the area will have to be carried out by the contractor at his own cost.

12.2.7 INFORMATION TO BE SUBMITTED AS PART OF THE TECHNICAL BID

If piles are envisaged in the structure, bidder shall submit the following information along-with the bid:

1. Number of the piling rigs proposed to be deployed.
2. Full Technical details of piling rigs and accessories in the form of catalogues, data sheets, etc.
3. Piling procedure, piling program and accessories to be mobilized by the contractor.
4. Complete Construction Methodology. However, work procedures and quality assurance plan (QAP) for the work will be required before start of the work. The contractor shall use only Ready mixed concrete from the batching plant for the proposed piling works.
5. All data sheets, rig register, test reports, Soil/Rock profile data.
6. Details of toe grouting to be done for all piles.

12.3 REQUIREMENTS

All work shall be carried out in accordance with this specification and contractor shall ensure meeting of all the requirements as laid down hereunder:

The work shall include supplying and providing necessary materials, mobilization / demobilization & operation of all necessary equipment, consumables providing necessary engineering supervision through qualified and technical personnel, skilled and unskilled labor etc. as required to carry out the complete piling work, and submission of records & reports as per schedule.

The Contractor shall confirm the "Safe Load" capacities by conducting both initial and routine load test on piles.

It is essential that all equipment and instruments are properly calibrated at the commencement of test so that they represent true values. The instruments shall be re-calibrated at the frequency as per manufacturer's specification. Certificates to this effect from an approved institution/National Accreditation Board for Testing and Calibration Laboratories (NABL) shall be furnished to the Engineer. If the Engineer desires to witness such tests Contractor shall arrange to conduct the test in his presence.

The contractor shall assure the quality of piling work including cleaning of pile bore, quality of concrete, integrity of piles, etc.

Each pile shall be identified with a reference number. Sequence of piling shall be such that there is no damage caused to the concrete recently laid in the adjacent pile and as per approved drawings. Construction of piles shall be done in accordance with the priority of construction of various buildings. The convenience of installation may be taken into account while scheduling the sequence of piling in a group. This scheduling shall avoid piles being bored close to other recently constructed pile. Sequence of piling shall be approved by the Engineer.

12.3.1 TERMINATION OF PILES

The casting of piles shall start from levels strictly as per approved construction drawings. In no case casting of piles should start from levels higher than those indicated in the approved drawings. The top of the pile shall be cast above the cutoff level so as to permit removal of all laitance and weak concrete before embedment into raft. The pile top shall be terminated at minimum 600mm above Pile cutoff level. The same will be chipped off up to cutoff level before the commencement of pile-raft construction to progress the job further.

12.3.2 SAFE LOAD CARRYING CAPACITY

The contractor shall conduct the tests as specified in the drawing or as per the direction of Engineer and determine the minimum safe load for the piles constructed for Vertical Compression/Lateral/Uplift.

12.4 MATERIALS

Materials shall conform to specifications for materials included in the specification of 'normal concrete', 'reinforcement' and 'coupler' in this tender document.

12.4.1 CONCRETE

The concrete shall be of M35 grade or as specified in the approved drawings. The minimum cement content shall be 350 kg/m^3 (including fly ash as defined in technical specifications for plain and reinforced cement concrete) and allowable slump shall be between 150mm to 180mm as specified in IS 2911 Part 1/Sec 2. The tests on concrete for piles shall be tested as per the relevant specification given in this tender. Suitable cylindrical cover blocks with center hole shall be used to maintain the specified cover

as per the approved drawings. The re-steel ties used for holding cover blocks for re-steel.

12.4.2 REINFORCEMENT & COUPLERS

Reinforcement & couplers shall conform to relevant technical specifications given in this tender.

12.4.3 STABILISING MUD/BENTONITE/POLYMER

The drilling mud for stabilizing the borehole in bored piling work should have properties and quality control conforming to the requirements of IS 2911-(Part1-Sec-2). In case polymer is used, the specification and methodology for its use shall have prior approval from NPCIL.

The bentonite / polymer slurry and the cuttings, which are carried to the surface by the rising flow of the slurry, shall pass through setting tanks of adequate size to remove the sand and spoils from the slurry before the slurry is re-circulated back to the boring. The bentonite slurry mixing and re-circulation plant shall be suitably designed and installed. The bentonite slurry shall be maintained at 1.5 m above the ground water level during boring operations and till the pile is concreted. When DMC (Direct mud circulation) or RMC (Reverse mud circulation) method is used the bentonite slurry shall be under constant circulation till start of concreting.

For tremie concreted piles, a sample of drilling fluid shall be taken from the base of the borehole by means of an approved sampling device in the first few piles and at a suitable interval of piles thereafter. The concreting operations shall not be taken up when the fluid density is more than 1.25g/ml.

After completion of piling work, area around piles shall be restored with compacted soil-cement mix after removal of bentonite slurry /muck, at no extra cost to NPCIL.

12.5 CONSTRUCTION

12.5.1 Construction of piles shall be carried out only after excavating ground up to the desired founding levels/levels as per requirement of ground improvement technique to be adopted and as per the approved drawings.

12.5.2 Pile shall be constructed by using temporary casing up to required depth as per site conditions. This is to ensure not only the stability of side soil and also to ensure good quality concrete in the entire length of pile. Adequate bentonite mud / polymer or any other suitable material (if required) may be used during the boring below temporary casing. The contractor shall ensure the stability of bore by adopting suitable combination of temporary casing pipe and bentonite/ polymer slurry for stabilization.

12.5.3 Immediately before placing of reinforcement and concreting, the bored hole shall be cleaned of all the loose material and debris. The pile tip zone shall be thoroughly cleaned by flushing the bore with fresh bentonite slurry/polymer to completely replace

the old bentonite slurry / polymer used during the previous operations. This shall be carried out for about 45 minutes in two stages. Cleaning for about first 30 minutes shall be done before lowering of reinforcement cage & cleaning of about second 15 minutes after lowering the reinforcement cage.

12.5.4 The time interval between the completion of boring and placing of concrete shall not exceed 6 hrs. In case the time interval exceeds 6 hrs the pile bore shall be abandoned. However, the Engineer may allow concreting provided the Contractor extends the pile bore by 0.5 m beyond the proposed depth and clean the pile bore.

12.5.5 The soil profile and design requirements shall dictate length of temporary casing pipe for construction purposes and shall be withdrawn during casting of the pile. The temporary guide casing shall be withdrawn cautiously, after concreting is done up to the required level. While withdrawing the casing concrete shall not be disturbed.

12.5.6 Cut-off level of the piles shall correspond to those given in the approved drawings. To ensure dense and sound concrete up to cut-off level, concreting shall extend minimum 600 mm above cut-off level. The vertical reinforcement shall project above the cut-off level as per the approved drawings.

12.5.7 In case the reinforcement cage is made up of more than one segment, the same shall be assembled by threaded couplers before lowering. Reinforcement as required shall be made into stiff cages with stiffener rings of appropriate diameter at suitable spacing to withstand handling without any damage or distortion.

Borehole shall be thoroughly cleaned to make it free from sludge or any foreign matter before lowering of reinforcement cage. The full length of reinforcement cage should be in place before start of concreting. Reinforcement shall be placed immediately after cleaning and inspection of the bottom of bore holes. The reinforcement should be supported away from the sides of the shaft by means of suitable spacer blocks to ensure concentric alignment in the shaft. Care shall be taken to preserve correct cover and alignment of reinforcement and avoid damage to it throughout the complete operation of placing concrete.

12.5.8 Concrete shall be so placed as to fill the entire volume of the tube or bore without the formation of voids caused by the faulty consolidation or entrapped air. Proper care shall be taken to ensure that the fluid alluvial soil does not penetrate the concrete.
Concreting shall be done by tremie method. The operation of tremie concreting shall be governed by IS: 2911 (Part1-Sec2). Concrete shall be placed by means of tremie pipe, which will be suitably closed at bottom at the start of concreting. The tremie pipe must extend up to the bottom of the borehole at the start and may be withdrawn in sections as the level of concrete rises in the borehole; but its discharge end shall at all times be embedded in the concrete to a minimum depth of 2m. Placing of concrete should be continuous and the pile holes will be maintained full with the bentonite slurry where used throughout the concreting operation. Slurry displaced from the borehole by the concrete shall be channeled away or pumped into suitable mud pond for re-use or disposal to waste.

12.5.9 The record of volume of concrete poured in each of the piles shall be maintained. After concreting the actual quantity of concrete shall be compared with the average obtained from observations made in the case of a few piles already cast. If the actual quantity is found to be considerably less, the matter should be investigated and appropriate measures taken.

12.5.10 **Control of alignment**: Piles shall be constructed vertically as accurately as possible as per the construction drawing. The permissible limits for deviation with respect to position and inclination/alignment shall conform to IS-2911 (part 1/Sec2).

12.5.11 **Preparation of pile head:** Before casting the piled raft, the excess concrete shall be cut off up to pile cut-off level as shown in approved drawings. In case sound concrete is not met with at such elevation the piles shall be cut up to an elevation where sound concrete is met. Care shall be taken not to damage the reinforcement or the concrete below cut off elevation during such stripping operations. Where chipping to be done to a level lower than the specified cut off elevation to obtain dense and sound concrete, the Piling Contractor shall build up the pile up to cut off elevation at his own cost.

The exposed part of concrete above the Cut off level shall be removed/chipped off and made square at cut off level not before seven days of casting of pile. The projected reinforcement above Cut off level shall be property cleaned and bent to the required shape and level to be anchored into the pile raft as shown in the drawing.

The pile top shall be embedded into the pile cap/raft by minimum 50 mm or clean cover to reinforcement, whichever is higher.

12.6 DEFECTIVE PILES

The Engineer reserves the right to reject any pile which in his opinion is defective with reference to technical specification & construction drawing on account of load capacity, structural integrity, position, alignment, concrete quality, improper cleaning of borehole before concreting, etc. Piles that are judged defective shall be pulled out or left in place as decided by the Engineer without affecting the performance of adjacent piles. If the adjacent pile is affected, the contractor shall install additional piles to substitute the adjacent piles. The Contractor shall install additional piles to substitute the defective piles as per the directions of the EIC at no extra cost to NPCIL.

12.7 QUALITY ASSURANCE PROGRAMME

The Contractor shall submit and finalize a detailed Field Quality Assurance Program within 30 days from the date of award of the contract, according to the requirements of this specification. This shall include setting up of a testing laboratory, arrangement of testing apparatus/equipment, deployment of qualified/experienced manpower, preparation of field quality plan, etc., the Engineer shall identify, customer hold points, on finalized field quality plan, beyond which work shall not proceed without written approval from the Engineer. The testing apparatus/equipment installed in the field laboratory shall be calibrated/ corrected by the qualified persons as per manufacturer's instructions to give accurate testing results.

12.8 RECORDING OF DATA

Daily site records shall be maintained by the Contractor for the installation of piles against each Rig and shall contain the number and dimension of the pile, depth bored, time taken for boring and concreting. Contractor shall maintain field bore log. When drilling mud /polymer is used, amount of bentonite / polymer needed for stabilization of bore, specific gravity of the fresh supply and contaminated mud in the bore hole before concreting shall be checked and recorded regularly. Record of concrete volume actually cast per pile against required volume shall be maintained. Detail of any obstruction encountered its nature, depth and obstruction time. Any deviation from the designated location alignment or load capacity of any pile shall be noted. Typical data sheet in triplicate for facility of recording piling data to be prepared by the Contractor before starting of actual piling operation at site and information to be recorded against each pile in the data sheet shall be signed by the contractor and countersigned by NPCIL. One copy of the data sheet shall be retained by the Contractor and the other two copies to be submitted to NPCIL for records & future reference.

A full record of pile load test results shall be submitted in triplicate to the Engineer immediately on completion of each test. The record shall also include the plots of load settlement (for various stages of loads) characteristics of pile and also the interpretation of the pile load test curve as per criteria for safe loads mentioned in the specifications for testing concrete piles forming a part of this tender. Any special observations shall be duly explained by the contractor.

Contractor's competent supervisor (geotechnical engineer) shall always be present to record the necessary information during the installation of piles. The data to be recorded shall include:

1. Pile number and location
2. Existing ground level, cut-off-level and level of top of the casting
3. Nominal shaft and inside diameter of casing
4. Data and time of setting up of rig at the pile location.
5. Data and time of start of boring.
6. Length of casing driven and depths bored vs time.
7. Description and thickness of various strata bored.
8. Details of any obstructions encountered (depth from existing ground level, thickness and time taken to penetrate through the same)
9. Chiseling depth and time.
10. Final depth of boring (founding level).
11. Standard penetration test at the bottom of the bore hole, if any.
12. Date and time of completion of boring.
13. Data and time of start and completion of flashing of the bore hole with fresh Bentonite fluid before Concreting.
14. Time of lowering Reinforcement cage and tremie pipes with total length thereof.
15. Date and time of start of concreting
16. Level of concrete inside the bore hole and tremie pipes at various stages of concreting.
17. Concrete grade, mix proportion, water cement ratio and slump test results.

18. Empty boring length and concrete length below cut-off-level.
19. Results of tests on Bentonite slurry used.

Typical data sheets of recording piling data shall be as given in Appendix-D of IS: 2911(Part I/ Sec.2).

Any deviation from the designed location, alignment or load carrying capacity of any pile shall be noted and promptly reported to the Engineer..

On completion of each pile construction, pile record in triplicate shall be submitted to Engineer-in-Charge within two days of completion of concreting of the pile.

On completion of boring and cleaning the bottom of each pile bore shall be checked by the methods as approved by the Engineer, to ensure that it is free from pile bore spoil/debris and any other loose material, before concreting. Concreting shall be done only after the approval of Engineer.

12.9 PILE TESTING

The contractor has to prepare work procedure for conducting the tests in line with IS/ ASTM, Technical Specification herein under and get it approved from Engineer before start of test .

Pile Load Test: Both initial and routine load tests shall be conducted for all the types of testing i.e. vertical, lateral and pull-out. The load tests shall be carried out after concrete attains full strength.

Non-destructive testing of piles: NDT of piles (Low strain integrity test, high strain dynamic testing and cross-hole sonic logging test as per ASTM codes) shall be carried out by expert team or by engaging an expert agency. The staff of the team shall have experience of carrying out these types of tests and knowledge of analyzing the data. Credentials of expert team/expert agency shall be submitted for acceptance by NPCIL.

12.9.1 PILE LOAD TEST DETAILS

12.9.1.1 General

1. For pile load tests, the test set up shall be as per relevant BIS, ASTM standards and specifications for testing of concrete piles.
2. The testing shall be done by specified method of loading in successive increments as per the relevant clauses of IS: 2911 Part 4.
3. Tests shall be carried out at the cut-off level.
4. Maximum test loads for different types of piles shall be as per the approved drawings.
5. All the piles shall be provided sonic logging tubes to carry out Cross hole Sonic Logging Test.
6. The number of tests (other Cross hole Sonic Logging Test) required shall be as approved by the engineer.
7. A method statement for all the load tests shall be submitted to NPCIL and testing shall be carried out after approval of the same.

8. The details of tests to be carried out on piles are presented below.

PILE TESTING MATRIX

Tests on Piles		
Initial Load Tests	Routine Load Tests	Non-Destructive Tests (Both Initial and Routine)
1. Vertical Load Test	1. Vertical Load Test	1. Low Strain Integrity Test
2. Lateral Load Test	2. Lateral Load Test	2. High Strain Dynamic Test
3. Uplift Load Test	3. Uplift Load Test	3. Cross Hole Sonic Logging Test

12.9.1.2 INITIAL LOAD TEST

Initial load test shall be carried out on separately cast test piles following purposes:

1. Confirmation of estimated pile capacities at founding level.
2. To provide guidelines for setting up the limits of acceptance for routine tests.
3. To confirm suitability of piling system.
4. To have a check on calculated load by dynamic or static approaches.

The number of tests to be conducted for each mode (vertical compression, pull out and lateral) and each type of pile and maximum test load shall be as per approved drawings.

The following initial load tests shall be carried out as per IS 2911(Part 4):

1. Initial vertical load test.
2. Initial lateral load test
3. Initial pull-out load test.
4. Initial vertical cyclic test

12.9.1.3 ROUTINE LOAD TEST

Routine load tests shall be carried out on job (working) piles as per approved drawings. Routine load tests shall be carried out for following purposes:

1. To confirm the safe load of the pile.
2. Checking safe load and extent of safety for the specific functional requirement of the pile at working load
3. Detection of any unusual performance contrary to the findings of the initial test, if carried out.

The following routine load tests shall be carried out as per IS 2911(Part 4):

1. Routine vertical load test.
2. Routine lateral load test

3. Routine pull-out load test.

For routine lateral load test the loading shall be continued till one and half times the safe lateral load or 5mm deflection, whichever occurs earlier.

12.9.2 RECORDING OF DATA AND PRESENTATION

12.9.2.1 The initial and routine pile load test data essentially concerns three variables, namely, load, displacement and time. These are to be recorded sequentially for the tests under consideration and recorded in a suitable tabular form along with the information about the pile.

12.9.2.2 The initial and routine pile load test data may be suitably presented by curves drawn between the variables and safe loads shown on the graphs. Load-displacement curve should be an essential part of presentation.

12.9.3 REPLACEMENT OF DEFECTIVE/ REJECTED PILES

During execution of pile foundation work, if the bore holes need to be abandoned due to any reason and pile position to be shifted or realigned, other than for any design requirement by the Engineer, fresh bore holes are to be executed at a suitable new position, as decided by the Engineer, which may demand for resizing of pile raft including possible increase in reinforcement quantity due to resizing of pile raft. In all such cases the abandoned bore holes are to be filled up with plain cement concrete of grade M15 so that no cavity remains in the bore hole of the abandoned pile. No extra claim whatsoever from the contractor on account of abandoned bore hole, filling up of abandoned bore hole with concrete and any extra cost due to resizing of pile raft including increase in reinforcement quantity will be accepted and same is deemed to be carried out by the contractor at his own cost.

Piles showing unsatisfactory results as per load tests shall be treated as defective piles. Piles/boring/casing that are defective shall be left in place/ pulled out as directed by Engineer without adversely affecting the performance of the adjacent piles. In case the hole from which pile is pulled out is abandoned, the same needs to be filled up with concrete of grade M 15 at no extra cost to NPCIL. No payment shall be made for extra expenditure incurred in constructing alternative piles and implementing the changes in the design of raft on account of change in location of piles.

12.10 NON DESTRUCTIVE TESTING OF PILES

12.10.1 LOW STRAIN PILE INTEGRITY TEST

12.10.1.1 GENERAL

Low strain Pile Integrity Test (PIT) is a non-destructive integrity test method to establish the Integrity of the pile along its length and to identify the deficiency in quality of pile, if any.

In PIT the impact shall be made using small hand held hammer. The evaluation of PIT records shall be conducted according to the Pulse-Echo (or Sonic Echo – a time domain analysis) analysis method.

12.10.1.2 **TEST METHOD AND REFERENCE CODE**

The test requires the impact of a small hand held hammer on the shaft top and the measurement of motion of the pile top in terms of acceleration or velocity. The input compression wave from the hammer is reflected from pile toe (or a defect) and returns to the pile top at a time related to the speed of travel of the wave in the pile material. The test shall be performed as per ASTM D 5882 "Standard Test Method for Low Strain Integrity Testing of Piles".

The pile top velocity is displayed as a function of time with an exponentially increasing magnitude where high soil friction forces are present, such that the pile toe reflection is enhanced. Several records with consistent signals should be averaged. The averaged, amplified velocity shall be standard result of the Pulse Echo Method.

12.10.1.3 **TEST EQUIPMENT**

The test should be performed using digital data acquisition equipment. The signal conditioning and power supply must have very high signal-to-noise ratios to discern the reflected signals for long piles (and/or piles in high friction soils). The analog to digital resolution shall be at least 16 bits, and the sampling frequency at least 25,000 Hz. Data should be stored such that additional processing or further wave analysis is possible. The data must be displayed in the field for evaluations of preliminary data quality and interpretation. The apparatus shall include a graphic display of velocity. The equipment & software used for test and its data processing shall be compliant with ASTM D5882. The equipment shall have a provision of display of data on the field for preliminary evaluation and interpretation and the field print out shall also be feasible. The test agency shall deploy adequate number of equipment & spares to meet contingencies and achieve the desired progress of work to meet construction schedule.

12.10.1.4 **TEST PREPARATION**

Integrity testing shall be performed after the concrete has cured for a minimum of seven (7) days. The pile head shall have sound concrete, free from water, dirt or other debris and reasonably flat surface. The concrete at the pile top surface must be relatively smooth with sufficient space for both attachment of the motion sensing device 300mm away from the center and hammer impact area at the center of the pile.

Piles for integrity testing shall be selected by NPCIL.

The projecting re-bars need to be bent outside for easy access within core region. Safe and reasonable access to the pile is the responsibility of the contractor.

The data supplied to expert test agency at the time of test shall include length of the pile from testing level, cutoff level of the pile, pile diameter and pile reference as well

as location. Soil information available for the location or in the vicinity shall be provided for valuable interpretation of test results. Additional data like pile installation records, load test results etc., shall also be supplied to the test agency.

12.10.1.5 **DATA PROCESSING**

The data collected using test equipment shall be processed using compatible software. To ensure that the signals are clearly visible for interpretation, data shall be processed in terms of Magnification (MA to enhance the energy lost), reduce reflections from soil to evaluate concrete (HI PASS Filter), and reduce reflections from reinforcement (Wavelet Filter). The MA shall be a factor of the length of the pile and normally must be equal to the pile length. The magnification delay shall be default 20% to avoid errors in interpretation.

12.10.1.6 **RESULT PRESENTATION**

The testing agency shall submit test report within 2 working days, after performing the field test, clearly indicating the result of test results and Pile Integrity evaluation and further recommendations. For each pile tested, the averaged, amplified velocity versus time record shall be included in the report, with a table summarizing results and conclusions. On completion of field testing, a report shall be submitted and shall clearly describe the following:

- Uniformity of pile changes in cross-section qualitatively i.e. bulge or defect due to necking, etc.
- Sudden changes in soil stratum based on soil profile and graphs.
- Concrete quality in terms of wave speed.

12.10.1.7 **ACCEPTANCE AND REJECTION**

The report shall clearly indicate that tested piles are acceptable or questionable or needs to be rejected. The comments shall generally be based on the following guidelines.

1. Piles with toe response and no defect apparent shall be classified as acceptable.
2. Piles with no toe response and significant reduction or defect above the pile toe shall be rejected and replacement or any other remedial action may be considered. The test engineer should specify the approximate location of defect in such a case.
3. Piles with a sudden major increase in resistance or impedance may not show toe response and are termed as inconclusive and a typical such pile can be selected for static / high strain dynamic test at the discretion of the Engineer.
4. Piles that show toe response but some impedance reduction / defect maybe under-rated / replaced / repaired / or subjected to additional high strain dynamic or static testing at the discretion of the Engineer.

Acceptance / rejection of piles in 3 and 4 above shall also be based on construction records.

Construction records (concrete usage, grout pressure records, soil borings etc.) may be valuable in result interpretations. Based on the Expert agency recommendation, the decision to either reject and replace, or repair, any defective pile shall be taken by the NPCIL and replacement / remedial measure of such piles at no extra cost to NPCIL shall be binding on Contractor.
If the pile top appears questionable, further pile top cut-off and retesting may be advisable.
If a majority of piles diagnose as "inconclusive", partial or even complete pile excavation or another test method may be necessary for pile acceptance.

12.10.1.8 **REMEDIAL ACTION**

Rejected or questionable piles may be replaced or retested (e.g., static load testing, dynamic load testing, core drilling, ultra-sonic logging, etc.) based on the test results and recommendation of expert agency and as approved by NPCIL.

Remedial action may include pressure grouting through core holes wherever feasible as approved and accepted by NPCIL at contractor's own cost. The repaired piles shall be re-tested and accepted subject to qualifying the test. The cost of such re-testing shall be borne by the contractor.

12.10.2 CROSSHOLE SONIC LOGGING (CSL) BORED CAST-IN-SITU PILES

12.10.2.1 GENERAL

CSL testing shall be performed by sending ultrasonic pulses through concrete from one probe to another (probes located in parallel tubes). The CSL procedure inspects the structural integrity of the pile concrete between the tubes, and extent and location of defects, if any.

This work shall consist of furnishing all materials, equipment and labor necessary for conducting CSL tests on drilled and cast-in-place piles (hereafter each noted as test piles). The contractor shall be responsible for conducting the test through approved expert agency, including supply of material and labour as hereinafter specified and including prior to, during, and after the load test.

CSL testing is a non-destructive quick test and it is intended that the test pile be left in a condition, suitable for use in further construction and may be used as part of structure.

12.10.2.2 TEST METHOD & REFERENCE CODE

The Pile shall be instrumented & Tested as per recommendations of ASTM 6760 "Standard Test Method for Integrity Testing of Concrete Deep Foundations by Ultrasonic Cross hole Testing" unless noted otherwise.

Both the time between pulse generation and signal reception ("First Arrival Time" or "FAT") and the strength of the received signal give a relative measure of the quality of

concrete between transmitter and receiver. Dividing the distance between transmitter and receiver by the FAT value yields the approximate concrete wave speed which also is a relative indicator of concrete quality. For equidistant tubes, uniform concrete between the test tubes yields consistent arrival times with reasonable pulse wave speed and good signal strengths. Non-uniformities such as contaminated or soft concrete, honeycombing, voids and inclusions exhibit delayed arrival times with reduced signal strength.

12.10.2.3 TEST EQUIPMENT

The Contractor shall supply all materials and equipment required to prepare the test pile and restore the pile to a condition suitable for use in the permanent structure, wherever specified by the Engineer. Equipment required to perform the test includes but is not limited to following:

Provide a Cross Hole Analyzer (CHA) manufactured by Pile Dynamics, Inc., or equivalent CSL equipment. The equipment shall have the following minimum requirements.

1. A computer based CSL data acquisition system for display of signals during data acquisition, with a minimum 12 bit A/D converter with a sampling frequency of at least 250000 Hz, and recording of all pulse signals for full analysis and individual inspection. (Note: Converting signals with low noise using high A/D resolution and sampling rates is important to obtain quality data and allow proper full data interpretation.)

2. Ultrasonic transmitter and receiver probes with probe centralizer and signal transmission cables as per ASTM6760 capable of generating pulse with a frequency between 30,000Hz to 100,000Hz with good signal amplitude and energy through good quality concrete. The probes shall be less than 30mm in diameter and shall freely descend through the full depth of properly installed sonic logging tubes of at typically less than 50 mm diameter, in the piles.

3. Two depth sensors to independently determine transmitter and receiver probe depths.

4. Triggering of the recording system time base with the transmitted ultrasonic pulse.

12.10.2.3.1 Sonic Logging Tubes:

All Piles required to be tested shall be provided with sonic tubes for sonic logging tests cast into it. The tubes shall be manufactured from mild steel tubes. To form a single tube the pipes to be connected with Bell Mouth – push fit arrangement only. PVC or any kind of plastic material is strictly prohibited due to different coefficient of thermal

expansion with respect to concrete which may affect the test result. The tubes should be of 50mm Internal Diameter and 1 mm thick.

Tests to be conducted for Sonic Tubes assembly and desired results.

The Sonic Tubes assembly should be tested for following tests:

a) External Pressure Test

The minimum 50 mm inside diameter tube, minimum 1 mm wall thickness should be applied with external pressure up to 5 Mpa . Following are the desired results:

Description	Pressure in Mpa	Hold Time	Desired Results
Sonic Tubes Diameter 50 mm X 1.0 mm Thick	>= 5 MPa	>= 60 Sec	No Leakages from Inner Surface of Tubes and No Distortion of Tubes

Minimum 3 test results should be obtained.

b) Pull Out Test for Tubes

Description	Tensile Force to be applied	Desired Results
Sonic Tubes Diameter 50 mm X 1.0 mm Thick	>= 0.5 KN	No Distortion / Elongation of Tubes till test load of 0.5 KN.

c) Pull out test for Joint

Description	Tensile Force to be applied	Desired Results
Sonic Tubes Diameter 50 mm X 1.0 mm Thick, Bell Mouth – Push Fit Joint.	>= 0.5 KN	Joint should withstand the Pull out load of 0.5 KN.

d) Pull Out Test for tubes 'Fixing Ears'

Description	Tensile Force to be applied	Desired Results
Sonic Tubes Diameter 50 mm X 1.0 mm Thick	>= 0.5 KN	Fixing Ears should withstand the Load up to 0.5 KN.

e) Crush Test

For 50 mm diameter and 1 mm tick Tube following is the criteria for Crush test.

Sr. No.	Descriptions	Test	Desired Results
1	Direction tube	1500 mm	No Cracks After test 30 mm Steel ball can go through the tubes.
2	Drop Weight	4000 + 150/-0g	
3	Diameter of Drop	m	

12.10.2.4 CSL ACCESS TUBE PREPARATION

Every drilled shaft shall be equipped with sonic logging tubes to permit possible inspection by CSL. Drilled shafts with different diameters at the same site may require a different number of sonic logging tubes. Sufficient number of sonic logging tubes shall be installed in all the Piles (minimum 2 nos.) prior to concreting as given in the drawing based on the Pile Diameter. The Number of tubes shall be generally one tube for every 0.3m of drilled shaft diameter unless specified otherwise, but not less than 2 nos. in any case.

The number of piles to be tested by CSL shall be as specified in drawings. If not specified in the drawing, minimum 20% of the piles shall be subjected to this test or as decided by Engineer.

The parallel steel tubes shall be supported and braced securely so that they maintain their position during the subsequent operations. The splice connection of parallel pipes shall be of good quality, easy installation and proven water-tight performance having Bell-Mouth Socket system with rubber gasket joint unless mentioned and approved otherwise.

The couplings locations shall be properly recorded. Tubes shall be installed by the Contractor in a manner such that the CSL probes pass through the entire length of the tube without bending. Ensure that the sonic logging tubes are in plumb and verify that unobstructed passage of the probes is achievable.

The Sonic logging tubes shall be fitted with a watertight shoe on the bottom and a removable cap on the top. Tubes shall be secured to the interior of the reinforcement cage at regular intervals not to exceed (1.0m). Tubes shall be installed uniformly and equidistantly around the circumference such that each tube is spaced parallel for the full length and at the maximum distance possible from each adjacent tube. Tubes shall be spaced as far as possible from the main axial reinforcing steel. The bottom end of the Tubes shall be kept approx. 100 mm above the bottom of the drilled shaft , and the top end shall be at least (1.0m) above the top of the concrete of the Pile, and to at least (0.6 m), but not more than (1.5m) above the ground surface. Tubes shall not be damaged during installation of the reinforcement cage.

The tubes should preferably be filled with water prior to concrete placement, in any case it must be filled with water within at most 1 hour after placing concrete to prevent de-bonding of the sonic logging tubes from concrete, due to differential temperatures. The top of the tubes shall be capped to prevent debris from entering the sonic logging tubes. Excessive torque, hammering or other stresses which could break the bond between the tube and concrete when removing caps from the tubes shall be avoided.

12.10.2.5 TIMING OF THE CSL TEST

The pile shall be tested no sooner than seven (7) calendar days after placement of all concrete (having minimum compressive strength as 2/3rd fck) and preferably within 90 days after casting of pile. The concrete strength and quality generally increases as the concrete cures, longer wait times are usually desirable. After all CSL testing has been completed, and after acceptance of the pile by NPCIL Engineer, the Contractor shall remove the water in the tubes, place grout tubes extending to the bottom of the access tube, and fill all sonic logging tubes in the pile with cement sand grout.

12.10.2.6 PROCEDURE

Prior to CSL testing, the Contractor shall provide the expert test agency with a record of all pile lengths with elevations of the top and bottom, and installation dates of all piles. The sonic logging tubes shall be clearly labeled for identification. The CSL testing shall be performed with the transmitter and receiver probes in the same horizontal plane in parallel tubes.

Using the labeling established for the tubes, CSL testing shall be performed between all adjacent perimeter access tube pairs and across at least all major diagonals within the pile.

Probes shall be lowered from the top, effectively measuring the access tube lengths. Probes shall be pulled simultaneously, with CSL measurements taken at intervals of 50 mm or less from the bottom to the top of the pile. Defects indicated by late pulse arrival times and significantly lower amplitude/energy signals shall be immediately reported to NPCIL Engineer. The equipment used for test shall be properly maintained and calibrated.

The tests shall be repeated for each pair of tubes, i.e. three runs for a pile with three tubes and six runs for a pile with four tubes.

12.10.2.7 REPORTING OF RESULTS

A report shall be prepared for each pile tested. The photographic record of the oscilloscope displays shall be analyzed in detail. Any deviation from the record to be expected from a pile constructed entirely of sound concrete and without defect shall be reported. The report shall indicate the nature, location and severity of the defect and recommendations shall be made for further testing. The implication of the existence of the defect on the performance of the pile shall be evaluated.

Results of the CSL shall be presented in a written report within five (5) working days of completion of testing. The report shall include presentation of CSL logs for all tested tube pairs including:

1. Presentation of the traditional nested signal peak (e.g. "waterfall") diagram as a function of time plotted versus depth.
2. Computed pulse first arrival time (FAT) or pulse wave speed versus depth.
3. Computed relative pulse energy or amplitude versus depth.

A CSL log shall be presented for each tube pair. The rating of the shaft integrity considers the increases in "first arrival time" (FAT) and the energy reduction relative to the arrival time or energy in a nearby zone of good concrete. Pile is classified as satisfactory/ good provided the evaluation criteria for FAT increase and energy reduction are met. Pile is classified as having minor defect or poor concrete if either evaluation criteria of FAT increase or energy reduction are met. The criteria for evaluation of the concrete from the CSL test are given below.

Pile Classification	FAT Increase relative to good concrete	Energy reduction relative to good concrete
Satisfactory / Good	0-10%	<6 db
Minor Defect	11-20%	<9 db
Poor/Flaw	21 to 30%	<9 to 12
Poor/Defect	>31%	>12

Flaws must be addressed if they affect more than 50% of the profiles. Defects must be addressed if they affect more than one profile (a profile is the result of complete investigation from bottom to top between two tubes) at the same cross section. Flaws or Defects covering the entire cross section define a full layer concern requiring repair.

Immediately after testing, a signed copy of all the raw test data of a pile shall be handed over to the Engineer.

The piles with anomalous sonic logging results shall be rejected at the Engineer's discretion unless the contractor is able to demonstrate that the pile integrity is acceptable through proof coring.

12.10.3 HIGH-STRAIN DYNAMIC TESTING OF BORED CAST-IN-SITU PILES

12.10.3.1 GENERAL

High-strain dynamic testing shall be performed by obtaining and analyzing the records of pile force and velocity under drop weight impacts for evaluations of pile load carrying capacity, structural integrity, and load-movement and pile-soil load transfer relationships.

This work shall consist of furnishing all materials, equipment and labor necessary for conducting high-strain dynamic tests on bored cast-in-place piles (hereafter each noted as test piles). The contractor shall be responsible for conducting the test, including supply of material and labor as specified and including prior to, during, and after the load test.

High-strain dynamic testing is a non-destructive quick test and it is intended that the test pile be left in a condition, suitable for use in further construction and may be used as part of structure.

12.10.3.2 **TEST METHOD & REFERENCE CODE**

The Pile shall be instrumented & Tested as per recommendations of ASTM D 4945 'Standard Method of test for High Strain Dynamic Testing of Piles' unless noted otherwise.

12.10.3.3 **EQUIPMENT**

The test shall be conducted by the contractor through an approved expert agency. The Contractor shall supply all materials and equipment required to prepare the test Pile, dynamically load the Pile, and restores the pile to a condition suitable for use in the permanent structure, wherever specified by the Engineer. The test shall be conducted using Pile Driving Analyzer (PDA) to obtain and analyze the records of force and velocity under drop weight impacts. The field results shall be further analyzed with a signal matching technique such as CAPWAP (Case Pile Wave Analysis Program) or equivalent to refine the soil parameter assumptions.

In case of uncased pile – The Pile top shall be extended using a thin walled casing or equivalent, by a length equal to two pile diameters unless specified otherwise. This top length, shall be defined as the "test area" must be exposed and ready for test. Wherever the Pile top is below grade, the Contractor must remove surrounding soil (creating a safe working environment) so as to completely expose a test area of the Pile suitable for conducting the test to the satisfaction of expert agency engaged for the test. Windows on four opposite sides of the Pile have to be cut off in the steel casing to reach the concrete. The size of the windows shall be as suiting to the requirements of test agency and as approved by the NPCIL Engineer.

The pile top concrete shall be leveled above the casing. A drop weight shall be in the range of one to two percent (1 - 2%) of the anticipated pile capacity, or as determined by the expert agency and approved by the Engineer. A guide allowing variable drop heights typically between 3 and 13 ft (1 to 4 m), or as determined by the expert agency and approved by the Engineer shall be used for test.

Pile top cushion shall consist of new sheets of plywood with total thickness between 2 to 6 inches (50 to 150 mm), or as determined by the expert agency and approved by the Engineer.

A steel striker plate with a thickness of at least 2 inches (50 mm) and an area between 70 to 90% of Pile top area but not less than the area of the impacting surface of the drop weight to be placed on top of the plywood cushion.

Surveyors' transit, laser light, or equivalent for measurements of pile set under each impact.

12.10.3.4 **PROCEDURE**

a) The test Pile shall be constructed using the approved installation techniques.

b) If a permanent casing is not required, then the upper length equal to two Pile diameters, noted as the "test area", must be cased in a thin wall tube. Casing of this test area must be made as a continuation of the construction of the Pile.

c) Wherever, reinforcing bars are protruding out, the same shall either be encased within the concrete in the test area and on successful completion of the dynamic test, the surrounding concrete can then be removed to expose the bars using the same suitable for further construction, or a steel beam or pipe (cross sectional area approximately 20% of the Pile cross sectional area) shall be supplied with sufficient length such that the ram impact will not interfere with the reinforcing bars. Steel striker plates and plywood cushion must also be sized so that they cover as much of the impact area as possible. However, either of the above option shall be finalized in consultation with expert test agency with the prior approval of NPCIL Engineer.

d) There should not be any soil contamination or non-uniformities in the concrete located within or below the test area. Pile top shall be made level to the casing and smoothed.

e) Prior to testing time, the Contractor shall make the Pile test area length completely accessible to the suit the test.

f) Prior to the test four "windows" (approximate size of 6 by 6 inches (150 by 150 mm) diametrically opposite of each other shall be located and removed from the casing.

g) In cases where casing is not present, the circumferential area where transducer is to be fixed, shall be smoothened by grinding.

h) Gauges shall be attached to the exposed concrete or steel casing in a secure manner as to prevent slippage under impact.

i) Pile top should be examined to ensure that the concrete top is flush with or above the casing in any case it should not be below the casing level.

j) Apply plywood cushion and then striker plate to the Pile top.

k) At least two (2) hammer impacts should be applied to the pile top. First drop height should be minimal to assess the testing equipment, the driving system and pile stresses. Subsequent impacts can then be applied by utilizing higher drop heights.

l) Upon completion of the test, it is the Contractors' responsibility to return the pile to acceptable condition in a manner that the same can be used as part of structure.

12.10.3.5 **REPORTING OF RESULTS**

The Expert Agency shall submit a report of the field test results with its finding. In addition to the field results, results from at least one (1) set of wave equation analysis using CAPWAP or equivalent shall be submitted. The analysis shall be performed by same expert agency involved in the testing. The report must also provide the following:

1. Wave Equation analysis results obtained prior to testing.
2. Wave equation analysis results with a match quality preferably up to 5. If match quality is less than 5, reasons must be outlined for the same before acceptance by NPCIL.
3. For each impact, the maximum measured force, maximum calculated tension force, energy transferred to the gauge location, corresponding stresses, and the bearing capacity shall be tabulated.
4. Assessment of the test results both with respect to pile capacity and integrity.

The output from the test result shall provide:

a) Static capacity of the pile at the time of testing.
b) Simulated static load test curve
c) Total skin friction and end bearing of the pile
d) Skin friction distribution along the length of the pile
e) Compressive and tensile stresses developed in the pile during testing
f) Net and total displacement of the pile.
g) Pile integrity

12.10.4 EXPERT AGENCY TO PERFORM THE NDT ON PILES

The testing method and interpretation requires expertise and through understanding of wave mechanics. The agency employed for testing shall prove its competency by submitting previous reliability studies between static and high strain dynamic tests.

Contractor shall engage an Expert Agency of national repute and shall be approved by the NPCIL, to conduct the test. The Expert Agency shall be specialist having minimum of 5 years of experience in low & high strain integrity testing as well as sonic logging testing of the piles. The expert agency shall have sound knowledge of Wave Theory used for analyzing and interpretation of test results and at least performed minimum 5 nos. of correlation studies of Dynamic Pile Load Testing with conventional load test in various strata covering friction piles. The results of the correlation studies should have been accepted by the owners of the project, for whom tests were performed. Demonstration of case studies/correlation between CSL and HSDPT or PIT will be preferred. Performance certificates for completed projects shall be submitted.
The Expert Agency is required to perform wave equation analyses (using CAPWAP or equivalent) to determine the suitability of the proposed dynamic loading equipment and an acceptable range of ram drop heights so as not to cause damage in the pile during

the test. Performance certificates for completed projects shall be submitted. CV of the personnel carrying the test shall be submitted before performing the test.

The expert agency must possess, the following testing instrumentation in addition to that outlined in ASTM D 4945 Section 5: and other ASTM, in order to meet the project schedule and to maintain the redundancy. The test agency shall deploy adequate number of equipment & spares to meet contingencies and achieve the desired progress of work to meet construction schedule.

1. Pile Driving Analyzer (PDA)
2. Pile Integrity Testing Equipment.
3. Cross Hole Testing Equipment for Sonic Logging.
4. Required nos. of calibrated strain transducers.
5. Required nos. of calibrated accelerometers.

All other test equipment required for to conduct the above tests. The equipment and sensors shall be properly calibrated and the testing agency shall be able to obtain the calibration certificates upon request or prove the internal calibration of the system on site.

The Expert Agency shall study the Bore Log Data applicable to the test location, prior to perform the dynamic test, Pile installation records, concrete properties (strength, etc.) and submit the details regarding the anticipated dynamic loading equipment.

13 GROUT/ DRY PACK

13.0 General

Grout / Dry Pack shall be provided as specified on the drawings. The proportion of Grout shall be such as to produce a flowable mixture consistent with minimum water content and shrinkage.

Concrete surfaces to be grouted / dry packed shall be thoroughly roughened and cleaned of all foreign matter and laitance. Anchor bolts, anchor bolt holes and the bottom of equipment and column base plates shall be cleaned of all oil, grease, dirt and loose material. The use of hot strong caustic solution for this purpose may be permitted.

Prior to grouting/dry packing, the hardened concrete surfaces shall be saturated with water.

Forms around base plates shall be reasonably tight to prevent leakage of grout/dry pack. Adequate clearance shall be provided between formwork and base plate, to permit grout/ dry pack to be worked properly into place.

Grouting, once started, shall be done expeditiously and continuously to prevent segregation, bleeding and within the initial setting time. Grout shall be worked from one side to the other, to prevent entrapment of air.

Water in anchor bolt holes shall be removed before grouting is started.

Forms and shims shall not be removed and the anchor bolts shall not be tightened for at least 24 hours after placing the grout. After the removal of forms and peripheral shims, area occupied by shims shall be filled and the area between the base and the edge of the foundation shall be finished smooth to allow drainage away from the base. Interconnecting piping and machinery shall not be attached to the machinery before anchor bolts are tightened. It is desirable to make these connections at least after a minimum of seven days from the date of grouting. During this period, the grout shall be properly cured.

13.1 Dry Pack

The dry pack shall consist of 1:2.5 (Cement: Sand), sand passing through 1.18 mm square hole opening standard sieve. Only enough water shall be added to produce a mortar, which will stick together when moulded into a ball by a slight pressure of hand and will not extrude water but will leave the hands just damp. Dry pack material shall be placed and packed in layers having a compacted thickness of about 10mm. Each layer shall be solidly compacted over the entire surface by use of hardwood stick and hammer. Sand for this job shall be as pure as specified for concrete making.

13.2 Grout

13.2.1 Normal Grout

The contractor shall supply and place normal grout consisting of an approved mixture of cement, normal fine aggregate, water, admixture and when specified by the Engineer, a non-shrink agent. Normal grout shall be placed as shown on the drawings or specified by the Engineer.

Grouting through holes in base plates shall be, by pressure grouting. The pressure to be used for grouting shall be as directed by the engineer. The grout proportions shall be as follows:

Mix proportion	**W/C Ratio(max)**
Mix 1:1 Cement: Sand grout with anti shrink compound	0.44
Mix 1:2 Cement: Sand grout with anti shrink compound	0.44
Mix 1:1:2 cement: sand with 6mm down stone chips and anti shrink compound	0.44

Note: If the requirement arises, mixes other than the specified above, such as mix 1:1.5, 1:1.75, 1:2.25 etc. shall be used with the approval of the Engineer.

The W/C ratio shall be as per the manufacturer's recommendation and in no case shall exceed the values specified above.

13.3 Inspection

All materials, workmanship and finished construction shall be subject to the continuous inspection and approval of Engineer

All materials supplied by Contractor and all works or construction performed by Contractor and rejected - as not in conformity with the specifications and drawings - shall be immediately replaced at no additional expense to NPCIL.

Preliminary approvals of any materials or phase of work shall in no way relieve the Contractor from the responsibility of supplying grouting materials and or producing finished grout in accordance with the specifications and drawings.

All grouting shall be protected against damage until final acceptance by NPCIL or his representative.

Upon the completion of grouting work, all forms, equipment, construction tools, protective coverings and any debris shall be removed from the area as directed by the Engineer.

13.4 GROUT / DRY PACK FOR EQUIPMENT BASES

13.4.1 SCOPE

Scope of work covered in this specification includes supply and place normal free flow grout / dry pack at all places below equipment base plate, structural steel base plates / bearing plates, anchor bolts, pockets and other areas. Normal cement sand grout in various proportions with anti-shrink compound, non-shrink cementitious precision grout and dry pack with cement sand in proportion of 1: 2.5 are included in this specification.

13.4.2 GENERAL

13.4.2.1 Grout/ Dry Pack shall be provided as specified in the drawings. The proportion of grout shall be such as to produce a flowable mixture consistent with minimum water content and shrinkage.

13.4.2.2 Concrete surfaces to be grouted/ dry packed shall be thoroughly roughened and cleaned of all foreign matter and laitance. Anchor bolts, anchor bolt holes and the bottom of equipment and column base plates shall be cleaned of all oil, grease, dirt and loose material.

13.4.2.3 Prior to grouting/ dry packing the hardened concrete surfaces shall be saturated with water.

13.4.2.4 Forms around base plates shall be reasonably tight to prevent leakage of grout/ dry pack. Adequate clearance shall be provided between formwork and base plate, to permit grout/ dry pack to be worked properly into the place.

13.4.2.5 Grouting, once started, shall be done expeditiously and continuously to prevent segregation, bleeding and within the initial setting time. Grout shall be worked from one side to the other, to prevent entrapment of air.

13.4.2.6 Water in anchor bolt holes shall be removed before grouting is started.

13.4.2.7 Forms and shims shall not be removed and the anchor bolts shall not be tightened for at least 24 hours after placing the grout. After the removal of forms and peripheral shims, area occupied by shims shall be filled and the area between the base and the edge of the foundation shall be finished smooth to allow drainage away from the base. Interconnecting piping and machinery shall not be attached to the machinery before anchor bolts are tightened. It is desirable to make these connections at least after a minimum of seven days from the date of grouting. During this period, the grout shall be properly cured.

13.4.3 DRY PACK

The dry pack shall consist of cement and sand in proportion of 1: 2.5. Sand passing through 1.18 mm square hole opening standard sieve shall be used in the dry pack. Only enough water shall be added to produce a mortar, which will stick together when molded into a ball by a slight pressure of hand and will not extrude water but will leave the hands just damp. Dry pack material shall be placed and packed in layers having compacted thickness of about 10 mm. Each layer shall be solidly compacted over the entire surface by use of hardwood stick and hammer. Sand for this job shall be as pure as specified for concrete work.

In case of heavy cement sand dry pack, heavy sand shall be used in place of normal sand.

