

Procurement of (Gr 92) Fittings - Annexure-A									
Sl no.	Schedule	MATLCD	Description	Quantity (NO)	Fitting Type	Specification	Construction	Drawing No	D1 Value
1	Schedule 1	921170020200	BW RED 60.3X5.54/33.4X4.55-SA234WP92	16.00	CONCENTRIC REDUCER	SA234WP92	SEAMLESS	ASMEB16.9	D-49.3/24.3
2	Schedule 2	925051600000	BW UEQT OD60.3X5.54/OD33.4X4.55 SA182F92	12.00	UNEQUAL TEE	SA182F92	SEAMLESS	3-80-452-33623/02	AS PER DRG
3	Schedule 3	925054840000	BW EQT OD33.4x4.55-SA234WP92	4.00	EQUAL TEE	SA234WP92	SEAMLESS	ASMEB16.9	D/24.3
4	Schedule 4	925241010000	BW LR 90Deg Elbow OD48.3x10.97-SA234WP92	10.00	ELBOW	SA234WP92	SEAMLESS	ASMEB16.9	D/28.9
5	Schedule 5	925241020000	BW LR 90 Deg Elbow OD60.3x8.74-SA234WP92	72.00	ELBOW	SA234WP92	SEAMLESS	ASMEB16.9	D/42.8
6	Schedule 6	925241030000	BW LR 45 Deg Elbow OD33.4x6.35-SA234WP92	8.00	ELBOW	SA234WP92	SEAMLESS	ASMEB16.9	D/20.7
7	Schedule 7	925241040000	BW LR 90 Deg Elbow OD33.4x6.35-SA234WP92	36.00	ELBOW	SA234WP92	SEAMLESS	ASMEB16.9	D/20.7
8	Schedule 8	925241050000	BW LR 90 Deg Elbow OD33.4x9.09-SA234WP92	24.00	ELBOW	SA234WP92	SEAMLESS	ASMEB16.9	D/17.2

Note:

TDG 102 REV 10

Quality Plan: NTPC Approved QP

QCP 17 R06

Painting scheme:As per TDG 102 REV 10

The materials shall be dispatched to the Talcher Project Site



1.0 SCOPE: -

The fittings shall meet Indian Boiler Regulations (IBR) except SS and Duplex SS (UNS32205) specifications unless otherwise specified, and the following requirements in addition to the standards specified in the Purchase Order (PO).

2.0 RAW MATERIALS: -

- All fittings shall be of seamless construction unless otherwise specified in the purchase order. Pipes used for manufacturing of seamless fittings shall be seamless pipes or forgings only.
- The raw material used for fittings shall meet the respective specification. The test certificate shall be furnished with Traceability.
- Raw material Steel for IBR items to be inspected at Mill & test certificate countersigned by IBR Authorized Inspecting Authority, if the mill is not approved under IBR as well-known steel maker.
- For Gr-92 items : Si : 0.10-0.50% ; Ni : 0.30max and Cu : 0.25 max. (both Ladle & Product analysis)

3.0 MANUFACTURING & TESTING REQUIREMENTS:

3.1 MANUFACTURING PROCESS :

(i) Seamless Fittings:-

- A) Tees & Reducers :** Upto 80mm thickness : Formed Type.
Above 80mm thickness Formed or Forged type.
- B) Elbows :** Formed type for all thickness

(ii) Welded Fittings:- Supplied only if indicated in P.O and shall be of **Two-Half construction**.

3.2 Machined Fittings (Max size permitted 4”- directly from bar) – Reducers, Couplings & End Caps : Fittings machined from Castings are **prohibited**.

Starting material	Heat treatment	CS – Normalised ; AS – Normalised & Tempered SS & Duplex SS (UNS32205) – Solution Annealed
	NDE – UT	To be done after Heat treatment. For size above 40mm – to be done as per ASTM A 388 Acceptance to - ASME Sec.VIII Div.2 Cl.3.3.4. Actual measured notch depth to be specified in Test Certificate.
Finished fitting (after machining)	Heat treatment	Not required
	NDE (for all sizes)	• MT (100%) - Procedure - As per ASTM E709. No linear indications are acceptable (Linear Indication : Length \geq 3XWidth) For WP91 & WP92 Wet MPI shall be done • LPI – SS & Duplex SS (UNS32205) : Shall be done as per ASTM E165. No linear indications are acceptable.
	Hardness	Base material Hardness for. WPB, WPC, WP11, WP12, WP22 – 197 HBW max. WP91 - 190-250 HBW – 100% to be checked WP92 - 196-250 HBW – 100% to be checked Duplex SS (UNS32205) – 300BHN max
	Dimension	ASME B16.9 or as per Engineering Drawing indicated in Purchase Order.
	Bend Test (for IBR items)	Specimen: 19mm. Thickness (t) x 25.4mm width - cold bent 180 deg. over thin section without fracture, mandrel radius: CS : \leq 6.35 mm. AS, SS : \leq 1.5 times specimen thick.

