

Technical Specifications

SL. No	Description and Technical Specification of the item	QTY	UNIT	Delivery
1	ER 70S-A1 GTAW ROD 2.40 MM /2.5 MM ASME SEC.II.C, SFA-5.28 ER70S-A1 LOW ALLOY STEEL BARE SOLID FILLER ROD FOR GTAW TO WCPI-101/10. DIAMETER 2.40 MM /2.5 MM length - 1000 MM LONG.	2000.00	KG	90 DAYS



BHARATH HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014
WELDING TECHNOLOGY CENTRE

Doc. Number: WCPI – 101

Revision No.: 10

Date: 06/04/2022

WELDING CONSUMABLE PURCHASE INSTRUCTION FOR
LOW ALLOY STEEL BARE SOLID FILLER ROD ER70S-A1

1.0 GENERAL:

- 1.1 The Rod shall comply with requirements specified in the Latest Edition and Addenda (Applicable on the date of Issue of Purchase Order) of ASME Sec.II.C.SFA-5.28, ER70S-A1. All tests, acceptance criteria shall be in accordance with this. Additional requirements specified in this document shall also be complied.
- 1.2 The Rods shall be supplied in sizes and quantities as specified in the Purchase Order.
- 1.3 The rods are intended for use as filler for radiographic quality butt welded joints in high pressure boiler tubes and pipes.

2.0 Chemical Composition:

- 2.1 The chemical composition of the Rods shall conform to ASME SECII.C SFA5.28-ER70S-A1.

3.0 Mechanical Properties:

- 3.1 The mechanical properties of the Rods shall conform to ASME SECII.C SFA5.28-ER70S-A1.

4.0 USABILITY AND RADIOGRAPHIC SOUNDNESS:

- 4.1 The Rod when used as filler in GTAW with 100 % Argon shielding shall deposit weld metal that flows freely, uniformly without sputter or other defects and shall exhibit excellent wetting characteristics. The resultant weld metal shall be smooth and uniform with no visible evidence of cracks/porosity or other defects and shall meet radiographic soundness requirements.

5.0 FORM & SIZE:

- 5.1 The Rods shall be supplied in straight lengths of 1000 mm +15, -0mm and as specified in the Purchase Order. The tolerance on diameter shall be as per SFA-5.02.

PREPARED:

Aditya Kumar

Aditya Kumar
Senior Engineer / WTC

REVIEWED & APPROVED:

R Arivazhagan

R Arivazhagan
SM/WTC



6.0 FINISH & UNIFORMITY:

6.1 The Wires shall meet the requirements of clause 4.2 of SFA-5.02

7.0 IDENTIFICATION:

7.1 Each Rod shall have the Classification designation “ER70S-A1”, brand/trade designation marked or embossed on both ends for positive identification.

8.0 MARKING:

8.1 The rods shall meet the requirements of clause 4.6 of SFA-5.02.

9.0 PACKAGING:

9.1 Rods of the same size and batch/lot shall be packed in water resistant plastic tube shaped cartons. Each tube carton shall weigh not more than 10 Kg. The cartons shall be provided with watertight lid to ensure waterproof during transit & storage. Tube Cartons shall be packed in waterproof boxes with crates so as to ensure no damage during shipment and normal storage conditions. Weight of each crate shall not exceed 1000kg.

9.2 The cartons shall have product information as per clause 4.6 of SFA-5.02

10.0 TESTING & CERTIFICATION:

10.1 Each consignment of rods supplied shall preferably be from one batch (more than one Batch is also acceptable).

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

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

10.4 The Testing Authority shall certify that supplies made against the batch conform to the requirements of the Latest Edition & Addenda (Applicable on the date of issue of Purchase Order) of ASME Sec.II.C.SFA-5.28 ER70S-A1.

10.5 “Original test certificates in English countersigned by Inspecting Authority (latest) approved by IBR for country of origin giving details of the tests done in compliance with this purchase instruction (WCPI- 101 /Revision No.:10) and ASME Sec.II.C, SFA-5.28, ER70S-A1 shall be sent”.

(OR)

“A copy of valid IBR Approval Certificate for the brand being supplied.

Original test certificates in English countersigned by manufacturer giving details of the tests done in compliance with this purchase instruction (WCPI- 101 /Revision No.:10) and ASME Sec.II.C, SFA-5.28, ER70S-A1 shall be sent

Sl. No.	Pre –Qualification Criteria – PR 0136640650	Bidder remark
1	If Bidder is a manufacturer, Confirm “Yes or, No” in bidder remark.	
2	<p>Bidder shall be a manufacturer of the Quoted items or an authorized dealer of the same.</p> <p>If the offer is quoted by agent, letter of authorization or agreement duly signed by the manufacturer is required to consider the offer.</p> <p>Tender Enquiry details must available on Letter of authorization or agreement to consider the offer.</p>	
3	Quoted Welding Consumables Brand Name/Product Name	
4	Quoted Product Catalogue	
5	Manufacturing Plant Address / Mill Address	
6	Manufacturer/Bidder shall submit manufacturing process flow chart (Raw material to finished product) along with offer for Quoted Item.	
7	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.	

Seal and Sign of Authorized Person

Sl. No.	Pre –Qualification Criteria – PR 0136640650	Bidder remark
8	Manufacturing Plant capacity for GTAW Process.	
9	Bidder should confirm and full fill the WCPI- 101/10. Any deviation from the Specification are to be mentioned in the “Bidder remark Space”. If There is no deviation vendor should indicate “No Deviation”.	
10	Seal and sign the WCPI- 101 revision 10 for confirmation.	
11	WCPI- 101/10 (Diameter 2.4 mm and Length 1000 mm) Diameter details and length details	
12	Valid IBR certificate status to be provided for Quoted material.	
13	<p>Manufacturer/Bidder shall have successful experience for supplying of ER 70S-A1 or, ER 80S-B2 or, ER 80S-G or, ER 90S-B3 or, ER 90S-G or GMAW Spool or GTAW Spool or GTAW Rod to any govt. Organizations/ PSUs/ Public ltd./ Company/Reputed Industries etc.</p> <p>Purchase orders copies/ related documents to be submitted along with offer to consider the offer.</p> <p>Note: Successful experience means – supplied and accepted.</p>	

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: <ol style="list-style-type: none"> 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)