13.4.4 NORMAL GROUT

13.4.4.1 The Contractor shall supply and place normal grout consisting of an approved mixture of cement, normal fine aggregate, water, admixture and when specified by the Engineer, a non-shrink agent. Normal grout shall be placed as shown in the drawings or as specified by the Engineer.

13.4.4.2 Grouting through holes in base plates shall be by pressure grouting. The pressure to be used for grouting shall be as directed by the Engineer. The grout proportions shall be as follows:

Mix Proportion		**W/C Ratio (Max)**
Mix 1:1	Cement: Sand with anti-shrink compound	0.44
Mix 1:2	Cement: Sand with anti-shrink compound	0.44
Mix 1:1:2	Cement: Sand with 6mm down stone chips and Anti-shrink compound	0.44

NOTE:

1. If the requirement arises, mixes other than the specified above, such as mix 1:1.5, 1:1.75, 1:2.25, etc. shall be used with approval of the Engineer.
2. The W/C ratio shall be as per the direction of Engineer and in no case shall exceed the values specified above.

13.4.5 NON-SHRINK CEMENTITIOUS PRECISION GROUT

Powdered non-shrink, high strength, free flow cementitious grout complying with the requirements of ASTM C348 & C109 that expands in two stages to counteract the plastic as well as the drying shrinkage normally associated with cement grouts. Mix proportion shall be as per manufacturer's recommendations. The compressive strength of the grout at optimum W/C ratio recommended by Manufacturer shall not be lesser than 55MPa, 65MPa & 75 MPa at 3days, 7days and 28 days respectively. It shall also possess following properties:

Property	**Acceptable Limit**	**Test Method**
Workability	Flowablility:	ASTM C 230
	Instantaneous, 240mm	
	After 20 mm, 220mm	
Setting Time	Initial Set, 4Hrs	IS 4031(Pt-5)
	Final Set, 5hrs	
Compressive Strength, 28 days	75 MPa	ASTM C 109
Tensile Strength, 28 days	8.1 MPa	ASTM C 1107
Flexural Strength, 28 days	9 MPa	ASTM C 378
Coefficient of Thermal Expansion	$11X\ 10^{-6}$ / ^{0}C	
Expansion in Plastic Stage	1.25%	ASTM C 940
Shrinkage	Nil	
Pullout Bond Strength	>17MPa	ASTM D4541

13.4.6 INSPECTION

13.4.6.1 All materials, workmanship and finished construction shall be subject to continuous inspection and approval of the Engineer**.** Grout material shall be tested for cube compressive strength both for pre-qualifications and batch qualifications at no extra cost to NPCIL. No material exceeding the shelf life will be used and all such material shall be immediately removed from site.

13.4.6.2 All Materials supplied by the Contractor and all works or construction performed by the Contractor and rejected – as not in conformity with the specifications and drawings shall be replaced at no extra cost to NPCIL**.**

13.4.6.3 Preliminary approvals of any materials or phase of work shall in no way relieve the Contractor from the responsibility of supplying grouting materials and or producing finished grout in accordance with the specifications and drawings**.**

13.4.6.4 All grouting shall be protected against damage until final acceptance by the NPCIL representative.

13.4.6.5 Upon completion of grouting work, all forms, equipment, construction tools, protective coverings and any debris shall be removed from the area as directed by the Engineer.

14 INJECTION GROUTING

14.0 SCOPE

14.0.1 The Scope of work covered under this specification is injection grouting at the following locations:

a) Where required impermeability of concrete is not achieved.

b) Where defective concrete is suspected and observed.

c) Where water seepage is observed.

d) Construction joints for all underground basements

e) Any other location specified in the drawing or as directed by the Engineer

14.0.2 The Grouting shall be carried out at specified locations as shown in the drawing or as directed by the Engineer

14.1 GENERAL

The injection grouting shall be carried out either through threaded GI nozzles of suitable length fixed in the area to be grouted or through non-return packer type nozzles either installed in the existing GI nozzles or in drilled holes. The nozzle length and spacing shall be as specified in the drawing or as directed by the Engineer. The diameter of the nozzle shall be as per site conditions and generally 16/12 mm diameter may be adopted for cement grouts (without non return valve) and 12 mm diameter (with non-return valve) for epoxy and polyurethane based hydrophilic grouting. The entire scheme shall be duly approved by the Engineer before commencing the work.

14.2 MATERIALS

The grouting material shall be epoxy, cement based with non-shrink additive or polyurethane based hydrophilic material as specified in the drawings, specifications or as directed by the Engineer as per site conditions.

14.3 EPOXY GROUT

14.3.1 The epoxy grout shall comprise of an injectable solvent free, aggregate free, ultralow viscosity, free flowing, two-component epoxy injection resins, which shall be pumped through the nozzles (fixed prior to concreting or drilled after concreting) under pressure and rapidly cure to a high strength material. It shall comply with ASTM C-881-1987 Type I–Grade I Class (B+C) & class F as applicable. It shall be suitable for application in both dry and damp conditions,

14.3.2 The Generic name 'epoxy resin' covers a very diverse range of chemically and physically different polymers. To achieve durable repairs, careful selection of the resin composition appropriate to the application and service condition is essential.

14.3.3 The Proposed resin injection system is required to have following characteristics. The material shall comply with the requirement of ASTM C 881 Type I Grade I Class (B+C) & class F as applicable.

f) It should be two component (resin/hardener), low viscosity, solvent free, aggregate free, injection liquid based on high strength epoxy resin and suitable for deep impregnation. The epoxy and hardener system shall be able to cure in moist/wet conditions also.

g) It should rapidly cure to a high strength, shrinkage free hardening and without embrittlement.

h) It shall possess anti corrosion property, good adhesiveness and bond with the concrete with adhesive strength both under dry and damp conditions and should be capable for use under extreme ambient conditions and remain fluid during applications.

14.3.4 The proposed resin to be used shall be of two parts preferably supplied in different containers according to the manufacturers recommended proportions indicating identifications such as base hardener, recommended proportion, batch number, shelf life, date of manufacturing, grade, type, class, quantity, etc. Each batch shall invariably carry test certificates as per table 14.1 for tests conducted in NPCIL approved laboratory. The Engineer may at his discretion, appoint his representative to witness these tests at the laboratory. No separate payment will be made for testing. The chemical composition of epoxy resin constituent of component 'A' shall have an epoxy equivalent of 160-275 g/g mole and physical requirements shall be in line with ASTM C-881. A sample of proposed material intended to be used shall be supplied by the Contractor to the Engineer to verify the required parameters. The material shall be generally used within six months from the date of manufacture or date of expiry whichever is earlier.

TABLE - 14.1

LIST OF TESTS TO BE CONDUCTED AS PER ASTM C-881

SI. No	Property	Tested as per ASTM No.	Requirement
1.	Viscosity	D – 2393	2* poise (Max)
2.	Bond Strength		
	2 days (moist cured)	C – 882	10 N/mm^2 (Min)
	14 days (moist cured)	C – 882	14N/mm^2 (Min)
3.	Water Absorption (24 hours)	D – 570	1.0% (Max)
4.	Compressive strength 7 days	D – 695	70N/mm^2 (Min)
5.	Tensile strength 7 days	D – 638	50 N/mm^2 (Min)
6.	Flexural Strength	D – 638	55N/mm^2 (Min)
7.	Full Chemical Cure	7 days at 20 ^{0}C	
8.	Slant Shear Bond Strength 7 days	C-881	18N/mm^2 (Min)
9.	VOC Content	ISO11890-2	<1.5%
10.	Elongation at break	D638	2% (Min)

* Please note that requirement of viscosity is in variance with ASTM C-881.

14.4 CEMENT BASED GROUT

14.4.1 CEMENT AND WATER

The cement shall be Ordinary Portland Cement 43 Grade conforming to IS 8112. It shall be mixed with water to achieve required consistency for pumping. The quality standards of water to be used shall be same as that of RCC works.

14.4.2 ADMIXTURES

To achieve high consistency with low water cement ratio of around 0.3, suitable water reducing admixture as approved by the Engineer may be used. Suitable anti shrinkage compound shall be added in the mix if specified or as directed by the Engineer.

Proportion of cement & water shall be as directed by the Engineer. Quantity of admixture and type of mixing shall be as per manufacturer's instructions. Compatibility of admixture with the type of cement used shall be ascertained before use of any admixture with cement.

Typically the properties of the resulting mix shall exhibit the following properties:

PROPERTY	ACCEPTANCE VALUE	TEST METHOD
Flow Cone test using Marsh Cone	23 secs at mix time	ASTM C 939
	34 secs after ½ hr	
	39 secs after 1 hr	
Specific Gravity	2.06	ASTM C 939
Setting time using Vicat's Apparatus	4 hrs for Initial Set	ASTM C 939
	5Hrs for Final Set	
Expansion	500 µm/m	ASTM C 878
Bleed Water	0.16%	ASTM C 232
Water Retention	96%	ASTM C 91

14.5 POLYURETHENE BASED HYDROPHILLIC GROUT

The material shall be one component high grade, low viscosity polyurethane injection foam resin which expands its volume to cure to very dense foam upon contact with water. This material shall be used to arrest excessive seepage of water through the concrete. Approval of the Engineer shall be obtained for the material, before use. The typical properties of the low viscosity polyurethane grouts are as follows:

PROPERTY	**ACCEPTANCE VALUES**
Density (at 20 ^{0}C)	1.16
Viscosity (at 23 ^{0}C)	320 mPa.s
Flash Point	180 ^{0}C
Application Temperature	+5 ^{0}C to 40 ^{0}C
Max foam expansion rate@10% accelerator dosage	25-30

14.6 GROUTING OPERATIONS

Grouting operations shall normally begin after six weeks of the last concrete poured. A high-speed mechanical mixer shall be used to mix the epoxy grout as per manufacturer's recommendation. The grouting shall be done by using hand pump and pressure will be decided based upon the nature of work and grade of concrete, or as directed by the Engineer. The grouting range can be achieved by injecting the grout with initial low pressure proceeding further with increasing pressure gradually. Slow and steady increase in pressure shall be followed to produce uniform impregnation of the zone under treatment. The injection pump shall be connected to the lowest tube and the injection allowed to proceed at gradually increasing pressures until grout appears at the adjacent/higher point or refusal of further grout entry at the operating pressure. Cement grouting shall be done normally starting with lean mix and slowly increasing the richness of mix. Cubes shall be cast to test the strength of the cement grout as directed by the Engineer. After successful completion of grouting the nozzles shall be cut and ground properly and finished with dry packing. Wherever specified in the drawing, Contractor has to make suitable arrangements for placement of nozzles prior

to concreting for its rigidity, thoroughness etc. complete with or without piercing through formwork. Contractor has to arrange adequate equipment/ manpower required for the work to carryout grouting in different areas simultaneously. Contractor at his cost may appoint a specialized agency to carry out grouting works. Detailed procedure of grouting shall be prepared by the Contractor and submitted to the Engineer for approval before commencement of work.

14.7 GROUTING AROUND PENETRATION EPs HAVING DIAMETER ABOVE 300 MM

Grouting is required to be done around penetration EPs having diameter above 300 mm and some special EPs. Procedure for grouting shall be generally same as above with the grouting pressure not exceeding the specified value in the drawing. The nozzles for grouting may be placed prior to concreting and the length and diameter of the nozzles shall be as given in the drawing.

15 CAULKING AND SEALANTS AROUND PENETRATIONS

15.0 SCOPE OF WORK

Scope of work covered under this specification is caulking of expansion joints, around embedded parts, penetrations and construction joints at various locations in all buildings as shown in the drawings and as directed by the Engineer.

- Caulking and sealing around penetrations.

15.1 MATERIAL

15.1.1 Polysuphide sealing compound shall conform to BS: 4254 and PP-M-400.

15.1.2 Epoxy quartz sand caulking compound shall be as per manufacturer's specifications.

15.1.3 Bituminous sealing compound (bitumen-polymer cold mastic) conforming to IS:1834-1984 Grade-B (working temperature 155°C to 165°C and density of 1200 kg/cu.m).

15.2 DESCRIPTION

Before proceeding with caulking, the grooves shall be cleaned for dirt, dust and grease if any. The grooves shall be finished to line and level.

15.3 CAULKING WITH POLYSULPHIDE SEALING COMPOUND

15.3.1 GENERAL

The work to be done under this specification covers the supply and applying of caulking polysulphide base sealing compounds and primer, all in accordance with the requirements of this specification together with PP-M-400. Installation of the material will be done by the Contractor as per drawing, specification and direction of Engineer.

15.3.2 REFERENCES

ASA	:	116-1
ASTM	:	D676-59T
ASTM	:	1191-52
TTS	:	227 b
ASTM	:	E42-69
BS	:	4254
PP-M-400	:	NPCIL Specifications.

Wherever, this specification is at variance with the requirements mentioned in the above references, this specification shall govern.

15.4 DESCRIPTION

Materials covered under this specification are two-package system consisting of polysulphide base compound and an accelerator compound. The compounds shall be stable separately and when properly mixed, convert to a rubber like solid, which meets the requirements specified herein. The selection of base polymers, fillers and other components shall be optional with supplier, but shall be suitable for the application intended. Properties of base polymer should be similar to Thiokol and have low molecular weight. The consistency of the compound should be plastic.

15.5 INTENDED USE

The sealing compound is proposed to be used for caulking construction joints in RCC walls, slabs and expansion joints. The caulking may also be required around some embedded parts and concrete hatch covers. Size of 'V' groove to be caulked in construction may vary in size from 12 mm X 12 mm to 25 mm X 40 mm while the rectangular gap to be caulked in expansion joints may vary from 25 mm X 10 mm to 75 mm X 10 mm thick. The sizes given above are approximate only and intended to give general idea of work involved.

15.6 CLASSES OF MATERIAL

The sealing compound shall be applied in two classes as follows:

a) Class-A (Self-Leveling): shall be compound which when properly accelerated has sufficient flow to give a smooth level surface when applied in horizontal joints at ambient temperatures between 40°F & 120°F. The compound should also permit its application in joints sloped up to 1:10.

b) Class-B (Non-Sag): shall be compound which when properly mixed permits application in vertical joints, without sagging at ambient temperatures between 40°F & 120°F.

15.7 COLOUR

The sealing compound may be supplied in any colour as agreed upon by the supplier and NPCIL.

15.8 MATERIAL REQUIREMENTS

Application life: A properly mixed compound shall be suitable for satisfactory application for at least 4 hours when maintained at a temperature of 77° ±2°F and relative humidity of 50% ±5%. It shall also be suitable for at least 1 hour when at a temperature of 110°F.

Stability: The base compound and accelerator in original unopened containers shall be stable for at least one year from the time of delivery when stored at a temperature not exceeding 110°F. When tested at the end of one year after the time of delivery, the compound shall meet the requirements specified herein.

Temp. Range performance: Continuous exposure 40 to 175°F
Continuous exposure 40 to 250°F

Recovery: The test assemblies shall be prepared and tested in accordance with ASA 116.1. The recovery of the compound in the test joint shall not be less than 25% within 1 hour at a temperature of 77°±2°F.

Resistance to crazing: The surface of compound of test panel prepared and tested in accordance with ASA 116.1 shall not craze more than 3 mils in depth.

Staining of concrete and masonry: The staining test shall be conducted on a test mortar in accordance with ASA 116.1 and there shall be no staining on the test mortar within 14 days. Staining on the test mortar indicates that the sealant is capable of staining.

Specific gravity: 1.6 to 1.7.

Toxicity: Safe lead content should not exceed 5%.

Properties required for Class A Compounds:

Hardness, Tensile Strength and Elongation

	Shore A Hardness	**Minimum Tensile Strength psi**	**Minimum Elongation %**
Original	35 ± 2	200	350
72 hrs. at 250°F	55 ± 3	325	150

Hardness shall be tested in accordance with ASTM D 676-59T, Tensile strength according to ASA 116.1 and Elongation according to ASTM 1191-.52.

Properties required for Class B compounds:

Sag: When tested in accordance with federal specification no. TTS-227b on a bead of ½" x ¾" there shall be no sag.

Hardness, Tensile Strength and Elongation:

	Shore A Hardness	**Min. Tensile Strength psi**	**Minimum Elongation %**
Original	22 ± 3	40	420
72 hrs. at 220°F	18	48	450
24 hrs. at 30°F	-	> 100	450

The testing method for these properties shall be same as specified for Class 'A' compounds.

Cohesive Strength: Surface-to-Surface Bond

	Aluminium	**Glass**	**Steel**	**Concrete**
Tensile (psi)	45	30	23	45
Elongation (%)	375	350	270	360

Cohesive strength shall be tested in accordance with ASTM 1191-52.

Durability:

Hours in weather-meter	**Equivalent in years**	**Shore A Hardness**	**Elongation %**
1440	5 years	23	340
2880	10 years	28	260

Durability shall be tested in accordance with ASMT E42-69.

The sealing compound shall be supplied separately in two parts the accelerator and the base compound. The quantities of the two component packs shall be such that when mixed they would readily produce the compound ready for application, giving the best performance.

15.9 CAULKING WITH EPOXY MORTAR

Epoxy mortar consists of epoxy resin and hardener mixed with quartz sand in the proportions as recommended by the manufacturer. The epoxy mortar shall be mixed thoroughly and shall be caulked in grooves. Epoxy primer consisting of epoxy resin and hardener without quartz sand shall be mixed as per the manufactures recommendations and applied on the concrete surface prior to caulking of the epoxy compound. The top surface shall be finished smooth using trowel. It should be ensured that only such quantity is mixed which can be consumed before setting.

15.10 CAULKING WITH BITUMINOUS SEALANT

The joints shall be cleaned thoroughly and made free of debris. The bitumen based primer as per manufacturer's recommendations shall be cold applied prior to caulking with bituminous sealing compound, which shall then be hot applied. Care shall be taken that the working temperature of the sealant shall not exceed 155^0 to165^0 C since overheating of the sealant may lead to loss of its properties.

TABLE 15.1
PROPERTIES OF BITUMASTIC SEALANT

SI. No.	Characteristic	Unit	Characteristic Value
1.	Adhesion • To iron • To galvanized iron • To concrete (dry surface) • To concrete (hot humid surface)	MPa	 1.0 0.6 0.8 0.6
2.	Length development at breaking	%	>700
3.	Thermal stability	°C	110

All the sealant materials must be durable and retain their physical and mechanical characteristics and properties during its entire service life.

15.11 PROCEDURE

Before proceeding with the work, a detailed procedure shall be prepared by Contractor and submitted to the Engineer for approval. The materials shall be tested in approved test houses and each batch shall accompany with test certificates. Engineer may at his discretion, appoint his representative to witness these tests. Contractor shall also supply samples of materials to the Engineer for verification of specifications. No separate payment will be made for testing and supply of samples for testing/ verification.

All the sealant materials must be accompanied by following test certificates.

a) Chemical composition of the material
b) Compliance certificate
c) Fire-safety certificate
d) Certificate for health safety
e) Work instructions for usage

15.12 INSPECTION

15.12.1 All materials, workmanship and finished construction shall be subject to continuous inspection and approval of the Engineer. Caulking material shall be tested for specified properties at no extra cost to NPCIL. No material exceeding the shelf life will be used and all such material shall be immediately removed from site.

15.12.2 All materials supplied by the Contractor and all works or construction performed by the Contractor and rejected – as not in conformity with the specifications and drawings shall be replaced at no extra cost to NPCIL.

15.12.3 Preliminary approvals of any materials or phase of work shall in no way relieve the Contractor from the responsibility of supplying caulking materials and or producing finished caulking in accordance with the specifications and drawings.

15.12.4 All caulking shall be protected against damage until final acceptance by the NPCIL representative.

15.12.5 Upon completion of caulking work, all forms, equipment, construction tools, protective coverings and any debris shall be removed from the area as directed by the Engineer.

16 STRUCTURAL STEEL & EMBEDDED PARTS

16.0 SCOPE

This specification covers the technical requirements for supply of all steel items required for the work as per drawings including design of connections, preparation of fabrication drawings, fabrication, inspection, testing and painting after necessary surface preparation, transporting and erection at site at desired location of:

a) Main Structural Steelwork
b) Miscellaneous structural steelwork
c) Embedded parts (Standard/ Non-standard EPs)

The specifications given below are a general guideline and reference shall be made to PC-E-160 for detailed specifications and requirements on Embedded Parts. Additional requirements for fabrication and erection of critical and important Embedded Parts which are over and above these specifications are covered in NPCIL Specification PC-E-00034.

All the works shall be carried as per approved QA procedures.

16.1 MAIN STRUCTURAL STEEL

a) Beams, girders, monorails made of rolled section and / or rolled sections with cover plates, and/or compound girders, and/or plate girders, and / or box type sections.

b) Columns made of rolled sections with or without cover plates and / or compound sections battened / laced and / or built up sections from plates with or without grinding at ends and at splice locations,

c) Roof structure such as roof trusses, purlins, bracings, etc.

d) Base plates for columns including grinding (where specified) on top of base plates and underside of column shafts.

e) Any other item of structural steel framing, though not specifically mentioned but required for the building(s).

f) Sheet metal work of minimum 0.8mm thick.

g) Floor rails of IRST 18 grade.

h) Any other structures as shown in the drawings for fabrication

i) Rail section

16.2 MISCELLANEOUS STEELWORK

a) Platforms and walkways with chequered plates / gratings.

b) Ladders with or without cages.

c) Handrails.

d) Miscellaneous equipment supports, rails for equipment movement and their associated connections.

e) Steel enclosures for equipment or electrical instrument panels, rooms etc.

f) Any other miscellaneous structures shown in the drawings for fabrication.

16.3 EMBEDDED PARTS

16.3.1 GENERAL FUNCTION AND DESCRIPTION

Embedded Parts (EPs) are any structural member, angles, channels, plates, pipe sleeves etc. cast in the concrete and used to transmit the load from attachment to concrete structure. Eps fall into following two categories.

(i) Penetration Eps are opening through the concrete structure for the passage of process piping, ducts and cables, materials and personnel.

(ii) Non penetration Eps are used primarily as a means of supporting items such as piping, cable trays, ducts, equipment and platforms to the concrete structure or for edge preparation of concrete.

Penetration and non-penetration EPs are of different types and their descriptions are given below.

(a) Plate EPS

Plate Eps are used to support piping, cable tray, ladders and equipment. A typical plate EP consists of a plate and anchorage welded to it. Component supports can directly be welded or bolted to these EPS.

(b) Pipe Sleeves

Theses EPs are used for passage of piping, cables etc. from one side of concrete structure to other side. Pipe sleeve Eps consists of a pipe and one or more puddle flanges, provided through the length of pipe for anchorage and also for improving leak tightness. These pipes are either projecting out of the concrete surface or flush with it depending upon the requirement.

(c) Anchor bolts

Anchor bolts are used for anchoring equipment like pumps, motors, heat exchangers, tanks, pipes rails for cranes and hoists etc. The threaded portion of anchor bolt projection out of the concrete shall be suitably protected by caps/ sleeves from any possible damage to the threads till the equipment is erected.

(d) Threaded sockets/ embedded inserts

Threaded socket Eps are used for anchoring the equipment like heat exchanger, motors, pumps, tanks rails for cranes, hoists etc. The threaded portion remains below the concrete face. Suitable protective plugs shall be inserted to prevent damage to the threads during construction phase.

(e) Rectangular Box type penetration EPs

These Eps are generally used for passage of a bunch of piping or cables. It consists of a rectangular box made of plates and anchorage welded to it. The anchors help in transferring the loads from the EP to concrete structure and also improve leak tightness. These EPs are either projecting out of the concrete surface or flush to it depending upon the requirement.

(f) Expansion anchors

A post-installed anchor inserted into the concrete that transfers the loads to or from the concrete by direct bearing or friction or by both. Expansion anchors may be torque controlled where the expansion is achieved by a torque acting on the screw or bolt or displacement controlled where the expansion is achieved by impact forces acting on a sleeve or plug and the expansion is controlled by the length of travel of the sleeve of the plug. These anchors are used only if

(i) EPs are missed or misplaced from actual support location with respect to reference drawings during construction. Civil contractor shall substitute these EPs with suitable anchors meeting the design intent and cost for these shall be borne by them.

(ii) Additional requirement of anchors are arisen after concreting is done on account of design change.

Approved type of expansion anchors (for seismic/ non-seismic loads) for respective systems/ buildings/ structure from approved vendors shall be used.

(g) Grouted Anchors

Grouted anchor is an anchorage system which has the anchor rod, bolt or bar grouted or dry packed into pockets left in the hardened concrete.

(h) Embedded Piping

These are the part of the process system piping, which are embedded in the concrete and are projecting out of the concrete surface for joining with other part of the system piping while erection.

(i) Special EPs

The configuration of these EPs are different from the EPs described above and are designed to suit the particular requirement. These may have stringent tolerances depending upon the requirement of the equipment.

Different EPs used in the work and covered in these specifications are given below.

a) Anchor bolts of different sizes and Plate embedded parts (EPs)
b) Pipe sleeves with circumferential baffle plates of various diameters in carbon steel and stainless steel.
c) Electrical Canister EPs
d) Drain hubs and penetration in walls/slabs which are not joined to buried piping.
e) All Hatch frames both on the receiving hatch opening and hatch blocks/beams
f) All other embedded parts as shown on drawings released for fabrication.

16.4 APPLICABLE CODES, SPECIFICATIONS

IS : 102	Ready mixed paint, brushing, and red lead. Non-setting, priming.
IS : 800	General construction in steel- Code of Practice.
IS:801	Code of practice for use of old formed light gauge steel structural steel members in general building construction.
IS: 806	Code of practice for use of steel Tubes in General Building Construction.
IS : 808	Dimensions for Hot Rolled Steel Beams, Column Channel and Angle Sections.
IS :813	Scheme of symbols for welding
IS:819	Code of practice for resistance spot welding for light assemblies in mild

	steel.
IS:822	Code of practice for inspection of welds.
IS : 875	Code of practice for Design loads, For buildings & Structures (Part 1 to 5)
IS : 919	ISO systems of limits and fits. (Parts 1& 2)
IS : 1161	Steel Tubes for Structural Purposes- Specification
IS : 1200	Method of Measurement of Building and Civil Engineering Works (Part 1 to 28).
IS: 1239	Mild steel Tubes, Tubulars and other wrought steel fittings. (Parts 1 & 2)
IS :1363	Hexagon Head Bolts, Screws and Nuts of product Grade C (Part 1 to 3).
IS:1365	Slotted counter sunk head screws.
IS : 1364	Hexagon Head Bolts, Screws and Nuts of product Grade A & B.
IS : 1367	Technical supply conditions for threaded steel fasteners (Part 1 to 20)
IS : 1477	Code of practice for painting of ferrous metals in buildings. (Part 1 & 2)
IS: 1608	Metallic materials – Tensile testing at ambient temperature.
IS :1730	Dimensions for steel plate, sheets, strips and flats for structural and general engineering purposes.
IS : 1852	Rolling and cutting tolerances for hot rolled steel products.
IS : 1893	Criteria for earthquake resistant design of structures.
IS : 1977	Low tensile Structural Steels – Specification.
IS : 1978	Line Pipe
IS : 2002	Steel plates for pressure vessels for intermediate and high temperature service including boilers.
IS : 2016	Specification for Plain washers.
IS: 3502	Steel chequered Plates – specifications.
IS : 2062	Hot rolls low, medium and high tensile structural steel.
IS : 3589	Steel Pipes for water and sewage.-Specification
IS : 3757	Specification for high strength structural bolts
IS : 5372	Taper washers for channels.(ISMC)
IS : 5374	Taper washer for I beams (ISMB)
IS : 5620	Recommendation for structural design criteria for low head slide gates.
IS: 5624	Foundation Bolts – specification.
IS : 6005	Code of practice for phosphating of iron and steel.
IS: 6623	High strength structural nuts - specifications.
IS: 6533	Code of practice for design and construction of steel chimney Part 2- Structural Aspects
IS: 6639	Hexagon Bolts for steel structures – specifications.
IS :6649	Specifications for Hardened and tempered washers for high strength structural bolts and nuts.
IS : 7205	Safety code for erection of structural steel work.
IS : 7215	Tolerances for fabrication of steel structures.
IS : 8500	Structural steel - micro alloyed (medium and high strength qualities)- Specification
IS : 8629	Code of practice for protection of iron and steel structures from atmospheric corrosion (Part I-III)
IS: 9537	Conduits for electrical installations – General requirements.
IS: 10842	Evaluation procedure for Y-groove weld crack-ability test in structural steel.

IS : 11855	Guidelines for design and use of different type of rubber seals for hydraulic gates.
IS : 12843	Tolerances for erection of steel structures
SP:6(1)	ISI Hand Book for structural engineers –1, Structural Steel Section
BS : 3139	High strength friction grip bolts for structural engineering.
BS: 4395 (I)	High strength friction grip bolts and associated nuts and washers for structural engineering.
BS : 4592	Industrial type flooring and stair treads –Metal open bar gratings
BS : 4604	The use of high strength friction grip bolts in structural steel work.
AWS D1.1.	Structural Welding Code-Steel
AERB/SS/ CSE-2	Design, Fabrication and Erection of Steel Structures Important to Safety of Nuclear Facilities
ASME Sec II, Part C	Specification for Welding Rods, Electrodes and Filler Material
ASME Sec V	Non –destructive Examination.-
ASME Sec VIII, Div 1	Rules for Construction of Pressure Vessels.
ASME Sec III, Div 2	Code for concrete Reactor vessels and containments
ASME Sec IX	Qualification standard for Welding and Brazing procedure welders, brazers and welding and brazing operators
ASTM A-36	Specification for Structural Steel
ASTM A 167	Standard specification for Stainless and Heat Resisting Chromium Steel Plates, Sheet, Strip
ASTM A 262	Standard practice for Detecting Susceptibility to Intergranular attack in Austenitic Stainless Steels
ASTM A 380	Standard Practice for Cleaning and descaling Stainless Steel Plates, Equipment and Systems
ASTM A 516	Standard specification for Pressure Vessel Plates, Carbon Steel for Moderate and lower Temperature Service.
ASTM E 94	Standard Guide for Radiographic Testing
ASTM E 165	Standard test method for Liquid Penetrant Examination
ASTM E 709	Standard Guide for Magnetic Particle Examination
PC-E-160	NPCIL Specifications for Embedded parts
British Standard	EN Series carbon steel materials like EN8, EN24

The pertinent clauses and sections of the above codes, standards and specifications (latest revision), shall apply to the material, design, detailing, fabrication and inspection of the work covered by this specification as specified in the other sections of this specification.

In the event that certain requirements of this specification, applicable drawings and above standards & codes conflict with each other. The following priority shall govern in descending order.

i) Requirement given in the drawing
ii) Requirement given in specification No. PC-E-160, for EPs, PC-E-0034 for critical and

important EPs and this specification for other steel structures.

iii) Requirement given in ASME/ ASTM

iv) Requirement given in Indian standard

16.5 DRAWINGS

16.5.1 ENGINEERING DESIGN DRAWINGS

Design drawings shall show all the dimensions and if necessary, clearances of the structure, typical connection details including size & length of the weld, weld arrangement, number of bolts, size of bolts and types of bolts, size of each member, definite location of openings, to various levels, and all other information necessary to prepare drawings for fabrication and erection.

16.5.2 Fabrication Drawings

16.5.2.1 Contractor shall prepare all fabrication and erection drawings in metric units for the entire work based on the design drawings. Shop detail drawings shall show all shearing, punching, drilling, bevel cutting, bending, and all welding / bolting in complete detail. All connections and splices shall be detailed by the Contractor and clearly shown on the drawings.

EPs shall not be welded to the main reinforcement. Bill of material shall show number, size, length, weight and assembly work of each erection piece. Bill of material for each drawing shall include fasteners/ bolts, nuts, washers and other accessories complete with specification, size, length and number etc. for each erection mark and proper identification for each joint.

Bill of material shall be prepared erection mark wise, showing weight of each component part and total weight of each erection mark. All revisions after initial issue of a drawing shall be clearly indicated with issue number and date of revision. Details shown in the drawings shall be clear and legible.

16.5.2.2 Contractor shall not commence shop detailing from information on Engineering design drawings unless such drawings or part of such drawings are officially released with the stamp bearing "Released for Construction". Contractor shall be responsible for the correctness of all shop drawings. Six (6) prints of shop drawings shall be submitted to the Engineer for scrutiny and approval. The fabrication drawings shall be revised by the Contractor to reflect all revisions in design drawings as and when such revisions are made by Engineer. Six (6) prints of the revised fabrication drawings shall be submitted to the Engineer for approval.

16.5.2.3 No detailed shop drawings will be accepted for examination by the Engineer unless they are complete and checked and approved by Contractor's qualified Structural Engineer and accompanied by an erection plan showing the location of all pieces detailed.

16.5.2.4 Contractor should check for erection clearance and ensure that detailing of connections is carefully planned to obtain ease in erection of structures including field-welded connection and bolting. Field connections/ splices may be welded or bolted type, as specified in drawings.

16.5.2.5 Fabrication shall not be started until Contractor has received copies of such

drawings upon which Engineer has endorsed his approval. Approval by Engineer of any of the drawings shall not relieve Contractor from the responsibility for correctness of engineering, workmanship, fit of parts, details, material, errors or omissions if any and all work shown thereon. Any work done prior to approval of shop drawings will be at the Contractor's risk. The Contractor shall make such changes in the design when so directed, which are considered necessary to make the structures conform to the provisions and intent of the specifications, without any additional cost to the NPCIL. Engineer's approval shall not invalidate any claim for damages of any kind for incorrectly detailed/ fabricated steel, notwithstanding any approval of such drawings by Engineer.

16.5.2.6 Contractor shall submit design calculations, for each and every connection detail proposed by him and also for any substitution for members, desired by him and approved by the Engineer. Fabrication drawings not accompanied by calculations for the connection design are liable to be rejected.

16.5.2.7 Each lot of drawings sent by Contractor for approval shall contain a limited number of drawings and shall be in an order and manner which follows erection sequence or as required by Engineer based on priorities allocated.

16.5.2.8 Engineer will return one copy of Contractor's drawing marked with Engineer's approval/ comments. Contractor shall furnish the Engineer, Six (6) prints of all approved final drawings for field use and record purpose. Contractor shall also furnish the Engineer with one reproducible of each drawing. These reproducible shall incorporate all modifications, field changes substitutions etc. affected and shall reflect the status "as built". It should be noted that so-called sepia or similar process reproducible are not acceptable. All these reproducible are not acceptable. All these reproducible shall be submitted rolled (not folded) on the outside of regular mailing tubes.

16.5.2.9 All these drawings will remain the property of the Engineer (NPCIL). Engineer reserves the right to use them in any manner whatsoever.

16.5.2.10 Two sets of soft copies of all final approved Contractor's drawings in the form of CDs shall be furnished by the Contractor for Owner's use after incorporating the as built status.

16.5.2.11 Time consumed by the Contractor in securing approval of drawings should not be added to the time allowed for completion of contract. A period of four (4) weeks from the date of receipt of drawings by the Engineer should be anticipated for this item of procedure in the schedule.

16.6 MATERIALS

16.6.1 STEEL SUPPLY

All steel shall be procured and supplied by the Contractor, from reputed sources as approved by Engineer and shall conform to the following:

16.6.1.1 Contractor shall use materials for fabrication as specified in the approved drawings. All materials supplied by the Contractor shall be in sound condition, of recent

manufacture, free from defects such as loose mill scales, slag intrusions, laminations, pitting, flaky rust etc. The lengths/sizes of steel sections and plates shall be as supplied by the steel mills and conform to the latest issue of the relevant IS /ASME specification.

16.6.1.2 All materials required for the work shall be correlated with manufactures test certificates. In the absence of test certificates, materials shall be tested by Contractor through an approved laboratory for establishing conformance to specification's requirement at Contractor's cost, and as directed by the Engineer. All tests shall be witnessed by owner's representative.

16.6.1.3 The Contractor shall supply the mill test certificate for the materials being supplied by him.

16.6.1.4 Material supplied against these Test Certificates (TCs) should have identification stamped or stenciled on them. All such identification markings shall be authenticated by the inspection agency, which has inspected and approved the material.

16.6.1.5 The Engineer shall have the right to test random samples to prove authenticity of the test certificates produced by the Contractor at the Contractor's cost. Any material found not meeting the specification requirement would be rejected. In the absence of material specification in the drawing following guidelines are given for structural steel members:

a) Rolled sections and Bars

Rolled steel sections supplied by the Contractor shall be of following quality.

Rolled Section	: IS 2062 E 250-Quality. A
Plates below 12mm	: IS 2062 E 250-Quality. A
Plates 12mm and above	: IS 2062 E 250-Quality. B0
Plates for crane girder	: IS-2062 E 250-Quality. C

Rail section:

The Y- Groove crackability test shall be performed in accordance with IS 10842 for material of Grade E 250Quality C, having thickness 12mm and above.

b) Pipes and Pipe fittings

For pipes and pipe fittings the following standards shall apply

For pipes up to 150 mm diameter IS: 1239 Part I and II,

For pipes beyond 150m to 2000mm diameter IS: 3589.

16.7 SUBSTITUTIONS

Whenever the Contractor desires to substitute structural members, shown on the drawings, due to non-availability of requisite materials, such substitutions shall be made only after authorization in writing by the Engineer.

Engineer may also direct to make substitution, when he considers such substitution is necessary.

16.8 FABRICATION OF STRUCTURAL STEEL

16.8.1 GENERAL

All workmanship and finish shall be of the best quality and shall conform to good engineering practice and the best-approved method of fabrication. All materials shall be finished straight and shall be machined true and square where so specified. All holes and edges shall be free of burrs. Shearing and chipping shall be neatly and accurately done and all portions of work exposed to view shall be neatly finished. Standard fabrication clearances as detailed in American Institute of Steel Construction Manual and IS Codes shall generally be followed unless otherwise directed/ approved. For EPs specific requirements given in para titled 'EMBEDDED PARTS' and 'PAINTING' of this specification shall be followed in case found to be in variation with other clauses of this section. Materials at the shop shall be kept clean and protected from weather. In addition

a) All care should be taken to avoid undue welding distortions.
b) Complete layout shall be prepared and got approved by the Engineer before actual fabrications are started. If needed mock-ups may also be prepared.
c) All fit ups shall be got approved from the Engineer.
d) Standard tolerances as per relevant IS specifications shall be followed in case they are not provided in relevant drawings and specifications.

16.8.2 ELECTRODES

All Electrodes and welding shall be of low hydrogen type conforming to ASME Sec II Part C. Brands approved by NPCIL shall only be used. The bidders shall submit the list of venders and seek approval of NPCIL.

16.8.3 CONNECTIONS

16.8.3.1 All connections shall be designed (In case these are to be designed by the contractor) for forces indicated on the design drawings. The contractor shall be responsible for selection of standard connections from AISC, "Manual of Steel Construction" unless specified in drawings. Where standard joints are not available, contractor shall design connections and shall get Engineer's approval prior to fabrication.

16.8.3.2 Connections shall be effected either by welding or bolting or as specified on the drawings. Type and quality of weld/bolts shall be in accordance with relevant IS Codes and as specified in the drawings.

16.8.3.3 Where necessary, tapered washers, flat washers or spring washers shall be used with bolts. The length of the bolt shall be such that at least one thread of bolt projects

beyond the nut, except in case of high strength friction grip bolts where this projection shall be at least three times the thread pitch.

16.8.3.4 In all cases where bearing is critical, the unthreaded portion of bolt shall bear on the members assembled. A washer of adequate thickness may be provided to exclude the threads from the bearing thickness, even if a longer grip bolt has to be used for this purpose.

16.8.3.5 Wherever applicable, all connections and splices shall be designed for full strength of members or loads indicated unless otherwise approved. Column splices shall be designed for the full tensile strength of the minimum cross section at the splice. Unless otherwise specified, beam end connections shall be designed for 60% of the shear capacity of rolled sections and 80% of shear capacity for built-up sections plus additional axial forces, if any.

16.8.3.6 All members likely to collect rainwater shall have drain holes provided.

16.8.3.7 Shop connections shall be generally welded. Field connections shall be made with bolts or HSFG bolts or welding as specified on the drawings.

16.8.3.8 In general, splice joints are not permitted except where standard length of the section under consideration is not sufficient to build the full length of the member. However, under exceptional condition, not more than one shop splice shall be permitted to make up the full length of a member with prior approval of Engineer at no extra cost to NPCIL. Shop splices to make the full member lengths shall be of full penetration butt-welded type and radio-graphically tested.

16.8.4 STRAIGHTENING

16.8.4.1 Rolled material, before being worked, shall be straightened, unless otherwise required/specified. If straightening or flattening is necessary, it shall be done by methods that will not injure the material. Long plates shall be straightened by passing through a mandrel or levelling rolls and structural shapes by the use of mechanical or hydraulic bar/section straightening machines. Heating or forging shall not be resorted to without the prior approval of the Engineer in writing. In case of site fabrication, the Engineer shall approve the straightening methods in writing before commencing the work.

16.8.4.2 Checking of the straightness of the structural members like angles, channels, beams etc. shall be done by using the thread. For checking of the straightness of the column sections piano wire shall be used. The sections, which are twisted beyond repairs, shall not be used for fabrication. Heating or hammering shall not be permitted. After removal of bends, structural members shall be submitted for inspection and approval of Engineer.

16.8.5 CUTTING

16.8.5.1 Cutting may be done by shearing, chopping, sawing or machine flame cutting. All re-entrant corners shall be shaped notch free to a radius of at least 12-mm. Sheared

or cropped edges shall be dressed to a neat workmanlike finish and shall be free from distortion and burrs.

16.8.5.2 Hand flame cutting shall be undertaken, only if so permitted by the Engineer and shall only be carried out by an expert in such work. Hand flame cut edges shall be ground smooth and straight, for minimum 2mm in depth to remove the oxide layer.

16.8.5.3 Edges of flange cover plates and plates used to form any sections shall be ground smooth/planed.

16.8.6 PUNCHING AND DRILLING

16.8.6.1 Holes for all connections shall be drilled accurately and the burrs removed effectively. Where several parts are to be connected, such parts shall be first assembled, tightly clamped together and drilled through. Holes in secondary members such as purlins, girts, lacing bars etc. may be punched full size through material not over 12 mm thick. Holes should be clean cut, without burr or ragged edges.

16.8.6.2 ub-punching may be permitted before assemble, provided the holes are punched 3 mm smaller in diameter than the required size and reamed after assembly to the full diameter. The thickness of material punched shall not in such cases exceed 16 mm.

16.8.6.3 When match drilling is carried out in one operation through two or more separate parts, these parts shall be separated after drilling and the burrs removed.

16.8.6.4 Holes for turned and fitted bolts shall be drilled to a slightly smaller diameter and reamed to a diameter equal to the nominal diameter of the shank or barrel subject to HB tolerance specified in IS: 919.

16.8.6.5 Where reamed members are taken apart for transporting or handling the respective pieces reamed together shall be so marked that they may be reassembled in the same position in the final setting up. No interchange of reamed parts will be permitted. Poor matching, over drilling and ovality in holes shall be a cause for rejection. Burning holes with gas is strictly prohibited.

16.8.6.6 Holes may be required to be drilled by the Contractor at site for installing equipment or steel furnished by other agencies. The information for this will be supplied to the Contractor by the Engineer before or after erection of the steel. Holes should be by drilling or other machining process and not by gas cutting sets.

16.8.7 ROLLING AND FORMING

Plates, channels, RSJ, etc., for circular bins, crane girders, gantry girders etc shall be accurately laid off and rolled or formed to required profile/shape as called for on the drawings. Adjacent sections shall be match-marked to facilitate accurate assembly, welding and erection in the field. In the case of stainless steel materials while rolling care shall be taken to avoid direct contract of MS/CS rollers with SS material in view of iron contamination to SS materials. A detailed rolling & forming procedure shall be

prepared by the contractor and Engineer approval shall be obtained prior to execution.

16.8.8 GRINDING

Column ends bearing on each other, resting on base plates, compression joints designed for bearing, base plates coming in contact with column end and cap plates shall be ground smooth to ensure 90% contact with local gap not exceeding 0.10 mm (filler gauge shall be used to check this gap), unless mentioned and approved otherwise. All ground surfaces shall be protected from dirt and mechanical damages till the assembly is completed. However the underside of base plate bearing on cement grout need not be ground smooth.

16.9 GRATINGS

All gratings shown and/or listed in the drawings shall be fabricated as a complete unit as detailed or as necessary for connections to structural steel framing. The gratings shall be capable of sustaining a safe live load of 500 kg/sq. metre of plan area unless otherwise specified on the Engineer's design drawings. Treads and landings shall be suitable for the prescribed loading and be furnished complete with a one-piece standard non-slip abrasive nosing of approved type.

16.9.1 ELECTROFORGED GRATINGS

Electro forged Gratings shall be of custom fabricated/ cut to size in shapes (rectangular/ circular etc.) as required with serrated bearing bars. Gratings shall be fixed at all elevations with clamps, siddle clip & slotted clamps including drilling, providing and fixing screws. It shall be hot dip galvanized as per IS 4759 but in no case it shall be lesser than 610GSM. Wherever, due to functional requirements Galvanizing is not acceptable the grating shall be painted with high build epoxy with minimum DFT of 200 micron (excluding primer) over 75 micron zinc silicate primer etc. The gratings shall be capable of sustaining a safe live load of 500 kg/sq. meter (unless specified otherwise) of plan area. Treads and landings shall be suitable for the prescribed loading and be furnished complete with a one-piece standard non-slip abrasive nosing of approved type. The Contractor shall submit the design and fabrication drawing to NPCIL for approval prior to procurement of gratings.

16.10 HANDRAILS

Handrails shall be provided on open sides of platform, stairways and around all openings as shown in drawings. Handrails shall be of SS/mild steel pipe as specified in the drawings of flush welded construction and ground smooth. Unless specified otherwise the handrail shall be fabricated using 32mm nominal bore medium class pipe provided with double rail, top rail about 1 meter above platform / walkway level and the intermediate rail 450 mm below top rail and pipe posts spaced not more than 1.5 metres apart and 150 mm high 6mm thick toe plate. All MS handrails shall be painted as per requirement given in the drawings.

Smooth uniform curves and bends shall be provided at stair returns and also where so

ever required /specified. Posts connected to curb plates shall have a neat closure at the bottom and a 6mm thick plate nearly welded to posts for attachments to curb plate/ toe guards. All necessary fittings including inner dowels at splices, brackets, bolts, bends, flanges and chains, shoes for removable type handrails where required shall be furnished by the Contractor. Open ends of all the pipe posts shall be plugged and welded. A minimum radius of 3 times the pipe diameter shall be provided at all points of direction changes in the handrail.

16.11 CHEQUERED PLATE

Chequered plates used shall be minimum 6mm thick or as indicated in the drawings and shall be capable of carrying a minimum live load of 500 kg/sq.m unless otherwise specified in the design drawings. Chequered plate shall be fixed by 8mm diameter cadmium plated M.S. screws with countersunk heads at a maximum spacing of 400mm. Members supporting the chequered plate shall have matching holes tapped in them. Chequered plates may also be required to be welded to the structural steel framing. The decision in this regard will be given by the Engineer wherever required/ specified.

Thickness of zinc coating shall be as per IS: 4759 for structural steel plates, angles, channels etc. and as per IS: 4736 for pipe sleeves.

16.12 WELDING

16.12.1GENERAL

16.12.1.1 Welding procedure specification (WPS) shall be established and Qualification of weld procedure (QWP) shall be done in accordance with the requirements of ASME Sec IX, or AWS D 1.1 as and where specified. Welders employed shall also be qualified as per above standards prior to taking up fabrication.

Following pre-qualified welding process shall be employed for fabrication, erection and repair by:

a) Submerged Arc Welding (SAW).
b) Shield Metal Arc Welding (SMAW).
c) Gas Metal Arc Welding (GMAW).
d) Gas Tungsten Arc Welding (GTAW)

16.12.1.2 All welds shall be free from defects like blowholes, lack of penetration, undercutting, cracks etc. All welds shall be cleaned of slag or flux and show sections, smoothness of weld metal, featheredges without overlap and freedom from porosity.

16.12.1.3 50mm on either side of the surfaces on which weld metal is to be deposited shall be smooth, uniform, free from fins, tears burrs cracks and absolutely free from grease, paint, loose scale, moisture or any other substance which would adversely affect quality and strength of weld.