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3.3 Seamless Formed Fittings – Ells, Tees, Reducers, Dished end (End cover / Cap)

Starting material:	Heat treatment shall be as per starting material specification	CS – Normalised AS – Normalised & Tempered SS & Duplex SS (UNS32205) – Solution Annealed				
1)Tube & Pipe	NDE – UT	UT shall be done as per - ASTM E 213 with longitudinal notch of 5% wall thickness with max.1.5mm and min. 0.3mm. Actual measured notch depth to be specified in Test Certificate.				
2) Forged blank (For End covers)	NDE – UT	For size above 40mm ; UT shall be done as per - ASTM A 388 In acceptance to - ASME Sec.VIII Div.2 Cl.3.3.4. Actual measured notch depth to be specified in Test Certificate.				
3) Plate	NDE – UT	For size above 10mm SA 578, Acceptance Level – B. Actual measured notch depth to be specified in Test Certificate.				
Finished fitting (cold/hot forming)	Heat treatment after forming	Shall be done as per SA234 and follow below table for heat treatment values.				
		Material	Heat Treatment Temp, °C		Soaking time, hr/in	
			Normalising	Tempering	Normalising	Tempering
		CS- WPB & WPC	870-900	-	1/2	-
		AS-WP11 & WP12	920-960	640-670	1/2	1
		AS-WP22	920-960	680-710	1/2	1
		AS- WP91	1040-1080	760-780	1/2	1
	AS- WP92	1040-1080	760-780	1/2	1	
		Stainless Steel - All grades & Duplex SS (UNS32205): - Solution Annealed: 1050-1100 Deg C Soaking time : ½ hr per inch with minimum 15 minutes Note: Normalising shall be done for a minimum time of 30 min while tempering to be done for a minimum time of 60min for all materials except SS & Duplex SS (UNS32205).				
	NDE (for all sizes) – Except for Plate formed Dished end	<ul style="list-style-type: none">• MT (100%) - Shall be as per - ASTM E709 No linear indications are acceptable. For WP91 & WP92 Wet MPI shall be done.• LPI – SS & Duplex SS (UNS32205): Shall be done as per ASTM E165. No linear indications are acceptable.				
NDE–for Plate formed Dished end	For Plate Formed Dished end – 100% MT as per - ASTM E709 on both inner and outer surfaces of Knuckle radius and weld ends. No linear indications are acceptable. UT shall be as per A578 Level-B. Actual measured notch depth to be specified in Test Certificate.					
NDE – UT For OD >= 219mm or W.T >= 6mm	If made from Pipe & Tube – Shall be done as per - ASTM E 213 with longitudinal notch of 5% wall thickness with max.1.5mm and min. 0.3mm. Actual measured notch depth to be specified in Test Certificate. If made from Forging - Shall be as per - ASTM A 388 In acceptance to - ASME Sec.VIII Div.2 Cl.3.3.4. Actual measured notch depth to be specified in Test Certificate.					
Hardness	Base material Hardness for WPB, WPC, WP11, WP12, WP22 – 197 HBW max. WP91 - 191-250 HBW – 100% to be checked WP92 - 196-250 HBW – 100% to be checked Duplex SS (UNS32205) – 300HBW max					
Dimension	ASME B16.9, As per Engineering drawing indicated in Purchase Order. The ends of reducers shall have a straight portion of Minimum 13mm.					
Bend Test for IBR items (if starting material is forged blank)	Specimen: 25.4 mm x 19 mm thick - cold bent 180 deg. over thin section without fracture, internal radius of bend: CS :<=6.35 mm. AS, SS: <=1.5 times specimen thick.					



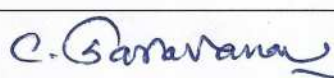

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3.4 Forged Fittings –Tees, Reducers, Couplings, Flanges & Dished End (End cover/Cap)

Shall be forged to the shape with a minimum forge reduction ratio of 1:4. Fitting shall not be machined from a forged block.

Starting material: Rolled or Forged Bars, Blooms, Billets (Killed steel)	Heat treatment shall be as per starting material specification	CS – Normalised AS – Normalised & Tempered SS & Duplex SS (UNS32205) – Solution Annealed				
	NDE – UT	To be done for diameter or thickness above 40mm Procedure - As per ASTM A388 In acceptance to - ASME Sec.VIII Div.2 Cl.3.3.4. Actual measured notch depth to be specified in Test Certificate.				
Finished fitting	Heat treatment After forging (cold/hot forging)	Shall be done as per SA234 and follow below table for heat treatment values.				
		Material	Heat Treatment Temp, °C		Soaking time, hr/in	
			Normalizing	Tempering	Normalizing	Tempering
		CS- WPB & WPC	870-900	-	1/2	-
		AS-WP11 & WP12	920-960	640-670	1/2	1
		AS-WP22	920-960	680-710	1/2	1
		AS- WP91	1040-1080	760-780	1/2	1
	AS- WP92	1040-1080	760-780	1/2	1	
		Stainless Steel - All grades & Duplex SS (UNS32205): - Solution Annealed: 1050-1100 Deg C Soaking time : ½ hr per inch with minimum 15 minutes Note: Normalising shall be done for a minimum time of 30 min while tempering to be done for a minimum time of 60min for all materials except SS & Duplex SS (UNS32205).				
	NDE – UT For OD >= 219mm or W.T >= 6mm	UT shall be done as per - ASTM A388 In Acceptance to - ASME Sec.VIII Div.2 Cl.3.3.4. Actual measured notch depth to be specified in Test Certificate.				
NDE (for all sizes)	MT- (100%) Shall be done as per ASTM E709. No linear indications are acceptable. For WP91 & WP92 Wet MPI shall be done. LPI – SS & Duplex SS (UNS32205): Shall be done as per ASTM E165. No linear indications are acceptable.					
Hardness	WPB, WPC, WP11, WP12, WP22 – 197 BHN max. WP91 - 191-250 BHN – 100% to be checked WP92 - 196-250 HBW – 100% to be checked Duplex SS (UNS32205) – 300BHN max					
Dimension	ASME B16.9 or ASME B16.5 or as per Engineering drawing indicated in Purchase order.					
Bend Test (for IBR items)	Specimen: 19mm. Thickness (t) x 25.4mm width - cold bent 180 deg. over thin section without fracture, mandrel radius: CS : <=6.35 mm. AS, SS : <=1.5 times specimen thick.					

