

Technical Specifications

SL. No	Description and Technical Specification of the item	QTY	UNIT	Delivery
1	E7018 SMAW DIA 5.00 MM E7018 (Diameter 5 mm and length 450 mm) SMAW ELECTRODE as per WCPI 204/00.	5,00,000.00	NO	120 DAYS



BHARATH HEAVY ELECTRICALS LIMITED

TIRUCHIRAPALLI-620 014

WELDING TECHNOLOGY CENTRE

WCPI - 204

Revision No.: 00

Date: 03.03.2015

WELDING CONSUMABLE PURCHASE INSTRUCTION (WCPI)
AS PER ASME SEC.II.C, SFA-5.1 E7018 FOR STRUCTURAL APPLICATIONS

1.0 GENERAL:

- 1.1 The electrodes shall comply with requirements specified in the latest edition and addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.1, E7018. All tests, acceptance criteria shall be in accordance with this. Additional requirements specified in this document shall also be complied.
- 1.2 The electrodes shall be supplied in quantities as specified in the purchase order.
- 1.3 All sizes of electrode shall be suitable for welding in all positions of boiler structural, IS 2062 material applications.

2.0 CHEMICAL COMPOSITION:

The chemical composition of the undiluted weld metal shall conform to ASME SECII.C SFA-5.1, E7018.

3.0 MECHANICAL PROPERTIES:

The mechanical properties of the weld metal deposited using this electrode after stress relieving the test plate assembly at $620 \pm 15^\circ\text{C}$ for 300 minutes shall meet the requirements of ASME SECII.C SFA-5.1, E7018.

4.0 RADIOGRAPHIC SOUNDNESS:

The electrode shall be suitable for radiography quality welding and the radiographic test shall meet the requirements of ASME SECII.C SFA-5.1, E7018.

5.0 SIZE:

The electrodes shall be supplied in diameters and lengths as specified in the purchase order. The tolerance on diameter and length shall be as per SFA-5.02.

6.0 CORE WIRE, COVERING, EXPOSED CORE AND IDENTIFICATION:

The electrodes shall meet the requirements of clause 3.2, 3.3, 3.4 of SFA-5.02.

7.0 MOISTURE CONTENT OF COVERING:

Moisture content of the electrode covering shall not exceed the limit specified in ASME Sec II C, SFA 5.1 E7018.

Prepared:

Suraj N
Engineer/WTC

Reviewed and Approved:

S. Singaravelu
SDGM / WTC



**Welding Consumable Purchase Instruction for
ASME SEC.II.C, SFA-5.1 E7018**

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8.0 FILLET WELD TEST:

Fillet weld test done using this electrode shall meet the requirements specified in ASME SEC II C SFA 5.1, E7018.

9.0 PACKAGING

9.1 Electrodes in standard quantity shall be wrapped tightly in a corrugated paper with moisture proof packing in polythene bags and sealed. These shall be further packed either in hermetically sealed containers or in cardboard packets and then packed with polythene bags and sealed.

The number of electrodes per packet shall be such that the net weight of each packet does not exceed 5Kg. Packets shall be further packed in cardboard cartons each weighing not more than 25kg. The cartons shall be packed in waterproof boxes with crates so as to ensure no damage during shipment and normal storage conditions.

9.2 Weight of each crate shall not exceed 1000kg.

9.3 Markings of packages shall be as per clause 4.6 of SFA-5.02.

10.0 TESTING & CERTIFICATION:

10.1 Each consignment of electrodes supplied shall preferably be from one batch only.

10.2 Batch /Lot classification shall be Class C1 as per SFA-5.01 filler metal procurement guidelines of ASME Sec.II.C. (latest edition and addenda)

10.3 The level of testing shall be Schedule K as per SFA-5.01 filler metal procurement guidelines of ASME Sec.II.C. (latest edition and addenda)

10.4 Three copies of original test certificates in English signed by the manufacturer giving details of tests done in compliance with this WCPI and ASME Sec II C, SFA-5.1,E7018 shall be sent.

10.5 The manufacturer shall certify that supplies made against the batch conform to the requirements of the latest edition & addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.1, E7018.