16.12.1.4 Machining, thermal cutting or grinding may be employed for joint preparation or removal of unacceptable work or metal. The weld edges shall be smooth & regular surface free from cracks & notches. Flame cut material above 50mm thick shall be pre-heated to 100°C prior to flame cutting.

16.12.1.5 All weld fit-up shall comply with tolerances specified in the design drawing. The parts to be joined by fillet welds shall be brought into close contact as practicable. The root gap in no event shall be greater than 3 mm for SMAW process and 1.5mm for SAW process. If the separation is greater than 1.6mm the leg of the fillet weld shall be increased by the amount of root opening. This shall apply only in the case of continuous welds. Abutting parts to be butt-welded shall be carefully aligned and correct root gap shall be maintained throughout the weld operation. The fit up of joints at contact surfaces that are not completely sealed by welds shall be close enough to exclude water entry after painting. The separation between laying surfaces of lap joint and butt joints with backing plate shall not exceed 1.5mm. Abutting parts to be butt-welded shall be carefully aligned and the correct root gap maintained throughout the welding operation. Misalignments greater than 25% of the thickness of the thinner plates or 3mm, whichever is smaller, shall be corrected and in making the correction, the parts shall not be drawn into a slope sharper than 2 degrees.

16.12.1.6 All tack welds shall be made using qualified procedure and qualified welders. Any preheat requirement specified in the welding procedure shall also apply to tack welds. All tack welds shall be examined visually for defects and if found defective, shall be removed.

16.12.1.7 Welding of temporary attachment/fixtures to retain fit up is allowed in case the parts have a nominal thickness of at least 6mm. Temporary attachments are welded to at the distance of at least 30 mm from the weld seam for construction of CS and least 60mm for welding austenitic steel. Welding of temporary attachments/fixtures into the joint slot is not allowed. All temporary fixtures to be removed after welding by grinding them to weaken the welded portion and hammering thereafter, followed by grinding the portion of any weld remaining on the base metal. A dye check at the discretion of the quality surveyor shall be done to detect any crack/defect at the point of fixture temporary weld.

16.12.1.8 It is not allowed to turn over and carry over heavy assemblies in tacking condition in order to control the geometric dimensions to the requirements of the drawings.

16.12.1.9 Non-flatness of the facing sheets being assembled into the subassemblies in the longitudinal and transverse direction is allowed within 10mm for 1m of the length.

16.12.1.10 During the installation of the structural steel members care shall be taken to prevent damage of the sheets and of the welding seams. The work shall be positioned for

flat welding wherever practicable and overhead weld shall be avoided as far as possible.

16.12.1.11 In the joints of the parts with dissimilar thickness smooth transition of one part to the other must be provided by way of the gradual decreasing of the thickness of the thicker part with the slope of the surface not exceeding 15 degree.

16.12.1.12 Welding shall not be done when the surface of the members are wet or exposed to rain or high wind velocities unless the welding operator and the work are properly protected. In joints connected only by fillet welds, the minimum size of fillet weld to be used shall be as shown in the following table unless otherwise specified in the drawing.

Material thickness of Thicker part joined (mm)	Minimum size of fillet weld (leg dimension of fillet weld) (mm)
Up to 6	3
Over 6 to 12	5
Over 12 to 18	6
Over 18 to 36	8
Over 36 to 56	10
Over 56 to 150	12
Over 150	16

16.12.1.13 Fillet welds 5 mm or larger in size for SMAW and 10mm for SAW shall be made with two or more passes. Welding rods shall be 3.15 in diameter maximum for root passes, and 4mm and above in diameter for subsequent passes. Complete penetration butt weld shall be terminated at the ends of the joint in a manner that will insure their soundness. Where abutting parts are 20mm or more in thickness, suitable run-on and run-off plates with similar edge preparation and having a width not less than the thickness of the thicker part shall be used. These extension pieces shall be removed after completion of weld and the end of the weld made smooth and flush with the abutting parts.

16.12.1.14 In case of full penetration butt welds without backing , root weld shall be back gouged to sound metal before second side welding for complete fusion throughout the entire cross section. However, in case of square butt welds done in flat position from both sides and with thickness of parts joined less than 8mm and root opening not less than half the thickness of the thinner part, gouging can be dispensed with, if approved by the engineer.

16.12.1.15 All welded shop splices in each component part of covered plate beam or built up member shall be made before the component part is welded to other parts of the member. Long girders or girder section may be made by welding sub assemblies

each made in accordance as explained above. When making these sub assembly splices, whether in the shop or field, the welding sequence should be reasonably balanced between web and flange welds. Where weld reinforcement interferes with the proper fit-up between components to be assembled for welding, these welds shall be ground flush prior to assembly.

16.12.1.16 Preheating for welding of steel shall conform to ASME Section VIII Div 1

16.12.1.17 Post weld heat treatment (PWHT) shall be carried out if the weld size is more than 50mm, unless specified otherwise. The procedure for PWHT shall conform to ASME Section VIII Div 1. No stress relief using oxyacetylene flame is permitted.

16.12.1.18 In assembling & joining parts of a structure or a built-up members and in reinforcing parts to members, the procedure and sequence shall be such as to minimize distortion and shrinkage. The fabricator shall prepare a welding sequence for a member or structure which in conjunction with WPS and overall fabrication method, will produce members or structure meeting the quality requirement specified. The welding sequence and distortion control programme shall be submitted to Engineer for comments and information before start of welding such program shall include, besides other appropriate details, full particulars in regard to the following:

a) Proposed pre-bending in components such as flanges and flange cover plates and pre-setting of joints to offset expected distortion.
b) Make up of sub-assemblies proposed to be welded before incorporation in final assembly.
c) Proposed joint forms, classification of wire and flux or covered electrodes, welding process including fit up and welding sequence with directions in which freedom of movement is to be allowed.
d) Proposed number, spacing and type of storage backs and details of jigs and fixtures for maintaining proper fit up and alignment during welding.
e) Any other special features like assembling similar members back to back or stress relieving procedure.
f) If so desired by the Engineer, mock up welding shall be carried out at Contractor's cost to establish the efficiency of the proposed programme, with any modification suggested by the Engineer in limiting distortion or /and residual stress to acceptable levels.
g) For sections made of rolled sections with cover plates, the ends of the plate shall be seal welded or alternatively flange cover plate terminated 25mm short of the full length and welded across to the beam for proper end sealing and/or as directed by the Engineer.

16.12.1.19 Welds shall be defect free and surfaces shall be thoroughly cleaned to remove all visible weld defects and extra material. All welds shall be stamped/identified with

System/Joint No/Welder punch etc. as per approved procedure at a distance of 30-35 mm from the weld seam.

16.12.2 WELDING CONSUMABLES

16.12.2.1 Electrodes, filler wires and flux used for welding shall be from approved manufacturers/Suppliers. When requested by the engineer, the contractor shall furnish certification that electrode or electrode flux combination will meet the requirements of classification. The classification and size of electrode, arc length, voltage & amperage shall be suited to type and thickness of material, type of groove, welding positions and other circumstances attending work.

16.12.2.2 Electrodes, filler wire and consumables shall conform to the requirements of ASME Sec. II Part C.

16.12.2.3 Only low hydrogen electrodes to AWS E7018 shall be used for welding for all Carbon Steel material. Whenever high tensile welds are required to be employed than E-8018 electrode are to be used of approved make. These electrodes shall be purchased in hermetically sealed containers or baked by the user as recommended by electrode manufacturer. Electrode flux coating shall be sound and unbroken. Broken or damaged coating shall cause the electrodes to be discarded. SMAW electrodes shall be properly stored. Before welding, the electrodes shall de dried in a holding oven as per manufacturer's recommendations. Only limited quantity shall be issued to the welders. The electrodes shall be kept in "carry ovens" and shall not be exposed to the atmosphere.

16.12.2.4 The filler wire and flux combination for submerged arc welding shall conform to the requirements of ASME Section II, Part C. The weld metal deposited by the submerged arc process shall have mechanical properties not less than that of base material specification. The flux used for SAW process shall be dry and free of contamination from dirt, mill scale or foreign material. The flux purchased in packages shall be stored in dry place. Flux shall be dried in case of damaged package at a temperature of 260° C for 1 hour prior to welding operation. Flux shall be placed in dispensing system immediately upon opening a package.

16.12.2.5 Welding plants and accessories shall be of adequate capacity and shall satisfy appropriate standards and be of the approved make and quality. Proper safety rules shall be followed and adequate means to measure the current shall be provided.

16.12.2.6 Wet magnetic particle inspection in accordance with ASME Sec. V may be performed.

16.12.2.7 For other magnetic materials dry power magnetic particle inspection in accordance with ASME Sec V.

16.12.3 WELD REPAIR

Whenever weld repair is required, Contractor shall give prior intimation to the Engineer and permission before the repairing is taken up. When a defect is detected in a weld, it shall be removed by cutting/grinding and smooth blending of the area with parent metal

without sharp edges, corners. If welding is required, the same shall be done using the qualified procedure/welder and stage inspection as per the original weld. Correction of defect in the same portion of the weld shall not be allowed more than two (2) times. Portion of the welding seams, which have been subjected to repair, must be indicated in the weld inspection reports.

16.13 ERECTION

16.13.1 GENERAL

16.13.1.1 The Contractor shall supply all erection bolts, permanent bolts and electrodes as required for the job. At all times the Contractor shall be responsible for the safety and protection of fabricated material, from loss or damage of any nature until the completion of erection work.

16.13.1.2 Structural steel work will involve the erection of columns, beams, bracing, crane girders, purlins, trusses, monorails, ladders, platforms, gratings, chequered plates etc.

16.13.1.3 The Contractor shall complete all preliminary works at site, including post concrete survey wherever required well before the arrival of fabricated structural steel, such as keeping in readiness electrical winches, mobile cranes, gin poles, compressors, all tools and tackles, welding sets, torque wrenches, impact wrenches, etc., as part of this contract and any other work that may be necessary so as to start erection immediately after the arrival of fabricated steel at site.

16.13.1.4 The Contractor shall arrange for such quantum of erection equipment, supervision staff, labour and other arrangements so as to carry out the work efficiently. The equipment and services provided by Contractor shall include but not be limited to, the supply of labour, transport vehicles, crane derricks, gin poles, winches, welding equipment and tools, compressed air if required, blocking, scaffolding, locked storage for tools, welding rods, positioners, cables etc required for site fabrication assembly and erection of the structure. If found necessary the Contractor shall also provide at hisown cost arrangements for inspection and testing of material used in erection. He shall satisfy the Engineer regarding arrangements for various types of work to be undertaken by him.

16.13.1.5 No dragging of fabricated structural steel shall be permitted.

16.13.1.6 All fabricated structural steel shall be stored 150mm above ground on suitable packing, to avoid damage during the monsoon. Steel shall be stored in the order of erection with erection/identification marks visible. Storage areas shall be prepared and maintained by the Contractor. Any steel stored near excavations shall be removed immediately to a safe distance to avoid burial under debris.

16.13.1.7 The Contractor shall protect all existing plants, embedded parts, all permanent and temporary structures, piping, conduits, equipment and facilities against damage during erection. The Contractor shall perform his work in a manner, which in no

way endangers the operations of any existing plant or structures or hinders other construction activities.

16.13.1.8 The Contractor shall arrange at his own expense, the necessary non-inflammable staging and hoisting materials or equipment required for the erection work and shall remove and take them away after the completion of the job. The Contractor shall also provide necessary passageways, fences, safety belts, helmets, safety shoes, lights and other fittings to the satisfaction of the Engineer and for protection of his men and materials.

16.13.1.9 All structures shall be erected as shown in drawings. The Contractor shall carry out all erection work in the sequence required/ approved by the Engineer. The methods of erection and complete erection scheme shall be subject to the approval of the Engineer and shall be modified wherever required by the Engineer. This, however, will not relieve the Contractor of the responsibility for safe and expeditious completion of the work, its quality and accuracy.

16.13.1.10 Drifts should be used only for drawing the members into position and must not be used to such an extent so as to destroy the holes. Drifts of a larger size than the nominal diameter of the hole shall not be allowed. Any damaged holes or burrs must be rectified to the satisfaction of the Engineer. Correction of minor misfits and reasonable amount of reaming, if any, shall be considered as a part of erection. Any error in shop work, which prevents proper fit even after a moderate amount of reaming and slight chipping or cutting shall be immediately reported to the Engineer. The Contractor's work shall also include straightening and repairing of materials slightly damaged and drilling some holes in members where required. This is deemed to have been included in the unit rate quoted and nothing extra shall be payable for the above operations. Non Conformance Report (NCR) shall be raised and got approved for all repairs and modification required.

16.13.1.11 In case of any faulty erection, all such dismantling and re-erection required will be at the Contractor's cost. Shim stock of mild steel plates, required for erection will be set, leveled and prepared for grouting / dry packing.

16.13.1.12 Where flat bearing beams occur, bearing plates shall be set, levelled and prepared for grouting/dry packing.

16.13.1.13 Structural Steel frames shall be erected plumb and true to tolerance indicated in the relevant clause. All steel columns and beams shall be checked for plumb and level individually before and after connections are made. Temporary bracing shall be introduced wherever necessary to take care of all loads to which the structures may be subjected including erection equipment and the operation thereof. Such bracings shall be left in place as long as may be required for safety. Proper size steel cables, slings etc shall be used to avoid any damage due to accidents.

16.13.1.14 As erection progresses, the work shall be securely bolted to take care of all dead load, wind and erection stresses. No final welding or bolting shall be done until the structure has been properly aligned and approved by the Engineer.

16.13.2 CODE

Unless specified in the relevant drawing and specification, all erection work shall be carried out in accordance with the latest edition of Indian Standard Code of Practice for use of Structural Steel in General Building Construction IS-800 & AISC code wherever applicable.

16.14 ANCHOR BOLTS & FOUNDATIONS

16.14.1 The Contractor shall carefully check the location and layout of anchor bolts embedded in foundation constructed to ensure that the structures can be properly erected as shown on the drawings. Any discrepancy in the anchor bolts/foundation shall be reported to the Engineer.

16.14.2 Anchor bolts shall be provided with two nuts of approved grade of materials as per relevant IS or ASTM standard codes on upper threaded portion, one of which may be used for levelling the column base to the required elevation and one will be a lock nut. All shim stock, required for keeping the specified thickness of grout and in connection with erection of structures on foundations, crane brackets or at any other locations shall be of good MS plates and shall be supplied by the Contractor at his cost .Required no of washers shall also be provided by the contractor at his cost.

16.14.3 Where beams bear in pockets or on walls, bearing plates shall be set and levelled as part of the work. The Contractor shall carry out all grouting under column base plates or beam bearing plates, unless the grouting is specifically excluded from the scope of work.

16.14.4 HIGH STRENGTH FRICTION GRIP BOLTING

16.14.4.1 High strength friction grip bolts and nuts shall conform to IS: 3757 and/or BS: 3139/ or ASTM A325.

16.14.4.2 Installation of high strength friction grip bolts in joinrs shall comply with IS : 4000 and / or BS : 3294 and or specification for structural joints using ASTM A 325 or A490 Bolts by Research council on Rivetted and Bolted Structural Joints.

16.14.4.3 The diameter of the bolt holes will not be more than 1.5 mm larger than the nominal diameter of the bolt. All contact surfaces in a connection including those associated with the bolt heads, nuts and washers shall be free of scales, burs, dirt and other foreign matters tending to inhibit uniform sealing of the joint components. However, tight mill scale and the light residual oil coating on bolts, nuts and washers need not be removed.

16.14.4.4 All fasteners in a joint shall be tightened to a tension equal to greater than the specified proof load .either by the calibrated wrench method or the turn –of- nut method.

16.14.4.5 Tightening may be achieved by use of pneumatic powered impact winches , long

handled manual torque wrenches with or without torque multiplier or electric wrenches . A hardened washer shall be placed under the element being turned. Bolts shall be tightened at the most rigid portion of the joint, proceeding towards the free edges.

16.14.4.6 When using the calibrated wrench method, adjustable power impact wrenches and manual torque wrenches shall be calibrated to induce the bolt tension of 5% in excess of the proof load values, for each size of bolt to be used in the installation. Every wrench shall be calibrated by having it tighten a minimum three bolts of the same diameter, in a hydraulic tension measuring device. Calibration shall be repeated whenever a wrench is required to tighten a different size bolt or at least once each working day if there is no change in the bolt size. Impact wrenches shall be set so as to stall or cut at the torque effort corresponding to the prescribed fasteners tension. When manual torque wrenches are used the torque indication corresponding to the calibrating tension shall be determined and taken as the job standard. Torque measurement shall be read while the turned element is in the tightening motion. As subsequent tightening of bolts in particular assembly is liable to loosen bolts already tightened, all bolts must be 'Touched up'.

16.14.4.7 If finger tight condition is used as a string point an extra full turn shall be taken to correspond to one half turn from the snug- tight position.

16.14.4.8 Load indicating bolts or load indicating washers may be used if so approved by the engineer in writing.

16.14.4.9 Inspection after tightening of bolts shall be carried out as stipulated in the appropriate standards depending upon the method and type of bolt used .

16.15 ERECTION PROCEDURES

16.15.1 The structures shall be erected by assembling in sections on the ground and hoisting successive sections into place, or they may be built up in place by individual members at the option of the Contractor. The staging in different sections already erected shall be self-sufficient in stability for all conditions or stresses including those caused by wind. If erected by assembling in sections, not less than 50% of all bolting in place shall be done in each section before starting another section.

16.15.2 All bolts shall be drawn up tight but not to such a degree as to endanger the strength of the bolts and nuts shall be locked in place with lock nuts. Only wrenches approved by the Engineer shall be used on the work and the use of any wrench, which may deform the nut, will not be permitted. At least ten percent of the bolts in each connection as directed by Engineer shall be tested for tightness by calibrated wrenches or other approved methods free of charges. If any bolt in any connection is found to be not sufficiently tightened, all bolts in that connection shall be re-tightened and tested again without claiming any extra.

16.15.3 The Contractor shall take all precautions for the safety of labourers at the time of erection. Safety belts shall be provided to workers while working at all levels for the

erection of tower. The erected structure shall be well secured and protected at the close of the day to avoid any damage to the structure and workman.

16.16 TOLERANCES

The dimensional and weight tolerance for rolled shapes shall be in accordance with IS: 1852 for indigenous steel. The tolerances for fabrication of structural steel shall be as per IS: 7215. Tolerances mentioned below shall be achieved after the entire structure or part thereof is in line, level and plumb. The tolerances specified below do not apply to steel structures where the deviations from true position are intimately linked with and directly influence technological process. In such cases, the tolerances of process technologists//suppliers which will be indicated in the drawing.

16.16.1 Columns

Deviation of column axes at foundation top level with respect to true axes

(a)	In longitudinal direction	:	± 5 mm
(b)	In lateral direction	:	± 5 mm

16.16.2 Deviation in the level of bearing surface of columns at foundation top w.r.t. true level : ± 5 mm

Out of plumbness (verticality) of column axis from true vertical axis, as measured at column top:	
(a)For columns up to and including15 meters in height:	± 1/1000 of column height inmm
(b)For columns exceeding 15 meters in height:	± 1/1000 of column height inmm or ± 20 mm whichever isless
Deviation in straightness in longitudinal and transverse planes of column at any point along the height:	± 1/1000 of column ht in mm or ± 10 mm. whichever is less.
Difference in erected position of adjacent pairs of columns along length or across width of building prior to connecting trusses/beams with respect to true distance.	± 10 mm
Deviation in any bearing or seating level with respect to true level	± 5 mm
Deviation in differences in bearing levels of a member on adjacent pair of columns both across and along the building	± 10 mm

16.16.3 Connection of Members

Beams up to 600 mm in depth - 1.5 mm

Beams over 600 mm in depth - 1.5mm every 600mm depth to a max. of 3mm.

Where abutting parts are to be joined by bolting through cleats or end plates, the connection requires closer tolerance.

Permissible deviation from the squareness of the end is
For Beams - 1 mm per 600 mm of depth up to a max. of 1.5 mm.

16.16.4 **Depth of Members**

Acceptable deviation from the specified overall depth is
For depth of 900 mm and under - +/- 3 mm
For depth over 900 mm and under 1800 mm- +/- 5 mm
For depth of 1800 mm and over - +8 & - 5 mm

16.16.5 **Trusses and Beams**

Shift at the centre of span of top : ± 1/250 of height of truss in mm

Chord member with respect to the : ± 15 mm whichever is less
Vertical plane passing through the centre of bottom chord.

Lateral shift of top chord of truss at the : ± 1/1500 of span of truss in mm

Centre of span from the vertical plane or : ± 15 mm whichever is less
passing through the centre of supports of the truss.

Lateral shift in location of truss from its : ± 10 mm
true vertical position

Lateral shift in location of purlin true
position : ± 5 mm

Deviation in difference of bearing : i) ±20 mm for trusses
levels of trusses or beams from ii) for beams :
the true difference Depth < 1800 mm : ±6mm
Depth > 1800 mm : ±10 mm

Deviation in sag in chords and diagonals : 1/1500 of length in mm
of truss between node points or 10mm whichever is smaller
Deviation in sweep of trusses, beams etc.: 1/1000 of span in mm
in the horizontal plane subject to a max. of 10 mm

16.16.6 **Crane Gantry Girders & Rails**

Shift in the centre line of crane rail with : ± 5 mm
respect to centre line of web of crane gantry girder

Shift in plan of alignment of crane rail with : ± 5 mm

respect to true axis of crane rail at any point

Difference in alignment of crane rail in plan : ± 1 mm
measured between any two points 2 metres apart along rail

Deviation in crane track with respect to true gauge

(a) For track gauges upto and including 15 metres : ± 5 mm
(b) For track gauges more than 15 metres : ± [5 + 0.25 (S-15)] where S in metres is true gauge

Deviation in the crane rail level at any point from true level : 1/1200 of the gauge distance or ± 10mm whichever is less

Difference in the crane rail actual levels between any two points 2 metres apart along the rail length : ± 2 mm

Difference in levels between crane track rails at

(a) Supports of crane girders : ± 15 mm
(b) Mid span of crane girders : ± 20 mm

Relative shift of crane rail surfaces at a joint in plan and elevation : 2 mm subject to grinding of surfaces for smooth transition

Relative shift in the location of crane stops (end buffers) along the crane tracks with track gauge S in mm : 1/1000 of track gauge S in mm subject to maximum of 20 mm

16.16.7 **Towers:**

Out of plumbness (verticality) from the true vertical axis : 1/1000 of the height of the chimney or tower in mm .

16.17 MARKING OF MEMBERS

16.17.1 After checking and inspection, all members shall be marked for identification during erection. This mark shall correspond to distinguishing marks on approved erection drawings and shall be legibly painted and stamped on it. The match mark shall be punched on both sides of the member and the erection mark on the face of the member. The erection mark shall be stamped with a metal dye with figures at least 20 mm high and to such optimum depth as to be clearly visible.

16.17.2 All erection marks shall be on the outer surface of all sections and near one end, but clear of bolt holes. The marking shall be so stamped that they are easily discernible when sorting out members. The stamped marking shall be encircled boldly by a distinguishable paint to facilitate easy location.

16.17.3 Erection marks on like pieces shall be in identical locations. Members having lengths of 7.0 m or more shall have the erection mark at both ends.

16.17.4 In case of embedded parts, identification mark shall be visible on the exposed surface after embedding in place.

16.18 STORAGE

16.18.1 The Contractor shall have proper arrangements for storage. He shall identify the storage area where raised platform will be constructed by him. The materials will be identified area-wise and quantity-wise with proper identification marks.

16.18.2 Covered storage (Storage of fabricated materials): The Contractor shall make storage arrangements category-wise for storing fabricated materials and these materials shall be available for erection whenever called for. Fabricated materials should be stored separately according to different categories viz. embedded parts, pipe sleeves, angle frames, gratings and fabricated structural shapes. All the above materials when stacked should have proper access for inspection either by the Engineer or his authorized representatives.. The fabricated materials should be properly identified by giving identification marks. Similar precautions shall be taken to prevent the above material from rusting or any damage during the storage. Any fabricated EPs/material damaged/rusted during storage shall be rectified/repaired at Contractor's own cost.

16.19 INSPECTION, TESTING & REPORTS

16.19.1 Contractor shall give due notice to Engineer in advance of the materials or workmanship getting ready for inspection. All rejected material shall be promptly removed from the shop and replaced with new material for Engineer's approval/inspection. The fact that certain material has been accepted at Contractor's shop shall not invalidate final rejection at site by Engineer if it fails to be in proper condition or has fabrication inaccuracies which prevents proper assembly. No material shall be painted or dispatched to site without the inspection and approval by Engineer unless such inspection is waived in writing by the Engineer.

16.19.2 Shop inspection by Engineer or his authorized representative or submission of test certificates and acceptance thereof by Engineer shall not relieve Contractor from the responsibility of furnishing material conforming to the requirements of these specifications, nor shall it invalidate any claim which the Engineer may make because of defective or unsatisfactory material or workmanship.

16.19.3 Contractor shall provide all the testing and inspection services and facilities for shop work except where otherwise specified. Contractor's inspection work shall be under the control of competent Chief Inspector whose primary responsibility is inspection (reporting to Management) and not to production department.

16.19.4 For fabrication work carried out in the field the same standard of supervision and quality control shall be maintained as in shop fabricated work. The inspection and testing shall be conducted in a manner satisfactory to Engineer. Fit ups shall be examined by the quality surveyor as per the approved QA plan prior to welding the joint .All welds shall be inspected for flaws by the method described under the relevant Clause The inspection and testing on structural steel members shall be as set forth below:

16.20 MATERIAL TESTING

16.20.1 All materials conforming to a particular Indian/ASTM or any other standard as called for shall be tested as required by such standard. Proof in the form of certified test reports or mill certificates indicating the required tests have been carried out as per specification at the source as acceptable. In case these are not available, then the Contractor at his cost shall perform these tests.

16.20.2 Engineer has option to specify additional inspection or testing as he deems necessary and the additional cost of such testing will be borne by the Engineer.

16.20.3 The Contractor shall maintain records of all inspection and tests, which shall be made freely available to the Engineer and shall be submitted to the Engineer at completion of each stage of work.

16.20.4 If mill test reports are not available for any steel materials, the same shall be got tested by Contractor to Engineer's satisfaction to demonstrate conformity with the relevant specification at his own cost.

16.20.5 The tests are restricted to as per Indian/ASTM or any other standard for a particular material as required by such standard. If any additional tests are required to be done actual expenses shall be reimbursable.

16.21 INSPECTION OF WELDS

The following methods are used for the quality control of welded joints. All weld shall be grinded and thoroughly cleaned before taking up the inspection

16.21.1 Visual Inspection

Visual inspection shall be performed prior to and during and after non-destructive testing. The completed welds should be checked for correct size and profile. All weld surfaces shall be free from slag, creators, abrupt ridges and vallies, arc strikes. Prior to fabrication proper included angle, route opening, route face, alignment and cleanness of joint shall be checked and ensured. All weld shall be visually inspected to ensure the welding performed are within the acceptable limits.

16.21.2 Magnetic Particle Test (MPT)

Wherever specified, all MPT shall be as per ASTM- E709. Defects if found, shall be repaired and retested.

16.21.3 Dye Penetrate Inspection

MPT may be substituted by Dye Penetrate Inspection where the former is not feasible due to configuration. All surfaces of the welds to be inspected by DPT shall be free from scale, flux, ridges etc. The testing should be in accordance with ASTM-E165. Defects, if found, shall be repaired and retested. The cost of demagnetizing after testing shall also deemed to be included in the quoted rates of the Contractor.

16.21.4 Radio-graphic Examination

Wherever specified, Full penetration butt welds shall be radio-graphed or spot radiographed as shown in drawings /QA plans in accordance with ASTM: E-94 and as specified.

16.21.5 Ultrasonic Testing

Wherever built up sections for crane runways girders are fabricated, the T-joints of the sections shall be subjected to ultrasonic testing as per ASME, Sec-V, Article 5.

16.21.6 Acceptance Standard

The acceptable standards for weld inspection shall be as per ASME Sec VIII - Div I.

16.22 DIMENSIONS, WORKMANSHIP AND CLEANLINESS

All the fabricated embedded parts of Structural Steel members shall be inspected at all stages of fabrication and assembly to verify that dimensions, tolerances, alignment and surface finish are in accordance with the requirements shown on the approved Contractor's shop drawings and/or Engineer's drawings.'

16.22.1 The dimensions of the fit ups shall be maintained as specified in the fabrication drawings.

16.22.2 Raw material with cracks, seams, laps, lamination and heavy pitting are not acceptable. Ultrasonic testing of plates above 50 mm thick or as per the material specification shall be carried out for the soundness of material.

16.22.3 The cut edges of plates more than 25 mm for fillet weld, butt welds, and the plates used for tension flanges and webs -100 % MPT / DPT shall be carried out.

16.22.4 Welding shall be carried out as per approved WPS and QWS by qualified welders.

16.22.5 Macro etch test on welds shall be carried out 1 per structures for built up girders, columns and other heavy structures for penetration.

16.22.6 For 100% weld length, MPT / DPT on root & final pass for thickness equal to or greater than 25mm for butt welds.

16.22.7 For 100% weld length, RT shall be carried out for thickness equal to greater than 32 mm butt welds.

16.22.8 For 100% weld length RT for butt welds of rolled sections having a depth greater than 600 mm shall be carried out.

16.22.9 Minimum 10% of Fillet welds length, for either plate thickness is up to and inclusive 25 mm or fillet size is less than 10 mm (inclusive 10mm), root & final pass MPT /DPT shall be carried out.

16.22.10 On 100 % weld length, MPT/DPT shall be carried out on root & final pass, for either plate thickness greater than 25mm or fillet welds is more than 10 mm size.

16.22.11 Dimensions of all the assemblies and sub-assemblies shall be as per fabrication drawings within the tolerances specified in IS 7215.

16.22.12 For full penetration welds, DPT shall be carried out after back gouging before second side welding.100% MPT shall be carried out on low alloy steel, flame cut edges for thickness greater than 12mm.

16.22.13 Wherever built up sections for crane runways girders are fabricated, the T-joints of the sections shall be subjected to ultrasonic testing as per ASME, Sec-V, Article 5,

16.22.14 The contractor shall maintain records of all inspection and tests, which shall be made freely available to the Engineer or his authorized representative and shall be submitted to the Engineer at completion of each stage of work.

16.22.15 The contractor shall ascertain that materials conforming to the requirements of this specification only are used.

16.22.16 The contractor shall check that the welding procedures (including the electrodes, flux, current, arc voltage, speed of travel) used are in accordance with the approved welding procedures.

No	Type of defect	Acceptance criteria	Remarks
1	Cracks	Not acceptable (NA)	
2	Incomplete or lack of fusion	Not acceptable (NA)	
3	Misalignment of butt welds	0.25 x T maximum of 3 mm	T: Thickness of thinner plate
4	Reinforcement	Max reinforcement of 2 mm for t < 10 mm 3 mm for t > 10mm < 15 mm. 4 mm for 15 mm and greater	
5	Undercut	0.25 mm deep max	
6	Sharp edges	Min radius of 2 mm	

16.22.17 **Inspection of Test Failure**

In the event of any failure of structural, steel members to meet inspection or test requirements, the Contractor shall notify the Engineer or his authorised representative.

A Non Conformance Report (NCR) has to be made and got approved from the Engineer or his representative before repair is undertaken. The quality control procedures to be followed to ensure satisfactory repair shall be subject to approval by Engineer. Contractor shall maintain records of all inspection and testing which shall be made available to the Engineer or his authorized representative, for three years from the date of completion of the contract.

16.23 EMBEDDED PARTS

16.23.1 General

The details furnished below are in addition to general requirements of material supply, fabrication, inspection, testing etc specified in the earlier clauses of this specification. In general, reference shall be made to PC-E-160 for detailed specifications and requirements on Embedded Parts.

16.23.2 Material

Contractor shall supply/ use materials for fabrication as specified in the drawings. In the absence of material specification in the drawing, following guide lines are given.

Design	**Spec**	**Remarks**
Plates for pipe sleeves of wall thickness less than 20 mm	IS-2062Grade E-250, Quality –B0	
Flanges and plate EP's and threaded fasteners of 20 mm thk/ dia and more	IS-2062, Grade E-250, Quality – B0	
C.S Pipes up to 150 mm NB	1S-1239 Heavy Grade	
C.S. Pipes of sizes 200 mm NB and above	IS-3589 Grade FE 410	
Stainless Plates	ASTM-A-240 type 304L	IGC tested
Stainless pipes	ASTM-A-312 type 304L	Seamless or seam welded by automatic or manual process. Inspection as per specification.

Rolled sections and Bars

Rolled steel sections supplied by the Contractor shall be of following quality.

Rolled Section : IS 2062 E 250-Quality. A
Plates below 12mm : IS 2062 E 250-Quality. A
Plates above 12mm : IS 2062 E 250-Quality. B

16.23.3 Electrodes

All electrodes and welding wire shall be low hydrogen type conforming to ASME Sec II Part C. Brands approved by NPCIL shall only be used.

16.23.4 Material test certificate shall be in original.

16.23.5 Material supplied against these TC's should have identification stamped or stenciled on them which can be correlated with the TC's

16.23.6 All such identification markings shall be authenticated by the inspection agency which has inspected and approved the material.

16.23.7 The contractor shall furnish to the Engineer duplicate copies of all purchase order copies covering the material ordered by him for this project and also test reports.

16.23.8 The Engineer shall have the right to test random samples to prove authenticity of the test certificates produced by the Contractor.

16.23.9 Fabrication of EPs

Fabrication of EPs shall be done as per the relevant drawings and specification to avoid any possible damage to the threading on the anchor bolts before erection of the equipment, suitable protective plugs are inserted. In some cases, internally threaded sockets are embedded with top of the socket kept flush with the concrete face.

16.23.10 Welding

All welding procedures and welder performance qualification shall be carried out as per ASME Section IX supplemented by ASME Sec. VIII Div 1 / Div 2 or ASME Sec.-III as and when specified. The welding and other fabrication requirements shall be as per PC-E-160.

16.23.11 Inspections and Testing

All fabricated EP's shall be inspected as per approved QA plan. The inspection shall cover visual examination, MPT, LPT, RT and UT such that these EP's are free from burrs, cracks, nicks and surface irregularities as per previous clauses of this specification. . The DP and Radiography examination and Air Hold Test shall be carried out as per specification No. PC-E-160.

16.23.12 Air hold test / Vacuum box test

All pipe and sleeve EPs of safety systems meant for sustaining pressure or otherwise specified shall be tested for leak tightness. The test pressure/holding time shall be as per the approved Drawings. Air pressure/vacuum shall be held minimum for 10 minutes to detect leakage and pin holes.

16.23.13 Rectification

Any rework / rectification on the EP's required due to improper placement after concreting shall be carried out by the Contractor to the satisfaction of Engineer without any extra cost. This shall also include any additional inspection requirements as decided by Engineer.

16.24 PAINTING

16.24.1 Contractor shall follow the best method of surface preparation and painting system. In order to achieve the maximum durability, one or more of the following methods of surface preparation shall be followed, depending on condition of steel surface and as instructed by Engineer. Adhesion of the paint film to surface depends largely on the degree of cleanliness of the metal surface. Proper surface preparation contributes more to the success of the paint protective system:

Manual or hand tool cleaning

Mechanical or power tool cleaning

Blast cleaning.

16.24.2 Mill scale, rust, rust scale and foreign matter shall be removed fully to ensure that a

clean and dry surface is obtained. The minimum acceptable standards in case of manual or hand tool cleaning shall be St2 or equivalent, in case of mechanical or power tool cleaning it shall be St3 or equivalent, in case of blast cleaning it shall be Sa 2 ½ or equivalent as per Swedish Standard SIS-055900 / ISO-8501-1.Where highly corrosive condition exists, then the blast cleaning shall be Sa3 as per Swedish Standard. Prior to surface preparation all other contaminants, oil, grease etc. Blast cleaning shall not be performed where dust can contaminate surfaces undergoing such cleaning or during humid weather conditions having humidity exceeding 85%. Engineers reserve the right to instruct the type of surface preparation depending upon the condition of material.

16.24.3 Irrespective of the method of surface preparation, the first coat of primer must be applied on dry surface immediately and in any case within 4 hours of cleaning of surface. However at times of unfavorable weather conditions, Engineer shall have the liberty to control time period, at his sole discretion and /or to insist on recleaning, as may be required, before primer application is taken up. In general during unfavorable weather conditions, blasting and painting shall be avoided as far as possible.

16.24.4 Surfaces shall not be coated in rain, wind or in environment where injurious airborne elements exist, when the steel surface temperature is below 5^0C and the humidity is greater than 85%.

16.24.5 To the maximum extent each coat of material shall be applied as a continuous film uniform thickness free of probes. Any spot or areas missed in the application shall be recoated and permitted to dry before the next coat is applied. Applied paint should have the desired wet & dry film thickness.

16.24.6 Paint manufacturer's instructions shall be followed strictly at all times. Particular attention shall be paid to the following.

16.24.7 Instructions for storage to avoid exposure as well as extremes of temperature.

16.24.8 Surface preparation prior to painting, Mixing and thinning, Application of paints and the recommended limit on time intervals between coats.

16.24.9 Painting shall be carried out preferably by spraying. Brushes may be used sparingly at certain locations only and the brushes used for painting shall be of a style and quality that will enable proper application of paint. Type of brush shall be chosen according to its application and there shall be a minimum of brush marks left in the applied paint. Engineer reserves to instruct type of application of paint.

16.24.10 Joints to be site welded shall have no shop paint for at least 50 mm from the welding zone. Similarly steel surfaces shall not panted in areas where connection is by use of friction grip bolts. On completion of joint the surfaces shall receive the painting as specified.

16.24.11 Primer and finish paints shall be compatible with each other to avoid cracking and wrinkling. As such it is recommended that the primer and finish paint shall be from

the same manufacturer.

16.24.12 Contractor shall furnish all the characteristics of paint material along with the test certificates. All paint material shall be of first quality.

16.24.13 All Structural steel surfaces except EPs shall be given the first coat of primer at shop and the second coat after it is erected in position. Further, any abraded surface of the first coat during transport from shop to site and during erection shall be provided with a touch-up coat of the primer. The field primer shall be compatible with the shop primer.

16.24.14 The surface of steelwork to be painted shall be thoroughly cleaned of all loose mill scale, rust, grease, dirt and other foreign matter by grit blasting to white metal in accordance with IS 1477 –Parts I & II./ Swedish Standard SIS 05-5900. At places where grit blasting is not feasible, one coat of suitable approved anti-corrosive paint shall be applied.

16.24.15 The paint treatment specified shall be applied soon after completion of pre-cleaning or pre–treatment in order to prevent contamination of the surfaces in any way, either by brushing or by spraying on the thoroughly cleaned and dry surface as desired by the Engineer. Airless spraying shall be carried out unless specified otherwise by the Engineer.

Sl. No.	Structure	Surface preparation	Primer	Finish coat
1	All steel structure	Clean off dirt, rust, weld spatter & loose mill scale by shot blasting	1 coat of epoxy based approved zinc silicate primer to a film thickness of 75 microns	Hi-build Epoxy paint conforming to relevant specifications to a DFT of 200 microns

SS members shall be painted with the peel able paint, which shall be removed at the time of passivation.

16.24.16 Acceptance Criteria

a) All painted surfaces shall be uniform & pleasing appearance.
b) All epoxy and enamel painted surfaces wherever finish paint is specified shall be of uniform texture and high glossy finish.
c) All storms, splashes & spatters of paints shall be removed.
d) Surfaces shall meet the minimum specified DFT for their respective systems.

16.25 SPECIFICATION FOR FABRICATION OF STAINLESS STEEL EMBEDDED PARTS

16.25.1 SCOPE

This specification covers the requirements for the supply fabrication, inspection, testing and transportation of stainless steel embedded parts.

16.25.2 SPECIFICATION

Mechanical Engineering Drawing Standards - IS 696 (latest)
Assessment of surface roughness - IS: 3073 (latest)
Liquid penetrant inspection of metallic surfaces – ASME SEC V.
Ultrasonic Inspection of Metallic Surfaces – ASME sec V
ASME Boiler and Pressure Vessel Code Section IX Welding (Qualifications)

16.25.3 a) MATERIAL AND WORKMANSHIP

Materials which are not specifically covered & which are necessary for fulfillment of this specification shall be procure by the contractor. He shall be responsible for the correct procurement and performance of these materials, & shall replace at no extra cost to NPC any material failing to meet the requirements of the drawings & specifications.

b) WELDING ELECTRODES

Use of S.S. 308L or S.S.347 electrodes for welding SS 304L is recommended. Electrodes used on the work are to be approved by the Purchaser.

c) WORKMANSHIP

Workmanship shall be in accordance with high standards and adequate, to achieve accuracies and surface finish as shown on the approved drawings and this specification is to ensure satisfactory operation and service life of the liners.

16.25.4 WELDING

Weld shall be made by the weld procedure and welders qualified by tests in accordance with IS: 817 & 1181 and ASME Section IX as specified by the Purchaser. Welding procedure shall be prepared by the Contractor and submitted to the Purchaser for approval before the start of welding.

16.25.5 a) INSPECTION OF WELDS

All services and facilities related to testing and inspection to be provided by the Contractor. The inspection work shall be under the control of a competent Chief

Inspector whose primary responsibility is Inspection and reporting to Management. Inspection by NPC or their authorised representative shall not relieve the Contractor of any of the inspection duties called for herein.

All welds including fillet welds shall be subjected to Liquid Penetrant Test.

b) OTHER INSPECTION

The Contractor shall conduct 100% inspection & maintain record for all components and final grids system in accordance with the Approved drawings & Specification. This shall include inspection of the following:

Dimensional accuracy, surface finish, hardness, fit and alignment, workmanship, cleanliness and lubrication, completeness.

16.25.6 TRANSPORTATION

After completion of segmented fabricated line grid, it shall be thoroughly cleaned, protected from dirt, corrosion and damage and suitably braced and packed for transportation**.**

16.26 QUALITY SURVEILLANCE FOR STRUCTURAL STEEL & EPS

16.26.1 General

The Engineer shall subject all works and materials covered by this specification to inspection.

The Contractor shall provide free access in his shop during working hours for the inspection staff, designated by the Engineer, at all phases of the work and assist them where necessary in conducting the inspection. The Contractor shall expeditiously furnish all gauges, instruments and other necessary measuring equipment required for inspection of the work in the shop. The shop inspection by the inspector is intended to ensure that the material and workmanship are in accordance with this specification, but it will be not relieve the Contractor of any of his responsibilities for the product. The inspector's inspection will include, but not be limited to, the following:

16.26.2 Material

The inspector will ascertain that only materials conforming to the requirements of this specification are used.

16.26.3 Dimension and Tolerances

The Engineer will ensure and check that the structural members conform to the dimensions and tolerances as set out on the drawings and as required by the specification.

16.26.4 Welding Procedure

The Engineer will witness the welding and testing of any procedure qualification tests that are required by this specification. The Engineer will also check that welding procedure (including the electrode, flux, current, arc voltage, speed of travel) used are in accordance with the approved welding procedures.

16.26.5 Welding Equipment

The Engineer will check the welding equipment to be used for the work to ensure that it is in such condition as to enable qualified welders to follow the procedures.

16.26.6 Welder & Welding Operator Qualifications

The Engineer will permit welding to be performed only by welders and welding operators who are qualified by tests in accordance with ASME – Section IX.

When the quality of a welder or welding operators' work, appears to be below the requirements, the Engineer may require testing of his qualifications by necessary tests.

16.26.7 Welds

The Engineer will ascertain that the sizes, length and the location of all welds conform to the requirements of this specification and the approved fabrication drawings. Temporary welds used for the works shall be removed and ground flush with the original surface.

The Engineer will identify with a distinguishing mark of all parts of the joints that has been inspected and accepted.

The Contractor shall comply with all the demands of the Engineer to correct improper workmanship and to remove and replace, or correct as instructed, all welds found defective or deficient.

In the event of faulty welding or its removal for rewelding results in damage to the base metal in the judgement of the Engineer, or its retention is not in accordance with the intent of the plans and specification, the Contractor shall remove and replace the damaged materials at his own cost.

17 FIRE PROOFING OF STRUCTURAL STEEL MEMBERS USING INTUMESCENT PAINTING

17.0 SCOPE

This specification covers the requirements in general that needs to be followed for thin Intumescent Coatings used as Passive Fire Protection measure on Steel Structures of defined fire ratings, wherever applicable. The specification in general covers the requirements for selection of coating, testing, application & quality control measures

which shall be followed to use the Thin Intumescent Coatings. Wherever Intumescent Paint is proposed to be used in radiation area, the adequacy of same shall be established prior to its use.

17.1 INTUMESCENT COATING SYSTEM

The system shall comprise the 3 layers i.e primer, basecoat and seal top or decorative coat. The Primer & Seal/Top coat shall be compatible with base coat. The product proposed for use shall be manufactured by a reputed & experienced company having In-house R&D & fire test facility, unless approved otherwise.

The Coating shall be certified from reputed agencies like UL (USA) & Warrington (UK) etc. The certifying agency shall be well recognized and acceptable to NPCIL.

Unless approved otherwise, the Primer, Intumescent base coat , seal coat or decorative top coat should be sourced from the same manufacturer, to assure their compatibility.

The coating system should be such, where recoating of the coating shall be feasible if required, with approved top / seal coat for asthetic reason. It shall also be feasible to repair the same as per approved procedure from Manufacturer in case of damage to Intumescent coating.

17.1.1 PRIMER

A protective coating, usually anti-corrosive, is applied to the substrate prior to application of the basecoat. It shall also provide adequate adhesion to base coat in case of fire.

For site applied Intumescent coatings, the primer is the only part of the total system that would normally be applied in shop and balance base coat & Seal Coats are applied a site.

17.1.1.1 PRIMER SELECTION

The choice and thickness of primer shall depend on

- the In-service environment, which affect the degree of anti-corrosive protection required.
- where the primer is to be applied, and subsequent Intumescent basecoat application requires a significant delay between steel preparation in shop and final erection and completion of coating at site, the primer needs to have suitable weathering properties and durability, it must be suitable for over-coating with the intumescent coating after the appropriate time interval, and it should be sufficiently tough to be transported with minimum mechanical damage. In such cases the primer may be applied in 2 stages, if recommended, by coating manufacturer.
- the primers having poor heat resistance, and likely to have a detrimental effect on the performance of the intumescent in a fire shall not be used.

- primers based on weaker solvents than the (solvent based) intumescent, may exhibit defects such as rivelling and/or wrinkling when over-coated, and therefore shall be avoided.
- the primer shall be compatible with base coat and generally manufactured by same manufacturer, In case primer from different producer, if used with prior approval, before application of the Intumescent basecoat, the confirmation from the Intumescent manufacturer shall be obtained in writing, such that the primer and Intumescent basecoat are compatible in both ambient and fire conditions. In such case the technical data sheet for the primer, the actual primer thickness and information regarding the length of time the primer has been applied should be shared with base coat material supplier, who should then be able either to give approval for use of the primer, or to provide alternative advice.

17.1.1.1.1 COMPATIBILITY OF INTUMESCENT COATINGS WITH ZINC RICH PRIMERS

Wherever Zinc rich primers, are used to avoid problems of inter-coat adhesion. It is essential that the zinc salts, if exist due to prolonged exposure prior to application of base coat, are completely removed by washing down with clean fresh water. Where full removal of zinc salts cannot be guaranteed, the option to remove the zinc coating and re-prime the steelwork shall be followed.

Formation of Zinc salts can be prevented by applying a tie-coat over the primer at the fabrication stage. The Intumescent coating can then be applied to the tie-coat.

The application of water based intumescent coatings(if approved to use) directly over zinc rich primers is not recommended.

In all cases, the intumescent coating manufacturer should be consulted to confirm the compatibility of the priming system with the intumescent system and, where applicable, the tie coat.

17.1.1.1.2 COMPATIBILITY OF INTUMESCENT COATINGS WITH EXISTING PAINT LAYERS

Steelwork requiring refurbishment will usually be treated with an existing coating system. The existing paint coatings are likely to be old and their adhesion to the substrate, or between layers of the system, may be poor.

In such cases earlier coating shall be completely removed and the application of a primer/primer system compatible with the new Intumescent system shall be applied. The old paint shall be preferably blast cleaned to Sa 2½ standard as defined in BS EN ISO 8501-1. The blasted surface provides a suitable base for the application of the new priming system.