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3.5 Welded Fittings– Ells, Tees, Reducers (Two-Half construction):

Pipe made from plate and long seam welded shall not be used as a starting material.

Starting material: Plate	NDE – UT	For thickness above 10mm SA 578, Acceptance Level – B.				
Finished fitting	Heat Treatment After forming	Shall be done as per SA234 and follow below table for heat treatment values.				
		Material	Heat Treatment Temp, °C		Soaking time, hr/in	
			Normalizing	Tempering	Normalizing	Tempering
		CS- WPBW & WPCW	870-900	-	1/2	-
		AS-WP11W & WP12W	920-960	640-670	1/2	1
		AS-WP22W	920-960	680-710	1/2	1
		AS- WP91W	1040-1080	760-780	1/2	1
	AS- WP92W	1040-1080	760-780	1/2	1	
	Stainless Steel - All grades & Duplex SS (UNS32205): - Solution Annealed: 1050-1100 Deg C Soaking time : ½ hr per inch with minimum 15 minutes					
	Post Weld Heat Treatment (PWHT)	PWHT shall be done as indicated below.				
Material		Heat Treatment Temp, °C		Soaking time		
CS- WPB-W & WPC-W If weld thk>19mm		595-635		2.5min per mm of weld thk; Minimum 30minutes.		
AS-WP11-W&WP12-W		650-680				
AS-WP22-W		690-710		2.5min per mm of weld thk; Minimum 60minutes.		
AS- WP91-W		760-780				
AS- WP92-W	760-780					
NDE (for all sizes)	<ul style="list-style-type: none">• MT (100%)- Procedure - As per ASTM E709. No linear indications are acceptable For WP91 & WP92 Wet MPI shall be done• LPI – SS & Duplex SS (UNS32205) : Shall be done as per ASTM E165. No linear indications are acceptable.					
NDE – for Weld	<ul style="list-style-type: none">• RT (100%)- Acceptance norm shall be UW 51 of ASME Sec VIII DIV-1.					
Hardness	Base material Hardness for WPB, WPC, WP11, WP12, WP22 – 197 BHN max. WP91 - 191-250 BHN – 100% to be checked WP92 - 196-250 HBW – 100% to be checked Duplex SS (UNS32205) – 300BHN max Weld Hardness WP91 - 300 BHN max. – 100% to be checked WP92 - 300 BHN max. – 100% to be checked					
Dimension	ASME B16.9 or as per Engineering drawing indicated in Purchase order.					
Bend Test (for IBR items)	Specimen: 19mm. Thickness (t) x 25.4mm width - cold bent 180 deg. over thin section without fracture, mandrel radius: CS : <=6.35 mm. AS, SS : <=1.5 times specimen thick.					

4.0 GENERAL REQUIREMENTS:

- Carbon < or = 0.25% for WPB (all thickness) and WPC (thickness < or = 20mm)
- Carbon < or = 0.30% for WPC (thickness > 20mm)
- If UT not done on the starting material, the same shall be done by the fitting manufactures before forming / fabrication.

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- d) **Chemical and Mechanical Testing** – Test samples shall be tested in the Heat treatment of fitting delivered condition.
- i) Product analysis – one / heat / size.
 - ii) Tension test – one / heat / heat treatment lot / size
 - iii) Hardness test – 100% for Gr91 and Gr92. 10% for others.
- e) **Photomicrograph test for WP91 & WP92** :- Photomicrograph test shall be carried out on one per heat, per size. 3 replicas in one fitting. 1 replica for the size Nb 80 & below. Acceptance norms - The Material shall be free from any micro fissures. Microstructure shall show tempered martensite and also to be examined for any grain growth and delta ferrite (to be maintained within 3% for Gr92 when measured as per VD TUV 1272). Photomicrograph with 500x (Min) magnification along with Photomicrograph report to be provided. The actual magnification shall be indicated.
- f) In case of welded fittings, WPS, PQR & welder qualification shall be approved by BHEL, prior to start of welding.
- g) Unless otherwise specified in the P.O SA 234 WP 11/12/22 fittings shall be supplied as per class1.
- h) **Stainless Steel (SS) & Duplex SS (UNS32205)** : Finished fittings shall be checked for radioactive contamination and reported. Survey meter shall be used to measure at 5cm near the surface. Acceptance limits: Shall be less than 0.1 milli Rontgen (MR) per hr or 1 micro Sievert per hr.

5.0 POSITIVE MATERIAL IDENTIFICATION (PMI) FOR ALLOY STEEL (AS), STAINLESS STEEL (SS) AND DUPLEX SS (UNS32205) FITTINGS.

Each AS, SS and Duplex SS (UNS32205) fitting shall be checked for the correctness of the material during manufacturing and final inspection using X-ray fluorescence principle or spark emission spectrography.

6.0 WORKMANSHIP, FINISH AND REPAIR

All items shall have smooth, workman like finish, and to be free from scale & defects like laps, seams, folds, cracks, etc. Surface defects can be removed by mechanical means and defective areas smoothly dressed up with the adjacent surface. Minimum dimension after repair shall meet drawing / Specification. Repairs by fusion welding are prohibited.