Sl. No.	Pre –Qualification Criteria - PR 0136277562	Bidder remark
1	If Bidder is a manufacturer, Confirm “Yes or, No” in bidder remark.	
2	Bidder shall be a manufacturer of the Quoted items or an authorized dealer of the same. If the offer is quoted by agent, letter of authorization or agreement duly signed by the manufacturer is required to consider the offer. Tender Enquiry details must available on Letter of authorization or agreement to consider the offer.	
3	Quoted Welding Consumables Brand Name/Product Name	
4	Quoted Product Catalogue	
5	Manufacturer/Bidder shall submit a valid ISO 9001 certificate or Quality management system certificate or Written down procedure for ISO 9001 or A valid ISO 45001 certificate or Written down procedure for Quality inspection.	
6	Manufacturing Plant capacity for SMAW Electrode.	
7	Manufacturing/Bidder should confirm and full fill the WCPI–204/00. Any deviation from the Specification are to be mentioned in the “Bidder remark Space”. If There is no deviation vendor should indicate “No Deviation”.	
8	Seal and sign the WCPI–204/00 for confirmation.	
9	Diameter details and Length details	
10	Any deviation from the Specification are to be mentioned in the “Bidder remark Space”. If There is no deviation vendor should indicate “No Deviation”.	

Seal and Sign of Authorized Person

Annexure – A- Additional Terms and Conditions for GeM Enquiry

The terms and condition mentioned in this document are applicable in addition to the GeM General Terms and Conditions. Bidders shall furnish pointwise confirmation/details.

<u>To be filled by bidder</u>		
Description of the Equipment:		
GeM Tender No. & Date		
Name of the firm (Bidder)		:
Address		:
<u>Contact person 1</u> Name: Designation: Office Phone: Mobile: e-mail:		<u>Contact person 2</u> Name: Designation: Office Phone: Mobile: e-mail:
Offer/Quotation reference with date		:
Sl	Terms and conditions	Vendor's confirmation
1.	Inspection by BHEL/as per Technical specification(if any).	
2.	Payment terms: 1. Payment terms for Non MSME Suppliers: 90 days from the Vehicle entry date (Against submission of GST invoice, GeM invoice, LR copy, Last Movement e-Way Bill, UD). 2. Payment terms for Micro & Small Enterprises (MSEs): 45 days from the Vehicle entry date (Against submission of GST invoice, GeM invoice, LR copy, Last Movement e-Way Bill, UD). The supplier should upload UDYAM Registration Certificate in proof of MSE. 3. Payment terms for Medium Enterprises: 60 days from the Vehicle entry date (Against submission of GST invoice, GeM invoice, LR copy, Last Movement e-Way Bill, UD). The supplier should upload UDYAM Registration Certificate in proof of Medium Enterprises. Note: Deviation in above payment terms is not acceptable.	
3.	Response to Tenders for Indigenous supplier will be entertained only if the vendor has a valid GST registration number which should clearly mentioned in the offer. Indicate the GST registration number. If any specific exemption is available, a declaration with due supporting documents need to be furnished for considering the offer.	GST Registration No. _____
4.	EMD / Performance Security:	Not Applicable
5.	Kindly Indicate the HSN Code for all items	HSN CODE : ____
6.	Rate quoted in GeM portal should be on FOR destination basis inclusive of all taxes, P&F, freight etc. Transit Insurance is under Supplier scope. Please indicate how much GST percentage is included in quoted price.	GST in %: ____

Vendor's Seal & Signature

/ On Bidder's office letter pad /

Self-Declaration

Enquiry No.	
Enquiry Date	

In line with Government public procurement order Number P-45021/2/2017-B.E-II dated 15.06.2017, and further modified order dt. 28.05.2018, 29.05.2019 & order 04.06.2020 issued by DPIIT

I / We hereby declare that I / We are a "Local Supplier" meeting the requirement of minimum local content (..... %) defined in the above government notification for the goods against above mentioned enquiry Number.

Details of location at which local value addition will be made is as follows:

Door No.	
Street / Address 1	
Street / Address 2	
District	
State	
Country	
PIN Code	

We also understand that the false declarations will be in breach of the code of Integrity under rule 175(1)(i)(h) of the General financial rules for which a bidder or its successors can be debarred for up to two years as per Rule 151(iii) of the General Financial Rules along with such other actions as may be permissible under law.

For Company Name:

Seal:

Signature:

Date:

Place:

Note:

" Local Content "means the amount of value added in India which shall ,unless otherwise prescribed by the Nodal Ministry, be the total value of the item procured(excluding net domestic indirect taxes) minus the value of imported content in the item(including all customs duties) as a proportion of the total value, in percent. "Local Supplier "means a supplier or service provider whose product or service offered for procurement meets the minimum local content.

The above declaration shall be submitted mandatorily along with the offer in company letter head with seal & signature.

(Please fill all the yellow color field)