In situations where site conditions may make abrasive blast cleaning impractical or unacceptable, the use of manual cleaning methods may be considered. Impact tools such as chipping hammers, needle guns are reasonably effective in removing old paint coatings . Power rotary wire brushes may also be used to remove the existing paint, where a compatible surface tolerant primer is used. When using power tools care should be taken to avoid polishing the surface, and to achieve an acceptable profile or anchor pattern.

The Intumescent system manufacturer should be consulted to provide advice about surface preparation standard, with appropriate supporting evidence.

Where a manufacturer wishes to demonstrate that compliance can be achieved by the application of an Intumescent system over existing painted surfaces of known generic type and thickness, fire test evidence should be available to provide a technical justification. Agreement should be reached with NPCIL about the applicability of the test data to the circumstances which prevail on the specific site.

17.1.2 BASE COAT

The base coat shall be Solvent based Intumescent Coating of approved Dry Film Thickness, unless approved otherwise.

The Intumescent coating (Base Coat) shall be fit for use for given "In service environment exposure condition". The coatings proposed to be used in exterior condition shall be specifically certified for its suitability for exterior use. Wherever, coatings of interior members needs to be left exposed, while erection for a reasonable period of time prior to completion of enclosure, the same shall be adequately protected with suitable seal coat to avoid any damage to base coat from moisture etc.

Wherever unusual conditions given below are likely to arise, the advice of the coating manufacturer about suitability of coating, should be sought:

- If environment change in the foreseeable future.
- If some form of local pollution present. For example, high levels of sulphur dioxide could produce acidic conditions and this in turn may influence the type of seal coat required.
- If conditions vary within the building. For example, roof spaces (of an air conditioned building) subjected to periodic condensation.
- If some elements of the construction particularly vulnerable to impact damage.
- If any unusual processes likely to cause localised special conditions, such as splashing, water pooling, localised high temperatures etc.

17.1.3 SEAL COAT OR TOP COAT

A Polyurethane coating of specified thickness shall be applied over the basecoat to prevent the basecoat from environmental degradation and abrasive damage as seal coat.

17.1.4 FIRE TESTING OF COATING

Fire protection systems for steel structures are tested for their ability to retard the rate at which the steelwork heats up in a fire.

If desired by NPCIL, the coating system (Inclusive of all 3 coats, as proposed to be used) shall be independently evaluated by performing the fire testing in independent approved laboratory, before acceptance of product. The number of test samples shall be decided based on variability of coating thickness proposed to be used in the project and with mutual consent of NPCIL & Contractor. Generally, for a given fire rating and coating thickness the member having highest Hp/ A (Heated Perimeter/ Cross-sectional Area) shall be most critical and selected for testing. The cost of testing upto 2 samples are deemed to be included in the coated rate . In case if it is decided to test more than 2 samples, the cost of such additional tests (Beyond 2 Samples) including materials & labour shall be reimbursable to the contractor on actual expenditure, If the product is successfully tested and qualified. However, in case of failure of coating on testing, the cost of testing shall be compulsorily borne by the contractor.

17.2 FIRE RATING

It is defined as the ability of an element of building construction/ component for structure to fulfill, for a stated period of time, the required stability, fire integrity and or thermal insulation and/ or other expected duty in a standard fire resistance test.
The fire resistance requirement for a building is defined in terms of the fire resistance period and stated in terms of minutes (15, 30, 45, 60, 75, 90 or 120 minutes) based on standard time temperature curve as per ISO 834 / IS 3809.
The fire rating of the members shall be derived, based on relevant codal provisions or from Fire Hazard Analysis. The fire rating for each member shall be as specified and approved by NPCIL.
Wherever specified, the ability of a component or material to achieve the required fire resistance period is demonstrated by subjecting it to a standard fire test as defined in BS 476-20 /21 or BS EN 1363-1 or ASTM E119 as approved from NPCIL.
In case of Intumescent Coating the adequacy of the system under test, shall be decided based on the fulfillment of requirement, that the substrate temperature does exceed the critical temperature when heated for rated duration as per standard time temperature curve given in IS 3809.

17.3 CRITICAL TEMPERATURE

Unless specified otherwise, the critical temperature for member with 4 side exposure & 3 side exposure shall be 550 deg C and 620 deg C respectively.

17.4 FILM THICKNESS OF INTUMESCENT SYSTEMS

Primer, Base Coat and seal coat / decorative top coat thicknesses shall be as specified and approved by NPCIL.

Unless specified otherwise, the thickness of primer & seal coat shall not vary with size of member, for a given fire rating. However, the thickness of base coat may vary as per its Section Factor, fire rating, critical temperature & exposure condition etc.

17.4.1 PRIMER FILM THICKNESS

The thickness of primer shall be as specified and approved by NPCIL. In no case, the primer thickness shall exceed the upper limit, if any, specified by the coating certifiying agency or by the coating manufacturer, above which the performance of the intumescent may be impaired in a fire situation.

Wherever, steelwork delivered to site is treated with a primer applied elsewhere in shop, the compatibility of the primer applied shall be ensured with Intumesecent coating by the coating manufacturer. The correct thickness of the primer applied in shop shall be properly documented and informed to Base coat applicator, to work out the thickness of base coat from combined thickness measured after application of base coat. In case, such records are not available, the site applicator must conduct a primer thickness survey prior to commencement of intumescent application to the satisfaction of NPCIL.

17.4.2 BASE COAT THICKNESS

Unless specified otherwise, the DFT of base coat shall be derived based on charts of proposed coating material, certified from the reputed agencies like UL (Under Writer Laboratories, USA) & Warrington, UK etc. The base coat thickness shall be derived based on critical temperature of the member, its desired fire rating, its section factor , no of sides exposed to fire etc. using above certified charts. The correct film thickness must be determined for each section, in order to produce a list of section sizes with their associated film thicknesses for the entire project.

The contractor shall prepare a painting schedule of primer, intumescent coating & seal coat thicknesses required to provide fire protection to each of the steel sections to achieve the specified fire resistance periods. This schedule shall be submitted to the NPCIL for review and approval, prior to commencing the works. The schedule must include, but not be limited to, the following.

(i) Fire resistance period(s) required.
(ii) Steelwork references as noted on general drawings.
(iii) Steelwork section sizes and section factors.
(iv) Details of any partial fire protection, if provided by concrete floor slabs etc.
(v) Name of intumescent product(s) specified / selected.
(vi) Method used to determine required coating thicknesses.

The average measured dry film thickness of any face of any member should not exceed the manufacturer's recommended maximum thickness for the particular member shape and orientation.

17.4.3 SEAL COAT FILM THICKNESS

The coat thickness shall be as specified and approved by NPCIL.

17.4.4 PAINT THICKNESS ON BOLT HEADS AND STEEL TO STEEL CONNECTIONS

Where structural steelwork is treated with intumescent in shop and erected in finished condition, special provision has to be made for the coating on site of bolt heads and other surfaces not previously fire protected. As per recommendations of BS 5950 Part 8, the protection coating thickness on bolt heads and connections should be the same as that on adjacent steel sections.

Where the coating operation is delayed for any reason or where the bolts/ connections are made of a special material proper cleaning prior to coating shall be carried out. In such case a special adhesion primer may be required before application of the intumescent in consultation with coating manufacturer and approval of NPCIL.

17.4.5 FILM THICKNESS DETERMINATION

The correct thickness of intumescent coating system applied on the members shall be confirmed before proceeding to application of the decorative topcoat, as any deficiency in intumescent thickness can be best corrected at this stage.

The average DFT of the primer coat shall be properly recorded and verified in the shop. If same is not available it shall be measured physically at site. prior to application of Base Coat. After application of the intumescent basecoat, the average primer thickness should be subtracted from measurements taken on the basecoat, to establish the true intumescent thickness.

The thickness of topcoat must be confirmed in the same way as for the intumescent basecoat above.

Where decorative appearance is important and requires additional coats of finish, or where additional topcoat thickness is required to protect from severe environmental conditions, the intumescent manufacturer should be consulted to confirm that the additional thickness will not inhibit the fire resistance of the system.

17.5 IN-SERVICE ENVIRONMENT

The nature of the environment to which the coatings will be exposed may affect their durability or their performance in a fire situation, and must therefore have a major influence on the properties required of them. Environment may have a significant

bearing not only on the choice of intumescent basecoat, but also on the type and thickness of anticorrosive primer and on the type and thickness of seal coat.
For steel protection generally, BS EN ISO12944-2:1998(7) defines a number of environments in terms of 'corrosivity', based on relative corrosion rates of carbon steel, as follows:
Category C1 Very low
Category C2 Low
Category C3 Medium
Category C4 High
Category C5-I Very high (Industrial)
Category C5-M Very high (Marine)

ISO 12944 relates these categories to the composition and thickness of different protective coating systems required to provide short, medium or long term protection against corrosion, but only categories C1 and C2 would be considered typical of most thin film applications.

Examples of typical environments for each category are given in Table 17.1 below.

For C1 environments (the most common for fire protection) corrosion protection may not be strictly necessary but for site-applied intumescent coatings an anticorrosive primer may still be specified to provide temporary protection .

For all other environment categories some degree of corrosion protection would normally be included, but the specifier must also consider the type and thickness of seal coat that may be necessary to prevent degradation of the intumescent by moisture from humid atmospheres, condensation etc.

TABLE 17.1: CLASSIFICATION OF ENVIRONMENT TYPES

Corrosivity Category	Corrosion/ Exposure Rating	Examples of typical environments in a temperate climate (information only)	
		Exterior	Interior
C1	Very low	N/A	Inside heated or air-conditioned buildings with clean atmospheres. Low relative humidity and no likelihood of damp or condensation e.g. offices, schools, shops, hotels.

C2	Low	Atmospheres with low level of pollution and fairly dry climate. Mostly rural areas. Intumescent use mainly in sheltered locations e.g. under canopies.	Occasional damp or wet conditions. Unheated buildings where water leakage or condensation may occur, e.g. unheated warehousing, sports halls, plant rooms etc and in roof voids.
C3	Medium	Urban and industrial atmospheres, moderate sulphur dioxide pollution. Coastal areas with low salinity. Examples would include exposed car parks.	Constant damp atmosphere, but may be warm and well ventilated. Production rooms with high humidity and some air pollution, e.g. food processing plants, kitchens, laundries, breweries, dairies.
C4	High	Industrial areas with high sulphur dioxide pollution and coastal areas with moderate salinity. Typical areas include tank farms, petrochemical installations etc or exposed exterior surfaces of any structure in a polluted environment.	Interior of chemical plants subject to continual injection of chemical vapours or steam in the atmosphere. Constant warm and high humidity conditions such as in swimming pools. Coastal ship and boat yards.
C5-I	Very high	Industrial areas with high humidity and aggressive atmosphere. Thin film intumescents should only be used with manufacturer advice.	N/A
C5-M	Very high	Coastal and offshore areas with high salinity. Thin film intumescents should only be used with manufacturer advice.	N/A

17.6 STORAGE

The storage of all material(s) should be strctly in accordance with the manufacturer's recommendations . As a general guide, the storage temperature for all material(s) will be within the range of 5 -30°C, and any water based materials in particular should always be protected from frost. Material containers should remain unopened until needed and should be used in date order (FIFO).

All materials delivered to site must be used within the manufacturer's stated shelf life, or otherwise be approved in writing by NPCIL, if declared suitable for use by the original manufacturer.

17.7 APPLICATION OF COATING SYSTEM

17.7.1 PREREQUISITES

Application must not proceed, if the prevailing environmental conditions are outside the limits set out in the manufacturer's technical data sheets.

As a general rule, environmental conditions – air and steel temperatures, humidity and dew point – should be determined before commencement of work in the morning, afternoon and evening (if appropriate), and at other times if conditions show a noticeable change (e.g. if it starts raining). All measurements should be logged and be available for inspection at all times.

Prior to site application, all surfaces to be coated should be in a clean, dry condition and any areas not requiring fire protection or which may be exposed to overspray should be appropriately protected by masking.

The applicator should ensure that all equipment required to carry out the surface preparation and application of all components of the intumescent coating system, according to technical specification, are available and in good working order.

The applicator must ensure that all relevant Health and Safety data sheets, application instructions and method statements are available and are fully understood.

Where required, mixing should be carried out in accordance with the manufacturers' instructions. Materials taken from store should attain the temperature recommended for use before being applied.

The scheduling of the works should be such that sufficient areas are made available, allowing free access for the applicator of the intumescent coating system to apply the material to the required specification.

All work should be scheduled to ensure that the conditions required by the manufacturer (temperatures and humidity, over-coating times etc) can be met.

It is particularly important that where application is to be carried out in a partially clad building (i.e. not theoretically open to the elements), the contractor ensures that the building is water-tight and that areas where coatings are to be applied are not directly exposed to external weather conditions at any time.

17.7.2 MONITORING OF ENVIRONMENT CONDITIONS

No application should take place on site when environmental conditions – air and steel temperatures, relative humidity, dew point – are outside the limits laid down by the coating supplier, to avoid any detrimental effects on both film formation and integrity of the coating (especially water based systems) as well as on long term performance.

Typically, steel temperatures should be more than 30 C above the dew point to ensure that no (visible or invisible) moisture or condensation is present on the surface during application.

The applicator's shall monitor these conditions in accordance with the specification, and to maintain auditable records to demonstrate compliance.

17.7.3 SURFACE PREPARATION

Steel surfaces should be prepared by removing scale and rust using abrasive shot blasting to a minimum standard of Sa2½ as defined in BS EN ISO 8501-1: 2001 "Preparation of steel substrates before application of paints and related products"

Prior to the commencement of blast cleaning all steel surfaces should be clean and dry. Oil and grease contaminants, if present, should be removed by the use of suitable emulsifying degreasers, suitable clean organic solvents or steam cleaning before the commencement of blasting.

A surface profile shall be within the range of 35 – 75 micron in general suiting to primer and as specified by the Coating Supplier and shall not exceed 100 microns.

All dust and spent abrasive must be removed from the prepared steelwork by blowing down with clean dry compressed air.

17.7.4 APPLICATION OF PRIMER

The primer of specified thickness should be applied before the blast cleaned surface deteriorates.

Where the steel sections are (more normally) blasted and primed in shop, the same surface preparation standards as above would be specified, but after transportation and site storage further measures need to be included to ensure cleanliness of the primer prior to over-coating with the Intumescent basecoat. In such case the primer may be applied in 2 stages, if recommended, by coating manufacturer. The first stage primer shall be applied in shop to protect the shot blasted surface till final painting, and second coat of primer shall be applied prior to application of Intumescent Coating in consultation with coating manufacturer. The necessary surface preparation at each stage shall be carried out in line with coating manufacturer recommendations. The next stage of coat shall be applied after minimum curing time of previous coat and shall also be completed before the end date if specified by the coating manufacture.

The coating manufacturer shall ensure and certify that the primer & process followed in such a way shall not adversely affect the performance of the coating.

The primer should be applied to the specified dry film thickness and the thickness measured in accordance with the approved procedure.

When thicknesses are found to be outside the specification, the advice of the designer and/or primer and intumescent coating manufacturer should be sought and remedial action carried out as necessary.

Because different structural steel sections may require different intumescent basecoat thicknesses, it is important to ensure that all sections are correctly marked or otherwise identified for application and record purposes. Marking is best carried out after completion of priming and should not interfere with the application or operation of the intumescent coating system.

Where unprotected elements meet fire protected elements in a structure, it is normally considered good practice to overlap the fire protection onto the adjoining 500mm of 'unprotected' structural steel to limit heat transfer into the protected substrate.

17.8 QUALIFICATION OF APPLICATOR

The fire performance of a product, component or structure is dependent on satisfactory site application and maintenance. Competence in application requires an understanding of the importance of such factors as surface preparation, data sheet limitations for conditions during applications, achievement of film thickness etc. Such competence is important for any coating operation, but for intumescent paints the potential consequences of coating failure make the standard and control of application quality even more critical. Therefore, these coating shall be applied by experienced persons who know and understand not only the practicalities of coating application, but also the importance of attention to detail in the installation process. The applicator shall be certified by the Intumescent Coating Manufacturer, which shall provide confidence in the appropriate standard of workmanship being provided.

17.9 APPLICATION METHODS

The application of all coatings should be carried out fully in accordance with manufacturers' technical data sheet requirements and the applicator's method statement approved by NPCIL. These in turn must reflect fire test and assessment conditions.
While airless spray is generally the preferred method of application for most coatings, the use of this method on site may be restricted, in such cases either provision to protect adjacent buildings and the surrounding environment from overspray shall be made, or brush/ roller application may be followed if permitted as per coating manufacturer recommendations.

Where spray is not possible, a larger number of coats by brush or roller may be required, and minimum and maximum over- coating times must be observed. In such case he recommended thicknesses provided on manufacturer's data sheets, along with the maximum achievable thickness per coat by the different methods may be used as basis of application.

17.10 THINNING AND EQUIPMENT CLEANING

Thinning of Intumescent product may be permissible to aid application characteristics with prior approval of NPCIL, particularly where ambient temperatures affect product

viscosity and make a good quality finish difficult to achieve. However, excessive thinning can create sagging, drying and film formation problems, particularly where high film thicknesses are involved, so all thinning is subject to approval by the manufacturer in writing. Only thinners approved by the manufacturer may be used, if approved.

Wherever, solvent is used for equipment cleaning, the same should be approved by the coating manufacturer as being compatible with the coating system, as incompatible gun-washes left in equipment overnight can give rise to film formation defects if mixed in with the coating.

It should be noted that thinning with solvent will invalidate the wet to dry ratio given on the product data sheet and may significantly affect the VOC (Volatile Organic Compound) content of the coating, and hence its use should be limited so that it does not adversely affect compliance with environmental legislation and does not causes any health hazard to the applicator and surroundings.

17.11 HANDLING, TRANSPORTATION AND STORAGE OF SHOP-PRIMED STEELWORK

The primers used for the shop priming of structural steelwork shall be fairly tough ,resilient, and shall be resistant to mechanical damage . Further, the contractor is required to implement protective measures and appropriate care during the transport, storage and erection of steel structures.

Coatings should be sufficiently dry before handling and members should be lifted at designated lifting points or by using lifting brackets where available. The use of lifting chains in contact with coated steel is preferred to strops/webbing slings as the former cause only minimal damage that is normally easy to rectify. Member shall be preferable lifted in single lift.

The loading of trailers should be carefully planned, with timber supports positioned, where possible, in uncoated contact areas (e.g. areas to receive bolted connections). Where contact of supports with coated areas is unavoidable, members should be supported on their toes to minimise the contact area. Where thin-film prefabrication primer only has been applied in shop, members which may fill with water should be prevented from doing so by the use of covers to avoid premature breakdown under immersion. Loads are best secured with the careful use of clean chains and it is advised that the loaders wear overshoes and where possible avoid walking on coated surfaces in order to minimise contamination.

Where site storage is unavoidable, similar care should be taken in the handling and support of the coated steel using the same lifting and support points as those used in transportation. Where possible members should not be stacked and water ponding should again be avoided using localised protection where necessary. The contractor should be made fully aware of the importance of good handling practice and storage areas should be roped off with signage clearly explaining the need to avoid contamination and mechanical damage to the coating finishes.

Similar care should be taken during the erection phase, with any lifting activities making use of strategically positioned holes, lifting lugs and brackets etc to minimise damage to the body of the paintwork.

17.12 TREATMENT OF SHOP-PRIMED STEELWORK AT SITE

17.12.1 REPAIR OF TRANSIT DAMAGE

Despite the contractor's efforts to be careful, some damage to the coating will inevitably occur during handling and transportation. Further damage may occur as a result of site modifications, welding etc prior to the application of the intumescent basecoat.

The nature and extent of primer repair required will vary, dependent on

- The scale of damage incurred.
- The degree of deterioration of the damaged surface.
- The type of exposure – i.e. the service environment and the importance of the primer in providing long-term anticorrosive protection.

Even where damage to the primer is extensive, provided that the exposed steel surface has not badly corroded it may be sufficient to re-prepare the surface to an acceptable standard prior to application of the intumescent basecoat overall i.e. without reinstating the primer. This might be acceptable, for example, where conditions during application are acceptable and subsequent exposure is to an environment of corrosivity category C1, provided the intumescent coating manufacturer agrees.

17.12.2 Repair of weld damage area

In cases where on-site welding, cutting or grinding has been necessary, all affected areas must be re- prepared to a standard agreed with the intumescent manufacturer, and cleaned down to remove any resultant contamination.

In general, site welding would be carried out prior to application of the intumescent basecoat, and the welds and heat-damaged areas then re-prepared by suitable mechanical means such as power discing and/or grinding prior to reinstatement of the primer. Where welding is carried out after application of the intumescent basecoat, any heat-damaged coating should be cut back to a sound coating (distance) prior to re-preparation and reinstatement of all coats in the area of repair.

Where subsequent service is to be in an environment subject to damp or wet conditions – e.g. humid buildings without air conditioning, swimming pools etc – the anticorrosive coating may be important to the long term performance of the system and a good standard of surface preparation and reinstatement of the full anticorrosive primer thickness may be necessary. In all cases, the advice of the intumescent manufacturer should be followed.

17.12.3 Contaminated and corroded primer

Where a thin coat of primer is specified to provide protection of the blast cleaned steel during the transport and erection stages only, any delays in the build programme may

result in some breakdown of the coating and consequent corrosion (rust rashing) of any exposed steelwork. In such cases if decided by the Engineer, re-preparation shall carried out by the contractor. Depending on the extent of corrosion and the nature of the intended service environment, the decision may range from no re-preparation to manual re-preparation of affected areas followed by immediate application of the intumescent basecoat overall, or manual preparation to BS EN ISO 8501-1 St3 standard, followed by re-application of primer prior to completion of intumescent coating. Wherever, the primer forms a functional part of the long term protective system and to be used under severe exposure environment re-preparation at site shall be required.

Where the primer is in good condition but in a contaminated state, it be cleaned using suitable methods such as washing using detergent and/or fresh water pressure washing and allowed to dry before application of the intumescent basecoat. The decision of NPCIL in this regard shall be final.

17.13 SEALING OF INACCESSIBLE AREAS

If some gaps are present in structures, where moisture ingress may occur and if not sealed may cause problems such as blistering or degradation of the intumescent coating after application. Such areas need to be sealed prior to application of the intumescent basecoat, with a moisture resistant intumescent mastic or equivalent, prior to the application of intumescent basecoat.

Areas like interface between the top flange and concrete decking, may allow moisture to penetrate and this will take a long time to dry out, even if environmental conditions are satisfactory for paint application.

17.14 REPAIR PROCEDURE

During the application process and after completion of the work, repairs may be necessary to ensure that the standard of fire protection, surface integrity and finish is in accordance with the original specification. The cause of the damage or degradation should be addressed prior to carrying out the repairs, to avoid any repetition.

Before carrying out on-site remedial works, a written Method Statement for repair procedures shall be prepared by the contractor and submitted to the NPCIL for review and approval.

The contractor shall be responsible for identifying all areas requiring remedial works and for rectification in accordance with the coating manufacturer's recommendations. Issues such as compatibility, effectiveness and adhesion of combined thicknesses etc shall be considered while taking the decision.

In case, where the intumescent coating has detached due to mechanical damage, or suffered localised degradation due to water ingress, the normal repair procedure of mechanical removal of the damaged or denatured coating to a firm (unaffected) edge, followed by reinstatement of the system to the original, specified thickness shall be followed.

17.14.1Repair of film thickness deficiencies

If the dry film thickness of the intumescent basecoat or topcoat, does not comply with the nominal dry film thickness stated in the schedule of thickness, work shall be undertaken to bring the affected area up to the required thickness.

Where a decorative finish has been specified, the contractor shall make provision for the removal of all visible dirt from the surface of the coating, following erection of the steelwork.

17.14.2 Repair of damage to completed Intumescent coating systems

Remedial work on complete fire protection systems will depend on both the extent of the damage and whether or not a seal coat was applied to the original coating.
Minor damage, such as chips and scrapes, will not normally affect the performance of the material unless the service environment is wet or exposed, in such case damage may allow moisture ingress and lead to degradation of the intumescent. It is therefore recommended that minor damage should be repaired with the approval of NPCIL at the earliest opportunity, following the procedure given below:

a) In cases of damage to the basecoat, the damaged area should be cut back to a firm edge. If the primer coat is damaged, any corrosion products which may have formed should be removed and the steelwork "patch primed" using a suitable compatible primer.

b) If only the basecoat is damaged, fresh basecoat or approved repair material should be applied to match the existing thickness, taking care not to excessively overlap onto the surrounding intact seal. When the dried intumescent material matches the surrounding thickness, the recommended seal coat (if any) should be applied either to the patch repair or overall.

c) If only the seal coat is damaged, fresh seal coat should be applied, either to the localised area, or over the whole section.

In the unlikely event that major repairs are required (i.e. due to water or chemical attack), the intumescent coating manufacturer should be consulted for expert advice and repair shall be carried out as per approval of NPCIL.

17.15 HEALTH AND SAFETY PROVISIONS

Products used on site shall comply with the recommendations of manufacturers' health and safety data sheets, and that the safety of all personnel in the vicinity of the application is protected. During and throughout the application process, full compliance with all relevant Health and Safety and Environmental legislation must be demonstrated. As a minimum this includes

- Observance of all precautions and conditions for use of the coating system, as defined in the manufacturer's Product Safety Data Sheets.
- Compliance with relevant Site Storage Regulations.
- Compliance with all applicable relevant Waste Disposal Regulations, in particular for the Hazardous Waste.

17.16 DESIGN LIFE AND LIFE TO FIRST MAINTENANCE

In general the intumescent systems along with seal coat should not require maintenance before 15 years, other than for decorative purposes or where mechanical damage has occurred and shall be guaranteed for same. The thickness of the seal coat shall be decided according to above requirements.

The Coating shall be regularly and frequently inspected of the condition of the fire protection. A schedule of regular maintenance shall be prepared in service. Wherever, there is any doubt about the capability of a thin film intumescent system to provide the required long term durability, a thick film system may be advised.

17.17 QUALITY PLAN, INSPECTION CRITERIA AND METHODOLOGY

17.17.1 QUALITY PLAN

Competent contractors and applicators shall have in-house systems in place to control site work and to demonstrate compliance with specification requirements. The quality plan shall cover the sequence of activities required to deliver the specified quality of finish. This plan shall also identify the inspection stages and hold point in the process, and shall be submitted to NPCIL for approval prior to commencement of the work.

17.17.2 Measuring Equipment

The following fully calibrated and certificated measurement equipment to be available on site

- Where steel surface preparation is to be carried out at site, pictorial standards for blast cleaning and for manual / mechanical surface preparation as supplied with EN ISO 8501-1:1988 should be available to ensure the correct standard is being achieved.
- Comparator plates or Testex tape and micrometer are required to determine the blast profile, where relevant. EN ISO 8503-1:1988 and EN ISO 8503-5:2004 apply.
- Ambient temperature thermometer.
- Minimum – maximum thermometer.
- Steel temperature gauge, preferably electronic.
- Whirling hygrometer, together with a relative humidity and dew point calculator as included in EN ISO 8502-4:1999, or electronic equivalent.
- Instruments which provide ambient and substrate temperatures, relative humidity and dew point calculations automatically.
- Tape measure to check steel section sizes, if necessary.
- Wet film thickness gauges.
- Dry film thickness gauges having a measurement range appropriate to the specified dry film thickness. Ideally the instruments used should have the capability to record

thickness readings in batches, and it would aid the completeness of records if the readings were also downloadable to computer.

17.17.3 Site inspection criteria

Typically, the inspection criteria shall include the following

1. Surface preparation

- Surface preparation standard – as specified, usually against EN ISO 8501-1 or equivalent
- Surface profile minimum and maximum – as specified (EN ISO 8503-2) or equivalent
- Dust or other contamination – visual or EN ISO 8502-3

2. Application

- Air temperature, substrate temperature, relative humidity and dew point (throughout the application process) – as specified or as manufacturer's data sheet.
- Batch numbers of all products used
- Dates and times of application and compliance with recommended over-coating times from manufacturer's data sheets
- Wet film thickness checks

3. Dry film checks

- Dry film thickness survey and records
  (i) at primer stage
  (ii) after application of intumescent basecoat and
  (iii) on completion of coating

  Thicknesses at each stage should be in accordance with the specification.
- Visual appearance – as specified or in accordance with agreed standard.

NB: Dry film thicknesses should always be checked against the approved film thickness schedule, which defines the required thickness for each individual steel member. Drawings or tables showing the correct thickness for each member must therefore be available to the inspector (contractor's QA representative or NPCIL representatives) prior to a dry film thickness survey.

17.18 INSPECTION METHODOLOGY

17.18.1 WET FILM THICKNESS

Wet film thickness measurements should be taken during application using a wet film gauge. These readings will provide a guide for the applicator to ensure that the required dry film thickness of the primer/basecoat/seal coat will be achieved. Wet film thickness measurements indicate the thickness of an individual coat. Care should be taken when applying subsequent coats, as readings may be misleading due to the gauge sinking into a softened previous coat.

Information on the wet film thickness necessary to give a specified dry film thickness should be obtained from the relevant intumescent manufacturers' technical data sheet(s).

17.18.2 Dry Film Thickness (DFT)

17.18.2.1 MEASURING GAUGES

The method of Dry Film thickness determination shall use a gauge employing the electro-magnetic induction principle. Such instruments shall have a range appropriate to the specified dry film thickness and shall be calibrated on a smooth plate prior to use. Calibration should use shims appropriate to the specified film thickness.

If feasible, the instruments should be capable of storing data. Ability to print and/or download to computer.

17.18.2.2 Thickness measurement

Primer thickness may be determined either after application in shop, or on site prior to commencement of application of the intumescent basecoat.

Allowing for the thickness of primer applied, the total dry film coating thickness of the intumescent basecoat should be determined prior to the application of any specified protective/decorative topcoat(s). Measurement at this stage will more easily facilitate any subsequent corrections which may prove necessary.

If the total intumescent dry film coating thickness, allowing for the underlying primer, is found to be within specified tolerances, application of the next coat (usually a decorative and/or protective coat) can proceed.

If the total intumescent dry film coating thickness is found to be outside the specified tolerances, the procedure outlined in section 19.4 should be followed.

Indentation of the coating by the measuring instrument probe indicates insufficient hardness of the coating and measurements should be deferred. However, if programming requires coating to precede urgently, with prior approval of NPCIL, a shim of known thickness can be used to spread the load of the probe tip on the coated surface, allowing measurement to proceed before the coating has fully hardened. The dry film thickness of coating and shim together can then be measured and the shim value deducted to give the coating thickness.

Application within the specified tolerances shall also be ensured by careful monitoring of material usage and the elimination of surface defect prior to application.

When taking dry film thickness readings, it is recommended that no readings are taken within 25mm of the edge of an I section or within 25mm of the join of flange to web of an I section.

Taking the above into account, readings should be taken randomly over the remaining areas of the section with a frequency as described in clause 19.3 below.

17.18.3 Frequency of measurement

Sections should be measured in accordance with the following guidelines

A) For first 10% members or till consistent performance to the satisfaction of NPCIL is achieved, whichever is later, the thickness measurement shall done as per following frequency.

(i) I Sections, Tee Sections and Channels
Webs: Two readings per metre length on each face of web
Flanges: Two readings per metre length on the outer face of each flange
One reading per metre length on the inner face of each flange.

(ii) Square and Rectangular Hollow Sections and
Angles: Two readings per metre length on each face.

(iii) Circular Hollow Sections
Eight readings per metre length evenly spread around the section

Where members are less than 2m in length, three sets of readings shall be taken, one at each end and at the centre of the member. Each set shall comprise the number of readings on each face given by (i), (ii) or (iii) above, as appropriate.

Following guidelines for setting out a film thickness survey shall be followed.

- The contractor must provide suitable and adequate means of access, including to difficult and / or partially inaccessible areas. It is therefore important that surveys are scheduled when the fullest possible access is still available on site.
- All equipment used must be correctly calibrated, and if more than one party is carrying out thickness checks, agreement regarding calibration of all instruments must be reached before commencing.
- At least 10% of steel sections should be measured in accordance with the frequency set out in 19.3 A) above. These should include a representative mix of section sizes, and difficult access sections as well as those that are easiest to access.
- All other sections should be measured with reduced frequency with prior approval of NPCIL, unless the detailed survey (of 10% of sections) identifies a recurrent problem of thickness.
- If the detailed survey reveals a trend of unacceptable thickness, this should be taken into account when planning the remainder of the survey.
- In the worst case scenario, a full and detailed survey according to 18.3 A) above may be adopted.
- If certain faces of the sections are repeatedly found to be unacceptable (e.g. top flange or one face known to be difficult to access), the remainder of the survey should include detailed measurements of that face as well as random measurements of other faces.

- Where no unacceptable trends are identified, the remainder of the survey should consist of random readings taken at a frequency of 4-5 readings per metre length.
- Unacceptable low areas should be marked up for remedial coating by the inspector.

17.18.4 Acceptance criteria

The coating thickness acceptance criteria shall be as follows, assuming that the specified thickness is a nominal value:

(i) The average dry film thickness applied to each element shall be greater than or equal to the specified nominal value.

(ii) The average measured dry film thickness on any face of any member shall not be less than 100% of the specified nominal value.

(iii) Dry film thickness values less than 80% of the specified nominal value are acceptable, provided that such values are isolated and that no more than 10% of the readings on a member are less than 80% of the specified nominal value.

Where any single thickness reading is found to be less than 80% of the specified nominal value, a further two, or where possible three, readings shall be taken within 150 to 300 mm of the low reading. The initial reading may be considered isolated if all the additional readings are at least 80% of the specified nominal value. If one or more of the additional readings are less than 80% of the specified nominal value, further readings shall be made to determine the extent of the area of under thickness. In such cases, low thickness areas identified should be brought up to the required thickness before proceeding to the next application stage.

(iv) The average measured dry film thickness of any face of any member should not exceed the manufacturer's recommended maximum thickness for the particular member shape and orientation.

17.19 CORRECTION OF DEFECTIVE OR INADEQUATE COATINGS

17.19.1 THICKNESS CORRECTION

Wherever inadequate thickness is identified, the deficient area shall be identified and further coat(s) of intumescent product to bring the overall thickness up to acceptable standards shall be applied, prior to application of the final seal coat / decorative top coat.

However, if low thickness is not detected until after the seal coat / decorative top coat has been applied, detailed guidance must be sought from the intumescent coating manufacturer. In some circumstances – and with supporting test evidence – it may be possible to remedy the situation by the application of further coats of intumescent paint, but in the other extreme it may be necessary to remove previous coatings in order to build up the necessary fire protection from scratch.

Wherever the intumescent coating thickness exceeds the limits stated in the manufacturer's recommendations, guidance should be obtained from the manufacturer.

17.20 RECORDS AND REPORTS

Where appropriate, site records should contain the following information

17.20.1 VERIFICATION OF PRODUCT AND SPECIFICATION

Confirmation of product testing and certification, preferably in accordance with a third party certification scheme.
In addition, any contract specific requirements regarding product or specification should form part of the site records. For example, where appearance of the finish is important, and where sample paints or panels have been approved by the NPCIL, these should form part of the product dossier.

17.20.2 Contract documentation covering the fire protection product and its installation

- Substrate type (i.e. section sizes and shape, orientation, Hp/A value, etc.)
- Substrate location
- Surface preparation (i.e. degreasing, blast cleaning, etc. and standard)
- Identification of any primer and information concerning compatibility with intumescent coating.
- Evidence of third party product certification, including proof of specific testing for cellular beams and fire-engineered situations, giving relevant report reference etc.
- Declarations of Supply covering the fire protection products used.
- Batch numbers of products supplied.
- Thickness of intumescent coating required for the specified fire resistance period.
- Any variations or concessions agreed during the course of the contract.
- Design review to confirm any design changes and their effect on the specification, prior to commencement of application.

17.20.3 Quality Control Records

- All records should identify the areas inspected with reference to the relevant drawings, and should include
- Environmental conditions – air and substrate temperature, relative humidity and dew point.
- Dry film thicknesses per coat and for the full fire protection system, for each element of the structure. Measurements should include

- the member identification mark

- the number of readings taken
- maximum coating thickness recorded
- minimum coating thickness recorded
- average coating thickness
- any supplementary readings taken to establish if low readings (below 80% of specification) are limited and isolated areas.

• Variations, corrective actions or concessions carried out in relation to environmental conditions or dry film thicknesses.

17.20.4 Site Remedial Work

Where dry film thicknesses are checked after application of each coat, it is a fairly simple procedure to correct low thickness as this can be achieved by simply applying an additional coat (or part coat) before proceeding to the next stage of the specification.

If film thicknesses are not carried out with the required regularity, or if low thicknesses are not detected until the application process has been completed, it will be necessary to seek the manufacturer's advice regarding the best method of bringing the coating up to the required level of protection.

Advice may vary from complete removal of applied coatings, to selective removal of seal coat or, if supporting test evidence is available, to building up the thickness of the intumescent base coat (on top of the seal coat) followed by re-application of further seal coat.

In all cases, records must show the nature of defect, source of remedial advice and the full extent of remedial work carried out at site.

18 PRECAST CONCRETE

18.0 GENERAL

All concrete for precast concrete work shall comply with specifications for general concrete work and with the following additional requirements.

18.1 TOLERANCES

All units shall be cast as per detailed drawings furnished by the Engineer and to the tolerances indicated thereon. In the absence of any such indication, the dimensions shall not vary by more than ± 3 mm.

18.2 PLATFORM

All precast units shall be cast on a suitable yard, bed or platform with firm foundation and free from wind. The platform shall be fenced and shall have a curing tank of adequate size. The Contractor shall be responsible for the accuracy of the level or shape

of the bed or platform. A suitable serial number and the date of casting shall be impressed or printed on each unit. Each unit shall be concreted in one operation.

18.3 FORMS

The forms shall be steel forms with rigid steel frames or plywood forms if specifically approved by the Engineer. All component parts of formwork shall be so held that during concreting, there is no deformation of the form resulting in the concrete units not conforming to dimensions indicated on the drawings.

18.4 STRIKING FORMS

Side shutters shall not be struck in less than 24 hours for ordinary Portland cement after depositing concrete or as specified by the Engineer.

18.5 IDENTIFICATION MARKS

The surface of the underside or upper side, which is reinforced, shall be distinctly marked.

18.6 CURING

The blocks shall be kept at not less than 90% humidity immediately after manufacture for 24 hours and thereafter wet cured for a period of 10 days at a temperature of not less than 16°C. Rapid drying at the end of curing period shall not be permitted. Therefore they shall be stored under a safe and shaded enclosure/area. During this period, the blocks shall be handled carefully without causing any damage to corners, edges, surfaces etc.

18.7 HOISTING

The lifting and removal of precast units shall be undertaken without causing shock, vibration or undue bending stresses to or in the units. Before lifting and removal takes place, the Contractor shall satisfy the Engineer or his representative that the methods he proposes to adopt for these operations will not overstress or otherwise affect seriously the strength of the precast units. Lifting hooks shall be embedded in correct position of the unit as shown in the drawings to facilitate erection. These shall be burnt off and finished after erection if directed so, by the Engineer. The units shall be incorporated in the work in accordance with details shown on drawings or as directed by the Engineer. Cracked or damaged precast pieces during, before or after erection shall be removed and replaced with good ones at the Contractor's expense.

18.8 JOINTING

The joints shall be filled in with cement mortar 1:3 unless otherwise specified on the drawings. After jointing, the joint shall be cured for a minimum period of 10 days. All

sharp and abrupt ridges and marked depressions shall be removed by grinding or filling with cement mortar properly bonded to the concrete.

18.9 PRECAST CONCRETE HATCH COVERS

All concrete for hatch covers shall comply with specifications for general concrete work and with following additional requirements.

18.9.1 All Hatch covers shall be cast as per detailed drawings furnished by the Engineer and to suit the openings as built. The tolerances in dimensions shall be + 0 or – 3 mm unless otherwise noted on drawings. No two adjacent hatch covers shall differ by 2 mm in elevation. However, before concreting hatch covers, site measurements of actual openings at the final location of hatches shall be taken. Clearance around hatch covers shall be maintained, if required, by adjusting their overall dimensions to suit actual size of opening.

18.9.2 As far as possible these hatch covers shall be cast very near to their final locations to minimize handling of these hatch covers.

18.9.3 Each Hatch cover cast for a particular location/opening shall be properly identified by use of metal plates as indicated in drawings.

18.9.4 Each Hatch cover shall have MS edge protection angle frame along its perimeter, and vertical connecting angles, as given in detailed drawings. The frame shall be fabricated taking into consideration, the actual size of opening at its final location.

18.9.5 Care shall be taken while concreting to ensure that this framework does not get distorted during/after concreting.

18.9.6 All Formed surfaces of the hatch cover shall have F3 finish and unformed surfaces shall have U3 finish.

18.9.7 The Hatch covers/blocks will have to be transported and placed in final location by the Contractor. Rectification of hatch covers or blocks will have to be carried out by the Contractor if tolerances as specified are not achieved. The unit rate for this item shall include casting, curing, transporting to final location, erection, rectification and re-erection after painting at final location. Hoisting shall be done as per relevant clause for precast concrete given above.

18.10 SAMPLING, TESTING AND STRENGTH

Prior to manufacture trial mixes shall be prepared. When suitable mixes have been established, a sufficient number of blocks shall be cast to permit the Engineer to check the density and surface finish. If accepted these shall be standardized for all blocks to be manufactured. Provisions of IS: 1199 (Method of sampling and analysis of concrete) shall apply in addition to the requirement of this specification. The compressive cube strength of cured concrete blocks shall not be less than the specified strength at 28 days after casting.

19 MASONRY AND ALLIED WORKS

19.0 SCOPE

This chapter includes concrete block masonry, brick masonry, stone masonry, plastering, rubble soling for floors on grade, expansion and separation joints, sealing of joints, PVC/ GI water stops, flooring, skirting and dado, general area painting, steel doors, fire doors, sewer and plant drains, sanitary and plumbing items and other finishing works of the main plant structures.

19.1 APPLICABLE CODES

19.1.1 INDIAN STANDARD CODES

The following Indian Standard Codes, unless otherwise specified herein, shall be applicable. In all cases, the latest revision of the codes shall be referred to.

IS: 277 Galvanized steel sheets (plain and corrugated)-specification

IS: 383 Specification for coarse and fine aggregates from natural sources for concrete

IS: 513 Cold reduced low carbon steel sheet & strip

IS: 702 Specification for Industrial bitumen

IS: 712 Specification for Building Limes

IS: 777 Glazed earthenware wall tiles

IS: 782 Specification for Caulking Lead

I.S: 1038 Specifications for Steel Doors, Windows and Ventilators

I.S: 1200 Methods of measurement of building and civil engineering works

IS: 1081 Code of practice for fixing and glazing of metal (steel and aluminium) doors, windows and ventilators

IS: 1443 Code of practice for laying and finishing of cement concrete flooring tiles

IS: 1834 Specification for hot applied sealing compounds for joints in concrete

IS: 1838 Specifications for Preformed Fillers for Expansion Joint in Concrete Pavement and Structures(Non-Extruding and Resilient Type)

Part I Bitumen Impregnated Fiber

IS: 2116 Specifications for Sand for Masonry Mortars

IS: 2185 (part-1) Concrete masonry units — specification; part 1 hollow and solid concrete block

IS: 2212 Brick Works - Code of Practice.

IS: 2508 Specification for low-density polyethylene films

IS: 2645 Integral waterproofing compounds forcement mortar and concrete— specification

IS: 2932 Enamel, synthetic, exterior a) Undercoating b) Finishing - Specification

IS: 2933 Specification for Enamel exterior a) Undercoating b) Finishing

IS: 3462 Specification for Unbacked flexible PVC flooring

IS 3495 Methods of tests of burnt clay building bricks

IS: 3614 (Part-1)Fire-check Doors, Part I: Plate, Metal Covered and Rolling type

IS: 4351 Steel door frames - Specification

IS: 4671 Specification for expanded polystyrene for thermal insulation purposes

IS: 6248 Specification for Metal rolling shutters and rolling grills.

IS: 9862 Specification for ready mixed paint, brushing, bituminous black, lead-free, acid alkali, water and chlorine resisting.

IS: 12894 Pulverized Fuel Ash-Lime Bricks - specifications

IS: 14811Rolled copper plate, sheet, strip and foils for general engineering purposes - specification

19.2 CONCRETE BLOCK MASONRY

In general, concrete block masonry shall be used in the work. Concrete block masonry shall be of solid concrete blocks having minimum average compressive strength of 5 $N/MM^2$and density shall not be less than 1800 kg/m^3.Precast concrete block masonry shall be constructed in various sizes in cement mortar 1:4 by volume with blocks manufactured as per IS: 2185 (part-1) and as per drawings and direction of engineer using standard equipment.

If Contractor proposes to cast concrete blocks at plant site, they shall submit a detailed procedure for casting of concrete blocks and submit it for the approval of the Engineer. Work shall start only after approval of the procedure. Concrete blocks shall be tested in accordance with the provisions given in IS: 2185. Contractor shall submit inspection and test plan for approval of the Engineer. Contractor shall develop proper casting yard with curing facilities for casting concrete blocks as per direction of the Engineer.

For construction of concrete block masonry, code of practice for brick works i.e. IS 2212 shall apply.

19.2.1 MATERIAL

The following are the materials to be used in the concrete block masonry work.

19.2.1.1 CEMENT

Cement shall be as covered in per specification titled 'Plain and Reinforced Concrete'.

19.2.1.2 SAND

The sand shall consist of natural sand from an approved source. The sand shall be hard, durable, clean and free from adherent coatings, mica, shale organic matter and appreciable amount of clay. The sand shall not have deleterious impurities such as iron pyrites, alkalis, salts, coal, mica, shell etc. Sand for masonry mortars shall have particle size grading conforming to IS: 2116 – latest edition. The grading of sand for use in mortar for unreinforced and reinforced brickwork shall be within the specified limits for respective works. The fineness modulus of sand for mortar used in brickwork shall be between 2.9 and 2.1. Where grading of the sand falls outside the specified limits due to excess or deficiency of coarse or fine particles may be processed to comply with the standard by screening and or blending.

19.2.1.3 WATER

Requirement of water shall be as covered in the specification for 'Plain and Reinforced Concrete'.

19.2.2 STORAGE, HANDLING OF MATERIALS, CONCRETE BLOCKS, CEMENT, SAND, ETC.

Concrete blocks shall not be dumped at site & they shall be stacked in regularities, even as they are unloaded to minimise breakages and defacement of blocks. The supply/ manufacture of blocks shall be so arranged that at least fifteen days requirements of blocks are available at site at any time. Blocks selected for different situation of use in the work shall be stocked separately.

Cement, sand etc. shall be stored as stated in specification for 'Plain and Reinforced Concrete'.

Concrete shall be as per the specification for 'Plain and Reinforced Concrete'.

19.2.3 MORTAR

Mix for mortar shall be as specified in Schedule of Quantities. The cement and sand shall be mixed dry in specified proportion and then thoroughly mixed to proper consistency. No mortar that has stood for more than half an hour shall be used.