Flatness on curved surfaces of fittings shall be limited to 6% of nominal OD.

Thickness: Outer Diameter & Transition: Variation shall be merged smooth to min 1:4 taper.

7.0 PAINTING, COLOUR CODING & MARKING


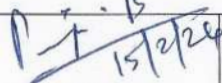
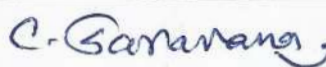

7.1 **PAINTING:** All fittings (except stainless steel and galvanized) shall be **painted** on the external surface as given below (unless otherwise specified): -

- a) **Surface preparation:** Blast cleaning to SSPC SP-10 (SA 2½) with surface profile 35-50 microns.
- b) **Primer coat:** One coat of 60 microns of In-Organic Ethyl Zinc Silicate primer.
- c) **Finish coat:** Two coats of 20 microns each of Heat Resistance Aluminium paint to IS13183 Gr-1.
- d) **Total DFT:** 100 microns minimum.
- e) **Shade:** Aluminium -- for all fittings.

The internal surface shall be protected with rust preventive coating or rust inhibitor. Edge preparations for Site ends shall be protected with weldable primer.

Stainless steel and Duplex SS (UNS32205) fittings need not be painted. Stainless steel and Duplex SS (UNS32205) fittings to be surface treated (Pickling & Passivation) as per ASTM A380.

7.2 **COLOUR CODING:** All fittings shall be colour coded circumferentially at all ends as given below:

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Material Specification		Colour Code
SA 234	WPB	Red
	WPC	Blue
	WP11	Green & White
	WP12	Black & Red
	WP22	Blue & Red
	WP91	Brown & Red
	WP92	Brown & Blue
SA 403	WP304	Blue & Yellow
	WP304L	Blue, Red & Yellow
	WP304H	Black, Blue & Yellow
	WP316	Black & Green
	WP316L	Blue, Brown & Yellow
	WP321	Blue & Brown
	WP347	Yellow & Black
SA815 (Duplex Stainless Steel)		Red, White & Green

7.3 MARKING (In English only):

7.3.1 For fittings of size above 2” (50mm) :

All the fittings shall be necessarily hard punched / etched and paint stencilled with the details: Material code, Heat number, material specification, size, maker's emblem, Inspectors seal, Running Serial number for the P.O. quantity and Statutory authorities seal as applicable, if fittings are sent to BHEL Stores. (Letter size shall be 6mm minimum and bordered with white paint for easy identification)

7.3.2 For fittings of size 2” (50mm) & below :


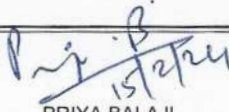
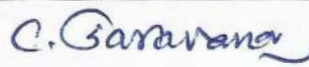
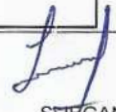
- Engraving on each fitting with minimum details like melt, branch no and Paint stencilling of all above details. Where paint stencil is not possible, permanent metal marker shall be used. (Normal white board permanent marker shall not be used).
- Fittings of size up to 2” (50mm) shall be tied together of appropriate numbers and the above details as indicated in Para 7.3.1 shall be engraved in a separate metal/plastic tag and securely tied to it.

7.3.3 For fittings of thickness less than 6mm :

If the thickness of the fitting is less than 6 mm, punching is not permitted. The above details as indicated in Para 7.3.1 shall be engraved and paint stencilled on each fitting. Where paint stencil is not possible, permanent metal marker shall be used. (Normal white board permanent marker shall not be used).

7.3.4 In case of fittings dispatched directly to project site as **DTS**, material code shall be replaced with DU code (14-digit work order DU detail) as given by Purchase during DTS advice. All other details shall be hard punched and paint stencilled as indicated in Para 7.3.1.

Sample format for Punching & Stencilling is given below.

Vendor code & Name : _____		Makers Emblem	
Material code / DU details : _____		Insp. Authority Stamp	
Melt No. : _____			
Material Specification : _____			
Qty. : _____			
Serial No : _____ (Example : 1,2,3,..... & 25)			
Weight. : _____			
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8.0 PACKING AND END PROTECTION:

Machined ends of the fittings shall be well Protected using end caps and fittings shall be suitably packed in box / crate as per the Packaging procedure PC: PKG: 01 to avoid transit & other damages.

9.0 INSPECTION & CERTIFICATION (In English only):

9.1 All items are to be Inspected at the manufacturer's works by the Inspection agencies / authorities as per IBR and as indicated in the P.O. Inspection certificate in IBR Form III C & Form III-I for Dished Ends shall be submitted along with the Work Test Certificate countersigned by the above authorities and shall include the following (Three ink signed originals required).

1. Test Certificate Number & date.
2. BHEL P.O Number & Amendment Number
3. BHEL P.O. Serial Number
4. BHEL TDC Number
5. Size-wise Quantity (MTC shall contain size and spec details strictly as per PO)
6. Specification, Grade & Year of code.
7. Heat/Melt Number
8. Starting material details with traceability.
9. Steel making process
10. Ladle Analysis of Raw Material and product analysis of fitting.
11. *Supplementary Test (Product analysis, Tension test) results.
12. Tensile Test Report.
13. Painting Report as per format Doc no TDG102:003.
14. Photocopy of Marking details of one sample for one PO Serial No vetted by TPIA.
15. *Guarantee of HTP shall be given as follows:- "Fittings are capable of withstanding without failure, leakage or impairment of their serviceability a hydrostatic test pressure equal to that prescribed for the specified matching pipe of equivalent material".