19.2.4 LAYING AND WORKMANSHIP

a) Blocks of same dimensions will be used on the same work except otherwise specially permitted by the Engineer. All blocks shall be sufficiently soaked but not excessively wet before laying. All blocks shall be soaked in water for a period of two hours before use and no blocks shall be used until there is complete cessation of bubbles when immersed in water. Concrete surfaces in contact with block masonry shall be hacked to remove the laitance and the surface roughened to the satisfaction of the Engineer for proper bonding.

b) All dirt and dust shall be removed from the block and the surfaces shall be moist at the time of laying.

c) No bats or cut blocks shall be used in the work unless absolutely necessary around irregular openings for adjusting the dimensions of different courses and for closers, in which case full block shall be laid at corners, the bats being placed in the middle of the courses.

d) The blocks shall be laid on a full bed of mortar and to line, level and shapes shown on the drawings. When laying, the blocks shall be slightly pressed so that mortar can get into all the pores of the brick surface to ensure proper adhesion. Cross-joints and wall joints shall be properly flushed in packed with mortar so that no hollow spaces are left. Blocks shall be handled carefully so as not to damage their edges. They should also not be thrown from any height to the ground but should be put down gently.

e) All courses shall be laid truly horizontal and all vertical joints made truly vertical. Vertical joints in one course and the next below shall not come over another and shall not normally be nearer than 1/4 of block length. Fixture, plugs, frames etc. if any, shall be built in at places shown in the drawing while laying courses only and not later by removal of the blocks already laid.

f) Care shall be taken during construction to see that edges of blocks at quoins, sills, heads etc. are not damaged. All block work shall be tightly built against columns, floor slabs, or other structural members around door and window frames with proper distance to permit caulked joints. In case of very dry weather, the surface of the block shall be kept wet to prevent drying of mortar. At the end of days work, provision shall be made to keep the surface of block work wet with water. Block work shall be added uniformly

throughout so that no portion of the work shall be left more than 900 mm lower than other. Verticality of walls and horizontality of the courses shall be checked very often with plumb bob and spirit level respectively.

g) Block work shall be laid out and arranged such that a minimum of cutting and shaping is required. Where necessary to trim block work units, they shall be cut, trimmed or broken at kerbs, or where required to a neat true line without chips on exposed faces.

h) Block work one and half blocks thick or more shall have both faces in true plane. Block work of lesser thickness shall have one selected face, in true plane.

i) Bond used shall be English bond and shall be carried throughout the work. At all corners alternate courses of brickwork shall be laid header and stretcher-wise as seen in the face so as to secure good bonds. The arrangement of bonds at quoins shall be symmetrical.

j) Blocks shall be laid in joints not exceeding 10 mm in thickness and this thickness shall be uniform throughout. Joints shall be struck flush with the face at the time of laying.

k) All joints on face shall be raked to minimum 10 mm depth while the mortar is still green to provide bond for plaster or pointing.

l) The rate of laying masonry may be up to a height of 1000 mm per day or as approved by the Engineer.

19.2.5 ENCASING OF STRUCTURAL MEMBERS

Where drawings show that structural steel columns and spandrel beams are to be partly or wholly covered with block work, the blocks shall be built tightly against all flanges and webs with all spaces between the steel and the block work filled solid with setting mortar and this mortar shall not be less than 12 mm thick.

19.2.6 REINFORCEMENT AND ANCHORAGE

a) For the walls, anchors in the form of M.S. flats or rods from columns and/or beams and embedment and any other anchoring and reinforcements, shown on drawings, shall be adequately embedded in the block work.

b) For reinforced blockwork, the reinforcements shall be as specified in the schedule of quantities. All reinforcements shall be thoroughly cleaned and fully embedded in the mortar. The thickness of the joints in blockwork containing steel bars shall be increased so as to have a minimum mortar cover of 6 mm around the bar interposed between the block and the reinforcement. Overlap in the reinforcement, if any, shall not be less than 50 times the diameter of the bar. The reinforcements shall be lapped with dowels left in R.C. columns or welded to steel stanchions. Where reinforced concrete bands are provided in the block walls, such bands shall be to the full width of the wall and the concrete of grade not lesser than M-25 shall be used. Such band will be measured separately under respective items of concrete in the Schedule of Quantities.

c) All half-block partition walls shall have M.S. reinforcing bars at every fourth course of the block work and they shall be securely anchored at their ends where the partitions bond.

d) All sash and door frames, louvers and other connections requiring weather proofing, shall be built in and the outside frames shall be cleaned out to uniform 20 mm depth and filled solidly with an approved elastic caulking compound applied with a caulking gun.

e) Scaffolding will generally be double but may be single if warranted for the particular work as approved by the Engineer. Scaffolding shall generally be erected with steel pipes. The Contractor shall take all measures to ensure safety of work and the working people.

f) Contractor shall be entirely responsible for any damage to property or injury to persons resulting from defective scaffolding, ladders and materials or otherwise arising out of default in this respect. Proper scaffolding shall be provided to allow, easy approach to every part of the work. Overhead work shall not be allowed.

19.2.7 CURING

All block work shall be kept constantly wet for at least 7 days from the date of laying of block work.

19.2.8 CLEANING

Upon completion of the masonry installation, all exposed block shall be cleaned of all mortar and cement grout incrustations and concrete stains. Protruding mortar joints shall be chipped off. As the cleaning progresses, all masonry work shall be examined and all imperfect jointing, nail holes, cracks, etc. shall be carefully pointed up and filled with mortar where required and the horizontal rakings left tooled and clean.

19.3 PLASTERING

19.3.1 WATER AND CEMENT

Water and Portland cement shall be as specified for masonry work.

19.3.2 SAND

Sand shall consist of natural sand, crushed stone sand or crushed gravel sand, from an approved source. The sand shall be hard, durable, clean and free from adherent coatings and organic matter, and shall not contain any appreciable amount of clay balls or pellets. The sand shall not contain any harmful impurities such as iron pyrites, alkalies, salts, coal, mica, shale or similar laminated or other in such form or in such quantities as to affect adversely the hardening, the strength, the durability, or the appearance of

the plaster or applied decoration, or to cause corrosion of any metal in contact with the plaster. Total of all deleterious substances shall not exceed 5% by weight. The sand shall be properly graded and of medium size with a fineness modulus of 2.0 to 2.2.

19.3.3 STORAGE OF MATERIALS

Cement and sand shall be stored as specified in specification for 'Plain and Reinforced Concrete'

19.3.4 MIX

The Mortar for plastering shall be mixed in suitable mechanical mixer in the proportion as indicated in the schedule of quantities. Water proofing compound conforming to IS: 2645 of approved manufacturer shall be added to the mortar mix for external plastering and finishes in the proportion as specified in the specification or in accordance with the manufacturer's instructions. Cement and sand shall be mixed in a dry state and then wetted and mixed thoroughly to obtain the required consistency, including machine mixing if desired by the Engineer. The mortar shall be consumed within half an hour of mixing. Any mortar for plaster, which is partially set, shall be rejected and removed from the site. Machine mixed mortar shall be prepared in an approved mixer as approved by Engineer-in-charge. Mixing for 1-1/2 to 2 minutes is normally sufficient. Only cement sand mortar shall be used in the plastering works. Cement mortar for plastering shall have a mix in the proportion of 1 part of cement and 3 parts of sand by volume unless otherwise specified in the schedule of quantities.

19.3.5 PREPARATION OF SURFACE

All joints in the masonry shall be raked out to a depth of at least 10 mm with a hooked tool made for the purpose while the mortar is still green. Surface on which plastering is to be applied shall be clean and free from all dust, loose materials, grease etc. and be well wetted for at least 6 hours before plastering. Brick/ block work shall be brushed down with a steel wire brush to remove all loose dust from the joints and thoroughly washed with water. All laitance shall be removed by chipping and roughening from concrete surfaces, which are to be plastered.

19.3.6 APPLICATION OF PLASTER

In all plaster work, mortar shall be applied with somewhat more than the required thickness and well pressed into the joint and on the surface and rubbed and levelled with a flat wooden rule to give required thickness. Plaster, when more than 15 mm thick, shall be applied in two coats, a base coat followed by the finishing coat. Thickness of the base coat shall be just sufficient to fill up all unevenness in the surface. No single coat, however, shall exceed 12 mm in thickness except in foundation / plinth work. The lower coat shall be thicker than the upper coat. The overall thickness of the coats shall not be less than the minimum thickness shown on the drawings. The undercoat shall be allowed to dry and shrink before applying the second coat of plaster. The under-coat shall be scratched or roughened before it is fully hardened to form a

mechanical key. The method of application shall be "thrown on" rather than "applied by trowel".

To ensure even thickness and true surface, patches of plaster about 100 mm to 150mm square or wooden screed 15 mm wide and of the thickness of the plaster shall be fixed vertically about 2000 mm to 3000 mm apart, to act as gauges. The finished wall surface shall be true to plumb, and the contractor shall, without any extra cost to NPC, make up any irregularity in the brickwork with plaster. All vertical edges of brick, pillars, door jamb etc. shall be chamfered or rounded off at no extra cost to NPCIL as directed by the Engineer. After the plastering work is completed all debris shall be removed and the area left clean. All corners must be finished to their true angles or rounded. Any plastering that is damaged shall be repaired and left in good condition at the completion of the job.

19.3.7 CURING

All plastered surfaces after laying shall be cured for a minimum period of seven days, by an approved method, and shall be protected from excessive heat and sunlight by suitable approved means. Moistening shall be commenced as soon as the plaster has hardened sufficiently and is not susceptible to damage. Each individual coat of plaster shall be kept damp continuously, for at least two days, and then dried thoroughly, before applying the next coat.

19.3.8 FINISH

In any continuous face of a wall, finishing treatment of any type should be carried out continuously and day break made to coincide with architectural break in order to avoid unsightly patches at junctions.

Generally, the standard finish shall be used unless otherwise shown on drawing or directed by the Engineer. Wherever any special treatment to the plastered surface is indicated, the work shall be done exactly as shown on the drawings, to the entire satisfaction of the Engineer regarding the texture, colour and finish.

19.3.8.1 STANDARD FINISH

Where punning is not indicated, the interior plaster shall be finished rough, otherwise the interior plaster shall generally be finished to a smooth surface. The exterior surface shall generally be finished with a wooden float.

19.3.8.2 NEAT CEMENT FINISH

Immediately after achieving a true plastered surface with the help of a wooden straight edge, the entire area shall be uniformly treated with a paste of neat cement at the rate of one (1) kg per sq.m and rubbed smooth with a trowel.

19.4 RUBBLE SOLING FOR FLOORS ON GRADE

The rubble shall be of approved quality. Thickness of soling shall be as shown on the drawings/schedule of quantities. The rubble soling shall be carefully hand packed as close as possible and bedded firmly with their largest side placed vertical, the broader faces downward, the smaller surface at top and voids and interstices filled in solidly by wedging with hard chips and small stones but of largest size possible to fit interstices finished with cement sand mortar 1:10 min. and thickness as indicated on drawing.

No stone shall be less than 80 mm in thickness or less than 2.8 kg in weight or more than the depth of soling in thickness and not to exceed in length or breadth twice its thickness.

When a sufficient length of soling has been laid, this shall be compacted with a three wheeler power roller and the surface shall be evened by blinding uniformly with sand not exceeding 10% silt during rolling. Places inaccessible to the roller may be compacted by hand with log hammer or mechanical tampers or by hand rollers subject to the approval of the Engineer.

19.5 EXPANSION JOINT FILLER

Standard heavy density expanded polystyrene of minimum density 35 kg/cu.m and conforming to IS:4671 shall be supplied in sizes and used in accordance with drawings. The thickness of the material shall be as indicated on drawing. Adhesive if any required to fix expansion joint filler to all forms of structure shall be supplied by the Contractor. A sample of material shall be approved by the Engineer before it is used on site. Installation shall be carried out as directed by the Engineer. The polythene sheet used for wrapping shall be minimum 250 micron thick and shall be got approved by the Engineer.

19.6 EXPANSION JOINT SEALING

Expansion joint shall be provided with PVC water stop / hot dip galvanised strips with class 2 zinc coating of width and thickness as stated in the schedule of quantities/ as shown on drawings or as approved by the Engineer. The strips shall be bent to shape indicated on the drawings and connected properly to the structure. Expansion joints shall be continuous and where two or more strips meet they shall be lapped 75 mm and brazed or welded as the case may be. Welding shall be carried out by qualified welders and shall be subject to non-destructive testing as directed by the Engineer. For the purpose of measurement, the laps provided shall be neglected.

19.6.1 G.I WATERSTOPS

The work to be done under this specification comprises the supply and delivery of Galvanized Iron water stops and accessories for the Main Plant Civil Works, all in accordance with the requirements of this specification. The Intent of this specification is to provide water stops completely in accordance with this specification ready for installation. Installation of material will be done by the contractor.

APPLICABLE CODES

IS: 277: 2003 Specification for Galvanized Steel Sheets (Plain and Corrugated)

DESCRIPTION

The GI Water stops shall be of 3.15 mm thick fabricated in accordance with IS: 277 (latest edition) and galvanized for dry film thickness of 60-100 micron

19.7 BITUMASTIC JOINT SEALING COMPOUND

Bitumastic joint sealing compound conforming to Grade A (normal) of IS: 1834 (latest Edition) shall be supplied and used in accordance with drawings. The size of groove to be sealed shall be in accordance with drawings/schedule of quantities. A sample of material shall be approved by the Engineer before its use on site. Work shall be carried out as per manufacturer's instructions or/and as directed by the Engineer.

19.8 BITUMASTIC PAINT FOR ISOLATION JOINTS

Bitumastic Paint Conforming to IS: 9862 shall be supplied and applied by the Contractor. Two coats of paint shall be applied over surfaces to form isolation joints. Painting shall be performed in accordance with the manufacturer's instructions or /and as directed by the Engineer. A sample of material shall be approved by the Engineer before it is used on site.

19.9 NEOPRENE & COPPER SHEET

Neoprene & copper sheet shall conform to the following specifications and a sample of material shall be approved by the Engineer.

19.9.1 NEOPRENE PAD

The pads shall be 100 percent Chloroprene compound known as "Neoprene" and shall be cast in moulds under pressure and heat. Compositions for pads shall meet the requirements listed below.

The pads shall meet the following physical test requirements:

PROPERTY	REQUIREMENT	ASTM TEST METHOD
Durometer (Type A), Hardness	60±5	D 2240
Ultimate Tensile PSI Min.	2500	D 412
Ultimate elongation at Break Min. %	350	D 412

HEAT RESISTANCE: 70 HRS. @ 212° F in AIR Change in Durometer Hardness , %Max Change in Tensile, %Max. Change in Elongation, % Max.	 +15 -15 -40	 D 573
COMPRESSION SET 22 HRS. @ 212° F,% Max	35	D 395 Method B
Compression set induced in vulcanized Rubber During Exposure to high energy Nuclear Radiation, % Max.	25	ASTM D-2309
OZONE RESISTANCE 100 pphm ozone in air by volume, 20 % strain 100 ± 2 ° F, 100 hrs, mounting procedure ASTM D 518 Procedure A	No Cracks	D 1149
TEAR RESISTANCE, (kgf/cm), Min.	45	D 624
LOW TEMPERATURE TEST Brittleness at - 40° F	Pass	D 746 Procedure B

Neoprene sheet shall be placed and cut suitably to shapes and sizes as mentioned in the drawings. Brazing shall be carried out as per manufacturer's specifications and by qualified persons, subject to testing as directed by Engineer.

19.9.2 COPPER SHEET

Copper strips of material type-"O" (annealed) conforming to IS: 14811 shall be used.

19.10 POLYETHYLENE SHEET

Polyethylene sheets 250 micron thick conforming to the IS 2508 shall be supplied and used to form separation joints. A sample material shall be approved by Engineer before its use at site.

19.11 SLIDING COVER STRIP

At the expansion joints, members like columns and beams have been duplicated on either side of the separation and provided with embedded parts for installing the sliding type cover strip to accommodate any building block movement. The cover strip shall be provided both at vertical and horizontal points in accordance with details shown on drawings. The strip element shall be of mild steel, plain or chequered as indicated, and of size and thickness shown on drawings and schedule of quantities and rates. The fixed edge shall be suitably attached to the embedded bearing plate, as provided, by plug weld or tap screw as shown or as instructed by the Engineer. At the sliding edge, the sliding surfaces of the embedded plate provided and underside of the cover strip shall be machined smooth. Adequate care shall be taken not to cause any damage to the strip.

19.12 **Aluminium Door, Windows and Partitions**

The type and construction of Aluminium Doors shall be similar to steel doors.

These (doors, windows and partitions) shall be of sections extruded from aluminium alloy conforming to IS: 733 . Door skin plates and stiffeners shall have a minimum 3 mm thickness. All sections shall be manufactured by Indian Aluminium Co. Ltd., All doors shall be insulated with spun mineral wool insulation for sound deadening. Doors, frames, mullions, transoms and all other exposed aluminum sections shall be alumilited, 0.015mm thickness, satin finished in natural aluminium colour. A protective transparent coating shall be applied to the sections before shipment from the factory.

Aluminium frame work for glazed partitions with aluminium glazed access doors shall be as shown in drawings, excluding supply of glass and glazing. All sections shall have a minimum 3 mm thickness and alumilited as specified above.

Aluminium door shutters, windows and partitions shall have mechanical joints with necessary fasteners.

Portions of aluminium frames which come in contact with masonry construction shall, before shipment from the factory, be protected with a heavy coat of alkali resistant, bituminous paint. Aluminium coming in contact with other incompatible metals shall be coated with zinc chromate primer.

All work shall be fitted and shop assembled to a first class job and ready for erection. Shop joints shall be made to hairlines. Work on the above, other than described, shall be carefully fitted and assembled with name joints with concealed fasteners. Wherever possible, joints shall be made in concealed locations and edges of doors. Field connections of all work may be made with concealed screws or other approved type of fasteners. All drilling of structural supports to install aluminium doors and frames shall be done and included in the work. All work shall be adequately braced and reinforced as necessary for strength and rigidity.

All work shall be erected in plumb and true to line and ready for building into masonry or other types of wall construction. Doors and frames, not properly installed or being out of line or distorted shall be reset and corrected by the contractor at his expense.

Hardware and fixtures shall be as specified under "Door/Window Schedule". All hardware shall be heavy duty and the door closers of extra heavy duty type. All exposed metal shall be satin finished aluminium. All locks shall be cylinder type. All hardware shall be approved by the Engineer before installation.

19.12.1 **Fabrication Drawings**

Before starting fabrication of all metal doors windows, etc. the Contractor shall submit detailed fabrication drawings to the Engineer for approval. Only after approval of drawings, the fabrication shall be started.

19.12.2 **Workmanship**

Workmanship shall be of best quality, free from any flaws and defects. Samples of each type shall be submitted and approval of the Engineer taken by the Contractor, before starting bulk manufacture.

19.12.3 **Transporting**

All metal doors, windows, etc., shall be packed and crated properly before dispatch, to ensure that there will be no damage to the fabricated materials. Loading into wagons and trucks shall be done with all care to ensure safe arrival of materials at site in undamaged condition.

19.12.4 **Sliding Door (Supply and Installation)**

19.12.4.1 Scope

This specification covers the design, supply of materials, fabrication, delivery and erection of MS sliding doors including all accessories as herein after specified.

19.12.4.2 General Description and Construction Details

The M.S. sliding doors shall be best quality adhering to the dimensions and details shown on drawings and schedule and as directed by the Engineer.

The sliding shutter shall be made of MS sheet steel panel of 16 gauge with siffeners made of 14 gauge MS, bent sheets of sizes & shapes as shown in the drawing.

The Heavy duty CI bracket shall be fixed to the lintel by means of coach screws of proper strength but of size not less 6mm diameter with length and spacing as given in the drawing.

The Standard Track/roller guide at top shall be supported on CI bracket at spacing not more than 1500 mm. The guide shall consist of Heavy duty 4 roller trolley fixed to the shutter by standard nut and bolt assembly of diameter not less than 5 mm.

The bottom guide shall made of MS section & it shall be fixed in the floors. This guide shall have 12 mm dia MS anchors of shape and spacing as shown in the drawing welded to it. 4 nos ball bearings16 dia ,with 16 dia stainless steel pin shall be fitted at bottom of each sliding leaf of the door.

The sliding shutter shall be provided with recessed handles and lock of approved make lockable on both sides. Each sliding leaf shall also have tower bolt.

The entire assembly of door shall be such as to have smooth & easy operations by a single person.

19.12.4.3 Erection

The doors shall be erected complete with all necessary hardware, operating mechanisms, equipment, wiring etc. complete, to suit sizes of openings. Upon completion, doors shall be in best operating condition. All installation and erection work, shall be done in accordance with the manufacturer's specifications. The Contractor shall arrange to have at no extra cost to NPCIL, the services of the manufacturer's Supervisor during erection. Any drilling to or cutting of concrete, masonry etc. shall be made good after erection of shutters.

19.12.4.4 Paint and Finish

Shutters shall be painted with one coat of red lead or zinc chromate primer in shop. Where specified, doors shall be galvanized and subsequently painted one coat of zinc chromate for adhesion of field coat. The doors shall be given final coats as given in the schedule and/or as directed by the Engineer.

19.13 STEEL DOORS AND WINDOWS

19.13.1 DOUBLE PLATE FLUSH DOORS

a) Double plate flush doors shall conform to IS: 4351 and shall be made from best quality 18 G galvanised mild steel sheets and shall be of hollow metal construction 45mm thick. Door frames shall be from the best quality 16 G pressed steel sheets. All doors shall be insulated with spun mineral wool / polyurethane foam insulation for sound deadening. All hollow metal doors shall be flush type as shown on drawings and spot welded to reinforcing members both vertically and horizontally. Reinforcing members shall be from steel sections spaced not over 150mm apart and shall extend for the full height of doors. The members shall be strictly as shown on drawing and/or as instructed by the Engineer. The doors to be provided shall be as per the drawings and shall be as per the approval of the Engineer. Generally, the doors frames shall be 45mm x 45mm x 6mm MS angle sections, shutters made of 43mm rolled steel channel section framework with stiffeners of 40mm x 40mm x 3mm M.S. angle section spaced approximately 45cms c/c, skin plate of one face of the shutter welded to the frame and stiffeners and the other face fixed with machine screws after inserting insulation material, all other details remaining as per the drawings and specifications. The mounting of the door shutters shall ensure leak tightness.

b) Built in louvers shall be stationary inverted ‘V’ blades and fabricated from 20 G cold rolled carbon steel sheets conforming to IS: 513. They shall be of sizes indicated in “Door Schedule” and completely installed in doors. Doors with vision panels shall have the openings formed into the face sheets so that no glass frame is required.

c) All bolts, counter-sunk screws, adjustable, fixing lugs, sleeves, chips etc. shall be provided for proper anchorage and support.

d) Doors and frames shall be fitted and reinforced for all hardware from templates.

e) Wherever required, provisions shall be made for fixing louvers (made of 16 G steel sheets) and/or 6 mm thick sheet glass, as shown on drawings. Glazing beads where required shall be from 20 G steel and shall be removable.

f)The steel doors shall be provided with 6 mm thick clear sheet glass vision panel of 240 mm x 340mm in each leaf.

g) The finished work shall be up to the satisfaction of the Engineer.

19.13.2 DOOR THRESHOLD

Wherever required, thresholds shall be provided as shown on drawings or schedule. Doors without threshold shall have bottom tie of approved type. Finished overall dimensions for doors shall conform exactly as shown on drawings.

19.13.3 STEEL WINDOWS, SASHES, VENTILATORS ETC.

These shall conform in all respects to IS: 1038 and IS: 1361 latest editions and as shown in the on drawings. The details as called for in the above specifications shall be applicable for coupling mullions, transom, weather bars, pivot arrangement for ventilators, fixtures and fastening etc.

All Finished overall dimensions shall conform to exactly as shown in the drawings. Individual members shall be of adequate strength and sections as per relevant IS codes and as shown in the drawings. All welds shall be dressed flush on all exposed and contract surfaces.

Where composite unit openings are shown in the drawings, the individual window units shall be joined together with requisite transoms and mullions and/or as shown in drawings. All projected out window shall be outside glazed, fixed with putty or metal glazing beads as shown on the drawings and/or specified under Schedule of Items. Where aluminium glazing beads are specified they shall be extruded aluminium channel 17/32" X 7/16" X 3/32" unless otherwise shown on drawings.

19.13.4 FITTINGS FIXTURES AND HARDWARE

Hardware and fixtures shall be as specified in "Door Schedule" and of best quality from the manufacturer as approved by NPCIL.

The Hardware and fixtures shall be of heavy-duty type and the door closers of extra heavy-duty type. Finish shall be dull bronze finish and/or anodised aluminium as specified in "Schedule of Items", except butts for interior and door closers. Interior butts shall be prime coat finish and door closers sprayed bronze.
The Contractor shall submit samples of each type of hardware and fixture to the Engineer for approval. The approved samples shall remain with the Engineer for comparing with the actual supply and only those conforming to the approved samples shall be accepted.

The Door closers shall be from approved manufacturer with ISI certification and manufactured and installed as per relevant IS Codes and good Engineering practices.

19.13.5 SHOP PAINT

The shop paint shall be best zinc phosphate primer of approved manufacturer. Before assembly, all surfaces shall be given a coat of rust resisting paint. After assembly, all exposed surfaces shall be cleaned and smoothened and two coats of approved make enamel paint shall be uniformly applied over the surface.

19.13.6 INSTALLATION

In general, the fixing of steel doors, windows, ventilators, louvers, etc. shall conform to IS: 1081 latest edition, and as shown in the drawings and 'DOOR SCHEDULE'. The Contractor shall assemble and install all steel doors, windows, sashes, fixed metal louvres etc. including transom and mullions for composite units in respective places as shown in then drawings. Keeping proper lines and levels, and in approved workman like manner. The installation shall be done according to the instructions of the manufacturer, and/or as approved by the Engineer. Care shall be taken to see that framework is not loaded with the weight of masonry or used for securing scaffolding or other temporary staging. Temporary struts may be fixed across the widths preventing sides bulging inwards, which should not be removed till brickwork is set. Care shall be taken to protect the hinges from getting embedded in the mortar while filling the gap between the frame and the masonry opening. If necessary, the installation shall have to be carried out under the supervision of the manufacturer's staff. The Contractor shall take every precaution against damage of the components during installation. Necessary holes, chases, etc. required for fixing shall be made by the Contractor without any extra charges and finished as per original, after installation.

After installation of steel doors, windows etc. all abrasions to shop coat of paint shall be retouched and made good with the same quality of paint used in shop coat. Rates quoted shall also include minor rectification at site if required such as welding of fixtures, making screw holes and providing screw and rectification of dents formed in the doors and shutters.

19.14 FIRE PROOF DOORS

19.14.1 SCOPE

The work under this section shall include supply and/or erecting and installing fireproof doors as shown in approved manufacturer's drawing with all material complete.

The scope of work shall also include assembly and erection of composite types of fireproof doors. Supplying and/or fixing of all door accessories and hardware and are also included in the scope.

The fire doors shall be single / double leaf fire rated hollow galvanized MS pressed

steel flush doors conforming to BIS : 3614 (Part-1), along with frame at all elevations, with or without removable panels and with or without panic bar having fire rating as approved. The Fire doors shall be of galvanised MS sheets for frames and leaves, mineral wool / PUF/ any other fire retardant insulation material, mastic caulking and grouting the frame, reinforcing and insulating the shutters with fire retardant material including heavy duty SS hinges, thresholds, fittings complete with frame, fittings, fixtures, handles, aldrops, latches, necessary access control hardware, necessary gaskets, drop seal, smoke seal, etc for air tightness. The vision panel shall be of borosilicate float glass or approved equivalent of size 240 mm x 340 mm or as specified in drawing with same fire rating including necessary beading, mastic cement, cleaning and also all hardware as per door schedule including one coat of approved primer and two coats of approved fire resistant / intumescent paint as necessary as per drawings, door schedules and specifications.

All the doors shall have provisions for installation of access control devices such that these devices if installed at a later date shall not impair the basic functions of the door as a fire barrier. These provisions shall be in the form of providing a separate steel plate of approved dimensions of the same material as the parent door, fixed to the main door at an approved location.

The fire rating of the door shall be clearly embossed on the doors.

The testing of Fire proof doors shall be carried out as per BIS:3614 Part-II standards for approved fire rating, for full size door with vision panel and all fittings and fixtures shall be conducted at approved laboratory for 3 nos. of doors. One door shall be tested from the first lot before shipment to site and remaining at random from balance supply.

19.14.2 DRAWING

Fire proof doors shall be as manufactured by manufacturer qualified by NPCIL. Before starting fabrication of all fire proof doors the contractor shall submit detailed fabrication drawings to the Engineer for approval. The fabrication shall be started only after approval of drawings.

19.14.3 APPLICABLE CODES

Following are some of the important I.S.Codes as relevant to this section:

I.S: 3614 - Fire doors
I.S: 1038 Steel door, windows and ventilators
I.S: 4351 - Steel door frames
I.S: 1081 - Code of practice for fixing and glazing of metal (steel and aluminium) doors, windows and ventilators.

19.15 ROLLING STEEL SHUTTERS

19.15.1 SCOPE

This specification covers the design, supply of materials, fabrication, delivery and erection of rolling shutters with motor drives and/or manual operation including all accessories as herein after specified.

19.15.2 GENERAL DESCRIPTION OF CONSTRUCTION DETAILS

The doors shall be of best quality rolling steel service doors adhering to the dimensions and details shown on drawings and schedule.

a) Slats for shutter shall be made from tested bright cold rolled, annealed M.S. Strips, not less than 18 gauge thickness, machined, rolled at 75 mm rolling centres, interlocking with each other. The profile will be such as to prevent excessive deflection under specified wind load.

b) Rolling grills shall be constructed out of 6 mm dia. rods at 35 mm centres running horizontally flexible connected with vertical links spaced not more than 200mm centres. Alternatively, rolling grills shall be made from perforated slates of approved design reinforced with 6mm dia. rods.

c) End locks shall be heavy type and provided at each end of alternate slats unless specified otherwise in the schedule.

d) Bottom bars shall be finished with two angles not less than 6mm thick for external shutters. When shown on drawings a flexible weather strip shall be applied to make tight contact with the floor.

e) Steel guides shall be of angle frames secured to the metal frames or masonry at openings. Guides shall be of such depth as to retain the shutter under a wind pressure of 150 kg/sq.m. or as specified in IS: 875 for the double rolling steel shutters a central guide which is movable by sliding by mechanical arrangement shall be provided. Material for guide channels shall conform to IS: 513 latest editions.

f) Shafts shall be of steel pipe of sufficient size to carry the torsional load with a maximum deflection of $1/360^{th}$ of span. Grease packed ball bearings or bushings shall be provided for smooth trouble free operation.

g) Hoods shall be formed of not less than 20 gauge steel, suitably reinforced to prevent sag.

h) Locks shall be slide bolt and hasp, or cylinder lock operable from one or both sides. Provision to securing hand chain with pad-lock, provision for removable handle for hand cranks etc. shall be made as described in Schedule or as desired by the Engineer.

i) Power unit shall be suitable for 3 phases, 50 cycles 400 Volt AC power supply and shall be higher floor or wall mounted unit. The motor shall be of sufficient capacity to move the shutter in either direction at a speed of 0.3 metres per minute. The electric motor shall be 3-phase 415V AC, 50Hz. TEFC enclosure complying with NPCIL

specifications PB-E-293. In addition to the gear motor each standard power unit shall include a magnetic brake, a reversing starter with built – in overload protection, a geared limit switch and one push button station located inside the building unless otherwise stated in schedule of drawing. It is desirable that the bottom bar of motor operated doors shall be provided with a sensitive edge electrically connected to stop the travel of the door on meeting an obstruction.

j) Operating chains shall be of tested quality, heavily galvanised and with all ends rounded to assure smooth operation and hand protection.

k) Reduction gears shall be high strength grave cast iron; machine moulded from machine cut patterns.

l) Bracket plate thickness shall be minimum 3.15mm.

19.15.3 OPERATION

19.15.3.1 MANUALLY/ MECHANICALLY OPERATED SHUTTERS

Manually operated shutters shall be easily operable by one person. In general, manually operated shutters shall be push pull type for openings up to 9 sq. m. in area. Larger shutters shall be either chain or gear operated or crank and gear operated. The crank handle shall be removable. All shutters shall be lockable from one or both sides as described in Schedule or as desired by the Engineer.

19.15.3.2 POWER OPERATED SHUTTERS

These shall be operable from a push button station conveniently located beside the door or as shown in the drawings. One emergency hand chain/crank operation shall also be provided for use in case of failure of the electric system. Where called for in schedule, externally mounted shutters shall be operated by control mechanism located inside the building. Limit switch shall also be included. The power drive shall be so designed that electric motors may be removed without affecting operation by means of an auxiliary endless chain gear operator.

Motor driven shutters shall have the following compulsory operation system. Mechanism shall be galvanised and of tested quality and shall be guaranteed to prevent chain from leaving wheel and of sufficient length to terminate approximately 600 mm above floor. Reduction gear shall be extra strong, cast without teeth for machine-finished pattern. Necessary lubrication shall be provided.

19.15.4 ERECTION

The shutters shall be erected complete with all necessary hardware, operating mechanisms; equipment, wiring etc. complete, to suit sizes of openings. Upon completion, shutters shall be in best operating condition. All installation and erection

work, shall be done in accordance with the manufacturer's specifications. The Contractor shall arrange to have at no extra cost to the owner, the services of the manufacturer's Supervisor during erection. Any drillingor cutting of concrete, masonry etc. shall be made good after erection of shutters.

19.15.5 PAINT AND FINISH

Shutters shall be painted with one coat of zinc phosphate primer and two coats of approved synthetic enamel paint unless specified otherwise.

19.15.6 ELECTRICAL WORK

All electrical work shall be in strict accordance with the latest Indian Electricity Rules or other approved codes as specified by the Engineer**.**

19.15.7 SHOP INSPECTION AND TEST AT MANUFACTURER'S WORK

After completion of the manufacture of different components of the rolling shutter, drive and other components/ accessories of the rolling shutter, arrangement for shop inspection by the Engineer shall be made to check the conformity with approved shop drawings.

If desired by the Engineer tests shall be carried out at the manufacturer's works in accordance with the approved standards in the presence of the Engineer. Four copies of all the test certificates shall be submitted for approval, if required by the Engineer.

19.15.8 ACCEPTANCE TEST AT SITE

After the equipment has been installed at site the contractor shall carry out performance tests to the satisfaction of the Engineer, after which the shutters shall be accepted. The doors shall be smoothly operable under all ambient conditions. All controls and locking devices shall have fault free performance.

19.15.9 DRAWINGS

The manufacturer / supplier of the rolling shutters shall be got approved by NPCIL before carrying out the work. Prior to fabrication of rolling shutters, the contractor has to measure exact size of the structural opening at site. Fabricated door shall suit to the actual structural opening at site. The Contractor then shall prepare necessary drawings/ detailing of the rolling shutters as per specification, which they intend to supply and seek prior approval of the Engineer. The contract drawings to be furnished by the Contractor shall include but not be limited to the following:

a) Foundation and anchorage drawings for the equipment and drive and their auxiliaries with similar detailed drawings for other equipment.

b) Dimensioned assembly and sub-assembly drawings showing plans and sections of the equipment, instruments and safety devices etc. clearly indicating limiting

dimensions, if any.

c) Complete assembly drawings wiring and connection diagram for all instruments, gauges and controls.

19.15.10 GUARANTEE

The design of the rolling shutter shall be made for withstanding a wind pressure of 150 kg/m2. The Contractor shall give one year's guarantee against operational and material defects and for safety against the design wind pressure.

19.15.11 APPLICABLE CODE

IS: 6248 - Metal rolling shutters and rolling grills.

19.16 CHAIN LINK FENCING AND DOOR

19.16.1 SCOPE

This specification covers the fabrication and installation of wire-link fencing and doors with necessary hardware.

19.16.2 GENERAL

The Fencing shall be constructed of M.S. pipe/ angle frame with welded wire-mesh cladding.

The chain-link doors shall have either single or double shutters of sizes as indicated in the 'Door Schedule'.

The door shutters shall be constructed of M.S. angle frame with welded wire-mesh cladding. The door frame shall be made of M.S. angles built in the wire link partition or in the brick masonry.

19.16.3 SHUTTER FRAME

The frame for door shutter shall consist of two vertical and three horizontal members securely welded together. The shutter frame shall have pivoted arrangement for swing.

19.16.4 WIRE LINK

Welded wire mesh of 50mm x 50 mm with mesh made of 3mm diameter from standard manufacturer shall be used. The mesh shall be made from high tensile wires welded at every intersection. The welded wire mesh shall be positioned inside the angles of the framework. The wire mesh shall be properly stretched and welded to the angle frame.

19.16.5 DOOR FRAME

The door frame shall be made of 80 NB GI Pipe and M.S. angles with necessary provisions to revive hardware. The finished work shall be strong and rigid, neat in appearance and free from defects. Doors shall not have more than 6 mm clearance at jambs & head and not more than 3 mm clearance at the meeting stile edges for pair door.

19.16.6 INSTALLATION

Door frames and shutters shall be assembled and installed such that frames and doors are set plumb, square, level, and at their proper location. All necessary hardware including hasp and staple for locking, pull handle, etc. shall be furnished. The frame shall be securely anchored with hold fasts at brick masonry openings.

19.16.7 CLEANING AND PAINTING

All welds shall be dressed flush on all exposed and contact surfaces. Steel frame members, wire-mesh and welds shall be cleaned of all rust, scale, grease and other foreign matter and then given a prime coat of zinc phosphate primer.

The finished work shall be to the satisfaction of the Engineer-in-charge.

19.17 FLOORING, SKIRTING AND DADO

19.17.1 SCOPE

This specification shall include furnishing of all labour, materials, and equipment, necessary to complete the different types of flooring work as shown in the drawings. Work under this section shall include:

i) Indian Patent Stone Floor (IPS)
ii) Concrete floor with metallic hardener
iii) Tiled floor (with underbed)
iv) Glazed tiled flooring and dado
v) Vacuum dewatering floors with ironite finish
vi) Cement Skirting and dado In-situ
vii) Precast tile skirting
viii) Ceramic tile flooring and dado
ix) PVC tile floor
x) Acid and/or alkali resistant floor
xi) Kota stone flooring and skirting
xii) Vitrified polished tile flooring and skirting
xiii) Granite flooring and dado/ cladding
xiv) PVC Electro static conductive flooring
xv) Precast cement concrete interlocking paver blocks

Any integral finish to the base concrete indicated in drawing or schedule like finishes F1, F2 & F3 for formed surfaces and finishes U1, U2 & U3 for unformed surfaces shall be deemed to have been provided in the structural slab.

19.17.2 PREPARATION OF BASE

For all type of flooring, skirting and dado work, the base cement concrete slab or the masonry surface shall be cleaned of all dirt with water and hard brush. If required the base surface shall be hacked or otherwise roughened to obtain a good bond. The surface shall be clean, free from grease, oil, dust, loose particles, etc. and thoroughly soaked with water to prevent absorption of mixing water from the base course. Before placing the under bed, and excess standing water shall be mopped out. Before laying the flooring, skirting or wall finish, approval of the Engineer shall be obtained as to the acceptability of the base.

19.17.3 INDIAN PATENT STONE (IPS)

a) Preparation of base shall be as specified above. The patent stone floor unless otherwise stated shall have a minimum thickness of 40mm. The under-bed shall consist of cement concrete with 10mm down, clean, well-graded, hard approved stone chips and clean, sharp, coarse sand. Elongated or thin flake like fragments of stone shall be avoided. The proportion of the mix shall be 1 part cement, 1parts sand and 2 parts stone chips by volume.

b) Water content shall be minimum, sufficient to give a workable consistency, which will allow finishing without excessive trowelling. Generally water cement ratio of 0.4 should suffice. The floor shall be cast in panels not exceeding 5 sq.m. in area and no side more than 2.5m long. Panels shall be made using aluminium strips. The casting sequence shall be in a chequered board fashion, no two adjacent panels being cast before the contraction of the previous one has taken place. The edge of each panel into which the floor is divided shall be supported by flat bars of steel or wood duly oiled to prevent sticking. The bars shall be removed before filling in adjoining panels. At least 48 hours shall elapse before the concreting in the adjacent bay is commenced. After laying, the under bed shall be levelled, compacted and brought to proper grade with a screed or float.

c) Then a layer of minimum 6mm thickness shall be laid over the green under bed and trowelled smooth with a mixture of cement and sand (1:1 by volume). The under bed and topping shall be completed in one operation.

d) The topping shall be trowelled smooth to the satisfaction of the Engineer. Any marks of trowel shall be mopped with a soft cloth to give a clean, even and smooth surface.

e) Where specified on drawings the thickness of the under bed shall be adjusted to make the total thickness as shown in the drawings.

f) When polishing is to be done, if specified in the drawings and/or “Schedule of

Quantities" it shall be done in a manner as approved by the ENGINEER.

19.17.4 CONCRETE FLOORING WITH METALLIC HARDENER

19.17.4.1 GENERAL

The specified hardening system shall be applied by a specialist applicator certified by the manufacturer of the system strictly as per the written method statement submitted by the manufacturer.

a) THICKNESS

Unless otherwise specified the metallic hardener finish shall be of 12 mm depth over 28 mm thick concrete base. Total thickness shall be 40 mm thick.

b) MATERIAL

The hardening compound shall be uniformly graded iron particles free from non-ferrous metal impurities, oil, grease, sand, soluble alkaline compounds or other injurious materials. Actual samples shall be tested prior to use at site.

c) MIX

Proportion of metallic hardener shall be as specified or as indicated by the manufacturer. However, in absence of any such direction, 1 part metallic hardener shall be mixed dry with 4 parts of cement, by weight. To this mixture 6 mm nominal size stone chips shall be added in proportion of 1 part cement (mixed with hardener) to two parts of stone chips by volume and uniformly mixed. Minimum quantity of water shall be added to make it workable.

d) LAYING

The concrete floor shall be laid as per the specification of Concrete work and levelled up to the required grade. The forms, if any, shall remain sufficiently projecting to take the finish. The surface shall be roughened by wire brush as soon as possible.

12 mm thick finish shall be laid while the concrete under bed 28 mm thick is still very green within 3 hours of laying the latter. The finish shall be of uniform thickness and free from trowel marks, pin hole, etc. The topping layer shall be pressed firmly and worked vigorously and quickly to secure full bond with the concrete base. The surface shall be smoothened with steel trowel.

The finished floor shall be cured for 7 days by keeping it wet.

19.17.4.2 SUBSTRATE CONDITION

The grade of concrete for substrate should be preferably M20. At the time of construction of floor, as soon as the plasticity of the mix is reached, the surface of the

freshly poured concrete shall be smoothened out and shall be flattened out with the vibrating straight edge. This concrete should be dense and compact which could be obtained by adding plasticizers like Plastiment BV 40 or equivalent (0.3% by weight of cement or it may vary due to site condition). It is preferable to use a mechanical trowel for smoothening operation.

19.17.4.3 **LAYING**

The ready mix non-metallic hardener compound shall be spread over the newly laid smooth concrete surface at a stage when a nail mark of 3-4mm shall be obtained at standard pressure. The spreading shall be done by hand or with a suitable apparatus @ approximately 6.0 kg/m² for a thickness of 3 mm surfacing.

Time should be given till the mixture has been uniformly moistened by the surface water contained in the green concrete. The surface shall be smoothened out with a mechanical trowel which shall be maintained perfectly flat, operating at a low speed.

Immediately, after the flooring surface is finished, it shall be protected from rapid drying. As soon as the floor is hardened sufficiently, it shall be kept moist for at least 3 days by wet gunny bags.

19.17.5 VACUUM DEWATERING SYSTEM OF FLOORING WITH IRONITE FINISH

19.17.5.1 GENERAL

a) Thickness, material and mix shall be as per specification on “concrete flooring with metallic hardener” included earlier in this chapter.
b) Grading of constituents of concrete and slump shall be as per manufacturer’s recommendation.

19.17.5.2 JOINTS

The concreting shall be done in bays as recommended by the manufacturer. In absence of which bays of 20 M x 20 M shall be followed. Aluminum strips shall be provided for separation of panels.

19.17.5.3 LAYING AND WORKMANSHIP

All arrangements including installation of guide rail, positioning of pipes for water and drainage, shall be placed either by pump or manually. Poker vibration and tremix surface vibrators are used sequentially to obtain proper leveling and compaction. Suction mat shall be used with proper arrangement of suction holes to vacuum pump, draining line, etc. so as to achieve recommended pressure by the manufacturer on the concrete surface. Proper care shall be taken to drain out excess water from concrete. Normally concrete shall be subjected to suction for a period of 1 to 2 min per centimeter thickness depending on the particle shape of the mix. Immediately after vacuum dewatering the surface is power floated with skim floater. To obtain smooth surface

skim floater fitted with troweling blades shall be used. The floating and troweling operation shall be completed within one hour for concreting.

19.17.6 TILED FLOOR WITH UNDERBED

19.17.6.1 GENERAL

The tiles shall be (a) plain cement tiles (b) plain coloured tiles, and (c) terrazzo floor tiles, conforming to IS: 1237 – latest edition and of dimensions as shown of under bed drawings. The wearing face of these tiles shall consist of plain or coloured cement for items (a) and (b) and white or coloured cement and marble chips for item (c), size, colour and proportions of which shall be as per instructions of the Engineer. All angles of tiles shall be right angles, and the colour and texture of the wearing face shall be uniform throughout its thickness, which shall not be less than 6mm. Colour shall be non-fading and lime-proof and the face of tiles shall be plane, free from cracks, depressions and projections and reasonably parallel to the back face.

The portion of cement to aggregate in the backing of tiles shall not be leaner than 1:3. Colouring material wherever used shall not exceed 10% by weight of cement used in the mix.

19.17.6.2 MATERIALS AGGREGATES

a) Aggregates used for mortar for fixing the tiles shall conform to IS: 383 – latest edition.

b) The cement used for fixing the tiles and cement grouting shall conform to IS: 12269 latest edition – or white cement of approved quality.

c) Pigments incorporated in mortar or used for Pigments grouting shall be stable and non-fading.

d) Water shall be clean and free from oil, water acid, alkali and organic or vegetable matters.

e) Aggregates used for the terrazzo topping aggregates shall be marble chips of size varying from for 1mm to 20mm. The proportioning of chips of terrazzo various grades shall be as per directions topping of the Engineer. Marble powder used for the topping shall pass through IS Sieve No. 30.

f) The delivery of tiles shall be so arranged as to minimise handling. Adequate precautions shall be taken to prevent accidental damage to tiles while unloading. The tiles shall be stored under cover to prevent exposure to dampness, sun, rain, accidental injury or straining.

19.17.6.3 LAYING AND WORKMANSHIP

a) Preparation of the base shall be as laying specified under 1.28.2 above. The surface shall be thoroughly soaked with water after soaking with water, the under bed of

thickness as shown on drawings shall be evenly as smoothly spread. The mortar for under bed shall be composed of 1 part cement and 3 parts sand. The under bed shall be well consolidated and brought to proper grade, to a level below the finished floor level equal to the thickness of the tiles. The tiles shall then be placed before the under bed has set.

b) The tiles shall be soaked in water for 10 to 12 minutes and allowed to dry for the same length of time. The under bed shall be thoroughly moist, and Portland cement shall be hand-dusted over this immediately before the tiles are laid. The tiles shall then be placed upon and firmly pressed on the under bed until exactly even with the finished floor level. The joints shall be carefully grouted and filled with cement grout of the same colour as the matrix of the tiles. The joints shall not be more than 1.5mm wide.

c) The setting of tiles shall be so done that minimum rubbing is required later on. Initial grinding and polishing of tiles shall be done in the shop and the final rubbing and polishing shall be commenced only after the floor as well as the joints have set and done in a manner approved by the Engineer. Chequered or grooved tiles whether plain or terrazzo, shall always be polished by hand.

d) All work shall be cleaned thoroughly and left in an acceptable condition on completion. No harsh abrasive cleaning powders, acid or steel wire shall be used for cleaning the tiles. Curing shall start on the next day after laying and shall continue for 14 days. The entire work of laying, polishing, finishing and cleaning etc. shall conform for 14 days. The entire work of laying polishing, finishing and cleaning etc. shall conform to IS: 1443 latest edition. Tiles shall be selected and used, such that colour of each area of the floor remains uniform.

19.17.7 GLAZED TILE FLOORING AND DADO

19.17.7.1 MATERIALS

The glazed tiles shall be 6 mm thick premium quality tiles conforming to IS 15622 of approved shade and make. The top surface of the tiles shall be glazed with a mat finish of uniform colour and texture and free from flaws, cracks, chips craze, specks, crawling or other imperfections. These shall be sound, true to shape with true and straight edges, non-absorbing and non-fading having a texture, dense and homogenous. The edges and the underside of the tile shall be completely free from glaze so that these may adhere properly to the surface below. The tolerances shall be +1.5mm for length and breadth and +0.5mm for thickness. Before bulk supply, the contractor shall give samples of tiles to the Engineer for approval. Bulk supply shall only be adopted if it conforms in all respects to the approved samples kept with the Engineer.

White cement, sand, pigments and water shall be as specified.

19.17.7.2 HANDLING AND STORAGE OF TILES

The delivery of tiles shall be so arranged as to minimise handling. Adequate precaution shall be taken to prevent accidental damage to tiles while unloading and these shall be

stored under cover in a manner approved by the Engineer.

19.17.7.3 LAYING AND WORKMANSHIP

a) Preparation of base shall be as specified. The under bed as shown in the drawings shall be laid with a mortar consisting of 1 part of cement and 3 parts of clean, sharp, coarse sand. The thickness of the under bed shall be at least 20mm thick for flooring and 10 mm thick for dado or as shown in the drawings. While still green, the under bed shall be deeply scratched. The under bed shall be laid not earlier than 48 hours before commencing to set the tiles.

b) A mortar setting bed 6mm thickness shall be laid over the under bed to make an even and true surface; over which the tiles shall be laid. This layer consists of 1 part of Portland cement, 1 part of lime putty and 3 parts of clean, sharp, medium sand. The under bed shall be thoroughly saturated with water immediately before applying the mortar setting bed. The setting bed mortar shall be applied over such an area as can be covered by tiles before the initial set of mortar. After the mortar setting bed has been levelled, a skin of neat Portland cement shall be trowelled to the mortar setting bed immediately before the tiles are set.

As soon as the mortar setting bed has sufficiently hardened, all tiles shall be firmly secured in place and gently beaten in, with finished surface brought to desired level. When grouting the glazed tiles, special care shall be taken to prevent scratching of the glazed surface. All surplus grout or mortar shall be removed before it has set or hardened and the face of tiles left clean. The completed work shall be free from cracked, broken or otherwise damaged tiles, No joint shall be more than 1.5mm thick. The joints shall be flush pointed with white or coloured cement to match the tile surface and cured for seven (7) days.

19.17.8 CERAMIC TILE FLOORING AND DADO

19.17.8.1 FLOORING

Non-slippery ceramic tile flooring shall be laid using premium quality mat finished 6mm thick ceramic tiles conforming to IS: 15622 in approved size (minimum 300 mm X 300), make and shade. The tiles shall be laid as per approved pattern over 20mm thick cement mortar 1:4 bedding, close jointed & pointed with matching cement slurry using white cement mixed with pigment, finished to levels / slope or plumb as required including cutting of tiles, curing, acid washing etc. all complete as per manufacturer's specifications and direction of Engineer. The quoted rates shall include the provision for covering of floor tiles with PVC sheet over it to protect the tiles laid from painting stains and scratches during various finishing activities.

19.17.8.2 DADO

Ceramic tile dado shall be laid at all the elevations using premium quality ceramic tiles average 6mm thickness of approved size (Min 450mmx300mm), shade and make conforming to IS: 15622. The tiles shall be laid on walls with average 10 mm thick

underbed with cement mortar 1:3 (1 cement : 3 coarse sand) and 6mm thick setting mortar, jointed with white cement slurry with matching pigment and curing, cleaning etc all complete. The final surface shall project at least 6mm beyond the plastering, but in no case shall the total thickness including under bed be less than 20mm. The surface shall be truly vertical and free from any scratched or cracked tiles. The quoted rates shall include the provision for covering the tiles with PVC sheet over it to protect the tiles laid from painting stains and scratches during various finishing activities.

19.17.9 CEMENT SKIRTING AND DADO IN-SITU

a) The height of cement skirting and dado shall be as shown in drawings and/or instructed by the Engineer. Preparation of the base shall be as specified earlier.

b) The mortar for underbed shall consist of 1 part of cement and 3 parts clean, sharp, coarse sand (by volume), mixed with adequate amount of water to make it workable (not too wet) and shall be thrown on the wall. After finishing with a wooden float, a neat cement paste of minimum 3mm thickness (6mm when polished) shall be applied and pressed to be finally finished with English trowel.

c) The total thickness shall be such that the finished surface projects 6mm beyond plastering, but in no case shall the thickness be less than 19mm or as specified on the drawing. The junction with floors and corners shall be rounded to 25mm radius and/or as instructed by the Engineer. Curing shall be done for a minimum period of seven days.

d) If polishing is specified on drawings and/or schedule of items, the surface shall be rubbed and polished as per standard practice approved by The Engineer.

19.17.10 PRECAST TILE SKIRTING

This shall be done exactly in the same way as specified above. The plaster at the upper edge of the dado shall be finished neatly as directed by the Engineer.

19.17.11 PVC TILE FLOOR

This shall include the quality of materials and the general requirements for the installation of different types of tiles manufactured from vinyl resins including cover base set with sticker on concrete or masonry base in the locations shown in the drawings.

19.17.11.1 MATERIALS

a) The type of tile shall be as indicated on the drawings, schedule and/or bill of quantities. Three types of Vinyl floor tile are covered.

i) Type - V

The tile shall be composed of 100% Vinyl from face to back with alkaline resisting

colour pigments and other plastic compounds.

ii) Type VA

The tile shall be of Vinyl – Asbestos consisting of a through blend of Vinyl plastic resins, asbestos fibres, and alkali resisting pigments and fillers from face to back.

iii) Type VL

The tile shall be Vinyl-laminated consisting of a top-wearing surface of solid vinyl permanently fused to applicant, felt cushion backing.

b) Cove base shall be extruded PVC (100% putty) with moulded top-set cover, colour, and the height of the base shall be as indicated on the drawings, schedules, and/or as approved by Engineer.

c) The face of the tiles shall be free from porosity, blisters, cracks, embedded foreign matters or other physical defects which affect appearance or serviceability.

d) All edges shall be cut true and square. The colour shall be non-fading and uniform in appearance, insoluble in water and resistant to alkalies; cleaning against and unusual floor polishes.

e) Samples of tiles and cove base shall be submitted to the Engineer and must be approved before work is started. Samples shall bear the labels stating the colour gauge and manufacturer's name. Colour, designs and sizes shall be approved by the Engineer after submission of samples. The thickness of the tiles shall be as indicated in the Schedule of Quantities.

f) Adhesive and cements shall be furnished as recommended by the manufacturer of the tiles. The adhesive shall have a short during time and long life in addition to toughness.

g) The tiles shall be square n shape and of approved dimensions and shall conform to the requirements of IS: 3461 and IS: 3462. The tolerance in dimensions shall be +1.5mm and in thickness +0.5mm.

19.17.11.2 INSTALLATION

19.17.11.2.1 GENERAL

The tiles shall be kept in the room to be tiled for at least 24 hours prior to laying to bring them to the same temperature of the laying area. The work should not the carried out under high humidity conditions. For air-conditioned space, the flooring shall not be laid until the conditioning units have been in operation for at least seven (7) days. During this period the temperature shall neither fall below 20° C. These conditions shall be maintained during laying and for 48 hours thereafter.

19.17.11.2.2 PREPARATION OF SUB-FLOOR

a) The surface to receive this finish shall be firm, even textured but not too smooth, without undulations and other deficiencies. If an under bed is laid the same shall be cured for at least seven (7) days by keeping it moist and fully dried. Before commencing the laying operations, the sub-floor shall be examined for evenness and dryness. The sub-floor shall be broom clean and free of paint, wax, grease or oil. Cracks shall be filled with crack filler.

b) The layout of the PVC on the sub-floor to be covered should be marked with guidelines. The PVC flooring shall be first laid for trials and approval without using the approved adhesive.

c) The adhesive shall be applied uniformly by using a notched trowel to the sub-floor and to the backside and edges of the tiles and allowed to surface dry. Any adhesive squeezed out through the joints and contaminating the face of the tiles shall be removed immediately. An appropriate solvent shall be used to remove any adhesive that has hardened. The traces of solvents shall be removed and the tiles cleaned before reuse.

d) The tiles shall be laid true, level and even exactly to the approved pattern and close to each other with minimum gap between joints. It is preferable to start laying of the tiles from the centre of the area. The tiles should be lowered in position and pressed firmly on to the adhesive. After laying, the tiles shall be rolled over, in two directions, with a light wooden roller weighing about 5 Kg. to ensure full contact with the underlay. If the edges tend to curl up, weights should be used to keep the edges down. Special care shall be taken to avoid formation of air pockets under the tiles. Any undulations noticed on the tiling surface shall be rectified by removing and relaying the tiles after thorough cleaning of the underside of the affected tiles. Work should be constantly checked against guide lines in order to ensure that all four edges of adjacent tiles meet accurately. Tiles shall be fitted carefully to and around all permanent fixtures. Borders shall be fitted accurately.

e) A minimum period of 24 hours shall be given after laying the flooring for developing proper bond of the adhesive. During this period, the flooring shall not be put to service. It is preferable to take up PVC flooring work after completion of plastering, painting, false ceiling and other decorative works so as to avoid any damage to the flooring.

f) Cove base shall be firmly cemented to the walls and accurately scribed to trim and finish.

g) The exposed edges of PVC tiles are doorways and other locations shall be provided protection against damage by metallic edge strips securely fastened to the sub-floor.

h) When flooring has been laid and fixed, it shall be thoroughly cleaned of surplus adhesive. The flooring shall then be cleaned with a wet cloth soaked in ware soap solution. All scraps, packing materials and debris shall be removed.

19.17.11.3 ACCEPTANCE

Improper application of the adhesive or imperfect embedment of tile in the adhesive as evidenced by ridges in the surface, by lack of even and uniform bearing, by loose bond, or by curled loose edges will be cause for rejection. All such defects shall be remedied to the satisfaction of the Engineer prior to acceptance.

19.17.11.4 GUARANTEE

All work executed under this specification shall be guaranteed free of defects in material and workmanship for a period of one year after completion of the work. Upon written notice of any defect in material or workmanship, repairs or replacements shall be made at no expense to Corporation. Corporation shall, however, arrange for the removal and replacement of all fixtures and equipment attached to the surface on which the work will be done.

19.17.12 ACID AND/OR ALKALI RESISTANT FLOOR

19.17.12.1 MATERIALS

The Acid and/or alkali resistant tile or rolls shall be to true and straight edges, shall be non-absorbing, without stains, non-fading, and obtained from approved manufacturers.

The rolls shall be 3 mm thick Thermo Plastic Polypropylene glass lined and shall be guaranteed to resist acid and alkalies of about 30% concentration. The laying of Acid proof rolls shall be carried out as per manufacturer's recommendation strictly and by a specialised agency.

The tenderer shall specify the characteristics of the tiles or rolls and shall enclose the manufacturer's literature for the same confirming their service ability for both acids and alkalis. The Contractor shall submit samples of tiles or rolls for approval to the Engineer and the bulk supply will only be accepted if it conforms in all respects to the approved samples kept with the Engineer.

19.17.12.2 LAYING AND WORKMANSHIP OF TILES

a) The surface should be levelled, dried, cleaned of dust, and should not be too smooth (sand finish) prior to pasting of PPG roll. The PPG roll should be cut into desired size for pasting. The required quantity of pasting compound should be mixed from the two components. The hardener should be added further in this mixture. The mixture is to be applied to the surface and the back side of the PPG roll after laying the fibre mat as per manufacturer recommendation and pasted by applying dead weight by putting sand bags etc. The pressure may be applied by jacks on the vertical surfaces.

b) Thermoplastic sheets should be welded by using fusion welding technique as per manufacturer's specification.

c) The Contractor shall furnish full details regarding the materials for the different treatments described above pertaining to this flooring work as per manufacturer's specifications, and shall lay and set the rolls properly in full conformation with the manufacturer's instructions. The entire work shall be done in workman like manner to the complete satisfaction of the Engineer.

d) The Contractor shall give a guarantee for the satisfactory life of the floor for a minimum period of one year under operating conditions. All defects appearing within this period shall be rectified to the satisfaction of the Engineer by the Contractor at no extra cost to Corporation.

19.17.13 KOTA STONE FLOORING AND SKIRTING

Kota Stone shall be of best quality and obtained from approved sources. Kota stones shall not be less than 20mm thick for flooring and 20mm thick for skirting or as specified in schedule and shall be cut to the required sizes, as approved by the Engineer. The stones shall have to be machine cut and double machine polished. The edges to be pointed shall be true to line and dressed wherever found necessary to the full depth all round. The stones shall be hard, sound, and free from cracks, veins and other defects and of uniform colour. In case of Kota stones available in different shades, the samples shall be submitted for approval of the Engineer.

19.17.13.1 LAYING AND WORKMANSHIP

Before laying the flooring the surface to laying be paved, shall be thoroughly hacked, cleaned of all mortar scales, concrete lumps, loose materials etc. Unless and until, the surface is approved by the Engineer, the paving shall not be taken in hand. A bedding of cement mortar (1:4) of 20 mm thickness for flooring shall be laid evenly and to the required slopes as directed. The stones shall then be truly and evenly set in a thin paste of neat cement applied to sides, bottom and to the prepared base. The stones shall then be tamped down with wooden mallet until they are exactly in true plane and line with the adjacent stones. All stones shall be extended up to the masonry wall and underside of plaster. The stones shall be close jointed and joints shall be as thin as possible.

The cement that oozes out thorough the joints shall be wiped clean. The joints shall then be pointed with matching cement and finished neatly. The flooring shall be cured for seven (7) days. The entire surface and flooring shall be re-polished with machine to the satisfaction of Engineer.

19.17.13.2 KOTA STONE SKIRTING

Kota stone skirting shall be laid against a bedding of cement mortar (1:3) 12mm thick to the full height of skirting to a true plane, level and plumb. The workmanship shall be similar to flooring. The skirting shall be laid projected beyond the finished plastered surfaces. The continuous horizontal groove at the top of skirting shall be provided as per drawing or as directed by the Engineer. No extra will be paid for grooves. The skirting shall be cured for seven (7) days. The skirting surfaces shall be re-polished with had to the satisfaction of the Engineer.

19.17.14 VITRIFIED POLISHED TILE FLOORING AND SKIRTING/DADO

19.17.14.1 FLOORING

Vitrified polished tiles shall be of premium quality of size 600mm x 600mm of approved make and shade, conforming to IS: 15622 having minimum thickness of 9 mm. The tiles shall be laid in approved pattern over 20mm thick cement mortar 1:4 bedding. The tile slabs shall be close jointed & pointed with matching pigmented white cement slurry and shall be finished to levels / slope as required. Scope of work also includes cutting of tiles to the required size , curing, washing etc. complete with all materials, tools labour etc. all complete as per manufacturer's specifications and direction of the Engineer. The quoted rates shall include the provision for covering of floor tiles with PVC sheet over it to protect the tiles laid from painting stains and scratches during various finishing activities.

19.17.14.2 DADO

Vitrified polished tile skirting/ dado shall be of approved make and shade, conforming to IS: 15622 having minimum thickness of 9 mm. This shall be laid at all elevations in approved pattern laid in skirting over and including on 12 mm thick cement mortar 1:3 (1 cement: 3 coarse sand) and jointed with neat white cement slurry with pigment of matching shade to match the shade of the tile including curing, cleaning etc. all complete as per manufacturer's specifications and direction of the Engineer..

19.17.15 GRANITE FLOORING AND DADO/ CLADDING

19.17.15.1 FLOORING

Granite slab shall be of 1st quality in approved colour and size (Minimum 600mmX600mm). Granites slabs shall be provided and laid in 20 mm nominal thickness, with inlay for the border as flooring design, laid in approved pattern over base 20 mm thick cement mortar 1:4 (1 cement : 4 coarse sand) and jointed with white cement slurry mixed with pigment to match the shade of the slab.The scope of the work shall also include surface preparation, rubbing, curing, moulding and mirror polishing complete as per manufacturer's specifications and as directed by the Engineer.

19.17.15.2 DADO

Providing and fixing 20 mm nominal thick granite slab of 1st quality as wall cladding with approved colour and size (to cover the entire height of the dado in single piece without any joint and minimum 600mm width) laid in approved pattern over a base of 20 mm thick cement mortar 1:4 (1 cement : 4 coarse sand) jointed with white cement slurry mixed with pigment complete as directed including filling the gaps between the base mortar and granite slab with 1 : 2 cement slurry and making 'V' grooves wherever required, inclusive of stainless steel fisher clamp with expansion bolts at least 2 nos. for each slab wherever necessary, including rubbing, curing and mirror polishing complete as per specifications and as directed by Engineer. Quoted rate shall include

supplying and providing stainless steel clamps as necessary with expansion bolts or any other accessories required to complete the dado work.

19.17.16 PVC ELECTROSTATIC CONDUCTIVE FLOORING AND SKIRTING

19.17.16.1 FLOORING

PVC Electrostatic conductive flooring and skirting 2 mm thick shall be installed over integral concrete floors finish/IPS/ hardonite flooring. The material specification and laying procedure shall be as per NPCIL Specification No. PPE-2273 (latest Rev.)

19.17.16.2 SKIRTING

PVC electrostatic conductive skirting shall be minimum 2 mm thick and shall be supplied and installed at various elevations inside main plant buildings over concrete / plaster surfaces satisfying all the requirements laid down in NPCIL technical specification PP-E-2273. The scope shall include all accessories / material required for installation of the same such as copper grounding strips, welding rods, surface preparation / levelling of floor, adhesive etc. as per requirements and testing at site all complete as per drawing, manufacturer's specifications and direction of the Engineer.

19.17.17 PRECAST CEMENT CONCRETE INTERLOCKING PAVER BLOCKS

Precast cement concrete interlocking pavers blocks shall conform to IS 15658. Paver blocks shall be of M-40 grade and 80mm thick factory made coloured blocks made by block making machine with strong vibratory compaction. The blocks shall be of approved colour and shape. Cement Concrete paver blocks shall be laid in approved pattern over 50mm thick compacted bed of fine sand, filling the joints with fine sand etc. all complete as per manufacturer's specifications and the direction of the Engineer.

19.18 GENERAL PAINTING ON INTERIORS & EXTERIOR SURFACES

19.18.1 SCOPE

a) This specification covers general painting on concrete, plastered and steel surfaces both interior and exterior as shown in drawings, schedules or as directed by the Engineer.

b) The Contractor shall inspect the surfaces of works completed by other agencies prior to the application of paint. If surface to be finished cannot be put in suitable condition for painting by customary preparatory methods, the painting contractor shall notify the Engineer in writing or assume responsibility for and rectify and unsatisfactory finishing that results.

c) Before commencing painting, the contractor shall obtain the approval of the Engineer in writing regarding the scheduling of work to minimize damage, disfiguration or staining by other trades. He shall also undertake normal precautions to prevent damage, disfiguration or staining to work of other trades or other installations.

19.18.2 MATERIALS

a) Materials shall be of the highest grade products of well known approved manufacturer and shall be delivered to the site in original sealed containers, bearing brand name, manufacturer's name, and colour shade, with labels intact and seals unbroken.

b) All materials shall be subject to inspection, analysis and approval by the Engineer. It is desired that materials of one manufacturer only shall be used as far as possible and paint of one shade be obtained from the same manufacturing batch.

c) All paint shall be subject to analysis from random samples taken at site from painter's bucket, if so desired by the Engineer.

d) All primer coats shall be compatible to the material of the surface to be finished as well as to the finishing coats to be applied.

e) All unspecified materials such as shellac, turpentine or linseed oil shall be of highest quality available and shall conform to the latest I.S. specifications. All such materials shall be made by reputable recognized manufacturers and shall be approved by the Engineer.

f) All colours shall be as per painting schedule and tinting and matching shall be done to the satisfaction of the Engineer. In such cases, where samples are required, they shall be executed in advance with the specified materials for the approval of the Engineer.

19.18.3 STORAGE

The contractor shall arrange for safe and proper storage of all materials and tools. The storage space if allotted within the building shall be adequately protected from damage, disfigurement and stains. Paints shall be kept covered at all times and mixing shall be done in suitable containers. All necessary precautions shall be taken by the Contractor to prevent fire.

19.18.4 PREPARATION OF SURFACE

Before starting the work the Contractor shall obtain the approval of the Engineer regarding the soundness and readiness of the surface to be painted.

19.18.4.1 MASONRY, CONCRETE AND PLASTERED SURFACE

Before taking up painting works F3 finish shall be carried out on concrete surfaces. Plastered Surface shall be wire brushed and sand papered, clean and free of all oil, grease, efflorescence, mildew, loose paint or other foreign and loose materials. Masonry cracks shall be cleaned out and patch filled with mortar similar to the original surface and uniformly textured. Where this type of resurfacing may lead to the finishing paint being different in shade from the original surfaces, the resurfaced area shall be treated with minimum one coat of cement primer, which should continue to the

surrounding area for a distance of minimum 100 mm.

Surface with mildew or efflorescence shall be treated as below:

a) MILDEW

All mildew surface shall be treated with an approved fungicide such as ammonia wash consisting of 7g of copper carbonate dissolved in 80 ml liquor ammonia and diluted to 1 litre with water, or 2.5 percent magnesium silica fluoride solution allowed to dry thoroughly below the paint is applied.

b) EFFLORESCENCE

All efflorescence shall be removed by scrubbing the affected surfaces with a solution of muriatic acid in water (1:6 to 1:8) and washed fully with clear water and allowed to dry thoroughly.

19.18.4.2 **METALSURFACE**

All metal surfaces shall be absolutely clean, dry and free from wax, grease or dried soap films. All steel and iron surfaces, in addition, shall be free from rust. All steel or galvanized iron surfaces shall be pre-treated with a compatible primer according to the manufacturer's direction. Prime coat for steel work shall, however, be applied by the fabricator. Any abrasion in shop coat shall be touched up with the same quality of paint as the original coat.

19.18.5 PAINTING

Various types of finishing shall be done as indicated in the 'Interior Finish Schedule' and/or as on drawings. The colour shall be in accordance with 'Painting Schedule' or as selected by the Engineer.

19.18.5.1 ACRYLIC PLASTIC EMULSION PAINT

Acrylic plastic emulsion paint shall conform to IS: 15489. It shall be water-based acrylic co-polymer emulsion with rutile titanium dioxide and other selected pigments and fungicide. It shall exhibit excellent adhesion to plaster and cement surface and shall resist deterioration by alkali salts. The paint film shall allow the moisture in wall to escape without peeling or blister. The paint, after it is dried, shall be able to withstand washing with mild soap and water without any deterioration in colour, or without showing flaking blisters or peeling.

Plastic emulsion paint shall be of premier quality conforming to IS 15489. It shall be applied in minimum two coats over a coat of approved primer to interior concrete, plaster & other surfaces after cleaning / scrubbing of the surfaces with wire brushes, soft brushes, sand papers, steel sheet scrappers and mechanical grinder etc. for removing all kind of burrs, imperfections, undulations and other such defects existing in the surface including filling surface imperfections such as holes, dents, cracks by

using mixture of white cement & fine sand (in the ratio of 1:3) to achieve plain & even surface. The scope of work includes spreading of suitable and clean protection covering on all exposed surfaces to protect them from staining. All surfaces surrounding to painted area including window frames & glasses shall be cleaned to sparkling clean condition using suitable thinners, detergents, chemical cleaners etc. under the scope of the item as directed, at all elevations as indicated in the drawings including labour, materials, scaffolding, preparation of the surface, protecting & cleaning etc. all complete as per specification and direction of the Engineer.

All concrete surfaces shall be F3 finished before taking up the painting works. Quoted rates of painting shall include cost of F3 finish. Lime gauged cement plastered surfaces shall not be painted for at least one month after plastering. A sample patch shall be painted to check alkali reaction if so desired by the Engineer. Painting shall be strictly as per manufacturer's specification.

19.18.5.2 SYNTHETIC ENAMEL PAINT

Synthetic enamel paint shall be made from synthetic resins and drying oil with rutile titanium dioxide and other selected pigments to give a smooth, hard, durable and glossy finish to all exterior and interior surfaces. White and pastel shades shall resist yellowing and darkening with aging. The paint shall conform to IS: 2932 & IS: 2933. Glossy synthetic enamel paint shall be used on metal surfaces. Ready mix matt synthetic enamel paint shall be used on wall surfaces.

Synthetic enamel paint shall be of approved make and shade premium quality mat / glossy (as directed). It shall be painted in minimum 2 coats to give an even shade on steel surfaces at all elevations after erection including surface preparation and touch up with zinc phosphate primer wherever required. The scope also includes providing and removing scaffolding, all as per manufacturer's specifications, drawings and direction of the Engineer. The rate shall be inclusive of surface preparation with wire brushing and touch up with zinc phosphate primer.

Synthetic enamel paint shall be applied on properly premiered surface. Subsequently, coat shall not be applied till the previous coat is dry. The previous coat shall be lightly sand papered for better adhesion of subsequent coats.

19.18.5.3 ACID, ALKALI RESISTING PAINT

Acid and alkali resistant paint shall be of approved make and colour conforming to IS: 9862. The paintshall be applied in minimum 500 micron DFT over a coat of approved primer on prepared surfaces of flooring, ceiling and walls and other surfaces at all elevations. The scope of work includes all labour, materials, scaffolding, preparation of the surface, protecting & cleaning etc. all complete as per manufacturer's specification and das per direction of the Engineer. Primer coat shall be as per manufacturer's instructions.

19.18.5.4 POLYURETHENE PAINTING

19.18.5.4.1 **GENERAL**

Polyurethane painting on concrete and steel surfaces shall be done at locations wherever specified in the drawings. Generally the external surfaces of the specified buildings shall be painted with polyurethane paint after completion of the work.

19.18.5.4.2 **SCOPE**

The scope of work covered under this specification is supply and application of one coat of primer and two coats of polyurethane finish paint of approved make for total dry film thickness of 125 microns (excluding 75 micron thick primer) on exterior surfaces.

19.18.5.4.3 **MATERIALS**

a) Primer compatible for PU paint shall have outstanding resistance properties and shall contain a high level of penetrating pigment, which renders superior performance when applied over concrete and it should be compatible when over coated with polyurethane paint.

a) The finish paint shall be two-component air-drying acrylic aliphatic polyurethane coating.

c) Suitable thinner for the above will be as per the manufacturer's recommendations.

d) Finish paint shall be glossy/ matt finish of approved shade and as specified by the engineer.

19.18.5.4.4 **DESCRIPTION**

The surface shall be cleaned of dust, loose particles, finished and cured properly. Biological growth if any, accumulated on the surface over the period shall be removed completely. Painting shall commence with application of one coat of 75 micron thick primer and finished with 125 micron DFT of polyurethane paint in two coats. The shade of the finish paint is generally light grey in colour and Contractor shall obtain prior approval of Engineer before commencement of work. Method of painting shall be either brush application or using air less spray equipmentusing a pump with nozzle tip of size 0.33 mm to 0.45 mm and more than 2000 psi pressure.The rate quoted shall cater for both methods.

A) Primer shall be two pack epoxy primer with outstanding resistance properties and shall contain a high level of penetrating pigment which renders superior performance when applied over steel/ concrete having the following properties.

PROPERTY	TEST METHOD	UNIT	ACCEPTANCE VALUE
Density	ASTM D 4052	g/cc	1.09 + 0.05 at 25°C
Mixing Ratio, by weigh	ASTM D 4052	ratio	100(Base): 35(Hardener)
Flexural Strength	ASTM C 580-02	Mpa	35 at 7 days
Tensile Strength	BS 6319, Pt 7	MPa	22 at 7 days
Compressive Strength	ASTM C 579	MPa	70 at 1 Day 75 at 3 Days 80 at 7 Days
Adhesive Bond Strength	ASTM D 4541	MPa	>1.5
DFT of Primer	ASTM D 1005	Micron	75

B) The two component polyurethane paint shall have the following parameters.

PROPERTY	TEST METHOD	UNIT	ACCEPTACE VALUE
Volume of Solids	ASTM D 2697	%	57±3
Pot Life	ASTM C603-90	Min	120 (at 25 deg C) 50 (at 40 deg C)
Mixed Density	ASTM D 4052	Kg/Ltr	1.2 (at 25 deg C)
Mixing Ratio, by Volume	ASTM D 4052		4(Base) : 1 (Hardner)
Touch Dry	ASTM D 1640	Min	90 (at 25 deg C)
Recoatable	ASTM D 1640	Hour	6 – 8 (at 25 deg C)
Final Curing Time		Day	7 (at 25 deg C)
Bond Strength	ASTM D 4541	MPa	>2 (Concrete Failure)
Abrasion Resistance , CS17 wheel	ASTM D 4060	Mg/1000 cycles	<125
UV Resistance	ASTM G 53	Hour	>1000
DFT in two Coats of PU Paint	ASTM D 1005	Micron	125

The acceptance criteria shall be based on Manufacturer test certificate except for Bond & Abrasion Resistance test, which shall be performed (one sample per lot) at independent approved Laboratory at the cost of contractor. The test certificate shall clearly specify the PU material as “Aliphatic”.

19.18.5.5 EPOXY PAINTING ON STEEL AND CONCRETE SURFACES

19.18.5.5.1 GENERAL

Epoxy painting on concrete and steel surfaces shall be done at locations wherever specified in the drawings.

19.18.5.5.2 SCOPE

The scope of work to be performed under this specification comprises of supply and application of heavy duty high build epoxy paint of approved make for painting of concrete and steel surfaces in various buildings and areas specified in the drawing, for walls, ceiling, floors and fabricated structural steel members as per relevant drawing and specifications to the thickness as specified in the drawings including surface

preparation.

19.18.5.5.3 MATERIAL SPECIFICATIONS

For the areas, important from radiological considerations, where decontamination and radiation resistance properties are required, the material shall conform to PP-M-1219 as applicable and as specified in the drawings or decided by the Engineer. This material shall be Polyamide cured two pack epoxy coating in mix and use form.

The areas which are not important from radiological consideration as specified or decided by the Engineer, material shall meet the requirements under relevant clause of this section.

19.18.5.5.3.1 **INTENDED USE**

19.18.5.5.3.1.1 **For areas important from radiological considerations**:

The epoxy coating would be used for painting the concrete floors, ceilings and walls. Mild steel surfaces on inorganic zinc silicate primed fabricated structural steel surfaces, construction joints caulked with polysulphide or epoxy mortar caulking compound, metallic expansion joints made from steel and copper etc. The materials used in the coating should not form radioactive isotope on absorbing neutrons. The paint should form a thick, radiation resistant, abrasion resistant, impact resistant, non-adsorbent, de-contaminable, humidity resistant, hot water and steam resistant liner.

19.18.5.5.3.1.2 For areas not important from radiological considerations:

The epoxy coating can be used for painting the concrete floors, ceilings and walls over Epoxy based compatible primer and on Mild steel surfaces over inorganic zinc silicate primed fabricated structural steel surfaces, construction joints caulked with polysulphide or epoxy mortar caulking compound, metallic expansion joints made from steel and copper etc. The paint should form a thick, abrasion resistant, impact resistant, non-adsorbent, humidity resistant liner.

19.18.5.5.3.2 **QUALIFICATION**

19.18.5.5.3.2.1 **For the areas important from radiological considerations:**

The qualification and procurement of epoxy paint shall be in accordance with PP-M-1219 as applicable. At the time of bulk supply samples shall be drawn from the batch in presence of representative from NPCIL, sealed and got tested by the contractor for batch tests in accordance with PP-M-1219 as applicable. The rate for application of paint shall include all the costs related with procurement.

19.18.5.5.3.2.2 **For the areas not important from radiological considerations:**

The Epoxy paint shall have following properties:

a) **For Epoxy on concrete floors**: The Epoxy shall be high build solvent free, self-smoothing, 4 component (Base, Hardener, Filler & Pigment) material. The DFT of coating (Excluding Primer) shall be minimum 1200 micron for its use on floors unless specified otherwise.

Property	Acceptance criteria	Reference Standard
Mixed Density	1.6+/- 0.05 kg/ liter	ASTM D14752
Pot Life	Min 40 min at 25 ^{0} C Min 15 min at 40 ^{0} C	ASTM C603
Setting time for foot traffic	15 Hour at 15 ^{0} C	ASTM D5895
Maximum Service Temperature	60 ^{0} C	ASTM 24712
Compressive Strength	24 MPa at 1 day 50 MPa at 7 days	ASTM C579
Flexural Strength	18 MPa at 7 days	BS 6319 PART 3
Tensile Strength	10 MPa at 7 days	BS 6319 PART 7
Abrassion Resistance H22 Wheel 1000 cycles – CS17 wheel	Less than 230 mg Less than 85 mg	ASTM D2240
Hardness, Shore D	Min 80	ASTM D2240
Adhesive Bond strength to concrete at 7 days	>1.5 MPa (Concrete failure)	ASTM D4541

b) **For Epoxy on concrete walls & structural steel**: The Epoxy shall be high build solvent free, 3 component (Base, Hardener & Pigment) material. The DFT of coating (Excluding Primer) shall be 250 micron for concrete walls & 200 micron on structural steel, unless specified otherwise.

Property	Acceptance criteria	Reference Standard
Mixed Density	1.48+/- 0.05 kg/ liter at 25 ^{0} C	ASTM D 14752
Volume Solids	100 %	ASTM D 2697
Pot Life	Min 60 min at 25 ^{0} C	ASTM C603-90
Setting time for foot traffic	2 days at 25 ^{0} C	ASTM D 5895
Compressive Strength	60 MPa at 7 days	ASTM C579
Flexural Strength	38 MPa at 7 days	ASTM C 580-02
Tensile Strength	8 MPa at 7 days	ASTM C307
Abrassion Resistance H22 Wheel 1000 cycles – CS17 wheel	Less than 230 mg Less than 130 mg	ASTM D2240
Hardness, Shore D	Min 80	ASTM D2240

Adhesive Bond strength to concrete at 7 days	More than 1.5 MPa Concrete failure	ASTM D4541

19.18.5.5.4 **SURFACE PREPARATION**:

Generally all surfaces to be painted shall be cleaned of oil, grease and other foreign matter. If the surface is very oily a detergent wash may be applied. The surface shall then be rubbed with No. 60 to 80 emery paper and the dust removed thoroughly with a clean cotton cloth.

19.18.5.5.4.1 CONCRETE SURFACES

Air water jet at a pressure of 7 Kg/cm2 shall be applied through a nozzle having a tip orifice of 1.5mm. The surface shall be allowed to dry. Pin holes if any exposed due to air water jetting shall be filled with cement paste and excess cement mortar shall be removed after drying by rubbing with emery paper followed by wiping with clean cloth.

In the case of floors, all laitance, stains and other deleterious substances shall be removed by using a floor polishing machine followed by a thorough air water jetting and cleaning. Oil and grease shall be removed by wiping with cloth soaked in thinner or acetone.

19.18.5.5.4.2 STEEL SURFACES

All steel work shall be cleaned of rust, scale, dirt, oil, weld splatter and other deleterious substances by shot blasting.

19.18.5.5.5 EQUIPMENT FOR PAINTING

Generally, only airless spray equipment of ratio not less than 66:1 shall be used for all painting works. Only trained personnel shall be allowed to operate the airless spraying equipment. The capacity of the equipment shall be such that it will provide maximum dry film thickness without sagging of the paint film. However, at places, where airless spray equipment cannot be used, painting with brushes shall be permitted at the discretion of the Engineer-in-charge only.

19.18.5.5.6 APPLICATION OF PAINT

General

Painting shall commence from top of walls and shall be worked down. Floors shall be painted from one corner working towards exit to avoid walking over painted areas. The paints shall be mixed and applied in accordance with manufacturer's instructions. Only approved primer coat shall be applied on the concrete or steel surfaces. The final finish

paint should give a dry film thickness as specified in drawings/ specifications. The thickness shall be made up in minimum number of coats as possible.

The curing time between successive coats shall be around 16 hours unless recommended otherwise by the paint manufacturer.

On concrete surfaces, inert filler shall be applied after the first coat to cover the uneven surface. It shall be noted that inert filler material shall not be applied over the entire surface as such layer will lead to loss of adhesion of the subsequent layers of paint. After application of the inert filler the surface shall be rubbed down with Nos. 80, 120 and 140 (as the case may be) sand paper and the rubbed surfaces cleaned by air jetting followed by cleaning with soft cloth before the successive coat of paint is applied. Each coat of paint except the final coat shall be slightly roughened using sand paper to obtain good adhesion of the successive coat of paint.

The paint shall be spread uniformly without runs, sags or brush marks (in case of brushing). Care shall be taken during spraying operations to hold the nozzle sufficiently close to the surface (not closer than 300mm) being painted to avoid evaporation of the volatile constituents of the paints and loss of materials into the air. The air pressure shall be kept at the required level through the entire painting operation. Each coat of paint shall be inspected after curing for the finish and dry film thickness. Necessary compositor plates shall be fixed on to the surface during painting, for checking the dry film thickness at various intervals as may be necessary. Wet film thickness gauges shall also be used during the painting and the thickness of wet film shall be recorded.

19.18.5.5.7 APPLICATION OF SELF LEVELING EPOXY FLOORING

The floor receiving the self-leveling epoxy flooring must be sound, dry, fine-grained and load bearing, free of laitance, loose and brittle particles and shall also be free from substrate and substances which impair adhesion such as oil, grease, rubber skid marks, paint or other contaminations.

The bond strength of the substrate must be at least 1.5 MPa. Ensure the compressive strength of the floor concrete is at least 25MPa and that floor slabs directly in contact with the ground have a proper vapour barrier installed and the moisture content of substrate shall not be higher than 4% throughout.

The temperature requirements shall be in the range given below:

A] Substrate temperature: 15°C - 35°C
B] Material temperature: 15°C - 30°C

The priming is essential to seal the concrete surface prior to the application of the self-level epoxy flooring. For primer shall be applied using medium nap roller ensuring a complete coverage without holidays, if after drying the surface appears patchy due to high absorption, recoating of primer shall be done in such areas. Primer shall be allowed to dry before commencing topcoat application of the self-level epoxy floor coating.

All mixing should be done mechanically, using a slow speed drilling machine fitted with a paddle, taking care to ensure that the mixing head is well within the material during mixing.
Applicator must wear spiked shoes during application. Mixed material shall be poured onto the primed and sealed surface and spread to full specified thickness using a pin screed or a notched trowel to achieve the specified thickness. The spread material should be immediately rolled with a spiked roller to release entrapped air and remove trowel marks. Control rolling shall be continued until all air is released well before the material starts stiffened.

19.18.5.5.8 PRECAUTIONS TO BE TAKEN

Required oil free compressed air at correct pressure shall be available with suitable compressors.

The equipment with all its accessories shall be cleaned immediately after the painting is completed with suitable thinner after painting.

All material such as paints, thinner, inert filler and Primer shall be stored safely, handled carefully and account of consumption recorded regularly. The paints used are volatile and hence proper ventilation shall be maintained in the areas of painting.

Explosion meters shall be used to constantly check the fume concentrations to avoid any explosion. The area to be painted shall be well ventilated by using fans/air blowers.

Sufficient lighting arrangements shall be ensured before start up of painting.

Proper staging and scaffolds shall be ensured while painting at heights.

Embedment, equipments pipes etc. shall be suitably masked before the painting commences.

After the painting, areas shall be cleaned of stains if any.
Care shall be taken to see that no welding/ Gas cutting is carried out where painting work is in hand or near to storage area.

19.18.5.5.9 Maintenance of records

A daily progress record shall be maintained.

19.18.5.5.10 Handling precautions

All the precautions must be taken to avoid direct contact of resin and hardener with skin. The persons handling epoxy resin and hardener must use rubber or polythene gloves. Parts of the skin, which come in contact with resin or hardener, should be washed with lukewarm water and mild soap. Manufacturer's recommendation on these aspects should be followed.

19.18.5.6 ANTI CARBONATION, ANTI CORROSIVE AND WATERPROOF COATING

19.18.5.6.1 SCOPE

The specification described here covers material description, physical and mechanical properties, testing, applicable codes and standards, acceptance criteria, surface preparation and QA requirement etc. for protective coating using Aliphatic acrylate system on external surface of buildings unless specified otherwise.

19.18.5.6.2 MATERIAL

The protective coating on the external concrete surfaces shall be pure aliphatic acrylate system. It shall be single component; solvated aliphatic acrylic resin based coating for protection of concrete from carbonation, chloride ions, weathering and industrial pollution.

19.18.5.6.3 SURFACE PREPARATION

The surface shall be clean and free from loose particles, oil, grease, or any other contamination. The concrete surface shall be cleaned with wire brush and shall be washed with clean water. The surface having oil and grease shall be cleaned with detergents.

The surface irregularities such as blow holes, honeycombs, crevices and surface blemishes shall be filled with polymer modified cement putty mortar to achieve smooth and level surface this shall be allowed to cure by spraying water for two days and to dry for one day.

The substrate shall be in dry condition before the application of protective coating for better performance. The compatibility of this system shall be checked with the existing coating system, if any.

19.18.5.6.4 APPLICATION

Prepared Concrete substrate shall be applied with a compatible coat of primer at least 2 hours before application of Coating. The Primer shall have following properties.

PROPERTY	UNIT	TEST METHOD	ACCEPTANCE VALUE
Mixed Density	Kg/ltr	ASTM D 6237	0.95
Volume Solid	%	ASTM 5201	Min 32%
Over Coating Time	Hrs	ASTM D 1005	2 (at 25 ^{o}C)

Over the primer the protective coating shall be applied using brush or roller or airless spray. The complete protective coating shall be applied in minimum one primer and two main coats. The first and the second main coat shall be applied approximately with a gap of 24 hours at right angles to each other. At low temperature, the subsequent coat shall be applied after ensuring that the earlier coat is fully dry.

19.18.5.6.5 CURING

The aliphatic acrylate based protective system is naturally air cured. Hence, no separate curing is required.

19.18.5.6.6 COVERAGE

The coverage depends on the type of surface (concrete, plaster, masonry) and surface finish. The Engineer In Charge shall check the coverage as per the manufacturer's specification. Engineer-in-charge shall verify the quantity of material used at site along with bills from the manufacture and the coverage specified in the manufacturer's specification.

The protective coating shall be applied in two coats over a primer coat. Each coat shall have a minimum thickness of 75 microns. The total dry film thickness inclusive of Primer shall be minimum 225 microns.

19.18.5.6.7 STORAGE AND SHELF LIFE

The material shall be stored under cover, out of direct sun light and shall be protected from extremes of temperature. The shelf life shall be as per the manufacturer's specification.

19.18.5.6.8 Properties

The properties of aliphatic acrylate based protective system are as follows. The base and system shall be pure aliphatic acrylate base and single component system.

PROPERTY	UNIT	TEST METHOD	ACCEPTANCE VALUE
Density	Kg/ litre		1.10 (min)
Volume solids	%	ASTM D 5201	37% (min)
Dry film thickness (DFT) for 1 Primer in white shade + 2 Top Coats	Microns	ASTM D 1186	225 microns in 1 Primer + 2 Top Coats
Adhesion with Concrete/ plaster surface	MPa	ASTM D4541	3.0 or concrete failure
Water vapour permeability test	gm/sq.m/day	ASTM D 1653	7 gm/sq.m/day at 75% RH at 25C (max)
Water penetration test	% weight gain	IS 3085	NIL at 5 kg/cm^2 hydrostatic test
Flexibility -Standard bend test		ASTM D 522	No cracks on the surface in 1/8 inch Mandrel

QUV- condensation test	Hours	ASTM G 53 for 500 hours	Passes - No discolourisation and chalking
A.C. Impedance Test in 3% sodium chloride	Coating resistance	Using Electrochemical impedence measurement for a frequency range of 100 KHz to 0.01Hz with AC amplitude of 20 Mv.	Initial value: $9x10^9$ Ohms (min) Final value after 30 days: $1x10^7$ 0hms (min)
CO2 diffusion resistance	Equivalent air layer thickness, R	AS/NZS 4548.5 – 1999: Taywood Method	>70m
	Equivalent Concrete Layer Thickness		>170 mm

Note: A.C. impedance test for the protective coating is required for application on RCC surface. This test may not be required for application on masonry/ PCC surfaces.

19.18.5.6.8.1 **Material**

Base: Aliphatic Acrylate Solvented System
Components: Single component

19.18.5.6.8.2 **Volume Solids**

Test Method: ASTM D 5201 –97 Standard practices for calculating formulation physical constants of paints and coatings.

19.18.5.6.8.3 **Dry Film Thickness**

Test Method: ASTM-D-1186: Test method for non-destructive measurement of dry film thickness of non magnetic coatings applied to ferrous base.

Methodology for adopting on concrete/masonry/plaster surface: Cleaned steel plates shall be fixed to the concrete surface firmly at regular intervals during application of protective coating. The dry film thickness (DFT) measurement shall be carried at every 100 sq.m area or part there off.

19.18.5.6.8.4 **Adhesion with concrete/ plastered surface**

Test Method: ASTM-D-4541-02: Standard test method for Pull-off strength of coating using portable adhesion testers.

19.18.5.6.8.5 **Water Vapour Permeability test**

Test Method: ASTM-D-1653: Standard test method for water vapour transmission of organic coating films.

19.18.5.6.8.6 **Water penetration Test**

Test Method: Water penetration resistance tested by immersing coated concrete cubes (5 cm x 5 cm x 5 cm size) for 12 days. Even at the end of 12 days, the weight gain shall be NIL to negligible.

19.18.5.6.8.7 **Flexibility- Standard bend test**

Test Method: ASTM-D-522: Standard test method for mandrel bend test for attached organic coatings.

19.18.5.6.8.8 **QUV- Condensation Test**

Test Method: ASTM-G-53: Standard practice for operating light and water exposure apparatus (fluorescent UV- condensation type) for exposure of non-metallic materials.

19.18.5.6.8.9 **Impedence Test (in 3.0% NaCl solution)**

Test method: Electrochemical impendence measurements for a frequency range of 100 kHz to 0.01 Hz with an AC amplitude of 20mV.

19.18.5.6.9 TESTING

The material shall be tested as per this specification by the contractor at no extra cost to NPCIL. Each batch of material used for the NPCIL job shall be tested in any of the approved independent laboratories. The independent test certificates along with the manufacturer's test certificate shall be submitted to NPCIL. The independent testing shall be witnessed by NPCIL representative, If felt necessary by the Engineer.

19.18.5.6.10 PACKAGING AND SHIPMENT

Materials delivered at site shall be clearly marked with legible and intact labels with manufacturer's name, brand name, product identification, manufacturing & expiry dates and batch number. The products shall be in original, unopened / sealed containers. Material shall be stored in areas where temperatures conform to manufacturer's recommendations and instructions.

19.18.5.6.11 SAFETY PRECAUTIONS

The work shall be carried out by an authorized contractors/applicator

The application shall comply with the procedure given above, all current relevant codes of practice and the Building Regulations.

All materials shall be stored clear of ground and moisture with weather protective covering. All the materials shall be kept away from sources of ignition.

The protective coating shall not be applied during inclement weather or when ambient condition is not allowing proper application.

Safety scaffolding, access ladders etc shall be provided in accordance with the current industrial safety and all the health and safety regulations shall be adhered to.

Care shall be taken during storage and use to avoid contact with eyes, mouth, skin and food stuff. The container shall be sealed after use.

19.18.6 PROTECTION

Furniture and other movable objects, equipment, fittings and accessories shall be moved, protected and replaced upon completion of work. All stationery equipment shall be well covered so that no paint can fall on them. Work finished by other agencies shall be well protected. All protections shall be done as per instruction of the Engineer.

19.18.7 CLEANING UP

In addition to the provision in 'Conditions of Contract' the Contractor shall, upon completion of painting etc., remove all marks and make good surfaces, where paint has been spilled, splashed or splattered, including all equipment, fixtures, glass furniture, fittings, etc. to the satisfaction of the Engineer.

19.18.8 ACCEPTANCE CRITERIA

a) All painted surfaces shall be uniform and pleasing appearance (gloss/ matt finish).
b) All varnished surfaces shall be of uniform texture and high glossy finish.
c) The colour, texture etc. shall match exactly with approved samples.
d) All stains, splashes and splatters of paints and varnishes shall be removed from surrounding surfaces

19.19 WATER SUPPLY, DRAINAGE AND SANITATION

19.19.1 SCOPE

The specification covers the general requirements for providing and laying water supply, piping, and providing and laying drainage lines.

19.19.2 CODES AND STANDARDS

Some of the important Codes and Standards relevant to this specification shall be followed: Latest editions shall always be consulted.

The following IS Codes shall be applicable:

IS: 1172 - Code of basic requirements for water supply drainage and sanitation.

IS: 1200 - Methods of measurement of building and civil engineering works.

IS: 1239 - Steel Tubes, Tubulars and other wrought steel fittings. (Pt. I & II)

IS 16098-2-Structured-Wall Plastics Piping Systems for Non-Pressure Drainage and Sewerage –specification

IS 7634-2- Plastics Pipes Selection, Handling, Storage and Installation for Potable Water Supplies - Code of Practice, Part 2: Laying and jointing of polyethylene (PE) pipes.