*Details furnished in the Tests certificate in lieu of chart/report is acceptable.

9.2 The following reports shall be **furnished separately** along with the IBR Forms & MTC indicated in para 9.1 above.


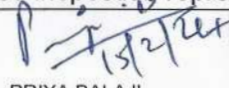
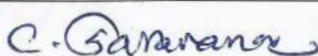
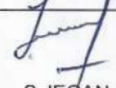
- i. NDE reports for MT, RT, UT (UT Reports in soft copy + hard copy). Actual measured UT-notch depth to be specified in Test Certificate.
- ii. Positive Material identification (PMI) report
- iii. Heat Treatment Chart.
- iv. Hardness Test report.
- v. Photomicrograph test report along with photomicrograph with minimum 500x magnifications.
- vi. Dimensional report (as built drawing with dimensions)
- vii. Thickness Measurement Report for Elbows & Tees as per Doc No : TDG102:001 & TDG102:002.

The above report numbers shall be indicated in the MTC for ready correlation. Vendor shall ensure correlation and traceability wrt documentation.

9.3 For CE marking items if indicated in P.O. the TCs with details specified above shall be submitted as per EN-10204 (Latest).

- i. For pressure parts test certificates of type 3.1 or 3.2 is acceptable.

Type 3.1 – Suppliers shall have ISO 9001-2008/2015 (with validity as applicable) certification certified by Notified Body recognized by European Community and test certificate certified by suppliers authorized inspection representative.

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Type 3.2 – Components inspected and test certificates certified by both the supplier's authorized inspection representative and Notified Body recognized by European Community.

ii. For non-pressure parts test certificates of type 2.2 is acceptable.

Type 2.2 – Suppliers test certificates certified by the supplier's authorized inspection representative with test results as required by this TDG.

10.0 AUDIT CHECKS AT BHEL :

BHEL reserves the right to carry out audit checks for Chemistry, HT condition, Mechanical test and NDT on fittings.

Supplies found defective during check at BHEL are liable for rejection.

11.0 RECORDS OF REVISION :

Rev 01 : a) Fully revised for better clarity.

b) Para 2.0 (e) added.

Rev 02 : a) Para 2.0 (c): UT acceptance norms revised from level A to B.

Rev 03 : a) Fully revised for better clarity.

b) Para 4.2, 6.0, 8.0 (11) added.

c) Para 2 (d), 4.1, 5 (d) are revised.

Rev 04 : a) Para 5.0 (g), 7.0 and 8.0 (17) are revised.

Rev 05 : a) New material specification SA 815 Duplex Stainless Steel included.

b) Para 4.1, 4.2, 5.0 (d), 7.1 & 7.2 are revised.

c) 5.0 (a), (b), (c), (e), (f), (g), 7.3.1 & 7.3.2 are modified for better clarity.

Rev 06 : a) Para 8.2 added.

b) Para 5.0(d), 5.0(g), 7.1, & 8.1 are revised.

c) Para 1.0 & 7.2 are modified.

Rev 07 : Para 8.2 - vii added.

Rev 08 : a) Title revised for better clarity

b) Para 1.0, 2.0(a), 5.0(c), 8.4, 9.1(8) & 9.2(vi) are revised.

c) From Para 3.0(f), 4.2, 5.0(d), (f), (g), 7.2 forging spec removed

d) Para 2.0(c), (f), 3.0(a), 7.0 & 10.0 added

e) Para 3.0(e) deleted

f) Document no. TDG102:002 Rev.00 added.

Rev 09 : Fully revised for better clarity

Rev 10 : (a) Title and Para 1.0 revised.



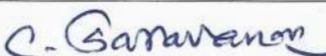

(b) Requirement of Gr92 fittings included, hence TDG 120 will become obsolete.

(b) CI 1.0 - Creep test requirement removed.

(c) CI 7.0 - Painting, Color coding & Marking modified for better clarity.

(d) CI 9.0 - Revised for improved documentation.

(e) Document no. TDG102:003 and TDG102:004 Rev.00 added.

 J. NANTHINI MGR/ QA	 PRIYA BALAJI SDGM / MM	 C. SARAVANAN AGM / ENGINEERING	 S. JEGAN SR.MGR / QUALITY
Prepared by	Reviewed by		Approved by



THICKNESS MEASUREMENT REPORT FOR ELBOW

Doc No: TDG102:001 Rev.00

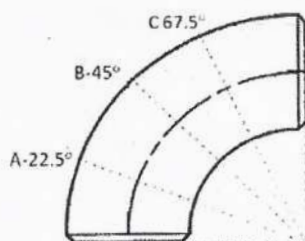
Date: 03.02.2014

PO Number:

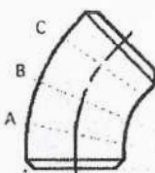
Work order/Du:

Heat no:

Size:



90° Elbow



Less than 90°

Measurement (Extrados) points

Angle	A	B	C
90	22.50°	45.00°	67.50°
60	15.00°	30.00°	45.00°
45	11.25°	22.50°	33.75°
30	NA	15.00°	NA

Description of item :
Material Spec :
Material Code :

No	Wall thickness at ends		Wall Thickness at angle			Remarks
	End 1	End 2	A	B	C	
1.						
2.						
3.						
4.						
5.						
6.						
7.						
8.						
9.						
10.						
11.						
12.						
13.						
14.						
15.						

J. N. H. E. J. NANTHINI MGR/ QA	Priya Balaji 15/2/24 PRIYA BALAJI SDGM / MM	C. Saravanan C. SARAVANAN AGM / ENGINEERING	S. Jegan S. JEGAN SR.MGR / QUALITY
Prepared by	Reviewed by		Approved by



THICKNESS MEASUREMENT REPORT FOR TEE's

Doc No: TDG102:002 Rev.00

Date: 20.06.2015

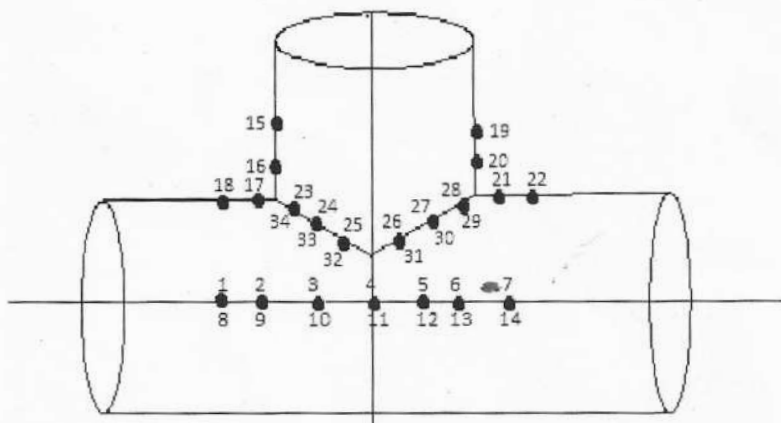
PO Number:

Description of Material:

Size:

Material Spec.

Work order/Du:



Location	Thickness (mm)	Location	Thickness (mm)	Location	Thickness (mm)
1		13		24	
2		14		25	
3		15		26	
4		16		27	
5		17		28	
6		18		29	
7		19		30	
8		20		31	
9		21		32	
10		22		33	
11		23		34	
12		24			

<i>J. Nanthini</i> J.NANTHINI MGR/ QA	<i>Priya Balaji</i> PRIYA BALAJI SDGM / MM	<i>C. Saravanan</i> C. SARAVANAN AGM / ENGINEERING	<i>S. Jegan</i> S.JEGAN SR.MGR / QUALITY
Prepared by	Reviewed by		Approved by



PAINTING & MARKING REPORT

Doc No: TDG102:003 Rev.00

Date: 15.02.2024

Report No:

Date:

BHEL PO. NO & Date :
TDG No :
Applicable Painting Scheme :
Surface Preparation :
Primer Coat :
Primer paint Batch no & Expiry date :
Finish Coat & Shade :
Finish paint Batch no & Expiry date :
Internal surface coating (if applicable) :

PO. Sl.No	Description	Quantity	Total DFT Required	Total DFT Measured	Remarks

(Add Annexure, if no of PO Sl.no is more)


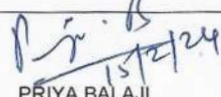
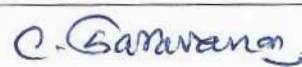

Color Code (marked Circumferentially at all ends) :

Marking : As per TDG & PO requirements.

It is hereby confirmed that the above mentioned components/items/equipment was/were painted as per the TDG & PO requirements as referred above and found acceptable.

Verified
(Vendor QC Sign & Seal)

Reviewed
(BHEL QC Sign & Seal)

 J. NANTHINI MGR/ QA	 PRIYA BALAJI SDGM / MM	 C. SARAVANAN AGM / ENGINEERING	 S. JEGAN SR.MGR / QUALITY
Prepared by	Reviewed by		Approved by



PRE DISPATCH INSPECTION REPORT

Doc No: TDG102:004 Rev.00


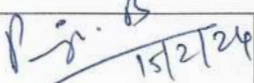
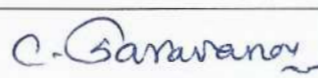

Date: 15.12.2024

S NO	PO NO & PO SI NO	MATERIAL CODE / WORK ORDER NO	ITEM DESCRIPTION	QUANTITY	WEIGHT (MT)

OBSERVATIONS : (Photos also to be enclosed)

PDI DONE BY

(BHEL/BHEL AIA Sign & Seal)

 J. NANTHINI MGR/ QA	 PRIYA BALAJI SDGM / MM	 C. SARAVANAN AGM / ENGINEERING	 S.JEGAN SR.MGR / QUALITY
Prepared by	Reviewed by		Approved by

DRAWING NO

EP.AS PER DRG. NO:
3-80-300-19825
STYLE-DL, d1=25.2

EP.AS PER DRG. NO:
3-80-300-19825
STYLE-DL, d1=49.22

(TYP)

R10
(TYP)

30 (TYP)

90

90

180

REV 03	DATE 28.11.25	ALTD :	DHARMENDRA
		APPD :	P SURESH

REVISIONS ARE INDICATED AS 

REV	DATE	ALTD :	RAVI KUMAR
02	11.02.21	APPD :	TRINADHA RAO

LENGTH CORRECTED

REVISIONS ARE INDICATED AS 

REV	DATE	ALTD :	P SURESH
01	04.05.18	APPD :	R SESHAGIRI

DESIGN PRESSURE CHANGED.
MATERIAL CODE DESCRIPTION CHANGED.