IS 14333 -High density polyethylene pipe for sewerage

IS: 1742 - Code of Practice for building drainage.

IS: 5329 - Code of Practice for sanitary pipe work above ground for buildings.

IS: 3076 - Specification for Low density polyethylene pipes for potable water supplies.

IS: 4984 - High density polyethylene pipes for potable water supplies.

IS: 458 - Pre cast concrete pipes (with and without reinforcement) - specification

IS: 783 - Code of Practice for laying of concrete pipes.

IS: 784 - Pre-stressed concrete pipes.

IS: 1726 - Specifications for Cast Iron Manhole Covers and Frames.
IS: 5961 - Specification for Cast Iron gratings for drainage purposes.

IS: 5219 - Specification for cast copper alloys traps. Part-1 - ‘P' & 'S' traps.

IS: 771 - Specifications for Glazed fire-clay sanitary appliances.

IS: 772 - Specifications for general requirements for enameled cast iron sanitary appliances.

IS: 774 - Flushing cistern for water closets & urinals (Other than plastic cisterns) - specifications.

IS: 775 - Cast Iron brackets & supports for wash basins and sinks.
IS: 2548 - Plastic seats and cover for water closets – specifications.

IS: 2527 - Code of Practice for fixing rain water gutters and down-pipes for roof drainage.

19.19.3 DRAWINGS

a) Checked and approved drawings showing locations of sanitary and water supply fixtures will be furnished to the Contractor and all drawings so furnished shall form a part of this specification. The Contractor shall refer these drawings for all information contained thereon which pertains to and required for his work. He is, however, not to commence detail plumbing, water supply and drainage on the basis of drawings unless such drawings or parts of such drawings are officially released as 'Released for Construction'. Revision to drawing and any new drawings made to include additional work by the Contractor shall be considered a part of this specification and contract.

b) Unless otherwise specified, the plans and specifications are intended to include everything obviously requisite and necessary for the proper and entire completion of the work and accordingly the job shall be carried out for completeness as required whether each item is mentioned here or not.

c) Based on line diagrams/drawings furnished by the Engineer, the Contractor will have to prepare detailed working drawings indicating the positions of fittings, valves, joints, nature, type and location of supports, connections to main lines etc. Four prints of each of these detailed drawings shall be submitted to the Engineer for approval. The drawings shall be got approved before proceeding with the execution of the work. The Contractor shall obtain permission from all local statutory authorities for all proposed works prior to commencement of execution and necessary fees, etc. shall be borne by him. The Contractor should, after completion of all works, give "as built" drawings incorporating all field changes made, for reference and use of the client. The final payment due to the Contractor will be effected only after such drawings are finalized.

d) Construction shall not be started until the Contractor has received copies of such drawings upon which the Engineer has endorsed approval. The approval of the Engineer of any of the drawings shall not relieve the Contractor from his responsibility for correctness of Engineering workmanship, fit of parts, details, materials, errors or commissions of any all work shown thereon. The Engineer's approval shall constitute approval of the design, sizes of pipes and layout only. The approval shall not invalidate any claim the Owner may make for damages on account of faulty construction.

e) The Engineer will return one copy of the Contractor's drawings marked with his approval/comments. The Contractor shall furnish the Engineer 2 prints and one reproducible of all final drawings for record purposes.

19.19.4 PIPING FOR PLANT DRAIN WORKS

a) Double walled corrugated pipes, conforming to IS:16098, Part 2

For equipment (plant) drain works underground double walled corrugated pipe conforming to IS: 16098, Part 2, stiffness class SN 8 shall be used. These pipes will be

used for external buried (underground) pipe lines. Work involved includes providing, jointing of pipe to pipe or pipe to long neck pipe ends by electric heating mirror at site, joints to be flanged joints, laying and jointing conforming to IS : 7634 (Part-2), cutting and trimming of pipes, preparation of bends as per requirement at site, preparation of bed for laying the pipes etc. all complete as per manufacturer's specification.

b) HDPE pipes conforming to IS:4984

For equipment (plant) drains works underground HDPE pipes of higher diameter conforming to IS:4984, grade PE 100, pressure rating PN 6 shall be used. These pipes will be used for external exposed pipe lines. Work involved includes providing, laying or fixing in position including jointing of pipe to pipe or pipe to long neck pipe ends by electric heating mirror at site, joints to be flanged joints, laying and jointing conforming to IS: 7634 (Part-2), cutting and trimming of pipes, preparation of bends as per requirement at site, preparation of bed for laying the pipes etc. all complete as per manufacturer's specification.

19.19.5 PIPING FOR PLANT SEWER WORKS

a) Internal sewer works

For internal sewer works of main plant buildings under floors or against walls, HDPE pipes conforming to IS: 14333, grade PE 100, pressure rating PN 12.5 shall be used. Scope of work shall include providing HDPE pipes and fittings, laying or fixing in position including jointing of pipe to pipe or pipe to long neck pipe ends by electric heating mirror at site, joints to be flanged joints. Laying and jointing shall conform to IS: 7634 (Part-2).Scope shall also include cutting and trimming of pipes, preparation of bends as per requirement at site, taking suitable supports from Ceiling and walls/ preparation of bed etc. all complete as per drawings, manufacturer's specifications and direction of the Engineer.

b) External sewer works

i) For external sewers under gravity flow underground double walled corrugated pipe conforming to IS: 16098, Part 2:2013stiffness class SN 8 shall be used.Scope of work shall include providing pipes and fittings, laying or fixing in position, including jointing of pipe to pipe or pipe to long neck pipe ends by electric heating mirror at site, joints to be flanged joints. Scope shall also include laying and jointing of pipes conforming to IS: 7634 (Part-2), cutting and trimming of pipes, preparation of bends as per requirement at site, preparation of bed for laying the pipes etc. all complete as per manufacturer's specification.

ii) For external sewers under pressure, underground HDPE pipes conforming to IS: 14333, grade PE 80, pressure rating PN 6 shall be used. Scope of work shall include providing pipes and fittings, laying or fixing in position including jointing of pipe to pipe or pipe to long neck pipe ends by electric heating mirror at site, joints to be flanged joints. Scope shall also include laying and jointing conforming to IS : 7634 (Part-2), cutting and trimming of pipes, preparation of bends as per requirement at site,

preparation of bed for laying the pipes etc. all complete as per manufacturer's specification.

19.19.6 WATER SUPPLY PIPING AND FITTINGS

a) All water supply pipes shall be 'C' class (heavy duty) galvanized M.S. pipes of the specified internal diameters, conforming to IS: 1239**.** The pipes shall be fixed in longest possible lengths with all necessary bends, tees and couplings, reducing tees, etc. in perfect straight lines vertically and horizontally. For joining pipes threads of tube sand fittings shall be smeared with white lead and screwed down together with jute threads smeared with lead. Exposed surfaces of pipes shall be coated with 2 coats of oil paint if required by the Engineer. G.I. pipes shall be embedded in a chase out in internal wall chase shall be filled with cement mortar when directed at no extra cost. All G.I. pipes inside shaft shall remain clear off walls by at least half an inch. They shall be fixed with galvanized malleable iron bat clamps.

b) All brass or chromium plated fittings shall be of approved make and of the best quality, heavy cast or drawn brass, thoroughly annealed and shall be seamless.

19.19.6.1 **VALVES**

Valves shall be of best quality gun metal sluice valves unless specified otherwise, of screw down type with cast iron hand-wheel. Valves up to and including 15 mm diameter shall have threaded sockets.

19.19.6.2 **SUPPORTS**

a) Supply pipes, ladders, soil drain rain water and waste pipes etc. installed in a vertical position shall be hold firmly in place by GI/ W.I. clamps unless projecting ears with fixing holes are provided at socket and of pipes or by approved inserts wall fastened to the walls or structural framing.

b) Sleeves shall be provided for all pipes passing through walls floor and partitions, except at locations specifically forbidden by the Engineer. All sleeves shall be painted steel pipes. Pipe hangers where provided shall not be wider apart than 1.5 m on centres for cast iron pipes. General scheme for support arrangement shall be got approved by the Engineer before it is erected in position. The Engineer shall have the right to increase the number or strengthen or modify the supports at site.

c) All piping, where not concealed and where location is not specifically fixed by drawings shall run parallel and as close as possible, to wall.

19.19.6.3 **PLUMBING WORK**

The pipes before being laid shall be thoroughly cleaned specially the inside of pipes if required. Socket ends of pipes shall always face upstream of effluent flow. The drains shall run in perfect straight lines between manholes. The trenches shall not be filled in until the joints have been tested and alignment of drains and connections into and from

the manhole and their positions have been examined and certified and certified by the Engineer, if required. The whole of sanitary work comprising provisions of drainage and water supply arrangements including sanitary and water fittings and fixtures complete in all respects shall be carried out in accordance with the rules and regulations of the local authority through the agency of a licensed plumber. If required, the Contractor shall have to get all materials brought on site for incorporation in the work approved by the local authority at his own expense.

19.19.6.4 **PROTECTIVE PAINTING**

All exposed wrought iron clamps, steel suspenders or brackets for fixing the pipes to the wall face in case of vertical pipes and suspending the horizontal run of pipes shall be painted with one coat of zinc phosphate primer and two coats of paint of approved make and shade.

19.19.7 **TEST AND GUARANTEE FOR WATER SUPPLY, SOIL AND VENT SYSTEM**

a) Water supply lines shall be tested to a hydrostatic pressure of 12 times the design water pressure at any point over a period of 24 hours. All soils, waster, rain water pipes and vents shall be tested under a pressure of 3 meters of water. Rain water pipes shall be tested to a height of water equivalent to the height of the building plus 3 meters to ensure no leakage in case of choking sections by first installing test plugs in all openings, erecting 3 metres stand pipe, filling the system with water or by hydrostatic plus air test. Pipes shall be deemed to have passed the test, if water level in the stand pipe remains reasonably constant for a period of one hour.

b) The Contractor shall deliver to NPC upon completion of this work under this Contract a written guarantee: -

i) That for a period of one (1) year after acceptance by the Engineer, plumbing and drainage work shall be free from defective material and workmanship;

ii) That for a period of one (1) year after acceptance by the Engineer the Contractor shall be responsible for the tightness of all joints make by him;

iii) That he at his own expense, repair and replace all such defective work, and all other work damaged thereby, which becomes defective during the term of guarantee;

iv) After the completion of the work, the Contractor shall obtain and hand over to NPC necessary certificates from the local authority/authorities concerned at no extra cost to NPC.

19.20 SANITARY FITTINGS/ FIXTURES AND TOILET REQUISITES

19.20.1 MATERIAL

All sanitary fixtures shall be of the best quality from approved manufacturers. Contractor has to obtain the approval from the Engineer, the names of the manufacturer whose product he proposes to use. All fixtures shall bear the seal of the approved manufacturer. All fittings, screws, gratings, etc. shall be chromium plated. The connecting lead pipes and bends shall weigh at least 3 kg per 25 mm diameter per metre length. After the fixtures are brought to the site, the Contractor shall arrange for their inspection by the Engineer and only after the approval, the fixtures shall be installed. All broken, damaged or rejected fixtures shall be removed from the site within two days after inspection.

19.20.2 INSTALLATION

All sanitary fixtures shall be installed to required level and plumb in the best workman like manner skilled labours and it shall be securely anchored to walls and floors.

All fixtures likely to be damaged shall be covered and protected during the progress of the building work, and uncovered after completion. Fixtures and accessories shall include all anchors and screw plates, screws, bolts, toggle bolts, expansion shields, set screws, wood blockings and plugs, lead connecting lead-pipes, etc. as required by the type of fixtures and accessories selected and by the type of construction to which they are connected. All fixtures and fittings shall be connected by water-tight joints. No dripping shall be accepted. All holes in walls and floors as required shall be made to the minimum desired size and depth only and they shall be properly made good and finished to match the existing finish. All brackets, supports, etc. shall be painted with a prime coat of anti-corrosive paint.

19.20.3 SANITARY FITTINGS &FIXTURES

The contractor has to mention the names of the manufacturers of the fixtures he intends to use. The sanitary fittings &fixtures shall be as described here under.

19.20.3.1 WATER CLOSETS

a) WESTERN STYLE

European water closet shall be of premium quality of size 710*390*765 mm of approved make and shade comprising of

(i) Double siphonic pattern coupled water closet with integral 'P' trap 180 mm roughing in and 'S' trap 250 mm roughing in,in glazed vitreous chinaware of matching colour.

(ii) 10 litres capacity PVC slim type single flushing low level flushing cistern (Dual Flush Tank white) with all fittings complete.

(iii) 15 mm NB heavy quality CP inlet connection pipe with brass unions and wiped solder joints at ends.

(iv) 15 mm NB screw down easy clean variety heavy quality CP brass angle valves with C.P. flange of superior quality.

(v) Germfree EWC solid seat cover (white) with C.P. brass hinges and rubber buffers of approved brand.

(vi) Jet spray provision with 1 Meter PVC tube (stainless steel) with 01 nos 15mm dia CP brass angle valve with CP flange as approved.

(vii) 15 mm NB heavy quality GI pipes and specials for overflow from cistern upto 150 mm above floor level, concealed in wall and terminated with 15 mm NB brass mosquito proof jali etc. all complete as per direction of the Engineer.

The European water closet shall be installed properly in all line and level as per direction of the Engineer.

b) INDIAN STYLE

Orissa type water closet shall be of premium quality of approved make and shade with 'P' or 'S' trap in vitreous chinaware best quality first grade with or without vent, having size 580mm x 440 mm or equivalent. It shall have following accessories.

(i) 10 liters capacity PVC slim type single flushing low level flushing cistern Dual Flush Tank with all fittings fitted over a pair of CI or MS bracket etc.

(ii) Lead valve loss syphon 15 mm nominal size, 32 mm NB GI flush pipe heavy quality of appropriate length with brass unions at end, wiped solder joints etc. complete.

(iii) 15 mm NB GI overflow pipe concealed in wall and brought down to 15 cm above floor level with mosquito proof jali at end as per specification.

(iv) 15 mm NB heavy type CP brass inlet connection with brass unions and wiped solder joints at ends.

(v) 15 mm NB heavy type CP brass screw down angle valve with C.P. brass flange of superior quality on inlet connection, recess concreting using 1:5:10 nominal mix as per site requirements.

The scope shall include all accessories, necessary brackets, supports, fittings, screws, gratings etc., installation including cutting and making good necessary opening chases etc. all complete as per specifications, drawing and as directed by the Engineer.

The WC pan shall be installed as per manufacturer's specifications. The W.C. pan shall be sunk in floor. The floor should slope towards the pan, care being taken not to damage the pan in the process of fixing. It shall be fixed on the proper cement concrete base taking care that the cushion is uniform and without having any hollows between the concrete base and the pan. The joint between the pan and the trap shall be made with cement mortar (1 cement: 1 sand) and shall be leak proof.

19.20.3.2 URINALS

(a) LIPPED URINAL

The lipped urinal shall be of premium quality white vitreous chinaware flat back lipped front urinal of approximate basin size 465 x 355 x 265 mm of approved make with PVC flushing cistern with all fittings, fitted on CI brackets, standard size galvanised iron flush pipe, waste pipe and CP brass spreaders with brass union, push cocks, specials, connecters & stopcock, CP brass fittings etc. and GI clamps, painting of fittings and brackets, cutting chase and making good the walls etc. all complete. The urinal shall be bowl type, flat back of angular, lipped front basin and shall be of glazed stoneware. It shall be fixed in position by using wooden plugs embedded in wall and screws of proper size.

The flushing of the urinals shall done for one urinal basin with 5 litres capacity automatic or equivalent with PVC flushing cistern. The flushing of the urinals shall done for range of two urinal basins with 10 litres capacity automatic or equivalent with PVC flushing cistern. It shall be supported on a pair of C.I. cantilever brackets which shall be embedded /fixed to wall by means of wooden plug and screws. The cistern shall be connected to urinal basin by means of C.F. brass flush pipe with fittings. The pipe shall be fixed by using proper holder – bat clamps.

The joint between the urinal basin and flush and waste pipe shall be made by means of putty or white lead mixed with chopped hemp.

(b) URINAL PARTITIONS

The Urinal partitions shall comprise of be premium quality black granite of 18mm thick with rounded exposed corners etc. as approved by Engineer. It shall be in size 600 x 1000 mm or as approved by the Engineer. The scope shall include installation of partitions by cutting the wall & making good the same after fixing the partitions in approved pattern including all materials, labour, fittings and fixtures complete as per specification and direction of the Engineer.

19.20.3.3 WASH BASINS

(a) STANDARD WASH BASIN

The standard wash basin shall be premium quality glazed vitreous chinaware wash basin of approved make and colour having size 550 mm x 400 mm or equivalent. This shall include one pair of wall bracket of 35mm x 35mm x 5mm M.S. angle painted with two coats of white enamel paint of approved quality and make., 32 mm NB CP brass waste coupling heavy quality with rubber plug and chain, angle valve and PVC connector, 32 mm NB CP casted brass bottle trap with extension piece and wall flange and connected C.P. pipe as approved., 15 mm NB, CP brass pillar tap heavy deluxe type with triangular / roundish knob for hot & cold water and 15 mm NB CP inlet connection with all brass unions and wiped solders joints, One no. central hole C.P. brass basin mixer without popup waste system with 450mm long braided hoses of superior quality as approved., 32mm dia B class G.I. waste pipe (concealed) of required length (from bottle trap to nahani trap) including painting with anti-corrosive bituminous paint etc. and accessory required for installation and fixing of the wash basin all complete as per the direction of Engineer. The wall plaster on the rear shall be cut to overhang with top edge of the basin.

(b) OVAL SHAPED WASH BASINS

The oval shaped was basin shall be of premium quality glazed vitreous chinaware wash basin of approved make and colour having size 560 mm x 450 mm or equivalent. This shall include one pair of wall bracket of 35mm x 35mm x 5mm M.S. angle painted with two coats of white enamel paint of approved quality and make., 32 mm NB CP brass waste coupling heavy quality with C.P. grating, rubber plug and chain, angle valve and PVC connector, 32 mm NB CP casted brass bottle trap with extension piece and wall flange and connected C.P. pipe as approved., 15 mm NB, CP brass pillar tap heavy deluxe type with triangular / roundish knob for hot & cold water and 15 mm NB CP inlet connection with all brass unions and wiped solders joints, One no. central hole C.P. brass basin mixer without popup waste system with 450mm long braided hoses of superior quality as approved., 32mm diameter B class G.I. waste pipe (concealed) of required length (from bottle trap to nahani trap) including painting with anti-corrosive bituminous paint etc. and any other accessory required for installation and fixing all complete as per the direction of Engineer.

19.20.3.4 SINK

(a) VITREOUS CHINAWARE LABORATORY SINK

The vitreous chinaware laboratory sink shall be of premium quality glazed conforming to BIS 771 Part-2 of bowl size 600mm x 400mm x 200mm with integrated drain board of approved make including all fittings, CI brackets, CP brass chain with rubber plug, angle valve and connector etc. complete with 40 mm CP brass waste fitting and 40 mm CP brass trap with necessary CP brass union, CP brass connecting pipes and any other accessory as required etc. complete as per specification and direction of the Engineer. The scope includes installation of the sink as per manufacturer's specification.

(b) STAINLESS STEEL SINK

The stainless steel sink shall be of premium quality of SS grade 304 glossy finish having size 600 x 400 x 200 mm (24"x18"x8") with edges rounded off. All fittings, fixtures, waste connection etc. shall be of standard size and appropriate for use with SS sink material. Accessories shall include: GI brackets: 32 mm NB CP brass waste coupling heavy quality with rubber plug and chain: 32 mm NB CP brass bottle trap with extension piece and wall flange: 15 mm NB CP brass inlet connection with all brass unions and wiped solders joints and all accessories such as choke stop stainer, outlet pipe upto floor trap and any other accessory as required. The sink shall be installed as required complete as per specifications and direction of engineer in charge.

19.20.3.5 **WATER CONNECTION**

Water connection to flushing cistern, wash basins and sinks shall be by means of PVC/ GI pipe connection pieces, with stop C. P. Brass cocks. The size of the PVC pipe connection and stop cock shall depend upon the size of water connection.

19.20.4 **TOILET REQUISITES**

a) MIRROR

Mirror shall be of premium quality cut edge mirror 6mm thick of overall size 600X450mm especially fabricated with superior glass (of approved quality) with designer acrylic PVC frame of approved colour and make mounted all-round with 6mm thick non-water absorbent Acrylic/PVC material backing fixed with cleats using C.P. brass screws and washers all complete as per the specifications and directions of Engineer. Scope shall include supply and fixing of mirror.

b) SHOWER SETS

Shower rose shall be of premium quality easy clean CP brass shower rose. It shall include shower arm 190mm long and wall flange of superior quality with 15 mm inlet of 100 mm diameter revolving type etc. all complete. Shower sets shall be swivel type CP brass shower rose, complete with water valve, supply pipes, and any other accessory etc. Scope shall include supply and fixing of shower rose.

c) GLASS SHELVES

Glass shelves shall be of premium quality of size 600 x 125 mm of sheet glass 6 mm thick or equivalent with CP brass brackets and guard rails, fixed to wooden cleat with CP brass screws. The scope shall include all fixtures and fittings required for installation of the glass shelves complete as per specifications and direction of the Engineer. Scope shall include supply and fixing of glass shelves.

d) TOWEL RAILS

Towel rods shall be of premium quality CP brass heavy quality of size 600 x 20mm with a pair of CP brass brackets, wall flanges etc. fixed to wall with CP brass screws, screwed on to rawl plugs. The scope shall include all fixtures and fittings required for installation of the glass shelves complete as per specifications and direction of the Engineer. Scope shall include supply and fixing of glass shelves.

e) LIQUID SOAP DISPENSERS

Liquid soap dispenser shall be of premium quality of CP brass with CP brass lid and brackets fixed to wooden cleat with CP brass screws. The scope shall include all fixtures and fittings required for installation of the glass shelves complete as per specifications and direction of the Engineer. Scope shall include supply and fixing of glass shelves.

f) TOILET ROLL HOLDER

Towel roll holder shall be of premium quality of size 150 mm x 150 mm or equivalent recess type in white glazed vitreous chinaware including cutting into wall and making good the same all complete. The scope shall include all fixtures and fittings required for installation of the glass shelves complete as per specifications and direction of the Engineer. Scope shall include supply and fixing of glass shelves.

g) COAT HOOKS

Coat hooks shall be of premium quality CP brass two pronged hooks fixed to wall / door with CP brass screws and rawl plugs including cutting and making good the wall etc. complete. The scope shall include all fixtures and fittings required for installation of the glass shelves complete as per specifications and direction of the Engineer. Scope shall include supply and fixing of glass shelves.

20 BUILDING JOINTS

20.1 EXPANSION JOINTS

20.1.1 SCOPE OF WORK

The work shall include providing and installing sealed expansion joints for various buildings in accordance with the requirements and details given in the specifications, drawings, schedule of quantities, together with the manufacturer's instructions, all to the complete satisfaction of the Engineer. The typical details of Expansion joint system are given in the enclosed drawing. The drawing given here is indicative. The contractor has to get the drawing prepared & approved before its actual use. The joints shall be designed utilizing extruded aluminum base members, self aligning / centering arrangement and support plates as applicable. The work involves sealing the Expansion Joints using properly designed extruded seals which may be mechanically fastened between extruded metal shapes, depending on the application. The design shall allow

for joint movement in all direction and shall guard against water ingress. The latter shall be provided for all external joints, joints in areas in contact with water and at all other locations as directed by the Engineer. The complete details of the material proposed to be used shall be furnished to the Engineer for his approval. The material shall be used only after obtaining the written approval of the Engineer. The contractor shall furnish the necessary documents, prepared by the manufacturer of the expansion joints, to enable the Engineer to satisfy himself regarding the suitability of the materials and adequacy of the design of the expansion joints.

20.1.2 The Work shall be carried out by the manufacturer or through an experienced manufacturer approved applicator, with the prior approval of the Engineer. In case, the work is carried out by the manufacturer-approved applicator, the manufacturer will have to provide the guarantee for the successful performance of total system including material & workmanship.

20.2 MATERIALS

20.2.1 The Expansion joint materials shall be procured from manufacturers such as Sanfield (India) Ltd. / Z. Tech (India) Pvt. Ltd/ BASF or any other equivalent as approved by the Engineer and shall be installed by the manufacturer themselves and not by any distributor / agent / any other externally appointed agency so as to guarantee the quality of workmanship.

20.2.2 The Material shall conform to the following Codes / Publications.

a) Aluminum Extrusions shall conform to ASTM B221. The alloy shall be 6063-T5 or Indian equivalent IS 63400.

b) Aluminum sheet and plates shall conform to properties of ASTM-B209. The alloy shall be 6063-T5 or Indian equivalent IS 63400.

c) Steel Shapes shall conform to ASTM-A36 or Indian equivalent IS: 2062.

d) Stainless Steel shall conform to ASTM-A-479 Gr. 304 or Indian equivalent IS: 6529 Gr. 0.4Cr18Ni10.

e) **Bronze Extrusions:** Materials shall be Architectural Bronze 385 Alloy.

f) **Electrometric Compression Seal**: these shall be preformed extruded multi-web cellular section of Chloroprene (Neoprene). Chloroprene shall conform to Clause 915.1 of IRC: 83 (Part II) and satisfy the Physical properties as Durometer Type “A” Shore hardness of 55±5and a tensile strength of 2000 PSI (min).

g) **Moisture barrier**: shall be vinyl EPDM / bituminous modified moisture barrier as recommended by the joint manufacturer or an approved equivalent, all as subject to the approval of the Engineer.

h) **Fire rated joint system**: shall have independent laboratory test reports reflecting the

endurance result of the materials run to time temperature curve.

i) **Elastomeric Joint Systems**: Material shall be a flexible extruded poly vinyl chloride or manufacturer's alternate material exhibiting a Shore "A" hardness of 64±5 with U.V. Stabilizer. Provide multi-cellular profile able to transfer loads to adjacent aluminum extrusions. The profile shall be flexible and exhibit a non-slip exposed surface that remains flat during all phases of movement. Block-out required for installation shall be provided at site by the contractor as per the dimensions given by the manufacturer.

j) Lubricant adhesive used shall be a one-part moisture curing polyurethane and aromatic hydrocarbon solvent mixture and shall conform to ASTM D4070.

k) **Visual seal**: shall be a flexible extruded poly vinyl chloride / santoprene or manufacturer's alternate material exhibiting Shore "A" hardness of 64±5 with U.V. Stabilizer. Other properties shall be in accordance with manufacturer's standard physical properties.

l) **Functional seal**: shall be flame retardant vinyl material.

m) **Sealant**: shall be a one-part polysulphide base synthetic rubber / Silicon sealant as per Manufacturer Specifications.

n) **Self-Centering Arrangement**: shall exhibit circular sphere ends that lock and slide inside the corresponding aluminum extrusion cavity to allow freedom of movement and flexure in all directions including vertical displacement so as to accommodate multidirectional seismic movement without causing stress to Joint components.

o) The materials used for Expansion Joints (other than air seal & metazeal type joint) shall have following properties.

Item Description	Given Specification	Indian Equivalent	Parameters to be Checked	Acceptable Values
Aluminium Extrusions. / Sheets & Plates	Alloy 6063-T5	IS 63400	Mechanical Properties Yield Stress (Ksi) Tensile Strength (Ksi) Elongation (%)	 15.00 21.00 8.00
Steel Shapes	ASTM – A36	IS: 2062	Mechanical Properties Yield Stress (Ksi) Tensile Strength (Ksi) Elongation (%)	 36.00 58.00 20.00
Stainless Steel	ASTM – A 479 Gr. 304	IS 6529 Gr. 0.4C Ni10	Mechanical Properties Yield Stress (Ksi) Tensile Strength (Ksi) Elongation (%)	 30.00 75.00 30.00

Neoprene Compression Seals	ASTM – D 2628	IRC – 83 (Part II) & MORT&H Specifications	Hardness (Shore "A") Elongation (%) [Min.] Tensile Strength (MPa) [Min.] Compression Set (%) [Max.]	55 +/- 5 250.00 13.80 28.00

20.3 JOINTS FOR NORMAL LOCATIONS

The Contractor shall provide all necessary accessories, related parts, devices, anchors etc. required for completing the installation of expansion joints in following locations.

a) Floor to Floor Joints at all internal locations
b) Roof to Roof Joints
c) Floor to Wall Joints at internal locations
d) Roof to Wall Joints
e) Wall to Wall Joints in exterior locations
f) Wall to Wall Joints & Slab to Slab Joints in case of underground trenches
g) Wall-to-Wall Joints & Slab to Slab Joints in case of underground tunnel subjected to ground water pressure from outside & water pressure from inside
h) Tunnel & Wall junction in case of underground structures.

20.4 JOINTS FOR CRITICAL LOCATIONS / HYDROSTATIC CONDITION APPLICATION

In case of underground structures which are susceptible for leakage due to ground water & hydraulic structures the expansion joint shall be provided with Airseal / Aladin type of expansion joint and/or Metazil type of expansion joint of M/S Sanfield / M/s BASF/ M/s Kanta Flex or any other equivalent with approval of Engineer. These joints are to be provided on the water face or both the faces depending on the wall thickness, severity of leakage & functional requirements as specified in the drawing or as directed by Engineer. These materials shall be qualified based on water hold test to the specified pressure and shall meet the following specifications.

20.4.1 AIR SEAL/ALADIN TYPE JOINT

The work shall consist supply and installation of Expansion Joint System model Airseal/Aladin of M/s Sanfield /M/s BASF or equivalent in accordance with the approved drawings and shall meet the following specifications.

The joints shall be designed utilizing neoprene profile, air pressurization and bonding in place with a specially formulated epoxy adhesive as per specifications.

The material shall be preformed, watertight, ozone and UV resistant, resilient and flexible neoprene profile with ribs on side faces for proper adhesion and bonding with the surface. The Joint shall be installed by air – pressurization technique only. Complete adhesion of the Epoxy to the neoprene seal profile and Joint Gap walls shall be achieved by air inflation during the installation. The relaxed (uncompressed) width of the seal

shall be equal to the Joint Gap value and the Seal shall be always installed in uncompressed position so as to allow maximum expansion & contraction movements. The Joint system should be able to sustain water pressures upto 2 Bars minimum.

The structural sealing joint profile shall be preformed and manufactured from an extruded neoprene compound exhibiting the physical properties listed in the table below.

TABLE 20.1
PHYSICAL PROPERTIES NEOPRENE COMPOUNDS

SL. NO.	*PHYSICAL PROPERTIES*	TEST METHOD	REQUIREMENT
1	Tensile Strength, Min.	ASTM D 412	2000 PSI
2	Elongation @ break, Min.	ASTM D 412	250 % Min.
3	Hardness, Type A Durometer	ASTM D 2240	65 + / - 5 Points
4	Oven Aging 70 hrs. @ 212 ^{o}F	ASTM D 573	
4.a	Tensile Strength	ASTM D 412	20 % loss Max.
4.b	Elongation	ASTM D 412	20 % loss Max.
4.c	Hardness	ASTM D 2240	0 to + 10 Points
5	Ozone Resistance @ 20 % Strain	ASTM D 1149	No Cracks

The adhesive used to fix the Airseal/ Aladin type joint with concrete/ steel surface shall be resistant to most common organic and inorganic acids in diluted form, also resistant to alkalis, water, oils, grease, etc. It shall have following properties.

SL. NO.	*PHYSICAL PROPERTIES*	TEST METHOD	REQUIREMENT
1	Tensile Strength, Min.	BS 6319	10 MPa @ 7days
2	Compressive Srength, Min. @ 25deg cen.	ASTM C 580	40 MPa at 1 day 60 MPa at 7 days
3	Flexural Strength	ASTM C 580	20 MPa at 7 days
4	Pot Life	ASTM C603-90	50 min at 25 deg cen. min at 40deg cen
5	Bond Strength, Min	ASTM D 4541	2 MPa.
6	Slant Bond Strength		13 MPa
7	Setting Time	ASTM D 5895	1 day Initial Cure 5 Days Final Cure

20.4.2 META ZEALTYPEJOINT

The work shall consist supply and installation of Expansion Joint System model Metazil of M/s Sanfield / M/s Z-tech or equivalent as approved by Engineer in accordance with the approved drawings and shall meet the following specifications.

The joints shall be designed utilizing a low density, closed cell, expanded polyethylene joint material and specially formulated epoxy adhesive for Bonding purpose as per specifications.

The material shall be a preformed, waterproof, ozone and UV resistant, resilient and flexible expansion Joint material. No Halocarbon gases or volatile hydrocarbons shall be used in the manufacturing of the product. The product should have a working

movement range of 60% compression and 30% tension. The Joint system should be able to sustain water pressures up to 2 Bars minimum. The same shall be demonstrated conducting water hold tests simulating site conditions. The product should be suitable for Potable water applications and should have ADA Compliance. The material shall exhibit the properties listed below.

PROPERTY	TEST	REQUIREMENTS
Density, Min.	ASTM D 3575	2.5 to 3.5 lb./cf
Tensile Strength, Min.	ASTM D 3575	70 psi
Water Absorption, Max.	ASTM D 3575	1.0 %
Compression Set, 22 hrs. @ 50 %	ASTM D 1056	
24 hrs. Recovery	(Residual Set, Max.)	8 %
Elongation @ break, Min.	ASTM D 3575	175 %
Tear Strength, Min.	ASTM D 624	13 psi

NOTE: For critical Joint locations, where the thickness of structural member (wall / slab) is exceeding 230 mm. Double layer Treatment comprising of Airseal on the critical / outer exposed face i. e. the face in contact with water / earth soil and Metazeal on the inner face is to be applied.

20.5 FABRICATION

20.5.1 Aluminum sections shall have factory-drilled holes spaced as per manufacturer's recommendation. Extrusions shall be miter cut at the site to suit directional changes.

20.5.2 Extrusions shall be supplied to site in their original packing in lengths as fabricated to suit the building dimensions.

20.5.3 Steel shapes shall be supplied in lengths as fabricated to suit the building dimensions.

20.5.4 Aluminum sections shall have mill finish unless otherwise specified.

20.5.5 Steel sections shall be blast cleaned and suitably treated against corrosion prior to their dispatch to the site. The cleaned metal surfaces which come in contact with the seal shall be protected against water logging / rusting till the seal and the adhesive are placed against the metal surface.

20.5.6 The Details of the finished colours offered by the manufacturer for Stainless Steel and Elastomeric components shall be furnished to the Engineer to enable him to exercise his choice.

20.6 EXECUTION

The expansion joint system shall be installed strictly as per the manufacturer's instructions and as directed by the Engineer. The work shall be carried out by the manufacturer or through an experienced manufacturer approved applicator, with the prior approval of the Engineer. In case, the work is carried out by the manufacturer-

approved applicator, the manufacturer will have to provide the guarantee for the successful performance of total system including material & workmanship.

20.7 QUALIFICATION OF MATERIALS

For qualification of material at site contractor shall supply the Test Certificates for the material confirming the properties given in above-mentioned tables. In addition to above one sample (3 specimens) from each batch supplied at site, shall also be tested at independent approved laboratory for all the desired properties listed above, in case of Neoprene compression seals & Airseal.

20.8 EXPANDED POLYSTYRENE BOARDS FOR EXPANSION AND ISOLATION JOINTS

20.8.1 GENERAL

Expansion and isolation joints in concrete structures shall be provided with expanded polystyrene boards of specified thickness and form expansion joints shall be provided with 500 micron thick polyethylene sheets as per the relevant drawings.

20.8.2 SCOPE

The scope of work covered under this specification is as follows:

- Supply and use of approved quality polystyrene boards wrapped in 250 micron thick polyethylene sheet at various expansion and isolation joints in all main plant buildings.
- Supply and use of 500 micron thick polyethylene sheets as form separation joint, wherever required.

20.8.3 MATERIAL

- High density polystyrene boards conforming to IS: 4671 of density 35 kg/m^3.
- Polyethylene sheets conforming ton IS: 5210 of 250 micron & 500 micron thickness.

20.8.4 DESCRIPTION

Heavy duty expanded polystyrene boards of specified thickness and sizes shall be wrapped all round with 250 micron thick polyethylene sheet. These boards shall be placed in the locations (both in vertical and horizontal) as specified in the relevant drawings. Polyethylene sheet shall be properly secured and tied in position with expanded polystyrene boards.

Wherever specified, 500 micron thick polyethylene sheet as form separation layer.

20.9 WATERSTOPS

20.9.1 GENERAL

Water stops made of polyvinyl chloride (PVC) or galvanised MS sheet shall be provided in construction joints as indicted in the relevant drawing and specifications for all main plant buildings including underground structures and tunnels.

20.9.2 SCOPE

The work under this specification comprises of

- Supply, delivery, install in position water stops in accordance with the requirements of specifications
- Polyvinyl chloride water stops
- PVC fix cap.
- Galvanised MS sheet water stop of 3.15 mm thick. Installation including necessary site connection by furing/welding.
- Testing of joints and DPT for 100% of the weld length.

20.9.3 MATERIALS

PVC water stops : Material shall conform to the following Standards of the American Society for Testing Materials (ASTM)

D412-66 Tentative method of Tension Testing of Vulcanized Rubber

D624-54 Standard method of Test for Tear Resistance of Vulcanized Rubber

D2240-64-TTentative method of Test for Indentation Hardness of Rubber by means of a Durometer

PVC fixocap type 38 or equivalent conforming to IS 4461

Metal water stops of 3.15 mm thick conforming to IS 2062 galvanised for dry film thickness of 60-100 microns.

20.9.4 DESCRIPTION

Generally water stops shall be provided in construction joints as indicated in the drawing, water stops may be PVC of different width (with or without centre bulb), fixco cap of standardtype GI water stopper of 3.15 mm thick plate made to different width. Generally, Fixo-cap shall be provided in expansion joints of underground tunnels and PVC water stops shall be provided in water retaining structures unless

specified otherwise by the Enginner .. The shear key shall be provided wherever specified and the water stops are generally located in the centre of wall at the construction joints or near to the edges in case of earth retaining walls and half of width shall be embedded into concrete. Necessary holding arrangement shall be made to ensure that water stops does not displace during concreting. It should be noted that, there shall not be any through supporting arrangement in order to prevent leakages. Continuity of the water stops shall be established by fusing or welding as the case may be. PVC water stops shall be joined together by fusing and metal water stops shall be 75 mm overlapped and welded on both sides. 100% dye penetrant test shall be carried on all joints. As far as possible care shall be taken to minimise the number of joints and also in-situ fusing/ welding.

21 Aluminium Lineal False Ceiling

Aluminium lineal suspended ceiling work shall be executed in flat, tapered, curved or circular form, both in plan and in section together with coves, etc. as required as per design.

21.1 General

Aluminium lineal ceiling shall be of Hunter Douglas as manufactured by Luxalon Building Products or approved equivalent together with all accessories and fittings such as carrier and clip, carrier splice, edge cover profile and corner splices, cross "T" connection near to the wall, etc.

21.2 Materials

21.2.1 Panels

The panels shall be 84C or 84R as per Luxalon's catalogue or approved equivalent and either plain or micro perforated. The length of the panel shall be 6m approximately. The panels shall be of any colours as approved by the Engineer, according to manufacturer's colour chart.

21.2.2 Panel carriers

Panel carriers shall be 4mm dia enamelled aluminium of satin black colour as per Luxalon's catalogue. The edges shall be provided with edge cover profile with a gap of specified width from the wall.

21.2.3 Suspension

The panel shall be suspended from the suspension system as mentioned in the relevant clause by means of adjustable turn buckle / level adjuster etc. In addition to the suspension system, the panel carriers shall be suspended by means of adjustable suspension steel rods of 4mm diameter with threaded rods and nuts for micro levelling, fixed to the slab/ beam by expansion fasteners. The expansion fasteners shall be fixed with epoxy/polyester resin. Seismic anchoring and isolation shall be provided as

directed by the Engineer. Bracing shall be provided as specified for Gypboard ceilings.

21.2.4 Acoustic Pads

Acoustic pads shall be laid on top of perforated panels. Acoustic pads shall be of the approved manufacturer and shall consist of an insulation of 25mm thick glass wool pad having a density of 32 kg/cum wrapped in glass cloth. The provision of these acoustic pads for perforated ceiling is deemed to be part of the quoted rate and noting extra shall be payable for the same.

21.3 **SHOP DRAWINGS**

Shop drawings shall be prepared for all suspended ceiling work by the Contractor. The shop drawings shall show the entire installation system, including framing around light fixtures, ducts, grilles, access panels, etc. Shop drawings shall be submitted to the Engineer for approval. It will be the responsibility of the Contractor to co-ordinate with all the service Contractor's doing work in ceilings, to incorporate appropriate suspension systems free of ducts, pipes, cable trays etc.

21.4 **APPROVALS**

The Contractor shall submit catalogues, samples of all items to be used in the ceiling and samples of workmanship, for approval of the Engineer.

22 GLASS AND GLAZING

22.1 Scope

The work in general shall consist of supplying and fixing all glass and glazing including all clips putty, mastic cement, etc., wherever required as shown on drawings and specifications.

In general, wherever applicable and unless otherwise noted, the work shall conform to IS 1081. Fixing and Glazing of metal (Steel and Aluminium) Doors, Windows, and Ventilators.

22.2 Installation

22.2.1 General

The Contractor shall supply and install all glass and glazing as required for various doors, windows, sashes, ventilators and fixed louvers, miscellaneous glazing and partitions, unless otherwise stated in the drawing or schedule. All glass shall be of superior quality from approved manufacturer like Modiguard or equivalent, having uniform refractive index and free from flaws, streaks, laminations and bubbles. The glass should be free from "wavy and rainbow formation". Float glass for glazing and framing purposes shall conform to IS : 1761 . The glass shall be brought to site in the original packing from the manufacturer and cut to size at site. The cut edges shall be straight and free from chips, spalls or any other damages. Wherever clear glass is

specified, it shall be flat drawn float glass and shall be at least 6mm thick. Where wire glass is mentioned, it shall be thick rolled glass with centrally embedded wire mesh of Georgian type. Where obscure glass is mentioned, it shall have a cast surface on one side. Heat absorbent and glare reducing glass shall be 'Calorex' of Modiguard , having a thickness of 6 mm unless specified otherwise in the schedule of Quantity. The Contractor shall submit samples of glasses for prior approval of the Engineer.

22.3 **Putty**

In general, the putty shall conform to IS:419. The putty shall be of best quality from approved manufacturer. It shall be brought to site in the manufacturer's original packing. Quick setting putty shall be used for windows and sashes except when glare reducing glass is used.

Neoprene gaskets with snap-fit glazing beads shall be fixed as per manufacturer’s instruction and shall sit snugly against glass to give a leak proof installation.

22.4 Glazing, Setting and finishing

All glazing clips, bolts, nuts, putty, mastic cement, etc. as required shall be supplied by the Contractor.

All glass shall be thoroughly cleaned before putting in position. Each glass pane shall be held in place by special glazing clips of approved type. As specified in relevant IS Codes, four glazing clips shall be provided per glass pane, except for large panes where six or more clips shall be used as per the Engineer's instructions. All holes that may be necessary for holding the clips and for all other attachments, shall be drilled by the Contractor at his own cost.

Glass panels shall be set without springing, and shall be bedded in putty and back puttied, except where moldings are specified. Putty, mastic cement, etc. shall be smoothly finished to a true even line. Obscure and figured glass shall be set with smooth side out.

Necessary glazing clips, putty mastic cement etc., shall be supplied by the Contractor. The Contractor shall be responsible for damage of glass supplied by NPCIL during handling, transportation, fixing etc. and shall replace the same at his own cost.

After completion of glazing work, the Contractor shall remove all dirt, stains, excess putty, etc. clean the glass panes and leave the work in perfectly acceptable condition. All broken cracked or damaged glass shall be replaced by new ones at Contractor's own cost.

22.5 **Float glass for Doors**

Float glass for vision panels in door shall have a minimum thickness of 4.0 mm unless otherwise specified or shown on drawings.

22.6 **Acceptance Criteria**

a) All installation shall be free from cracked, broken or damaged glass. Edge of large panes of thicker glass and heat absorbing glass shall be inspected carefully for chipping cracked or ungrounded edges.

b) Glazing shall be carefully done to avoid direct contact with metal frames.

c) All glass shall be embedded in mastic or fixed by neoprene gaskets to give a leak proof installation.

d) At completion, the panes shall be free from dirt, stains, excess putty etc. to the complete satisfaction of the Engineer.

22.7 **Drawings**

The contractor has to submit the drawings based on the above specification while quoting for these items.

23 ROOFING INSULATION, WATER PROOFING ETC.

23.1 SCOPE

The work under this specification shall cover all insulation and waterproofing necessary for the roofing work as shown in the drawings.

23.2 INSPECTION OF SURFACES

Prior to start of the work, the surfaces on which waterproofing /insulation is to be applied shall be inspected by the contractor and any visible/ noticeable defects found in the surfaces shall be rectified. The water ponding test shall be conducted by ponding water on the roof slab and maintaining minimum 50 mm head of water on it for a period of 3 days. Any noticeable leakage/ seepage shall be corrected by the contractor at no extra cost to NPCIL. The surface then shall be made clean and dry before laying screed concrete/ starting roof insulation / waterproofing work.

23.3 SCREED CONCRETE

The grading shall be provided by an under bed using M-15 grade concrete (with max 10 mm aggregate) prepared properly to the satisfaction of the Engineer Unless otherwise specified, the grading shall be done in such a way so as to ensure a run-off gradient of not less than 1 in 120. The minimum thickness at low points and/or valleys shall not fall below 25 mm. After curing the under bed for 7 days, insulation work shall be taken up with prior approval of the Engineer. The screed concrete shall be laid on the invert of gutters for maintaining slope in the gutter.

Fillets at junction of roofs and vertical walls/ pedestals etc. shall be provided along with the roof screed concrete. The fillets shall be 150 mm x 150 mm in size unless otherwise shown on drawings or instructed by the Engineer.

23.4 INSULATION

23.4.1 MATERIAL

In case of structure where thermal insulation requirements are specified in the drawings or as decided by the Engineer, the concrete surface shall be applied with polyurethane foam (PUF) insulation. The PUF should be a 75 mm thick layer of two components high density spray applied polyurethane resin foam. The spray PU foam is carried out by a smooth spraying or pouring (for small areas) action to obtain the fill. The spray application to be done using specially designed spraying machine. The product must comply to class B2 as per DIN 4102, part 1 and shall exhibit the following properties:

PROPERTY	**ACCEPTANCE VALUE**	**TEST METHOD**
Core Density	40 Kg/m^3	DIN EN ISO 845,
Thermal conductivity (λ),	< 0.024W/(m.K)	DIN 52612
R-Value of 50mm thick,	> 2.1	ECBC Code
Compressive Strength,	DIN 53423,	>175KPa
Flexural Strength,	DIN 53423,	> 250KPa
Closed Cells	ISO 4590	90%
Water Vapour Diffusion	DIN 52615	60
Water absorption,	DIN 52848	<2.25%

23.5 WATER PROOFING

23.5.1 FOR BUILDING ROOFS

After completion of the curing period of the roof slab/ screed concrete and insulation (wherever applicable), the top surface shall be waterproofed using a solvent free spray applied polyurethane membrane.

In case of concrete prior to application of PU membrane, the surface should be ensured to be sound, clean and free from grease, oil or loose particles, laitance free shall have at least 1.5N/mm2 surface strength and moisture content shall be less than 4%. The concrete can be considered sufficiently dry when the relative humidity at the surface falls to 75% or less when measured with a hygrometer conforming to BS 8201 Appendix A. The preferred surface pretreatment for concrete is grinding or scarifying as necessary for concrete or when the primer has become soiled or when the re-coating interval has been exceeded.