REVISIONS ARE INDICATED AS 

01. DESIGN PRESSURE : 68.8 kg/sq.cm.(g)
02. DESIGN TEMPERATURE : 608° C
03. ALL DIMENSIONS ARE FINISHED DIMENSIONS.
04. MANUFACTURING, INSPECTION AND TESTING SHALL BE AS PER IBR, ASME B16.9 AND SA182
05. FITTING TO COMPLY WITH ASME B16.9 AND DIMENSIONS ARE AS PER THIS DRAWING.
06. FOLLOW TDG:104 (LATEST VERSION)
07. WEIGHT GIVEN IN TITLE BLOCK IS INDICATIVE ONLY.
ACTUAL WEIGHT TO BE FURNISHED BY FITTING SUPPLIER.
08. CONSTRUCTION SHALL BE SEAMLESS

[illegible]

Reference : CC-ENGG-4540-001-102-QVM-Q-076

Date : 27/07/2023

From : Yogesh Kumar
ADDL. GENERAL MANAGER

To : BHARAT HEAVY ELECTRICALS LTD
NEW DELHI
110049
IN

Cc : singhjp@bhel.in

Subject : EPC TTPP3 (2x660MW)

Please find enclosed following drawings/ documents for necessary action at your end.

Vendor Drg. No. : 7519 QPC 20
Orgn. Drg. No. : 4540-001-102-QVM-Q-076
Revision No. : 00
Drg. Title : QP FOR GR-91/92 FITTINGS (BOUGHT OUT ITEM)
App. Category : CAT-I
Release Date : 27/07/2023



Scan to verify

Comments : Reviewed in Cat-I with Comments

ENDORSEMENT SHEET FOR DRAWING / DOCUMENT

TO BE FILLED IN BY SUPPLIER AT TIME OF SUBMISSION

Project Name	NTPC TALCHER THERMAL POWER PROJECT STAGE III (2x660 MW) – EPC PACKAGE
Contract No:	CS-4540-001A-2-FC-NOA-7227 DATED 27.09.2022
	BHEL WORK ORDER NOS:- 7519, 7520,7521 (MAIN BOILER) & 7254 (MAND SPARES)
Package name	EPC PACKAGE
Main Supplier	BHEL, Piping Centre, Trichy
Manufacturer Name	NTPC Approved Sub-Contractor and Sub-Vendors
Project/package Specific document	BHEL QP ref.: 7519:QPC:20 Rev 00 Dated: 13.07.2023
	NTPC ref. : 4540-001-102-QVM-Q-076
Drawing title	Quality Plan for SEAMLESS BW FITTINGS- GR91/92 MATERIAL - BOUGHT OUT ITEM

Reference Project Name	PATRATU STPP PHASE-I – (3X 800 MW) – EPC PACKAGE
Reference Contract No:	CS-9585-001-2
Reference Package name	EPC PACKAGE
Reference Main Supplier	BHEL, Piping Centre, Chennai
Reference Manufacturer Name	NTPC Approved Sub-Contractor and Sub-Vendors
Reference Project/package document	BHEL QP ref.: 7381: QPC: 20. Rev 00. Date: 25.06.2018
	NTPC Doc No.: 9585-001-102-QVM-Q-243 Rev 00 Dated: 01.02.2019
Reference Drawing title	Quality plan for SEAMLESS BW FITTINGS- GR91/92 MATERIAL - BOUGHT OUT ITEM

i) ✓ Certified that the item /component is identical to that considered for reference document approval.

ii) That there are minor changes in the item /component with respect to that considered for reference document approval and the same affect the reference document slightly as indicated below.

Material Gr & other relevant test shall meet Technical Specification requirement of the Project.

J.N.S.H.

SIGN: (Main Supplier)

Date: 13.07.2023

NTPC (Approved by/Date/Seal)

BHEL-UNIT: BHEL, Piping Centre, Trichy



ENDORSEMENT SHEET FOR DRAWING / DOCUMENT

TO BE FILLED IN BY SUPPLIER AT TIME OF SUBMISSION

Project Name	PATRATU STPP PHASE-I - (3X 800 MW)
Contract No:	CS-9585-001-2
Package name	BHEL WORK ORDER NOS:- 7381, 7382, 7383, 7384, 7385 (MAIN BOILER) & 7386(AUX. BOILER)
Main Supplier	EPC PACKAGE
Manufacturer Name	BHEL, Piping Centre, Chennai
Project/package Specific document	NTPC Approved Sub-Contractor and Sub-Vendors
Drawing title	BHEL QP ref.: 7381:QPC:20:Rev 00.Date: 25.06.2018
	NTPC ref.: 9585-001-102-QVM-Q-243
	Quality Plan for SEAMLESS BW FITTINGS - Gr-91/92 MATERIAL.
Reference Project Name	TELANGANA STPP PHASE-I (2X 800 MW)
Reference Contract No:	CS-9591-101-2
Reference Package name	SG PACKAGE
Reference Main Supplier	BHEL, Piping Centre, Chennai
Reference Manufacturer Name	NTPC Approved Sub-Contractor and Sub-Vendors
Reference Project/package document	BHEL QP ref.: 7313:QPC:19:Rev 02. Date: 21.05.2018
Reference Drawing title	NTPC Doc No.: 9591-102-102-QVM-Q-001A Rev 02. Date: 04.06.2018
	Quality plan for SEAMLESS BW FITTINGS - Gr-91/92 MATERIAL.

- i) ☒ Certified that the item /component is identical to that considered for reference document approval.
 ii) ☐ That there are minor changes in the item / component with respect to that considered for reference document approval and the same affect the reference document slightly as indicated below.