The scope of work shall cover supply and application of one coat of primer (DFT 75 micron) and polyurethane membrane of approved make for total dry film thickness of 2200 microns comprising 2000 Microns thick (DFT) base coat of aromatic/ aliphatic PU and 200 Microns thick (DFT) UV resistant Aliphatic PU top coat excluding primer on flat or curved roofs.

a) Priming shall be done when the temperature of the substrate is at least 3 degrees above the dew point with a two pack epoxy primer with outstanding resistance properties and shall contain a high level of penetrating pigment which renders superior performance when sprayed over concrete having the following properties:

PROPERTY	**TEST METHOD**	**UNITS**	**ACCEPTANCE VALUE**
Density	ASTM 4052	g/cc	1.09 + 0.05 at 25°C
Mixing Ratio, by weight	IS 104		As per manufacturer recommendations
Flexural Strength	ASTM C 580-02	MPa	>30 at 7 days
Tensile Strength	BS6319 Pt 7	MPa	>20 at 7 days
Compressive Strength	ASTM C 579	MPa	>65 at 1 Day >70 at 3 Days >75 at 7 Days
Adhesive Bond Strength	ASTM D 4541	MPa	>1.5 at 25°C

For acceptance of material listed in above table, Manufacturer Test Certificate (MTC) from manufacturer confirming to above specified properties except for Tensile, Compressive &Bond strength shall be acceptable. The Tensile, Compressive & Bond strength tests shall be conducted by the contractor as per QAP in laboratories like IITs, ICT etc. or other Government approved/ NABL accredited laboratories as acceptable to NPCIL at no extra cost to NPCIL.

On the tacky primer surface, sand shall be broadcasted using dried, graded silica sand (size 0.3 to 0.9 mm) on to applied Primer Coat prior to its hardening. The sand shall be evenly spread over the entire primed surface at the rate of 0.8 to 1.0 Kg/m2. When the surface is sufficiently cured, the surface is vacuumed to remove any loose sand.

The waterproofing system base coat shall be solvent free, two-component, fast setting, seamless spray applied Aromatic / Aliphatic Polyurethane (PU) membrane installed over the roof on primed substrate (concrete screed) using a pneumatic machine as per the manufacturer's specifications. The machine for application shall have optional pressure monitor kit to assure on mixing ratio. The pressure gauge shall monitor the spray pressures on both sides and shall automatically shut down the sprayer in case of non-acceptable conditions, like running out of material, pump cavitation, packing failures, leaks in valves or fittings, or plugged filters. The two component spray applied PU membrane for base coat shall have a total average dry film thickness of 2000 microns (excluding primer and top coat, with no single value less than 1800 microns). It shall possess the following properties:

Sr No	Property	Test Method	Values
1	Solids Content	ASTM D2697	> 95%
2	Density	ASTM D1475	>1.0 g/cm3
3	Ready for Light Traffic	DIN 53213	Max. 60 seconds
4	Adhesion Strength	ASTM D4541	Minimum 3.5 N/mm^2
5	Tensile Strength	ASTM D 412	> 8 MPa
6	Impact Strength	ASTM G14	>190 N/sq mm
7	Elongation at break	ASTM D 412	>400%
8	Average Tear Propagation	DIN 53363	>35 N/mm
9	Tear strength	ASTM D624	>25 N/mm
10	Puncture Resistance	ASTM E 154	>300 N
11	Crack bridging	ASTM C 836	No crack till 5 mm crack width
12	Shore Hardness (Shore A)	ASTM D2240	>65
13	Taber Abrasion Resistance	ASTM D4060	< 70 mg
14	Water Vapor Transmission	ASTM E 96	0.11 g/m2/day
15	Root Resistance	DIN 4062	No penetration

For acceptance of material listed in above table, solid content, density, tensile strength, % elongation at break, crack bridging & shore A hardness shall be performed in laboratories like IITs, ICT etc. or other Government approved/ NABL accredited laboratories as acceptable to NPCIL for every individual batch. For all other tests, MTC from manufacturer conforming to above specified properties shall be acceptable. Pull off adhesion test shall be done at site as per relevant standards using a portable pull off adhesion tester. All the laboratory tests shall be conducted by the contractor as per QAP at no extra cost to NPCIL.

b) The solvent free, two-component, spray applied base Polyurethane membrane system shall be protected using a two-component polyurethane UV stable aliphatic top coat having average 200 microns thick DFT (with no single value lesser than 150 microns). The top coat material shall have following properties:

Sl No.	Property	Test Method	Values
1.	Elongation at break (14 days)	ASTM D 412	>150%
2.	Tensile Strength (14 days)	ASTM D 412	>10 Mpa
3.	Tear strength	DIN 53515	>60 N/mm
4.	Density (Mixed)	At 20ºC	1.2 g/cm^3
5.	Viscosity (Mixed)	ASTM D2393	2000-4000 CPS at 23 degree C
6	Accelerated UV resistance	ASTM G 154	>1000 hours i.e No cracking, blistering or flaking
7	Shore A Hardness	ASTM D 2240	89

For acceptance of material listed in above table density, tensile strength, % elongation at break & shore "A" hardness as applicable shall be performed in laboratories like IITs, ICT etc. or other Government approved/ NABL accredited laboratories as acceptable to NPCIL for every individual batch. For all other tests, MTC from

manufacturer confirming to above specified properties shall be acceptable. All the laboratory test shall be conducted by the contractor as per QAP at no extra cost to NPCIL.

23.6 PROTECTION SCREED CONCRETE

The water proofing done on roof other than OC dome shall be protected against damage due to working of other agencies on the roof top, wherever specified or decided by the Engineer. The membrane shall be overlaid with a layer of M-15 grade concrete (with max 10 mm aggregate) for a thickness of 50mm. The concrete shall be laid in panels of 2m x 2m, with an expansion groove 10 mm wide and 15 mm deep between the panels. The expansion groove shall be sealed with polyurethane sealant.

23.7 TESTING OF THE ROOF WATER PROOFING

The water proofing system on roof other than OC dome shall be tested by ponding water for a depth of 50 mm over the membrane layer, before laying the protective screed concrete. The water shall be retained for a period of 24 hrs and inspected for leakages if any. In case leakage/ seepage of water is observed, the contractor shall identify the leakage/ seepage spots and take corrective action as per manufacturer's recommendations at no extra cost to NPCIL. Repair procedure shall have the approval of the Engineer. The cost of testing the water proofing system is deemed to be included in the item rate for water proofing.

23.8 PROJECTING PIPES AND PEDESTALS ON ROOF TOP

The pedestals on the roof top and pipes passing through a roof on which water proofing treatment is to be laid, a cement concrete angle fillet shall be built around it. The spray PU water proofing treatment shall be taken over the fillet in the manner shown in drawings. Where pipe is passing through pipe sleeve embedded in concrete, a 20 mm Square groove shall be cut at top of concrete around pipe sleeve and the same shall be filled with a hydro-swelling polymeric paste of 1.5kg/litre mix density. The paste shall be formulated to exhibit low premature swelling (less than 50% within 12 hours) and shall not release super absorbents during its service life. The re-swelling paste shall have low swelling pressure; not exceeding 0.25 MPa at full swelling capacity; confined between mortar & cement concrete angle fillet.

23.9 QUALITY ASSURANCE & SUPERVISION

A detailed work procedure in line with this specification and manufacturer's specification with resources deployment shall be prepared by the contractor and submitted to NPCIL for approval before proceeding with the work. Contractor shall carry out testing of materials as per direction of Engineer and shall submit testing reports and manufacturer's test certificates to the Engineer. A strict check on coating thickness and consumption of coating material shall be exercised by Contractor's QA Engineer and necessary records in this regard shall be submitted to NPCIL. Contractor shall provide necessary assistance to NPCIL in supervision of roof insulation and water proofing work and checking of PU coating thickness.

During the entire process of work under this specification, the Contractor shall arrange at his own cost the supervision of the work on insulation, water proofing and flashing by the manufacturer's representative to ensure that the work is being executed as per manufacturer's specifications and instructions.

23.10 GUARANTEE

The Contractor shall be responsible for maintaining the roof top insulation for a period of 10 years from the date of acceptance of the water proofing work by the Engineer. The Contractor shall make periodical inspection especially before start of the rainy season and repair the waterproofing for any apparent defects to ensure effectiveness of water proofing during the guarantee period.

The Contractor shall submit a bank guarantee from a scheduled commercial bank (other than co-operative bank) for 10% of the cost of roof insulation and water proofing works carried out. The bank Guarantee shall be valid for a period of five years from the date of acceptance of the water proofing work by NPCIL.

24 SURFACE DRAINS, UNDERGROUND TUNNELS, TRENCHES, SEWAGE CONVEYING SYSTEM ETC.

24.1 SCOPE

This specification covers furnishing all materials, plant, labour, equipment tools and services for the complete and proper construction of storm water, surface drainage, pitching using fly ash bricks and culverts as specified herein and shown in the drawings including all surveying and setting out necessary for the same and clean up of working areas.

24.2 GENERAL

All drains and culverts shall be constructed at the locations shown in the drawings or as directed by the Engineer. Care shall be taken to avoid clogging of the drains during progress of the work and should any drain become clogged or obstructed from any cause until final acceptance of the work, it shall be cleaned in a manner as approved by the Engineer or replaced by the contractor at no extra cost to NPCIL.

24.3 EXCAVATION

Excavation for storm water/ surface/ cut off drain and for culverts/ for laying RCC hume pipes shall be carried out as per the requirements covered in the technical specification for 'Excavation, Dewatering and Backfilling'

The excavated material shall be removed from the excavated/ adjoining area and disposed of at location(s) as directed by the Engineer.

24.4 STORM WATER/ SURFACE DRAINAGE

Where shown in the drawings, storm water/ surface drainage shall be constructed consisting of RCC trenches. Storm water/ surface drains shall be placed to prevent ground water from flowing directly into the structures and shall be constructed to a line and grade to allow proper drainage over the area of the site to the nearest natural drainage and in turn to the nearest natural water body. The contractor shall construct the storm water/ surface drainage system as per the details shown in the drawings.

24.5 PITCHING

Fly ash bricks of nominal size of 230x110x70 mm having compressive strength of minimum 75 Kg/sq cm shall be used in the work. Bricks shall be laid over sloped/ flat surfaces of the drain over well prepared and compacted bed of insitu soil. The joints between the bricks shall be filled with 1:6 cement mortar. Provision of weep holes with filter media etc. shall be provided in the pitching.

24.6 CUT OFF DRAINAGE

Where shown in the drawings, deep cut off drains shall be constructed at the various elevations to a line and grade to allow lowering of ground water levels and to arrest seepage water and surface runoff and direct the same to the nearest natural drainage for further flow to the nearby water body. The cut off drains shall consist of deep trenches, with concrete lining finished smooth of the bottom and the side facing as given in the drawing.

24.7 CULVERTS

Excavation in trenches for foundation of culverts and wing walls shall be done with side slopes as per drawings and as directed by the Engineer after clearing the site etc. as per specifications of Earthwork. The construction of culverts shall be done true to line and levels as shown in drawings. The specification for masonry and/or plain and reinforced concrete shall be followed as applicable**.**

24.8 REINFORCED CONCRETE SPUN PIPES

24.8.1 GENERAL

The drainage pipes unless otherwise shown in the drawings or instructed by the Engineer shall be made of R.C.C. and shall be of class NP3.

Pipe culverts shall also be made of reinforced concrete pipe and shall be of class NP3. All pipes materials shall meet the requirements of IS: 458-Latest edition and shall be procured from approved manufacturers with collars as per manufacturers standard specifications.

24.8.2 APPLICABLE CODES

The manufacture, testing, supplying, jointing and testing of pipes at worksite shall comply with the code of practices, latest revisions, as given below:

IS: 456 Code of practice for plain and reinforced concrete

IS: 458 Specification for concrete pipes (with and without reinforcement)

IS: 783 Code of practice for laying of concrete pipes

IS: 3597 Method of tests for concrete pipes

24.8.3 CARTING AND HANDLING OF PIPES

Pipes and fittings shall be transported from factory to work sites by the Contractor and he shall be responsible for the safety of the pipes in transit and loading/unloading. Any pipe, which shows sufficient damage to preclude it from being used, shall be discarded. Dragging of pipes along concrete or similar pavements shall not be allowed.

24.8.4 STORAGE OF PIPES

Storage shall be done on firm level and clean ground and wedges shall be provided at the bottom to keep the stack stable. The stack shall be in pyramid shape with height of pyramid not exceeding 1500 mm.

24.8.5 LAYING OF PIPES

a) Laying of concrete pipes shall correspond to IS: 783 – Latest edition – and specification given below. Safety requirements to be provided while laying of pipes shall conform to IS: 3764.

b) The foundation bed for pipe shall be excavated true to lines and grades shown in the drawings or as directed by the Engineer. When trenching is involved its width on either side of the pipe shall not be less than 150 mm not more than one-third the diameter of pipe unless otherwise instructed / permitted by the Engineer. The sides of the trench shall be as nearly vertical as possible. Side slope, shoring, bailing out water, etc. as required shall be done by the contractor without any extra cost. Side slope, if there be any, shall be removed by the contractor without any extra cost. Pipes shall be carefully lowered with the help of tripods with chain pulley blocks or any other mechanical means in the approved trenches. In no case pipe shall be dropped. Pipes damaged during lowering shall be rejected by the Engineer. After laying of the pipes are completed, back-filling of the trenches shall be done in 250 mm layers measured loose, clods and lumps broken, watered and compacted with iron rammers to the satisfaction of the Engineer. The surplus spoils shall be transported and filled in low-lying areas within the plant area, as instructed by the Engineer.

c) When bed-rock or boulder strata are encountered, excavation shall be taken down to at least 200 mm below the bottom level of the pipe with prior permission of the Engineer and all rock / boulders in the area shall be removed and space filled with approved earth free from stone of fragmented material, shaped to the requirements and thoroughly compacted to provide adequate support for the pipe.

d) Filling of trench shall be carried out simultaneously on both sides of the pipe in such a manner that unequal pressures do not occur.

e) When two or more pipes are to be laid adjacent to each other, they shall be separated by a distance equal to at least half the diameter of the pipe subject to a minimum of 450 mm.

f) Laying of pipes shall start from the outlet and proceed towards inlet. Pipes are to be laid perfectly true both in alignment and to gradient specified. Pipes must be secured in place with approved backfill material tamped under it except at the collar. Precaution shall be taken to ensure that dirt do not enter jointing space. Pipes shall be laid such that the marking on pipes appears at the top of the pipes.

g) Pipe bedding shall be first class projection bedding for positive projecting pipes as per IS: 783 – Latest edition – having a projection ratio of not greater than 0.70, in which the pipe shall be carefully bedded on fine granular materials in an earth foundation, carefully shaped to fit the lower part of the pipe exterior for at least ten percent of its overall height, and in which the earth filling material shall be thoroughly rammed and tamped in layers not exceeding 15 cm in depth around the pipe for the remainder of the lower 30 percent of its height.

h) If the pipe is laid in trench, pipe bedding shall be first class bedding as per IS: 783.

i) When indicated on the drawings or directed by the Engineer, the pipe shall be bedded on a cradle constructed of concrete having a mix not leaner than N/20. The shape and dimension of the cradle shall be as indicated on the drawing or directed by the Engineer. The pipe shall be laid on the concrete bedding before the concrete has set.

j) The drop walls shall be made with first class brickwork or stone masonry in 1:4 cement mortar.

k) The pipe culverts shall be made with proper care regarding the invert of the pipe, gradient, if any, etc. as specified on drawings and / or instructed by the Engineer.

24.8.6 Where R.C.C. pipes are encased in concrete at road crossings or at other places the pipes shall be suitably supported avoiding reinforcements of concrete blocks, and joints properly done before concreting is taken up. Concreting of total height of the block may be done in one single operation or may be done up to some height for pipes to be properly laid in position and the remaining height of the block concreted subsequently.

24.8.7 The R.C.C. pipes shall be joined with cement mortar. Cement mortar shall consist of 1 part cement and 2 parts of clean sand with only enough water for workability. Procedure of jointing shall be as per IS: 783 – Latest edition.

24.9 ROOF DRAIN PIPING

24.9.1 Double walled corrugated pipe (For underground works)

Underground double walled corrugated pipe conforming to IS: 16098, Part 2, stiffness class SN 8 shall be provided for roof drains works. The scope of work includes supplying pipes including jointing of pipe to pipe or pipe to long neck pipe ends by electric heating mirror at site, joints to be flanged joints, laying and jointing conforming to IS: 7634 (Part-2), cutting and trimming of pipes, preparation of bends as per requirement at site, preparation of bed for laying the pipes and any other fitting, fixtures, accessories required to complete the job etc. all complete as per manufacturer's specification and direction of the Engineer.

24.9.2 HDPE pipes for Roof drains works (Above ground)

HDPE pipes conforming to IS: 4984, grade PE 100, pressure rating PN 6 shall be used for elevated roof drain works. Scope of work includes supply of pipes including jointing of pipe to pipe or pipe to long neck pipe ends by electric heating mirror at site, joints to be flanged joints, laying and jointing conforming to IS: 7634 (Part-2), cutting and trimming of pipes, preparation of bends as per requirement at site, preparation of bed for laying the pipes etc. and any other fitting, fixtures, accessories required to complete the job etc. all complete as per manufacturer's specification.

24.9.3 RAIN WATER DOWN COMERS

24.9.3.1 GENERAL

Rain water down comers shall be ultra violet stabilized UPVC rain water pipes conforming to IS: 13592 Type-A and shall run along the exterior wall / column surface of all main plant buildings, unless specified otherwise.

24.9.3.2 SCOPE

The scope of work comprised in this specification are as follows:

- Supply, erection, fixing UPVC pipes at various elevations of main plant buildings including UPVC/ heavy cast iron roof drain and floor drain, all fittings and fixtures and including leak testing of the erected system.

- Supply, fixing necessary fittings inclusive of shoes, gratings, bends, sockets etc.

24.9.3.3 MATERIALS

- Ultra violet stabilized UPVC rain water pipes conforming to IS: 13592 Type-A and fittings conforming to IS 5382/ IS14735.

24.9.3.4 DESCRIPTION

Rain water down comers shall run along the exterior surface of walls/ columns and longitudinally over the roof and to be secured well to walls/ columns with strong clamps/ brackets as specified in the relevant drawings. Where desired by the Engineer these may have to be installed in chases cut in the structure. The brackets may be of galvanized iron/ anti-corrosive material clevis type, split ring or perforated strap iron type as approved by the Engineer. For vertical runs each pipe shall hang freely on its brackets fixed just below the socket. Suitable spacer shall be provided against the vertical surface. All bends and junctions shall be supplied with water-tight clean outs.

Roof drains at top shall be provided at locations as specified in the drawing and shall be provided with suitable MS gratings where ever specified.

25 QUALITY CONTROL, SURVEILLANCE AND ASSURANCE REQUIREMENTS

25.0 SCOPE

This chapter specifies requirements to be incorporated in the Contractor's quality assurance program for construction. The Contractor is responsible for planning and developing a program that assures that all his management, design and technical responsibilities for quality are incorporated and executed effectively. The program is aimed primarily at ensuring an efficient quality management in construction and taking corrective actions, when necessary.

Planning and detailed written procedures are essential for specifying how such activities as the following, which affect quality, are to be performed and controlled.

a) Design management whenever applicable

b) Procurement

c) Construction

d) Special processes

e) Measuring and testing equipment

f) Inspection and test

g) Handling, storing, preservation, packaging and shipping.

h) Item identification and traceability

i) Documentation and quality records.

j) Disposition of non conformances and corrective action.

25.1 APPLICABILITY

The requirements of this chapter apply to the construction activities when specified in a contract.

25.2 CONTRACTORS RESPONSIBILITIES

The Contractor's responsibilities

a) To develop and implement the controls and quality assurance procedures, specified herein, that will promptly detect and dispose of, or prevent, non-conformances to contractual requirements.

b) To comply with the NPCIL's requirements as specified in the contract.

c) To prepare a quality assurance manual which shall be submitted for the Purchaser's concurrence before the contract is awarded or at the latest before the work starts. This manual should cover activities of building design consultant, proof check consultant and building contractor and their subcontractors.

d) To prepare a quality plan which shall be submitted to the Purchaser before the work starts, as required in 25.3.3 (b).

e) To update and resubmit the quality assurance manual and quality plan to reflect current practices when significant changes occur in the Contractor's program or organization in order to improve its effectiveness or to prevent recurrence of non-conformances.

f) To initiate corrective measures promptly when the quality assurance representative notifies the Contractor of deviations from established requirements.

25.3 DEFINITIONS AND REQUIREMENTS

25.3.1 QUALITY ASSURANCE PROGRAM

The Contractor shall plan, establish, implement and maintain a quality assurance program that complies with the requirements of this chapter.

25.3.2 ORGANISATION

The Contractor shall :

a) Clearly define management policies, objectives and responsibilities for quality

assurance, including the responsibility of each division within a multi-divisional organization. The responsibility and authority for quality of those managing and performing the work and of these auditing and verifying conformance to quality requirements shall be defined and their relationships shown on organization charts.

b) Provide for the review by management of the status and adequacy of the quality assurance program.

c) Appoint a representative who shall report regularly to management at a level that ensures that quality assurance requirements are not subordinated to design, manufacturing, construction or delivery and define his authority to resolve quality matters. Purchaser shall be notified of the appointment in writing.

d) Define the responsibility and authority of personnel who are primarily responsible for quality assurance and their organizational independence during audits and define the responsibility and authority of personnel who are primarily responsible for quality control and their organisational independence to :

- identify and record quality problems
- initiate or recommend or provide solutions through designated channels.
- verify the implementation of dispositions.
- control further processing, delivery or installation of a non-conforming item or service until the deficiency or unsatisfactory condition has been resolved.

Note that, generally, audit personnel shall not be within the pattern of daily activities.

e) Use competent persons for inspection, other than those performing or directly supervising the work being inspected, unless specifically designated otherwise in the quality plan. Such persons shall report to an adequate level of management, excluding direct reports to supervisors responsible for producing the work being inspected.

Generally, inspectors shall verify the conformance to the specifications and drawings. In cases of problems or difficulties they shall request clarification from the design or other competent organisations and initiate appropriate measures.

If examinations, being a part of the whole inspections, are performed and documented by works personnel, the extent of the inspections by the independent personnel may be reduced, if such has been provided for by the quality plant.

25.3.3 QUALITY ASSURANCE DOCUMENTS

a) QUALITY ASSURANCE MANUAL

i) The Contractor shall :

- Prepare a quality assurance annual, approved and signed by a senior management official, and submit it for the Purchaser's concurrence before the contract is awarded

or at the latest before the work starts. A quality assurance manual submitted under a previous contract or tender maybe referred to.

- Review and update the manual to reflect current quality assurance polices and procedures and resubmit the resulting manual.

- Implement the program according to the provisions specified in the manual.

ii) The quality assurance manual shall deal as appropriate with the following :

Organization - The manual shall define the organizational measures as specified 25.3.2.

Quality plan - The manual shall identify the group responsible for the quality plant specified in 25.3.3 (b) and define its main principles and features in adequate procedures.

Quality assurance procedures - Documented quality assurance procedures as specified in 25.3.3(c) shall be included or shall be outlined and cross- referenced. Referenced QA procedures shall be made available to the quality assurance representative.

Manual review - A statement shall be incorporated for reviewing and updating the manual as specified in 25.3.3. (a)(i).

b) <u>QUALITY PLAN</u>

i) The Contractor shall :

- Plan the inspection and test activities

- Identify in the quality plan the inspections and tests to be performed on the items listed in the contract, in compliance with contractual and/or technical requirements.

- Submit the plan for the Purchaser's concurrence following the award of the contract and before the work starts. Referenced inspection and test specifications and/or procedures shall be made available to the quality assurance representative during the implementation of the quality plan.

- Update the plan during the life of the contract to reflect current conditions of manufacturing, construction, inspecting and testing and resubmit the plan to the Purchaser.

b) ii) The quality plan may be of any format to suit the Contractor's system. The quality plan shall deal as appropriate with :

- Identification of the characteristics or items to be inspected and tested.

- Identification of required inspection, test and special process operations and their

relative location in the construction cycle. The Contractor may include additional in-process inspection points for his own evaluation of quality which will not be subject to acceptance and witness by the quality assurance representative.

- Reference to inspection, test and special process procedures, standards, acceptance criteria and sampling plan, if any.

- Indication of hold points beyond which the activity shall not proceed until the required inspections or tests have shown satisfactory results and have been documented.

- Provisions for the Purchaser to insert witness points at which activities are to be observed. The activity may nevertheless proceed beyond a witness point should the Purchaser fail to attend in spite of due notification.

b) iii) The quality plans for subcontracted items, when concurred with by the Contractor, shall be submitted to the Purchaser as applicable, for concurrence & insertion of witness points.

c) <u>QUALITY ASSURANCE PROCEDURES</u>

The Contractor shall have procedures for the following specific requirements should they apply to the contract :

Document control	Cl.25.3.3
Design Control	Cl.25.3.5
Procurement	Cl.25.3.6
Measuring and testing equipment	Cl.25.3.7
Inspection and test	Cl.25.3.8
In-process inspection	Cl.25.3.9
Final inspection	Cl.25.3.10
Inspection status	Cl.25.3.11
Identification and traceability	Cl.25.3.12
Preservation, handling and storage	Cl.25.3.13
Construction	Cl.25.3.14
Special processes	Cl.25.3.15
Quality records	Cl.25.3.16
Non-conformances	Cl.25.3.17
Corrective actions	Cl.25.3.18

Each QA procedure shall define, as applicable, such things as: its purpose and scope; who is responsible for what; how all steps are to be performed; what materials, equipment and documentation are to be used; how it is all controlled.

Forms used shall be exhibited.

QA procedures shall be updated when necessary.

25.3.4 SPECIAL REQUIREMENTS

The Contractor shall

a) Establish measures to ensure that all essential quality related documents including but not limited to those listed below are reviewed for adequacy and approved for release by authorized personnel.:

i) Quality assurance manual required by 25.3.3 (a)

ii) Quality plan required by 25.3.3 (b)

iii) Quality assurance procedures required by 25.3.3(c)

iv) Design documents required as a consequence of 25.3.5

v) Procurement documents required by 25.3.6

vi) Calibration procedures required by 25.3.7

vii) Inspection and test procedures required by 25.3.8

viii) Manufacturing documents required by 25.3.13

ix) Special process procedures required by 25.3.15

b) Establish distribution lists for the above mentioned documents, update and maintain them in the current form to assure that the proper personnel are issued with all the documents necessary to perform the work.

c) Make the applicable issues of these documents available at areas where these activities are performed.

d) Establish and update lists of applicable documents for construction and distribute them systematically. Controlled distribution is required for these lists only.

e) Ensure that changes to documents receive the authorizations by the same organizations as the initial documents unless other organizations are specifically designated. Maintain a record of changes as they are made. Written notes or documents are acceptable provided that they are made by authorized persons according to established procedures. Documents shall be revised and re-issued after a practical number of changes have been issued.

25.3.5 DESIGN CONTROL

a) General

The supplier shall establish and maintain documented procedures to control and verify

the design of the product in order to ensure that the specified requirements are met.

b) Design and development planning

The supplier shall prepare plans for each design and development activity. The plans shall describe or reference these activities, and define responsibility for their implementation. The design and development activities shall be assigned to qualified personnel equipped with adequate resources. The plans shall be updated as the design evolves.

c) Organizational and technical interfaces

Organizational and technical interfaces between different groups which input into the design process shall be defined and the necessary information documented transmitted and regularly reviewed.

d) Design input.

Design input requirements relating to the product, including applicable statutory and regulatory requirements, shall be identified, documented and their selection reviewed by the supplier for adequacy. In complete, ambiguous or conflicting requirements shall be resolved with those responsible for imposing these requirements.

Design input shall take into consideration the results of any contract review activities.

e) Design output

Design output shall be documented and expressed in terms that can be validated against design input requirements.

Design output shall :

i) Meet the design input requirements.

ii) Contain or make reference to acceptance criteria;

iii) Identify those characteristics of the design that are crucial to the safe and proper functioning of the product (e.g. operating, storage, handling, maintenance and disposal requirements).

Design output documents shall be reviewed before release.

f) Design review

At appropriate stages of design, formal documented reviews of the design results shall be planned and conducted. Participants at each design review shall include representatives of all functions concerned with the design stage being reviewed, as well as other specialist personnel, as required. Records of such reviews shall be maintained

.

g) Design verification

At appropriate stages of design, design verification shall be performed to ensure that the design stage output meets the design stage input requirements. The design verification measures shall be recorded.

NOTE : In addition to conducting design reviews, design verification may include activities such as

- performing alternative calculations.
- Comparing the new design with a similar proven design,, if available.
- Undertaking tests and demonstrations, and
- Reviewing the design stage documents before release.

h) Design validation

Design validation shall be performed to ensure that product conforms to defined used needs and / or requirements.

NOTES:

11. Design validation follows successful design verification .
12. Validation is normally performed under defined operating conditions.
13. Validation is normally performed on the final product, but may be necessary in earlier stages prior to product completion.
14. Multiple validations may be performed if there are different intended uses.

i) Design changes

All design changes and modifications shall be identified, documented, reviewed and approved by authorized personal before their implementation.

25.3.6 PROCUREMENT

a) Selection of Subcontractors

The Contractor shall identify items to be procured. He shall undertake the following :

i) Determine for these subcontracted items the applicable Quality Management

Requirements. Classification of these Quality Management Requirements shall be in such a y that the overall quality is not impaired. The classification list shall be submitted to the Purchaser for acceptance.

ii) Evaluate and select subcontractors in accordance with of the applicable Quality Management Requirements with regard to their ability to meet subcontract and quality requirements.

iii) When `off the shelf' items are to be procured, evaluation of subcontractor may not necessarily be required. The Contractor shall nominate to the quality assurance representative those materials, parts and components that belong to this category.

b) <u>SUBCONTRACT REQUIREMENTS</u>

The Contractor shall include in subcontracts the following, as applicable:

i) A clear description of the items or services to be procured including technical data and inspection and test requirements by reference to standards, technical specifications, drawings, etc.

ii) A designation of the applicable Quality Management Requirements to be applied to the items and exceptions, if any.

iii) A designation of the Contractor's QA procedures to be implemented by the subcontractor, if applicable.

iv) Instructions for the submission, retention and disposition of quality records.

v) Requirements for packaging and shipping, where applicable.

vi) A statement related to the right of access to the subcontractor's premises and records for audit and/or surveillance by the Contractor or the Purchaser.

vii) Instructions for notification of witness points.

viii) Requirements for the subcontractor to report non-conformances.

ix) Applicable requirements to be extended to lower tier subcontractors, if any.

Subcontract documents shall be reviewed and approved in accordance with 25.4.4 (a).

All unpriced subcontracts and associated reference data shall made available on request for review by the quality assurance representative.

c) **Amendments to Subcontracts**

The Contractor shall process amendments to sub- contracts in the same way as the initial subcontract and reference the initial subcontract number in the amendments.

d) Verification of the Quality Management System Implemented by the Sub-contractor Refer applicable Quality Management Requirements.

e) **Receiving Inspection**

To the extent that is practical, receiving inspection shall be specified in the quality plan.

The Contractor shall:

i) Identify and inspect items on receipt to ascertain that they comply with contractual requirements. In determining the amount or nature of receiving inspection, consideration shall be given to the surveillance exercised at source and documented evidence of quality conformance. Receiving inspection shall cover as a minimum: verification of deterioration or damage during transport, identification control, review of required documentation.

ii) Initiate corrective action with sub-contractors when non-conforming items are received, as required by the nature and frequency of non-conformances.

iii) Hold incoming items until the required inspection and/or test have been completed or the necessary inspection and/or test reports have been received and verified except when items are released under positive recall.

25.3.7 **MEASURING AND TESTING EQUIPMENT**

All measuring and testing equipment and devices used to verify characteristics that can affect item quality shall be controlled and maintained. At prescribed intervals, or prior to use, they shall be calibrated and adjusted against certified equipment having a known valid relationship to nationally recognized standards. Where no national standards exist, the basis employed for calibration shall be documented.

No special calibration and control measures are necessary on rulers, tape measures, levels and other such devices, if normal commercial practices provide for adequate accuracy and/or if large tolerances are allowed for the corresponding measurements.

The Contractor shall:

a) Include in calibration procedures; equipment type, frequency of checks, description of check method, acceptance criteria and action to be taken when results are unsatisfactory. Exception will be allowed for measuring and testing equipment for which calibration is simple and does not require a specific detailed procedure. The Contractor shall identify those types of measuring equipment for which he has not

provided calibration procedures.

b) Identify measuring and testing equipment with a tag, sticker, or other suitable indicator to show the calibration status.

c) Maintain calibration records for measuring and testing equipment.

d) Assess and document the validity of previous inspection and test results when measuring and testing equipment are found to be out of calibration.

For concreting and earthwork activities :

e) The above mentioned requirements are mandatorily applicable only to the following equipment and instruments :

- laboratory scale
- concrete batching plant
- compression test machine
- tensile test machine
- prestressing pressure gauge
- soil-cement batching plant
- gauge for mechanical splicing
- grout batching machine

For all other equipment and instruments, the requirements are non-mandatory but they may be used as a guide.

25.3.8 **INSPECTION AND TEST**

a) The Contractor shall provide for the performance of inspections and tests as specified in the quality plan. These inspections and tests shall be carried out in accordance with written procedures that define the method, the materials, instruments or equipment to be used and acceptance/rejection criteria.

The Contractor shall amend the selected inspection methods in cases where their unsuitability is demonstrated.

b) Inspections and tests shall be documented on inspection and test reports that identify as a minimum the item inspected or tested, applicable drawings, specifications or procedures, the date of inspection or test, the inspector, tester or data recorder, the type of observation, the results, the acceptability and the action taken in connection with any deficiencies identified.

25.3.9 **IN-PROCESS INSPECTION**

The Contractor shall:

a) Identify, inspect and/or test items as required by the quality plan.

b) Monitor process methods, where inspection is not feasible.

c) Hold items until the required inspections and/or tests have been completed or necessary reports have been received and verified except when items are released under positive recall. Release under positive recall shall not preclude (a) above.

For concreting activities :

i) The Contractor shall establish adequate measures for preconcreting, in-process and post-concreting inspections to be performed as applicable.

ii) A part of these inspections and the documentation thereof may be delegated to the works personnel. In such cases, the independent inspections can be reduced to an extent to be defined in the quality plan or in the inspection procedures.

This applies particularly to the case where a specialist is incorporated into the work staff for difficult or sophisticated tasks such as reinforcement placing, prestressing, etc.

iii) Such measures do not preclude complete independent inspections to be performed on a programd basis or as a consequence of results obtained.

25.3.10 **FINAL INSPECTION**

The Contractor shall :

a) Identify, inspect and/or test the completed item as required by the quality plan.

b) Verify that the item has been inspected at all points shown in the quality plan and that the records are adequate and complete.

25.3.11 **INSPECTION STATUS**

The Contractor shall :

a) Provide means for assuring that required inspections and tests are performed and that the acceptability of items with regard to inspections and tests performed is known throughout manufacturing and construction.

b) Establish and maintain a system for identifying the inspection/acceptance status by means of tags, stamped impressions, or other physical means to be affixed to the item or its container or by means of inspection records.

c) Show the identity of the Contractor and his inspector on any inspection marking used.

d) Provide for measures for controlling status indicators including the authority for application and removal of tags, stamps or other marking.

e) Identify non-conforming items.

25.3.12 IDENTIFICATION AND TRACEABILITY

The Contractor shall establish and maintain as adequate system to :

a) Identify each item (lot, component or part) to the applicable drawing, specification or other technical document, throughout the whole construction process.

b) Assign to each item a unique identification where specific traceability is required by the contract.

c) Record this identification on all process, inspection and test records, where traceability is specified.

d) List the items that do or do not require traceability concerning concrete activities.

25.3.13 PRESERVATION, HANDLING AND STORAGE

The Contractor shall :

a) Establish, maintain and document a system for the preservation, storage and handling of all items from the time of receipt through the entire construction process and subsequent storage to prevent abuse, misuse, damage, deterioration or loss.

b) Periodically inspect stored items for condition and shelf-life expiry.

c) Inspect and test-special handling tools and equipment at specific times to verify that the tools and equipment are adequately maintained and will not damage the items and will ensure safe and adequate handling.

d) Use specific written procedures for lifting of critical or high value items.

25.3.14 CONSTRUCTION

a) The Contractor shall clearly define the responsibilities for the documented preparation of works.

This written preparation shall consist of instructions or work assignments. It shall be established in accordance with the construction schedules and be available to the works and inspection personnel prior to commencement of work. This work instruction will document the following :

- Work methods
- sequence of operations
- workmanship criteria
- type of equipment needed

- special working environment, if any.

For concreting and other common civil work activities, these instructions may be included in drawings, specifications or other design documents.

b) The Contractor shall ensure that prior to release for construction all jigs, fixtures, tooling masters, templates, and patterns used for verifying quality are controlled. The extent and frequency of tool control shall be defined.

25.3.15 SPECIAL PROCESSES

The Contractor shall :

a) Identify those special processes subject to the requirements of this clause. Special processes shall include welding, heat treating and non- destructive examination, as applicable.

b) Establish documented procedures to assure that these processes are accomplished under controlled conditions by qualified personnel using qualified documented procedures and suitable equipment in accordance with applicable codes, standards, specifications, criteria and contractual requirements.

c) Maintain documentation for currently qualified personnel and processes according to the requirement of pertinent codes and standards.

d) Define the necessary qualifications of personnel and procedures for special processes not covered by existing codes or standards, or where item or service quality requirements exceed the requirements of established codes or standards.

e) Not consider concreting as a special process. However, the Contractor shall ensure that foremen and vibrator operators are properly selected from experienced or trained personnel prior to assignment of works and are given regular training by concrete placement experts as needed.

25.3.16 QUALITY RECORDS

The Contractor shall :

a) Maintain quality records as evidence that :

i) The quality assurance program meets the requirements of these Quality Management Requirements (manual, procedures, quality plan).

ii) The items or services meet contractual or other applicable technical requirements (specifications, drawings, calculations, manufacturing, inspection and test procedures).

iii) Personnel and procedures for special processes are qualified as required by 25.3.15.

iv) Measuring and testing equipment is calibrated as required by 25.3.7

v) The procurements meet the requirements of 25.3.6

vi) Corrective actions are being taken and are effective as required by 25.3.18

vii) Audits are performed as required by 25.3.19.

b) Maintain final performance quality records which include as appropriate :

i) as build records
ii) material test reports or certificates
iii) non-destructive examination records or certificates.
iv) inspection and test records.
v) non-conformance reports.
vi) concrete batch plant printout.

Items (iii) and (iv) apply to those operations performed after receipt of materials from the supplier.

c) Identify, index and file quality records for easy retrival.

d) Retain quality records for the time specified in the contract. If not specified, final performance quality records shall be retained for 10 years.

e) Provide a suitable environment for storing of records to minimize deterioration or damage and to prevent loss (the use of a double filing system is an acceptable method).

25.3.17 **NON-CONFORMANCES**

The Contractor is responsible for the identification and disposition of all non-conforming items, including those of sub-contractors. Final acceptance of the Contractor's disposition of those items that violate contractual requirements is the prerogative of the Purchaser. The Contractor shall :

The Contractor shall :

a) Verify NPC certification.

b) Examine NPC supplied items on receipt for completeness and proper type and to detect transit damage. Further receiving inspection is not required unless the Contractor needs actual characteristics for subsequent work or unless specified in the contract. Examination may be deferred until further processing is scheduled if items are in sealed containers or have special preservation or packaging.

c) Control NPC supplied items from receipt onwards according to the requirements of this standard.

d) Report promptly in writing to the quality assurance representative, any NPC supplied items found damaged, lost, non-conforming, or otherwise unsuitable or unnecessary for use either on receipt or while in the Contractor's custody.

25.3.18 **CORRECTIVE ACTION**

The Contractor shall :

a) Investigate the causes of significant or recurring non-conformances and take appropriate action to prevent repetition.

b) Document and have reported to appropriate levels of the Contractor's management causes of significant conditions that adversely affect quality and the corrective action taken.

25.3.19 **VERIFICATION OF QUALITY**

25.3.19.1 **INITIAL EVALUATION**

Quality Assurance Program, Facilities and Physical Resources :

Prior to the award of a contract, and to the performance of the activity, the Purchaser shall evaluate the Contractor's quality assurance program, manufacturing facilities and resources to determine whether the requirements of this section can be met.

In the event of the Contractor not fulfilling all applicable requirements, NPC may award the contract provided that he takes the responsibility for those QA requirements that will not be met by the Contractor. In such a case, the exceptions shall be clearly defined in the contract.

25.3.19.2 **QUALITY PLAN**

NPC shall evaluate the quality plan and all revisions thereto in order to determine its acceptability.

NPC shall indicate witness points on the accepted quality plan.

In addition, NPC shall perform surveillance according to the accepted quality plan.

25.3.19.3 **ACCESS**

The Contractor shall provide for reasonable access of the competent authorities and of NPC to his premises and records for audit and surveillance purposes.

LIST OF ANNEXURES

1. Annexure – 1: Typical details of Bore log data

LIST OF TENDER DRAWINGS

1. Drawing no. KAIGA 5&6/10120/2001/DD- Borehole Location Layout
2. Drawing no. KAIGA 5&6/10000/2001/GA- Main Plant Layout
3. Drawing no. KAIGA5&6/16000/2003 /SK – Excavation Drawings

ANNEXURE – 1

Sohams Foundation Engg. Pvt. Ltd.Mumbai

SFE

Project :- Carrying Out Geo-Technical and Geo-Physical Investigations For Kaiga 5&6,Kaiga Site,PO Kaiga,Karwar, Uttara Kannada Dist. Karnataka State

Format No : SFE/KAIGA5&6/RD/01

Client:-NPCIL

Job No :- | Created By :- HPG | Created On:-

GEOLOGICAL LOG OF BORE HOLE

Hole No :- 110
Sheet : 1 OF 4
Feature: =

Location : TB-5 | Co-Ordinates :X-440226.0394,Y-1642944.9270 | GWL:-1.280m
Angle with vertical : 0° | Collar Elevation : | Existing Ground
Total depth : 56.10m | Type (s) of core barrel : D.Tube | Elevation : 96.356m
Started :3 / 5 / 2018 | Completed : 8 / 7 / 2018 | Drilling Agency : SFE

Depth , m	Elevation	Litholog: Description	Size of core pieces: < 10 mm	<10 to 25 mm	25 to 75 mm	75 to 150 mm	> 150 mm	Log	Percent Core recovery: 0-20	20-40	40-60	60-80	80-100	Type of Bit	R.Q.D , %	Facture Frequency per, m	SPT No	SPT Value: N1	N2	N3	N4	N	Drill Water loss: Partial	Complete	Permeability: Test section	lugeon	Penetration Rate,cm/hr	Special observations & interpretations
0.00	96.356																											
1.50	94.856	REDDISH COLOUR MURRUM																10	15	26		41						
1.95																												
4.50	91.856	BROWNISH SOIIL																11	17	23		40						
4.95																												
7.50	88.856	BOULDER												NX Diamond														
9.00	87.356	HIGHLY WEATHERED LIGHT GREY FRACTURED GRANITE			2,3		SP,1,SP		62						16													
10.50	85.856	GRAYISH HIGHLY FRACTURED HIGLY WEATHERED GRANITE			4,5	10	SP,6,7,8,9		72						53.33													
12.50	83.386				13,15	12,14	11,SP,16		58						29.5													
13.00	R3.356				17	18,19	SP,20		78						78													
14.00	82.356					21	22,23,24		97						94													
15.00	81.356				SP	25,27	26		23						15													
17.50	78.856	WHITISH TO GRAYISH SLIGHTLYFRACTURED SLIGHTLY WEATHERED GRANITE			28,SP	29,31,33	30,32		88						86													
											82				86													

SIGNATURE	SOHAMS		NPCIL	
	Logged By (Geologist)	Checked By (QA)	Civil	(QA)

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Client:-NPCIL

Job No :- | Created By :- HPG | Created On:-

GEOLOGICAL LOG OF BORE HOLE

Hole No :- 110

Sheet : 2 OF 4

Feature: =

Location : TB-5 | Co-Ordinates :X-440226.0394,Y-1642944.9270 | GWL:-1.280m

Angle with vertical : 0° | Collar Elevation : | Existing Ground

Total depth : 56.10m | Type (s) of core barrel : D.Tube | Elevation : 96.356m

Started :3 / 5 / 2018 | Completed : 8 / 7 / 2018 | Drilling Agency : SFE

Depth , m	Elevation	Litholog: Description	Size of core pieces: < 10 mm	<10 to 25 mm	25 to 75 mm	75 to 150 mm	> 150 mm	Log	Percent Core recovery: 0-20	20-40	40-60	60-80	80-100	Type of Bit	R.Q.D . %	Facture Frequency per, m	SPT: SPT No	SPT Value: N1	N2	N3	N4	N	Drill Water loss: Partial	Complete	Permeability: Test section	lugeon	Penetration Rate,cm/hr	Special observations & interpretations
18.50	77.856	WHITISH TO GRAYISH SLIGHTLYFRACTURED SLIGHTLY WEATHERED GRANITE		37,41	36,38,42	34,35,39 40,43	SP,SP				82			NX Diamond	59													
20.00	76.356			46,47	48,50,52,53	44,51	45,49,54				83				73.33													
21.50	74.856	GRAYISH TO WHITISH SLIGHTLY FRACTURED SLIGHTLY WEATHERED GRANITE			SP,58,59,62	60,61,63	55,56,57			80.66					72													
23.00	73.356				65,66,67,69 SP,72	68,SP,SP,70,71	64,73			70.66					52													
25.00	71.356				75,76,77,80	74,78,79	SP,81,SP,82,83			88.50					81.5													
27.50	68.856				87,90,92	86,88,89,91,93	SP,84,85			67.33					48.66													
29.00	67.356				96	97	94,95,98			91.33					91.33													
30.50	65.856					99,102,103	100,101,104,SP			99.33					83.33													
32.00	64.356	GRAYISH TO LIGHT GREY SLIGHTLY WEATHERED FRESH GRANITE			106	105,108	107,109			67.33					67.33													
33.50	62.856				111,112	SP,113,115	110,114			95.33					64													
35.50	60.856				118	117,119,121	116,120			71					63.5													

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Client:-NPCIL

Job No :- | Created By :- HPG | Created On:-

GEOLOGICAL LOG OF BORE HOLE

Hole No :- 110

Sheet : 3 OF 4

Feature: =

Location : TB-5 | Co-Ordinates :X-440226.0394,Y-1642944.9270 | GWL:-1.280m

Angle with vertical : 0° | Collar Elevation : | Existing Ground

Total depth : 56.10m | Type (s) of core barrel : D.Tube | Elevation : 96.356m

Started :3 / 5 / 2018 | Completed : 8 / 7 / 2018 | Drilling Agency : SFE

Depth , m	Elevation	Litholog: Description	Size of core pieces: < 10 mm	<10 to 25 mm	25 to 75 mm	75 to 150 mm	> 150 mm	Log	Percent Core recovery: 0-20	20-40	40-60	60-80	80-100	Type of Bit	R.Q.D. %	Facture Frequency per, m	SPT: SPT No	SPT Value: N1	N2	N3	N4	N	Drill Water loss: Partial	Complete	Permeability: Test section	lugeon	Penetration Rate,cm/hr	Special observations & interpretations
37.00	59.356	GRAYISH TO LIGHT GREEN SLIGHTLY WEATHERED FRESH GRANITE				SP,126,127	122,123,124				94.66				90.66													
40.00	56.356	GRAYISH TO WHITISH SLIGHTLY FRACTURED MODERATELY TO SLIGHTLY WEATHERED GRANITE		141,SP,142,143,144	137,138,SP,139,140,130,SP,133	136,SP,128,SP,129,131,SP	SP,132,134,135,SP				73				40													
41.00	55.356				145	146,147 148	60				83				32													
43.00	43.356					149,150,152,SP	151,153,154				70				63.5													
45.00	51.356	GRAYISH TO WHITISH MODERATELY FRACTURED MODERATELY WEATHERED GRANITE			SP,158,161	SP	155,156,157,159 160,162				96.5			NX Diamond	74.5													
48.00	48.356				175,176,177,178,179,163,164 165,166	167 TO 170,172,173,180,181	SP,171,174			60.33					44.66													
49.50	46.856				184,185	182,186,187,SP	183		24.66						10													
51.00	45.356				188,190,192 193	191,	189,SP			71.33					51.33													
53.50	42.856	GRAYISH TO WHITISH SLIGHTLY WEATHERED GRANITE		SP	203,204,195,196,197 206,198,200,201	205,199	202,SP,194,SP,207			80.66					74													

SIGNATURE	SOHAMS		NPCIL	
	Logged By (Geologist)	Checked By (QA)	Civil	(QA)