Material Gr & other relevant test shall meet Technical Specification requirement of the Project.

(Signature)
 SIGN: (Main Supplier)

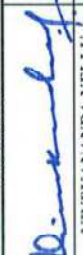
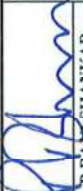
DATE: 25-06-2018


(Signature)
 NTPC (Approved by/Date/Seal)

BHEL-UNIT: BHEL, Piping Centre, Chennai

		CONTRACTOR'S NAME & ADDRESS BHEL PIPING CENTRE, CHENNAI		MANUFACTURING QUALITY PLAN ITEM : SEAMLESS BW FITTINGS CONFORMING TO ASME SA234 WP91, ASTM A234WP92 & ASME SA182 F91/F92 (BOUGHT OUT ITEM) System : Power Cycle Piping BHEL Customer No's : 7313, 7314, 7325 (MAIN BOILER) & 7315(AUX. BOILER)						QP No: 7313-QPC-19 Rev: 02 Dt: 21.05.2018		PROJECT : TELANGANA STPP PHASE-I (2X 800 MW) PACKAGE : SG Package CONTRACT No.: CS-9591-101-2 MAIN-SUPPLIER : BHEL, Piping centre			
S.No	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT #	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY	REMARKS					
1	2	3	4	5	6a	6b	7	8	9	D*	** 10				
1.0 Raw Materials & Fittings shall be procured from NTPC approved Sources. The Test Certificate received from RM manufacturer shall meet IBR requirements.															
1.1	Seamless Pipe/Forging	a) Chemical Composition, Mechanical Properties b) UT Condition c) Hardness test d) Dimensions Outer Dia., Thk. etc e) Material confirmation Test (Chemical)	Major	Verification of MTC	100%	100%	ASME SA335P91/P92 ASME SA182F91/F92 For Grade 92 : Ni-03%Max and Cu-025%Max For P92 : UT as per EN10246.7 1996 or equivalent, with longitudinal notch of 5% eptd of thickness (min 0.3mm and max. 1.5mm); For F92 : UT as per SA388 with Cl.3.3.4 of ASME Sec-VIII, Div.2 for Forging/Bars of dia or Thk >50mm	MTC	X	P	V	V	MTC - Mill Test Certificate Refer Note 01		
			Major	Verification of MTC	100%	100%			X	P	V	V	## : Hydro/UT for other material grades		
			Major	Verification of MTC	100%	100%	ASME SA335P91/P92 ASME SA182F91/F92		X	P	V	V			
			Major	Measurement	100%	100%	ASME SA335P91/P92 ASME SA182F91/F92	HC	X	P	V	V			
			Major	Spectro / X-ray fluorescence	100%	100%	ASME SA335P91/P92 ASME SA182F91/F92	PMI Report	X	P	W**	V	W** : Witness by IBR		
2.0 IN PROCESS INSPECTION															
2.1	Material receiving inspection	Marking & transfer of identification	Major	Visual	100%	--		HC	X	P	V	V	HC : History card Refer Note 02		
2.2	Design Proof Test (only for Formed Fittings)	Qualification of Fittings	Major	Burst Test	100%	100%	As per ASME B16.9 / applicable design code by Deepak Jindal		X	P	V/W*	V	W* : Witness required if report is not available		
2.3	Fitting Forming Procedure	Procedure qualification	Major	Review	100%	100%	ASME SA234WP91/ASTM A182F91 ASME SA182F91	Date: 2018.06.04 11/09/2018 Reason: CAT I	X	P	V	V	\$ Vendor's procedure to be approved by BHEL		
LEGEND: * RECORDS, IDENTIFIED WITH "TICK" (X) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M. MANUFACTURER/SUB-SUPPLIER, C. THIRD PARTY INSPECTING AGENCY W. WITNESS, V. VERIFICATION & R. REVIEW AS APPROPRIATE CHP: NTPC SHALL IDENTIFY IN COLOUR 'N' AS 'W' #: NTPC INSPECTION ENGINEER TO CHECK, APPROVAL DATE/REVISION NO. OF REF. DOCUMENTS AT THE TIME OF INSPECTION															
VIVEKANANDA YELLU Dy. Mgr /QA		P RAVI SHANKAR AGM/Q		NTPC				Location: 9591-102-QVM-Q-001A REV..... CAT... NTPCEOC							
MAIN-SUPPLIER		MAIN-SUPPLIER													
SIGNATURE		PAGE 01 OF 04		FOR NTPC USE:				REVIEWED BY		APPROVED BY		APPROVAL SEAL			

CONTRACTOR'S NAME & ADDRESS BHEL PIPING CENTRE, CHENNAI		MANUFACTURING QUALITY PLAN						PROJECT : TELANGANA STPP PHASE-I (2X 800 MW) PACKAGE : SG Package CONTRACT No.: CS-9591-101-2 MAIN-SUPPLIER : BHEL, Piping centre					
ITEM : SEAMLESS BW FITTINGS CONFORMING TO ASME SA234 WP91, ASTM A234WP92 & ASME SA182 F91/F92 (BOUGHT OUT ITEM) System : Power Cycle Piping BHEL Customer No's : 7313, 7314, 7325 (MAIN BOILER) & 7315(AUX. BOILER)		QUANTUM OF CHECK		REFERENCE DOCUMENT #		ACCEPTANCE NORMS		FORMAT OF RECORDS		AGENCY		REMARKS	
CLASS		TYPE OF CHECK		M		C/N		D*		M		C N	
3		5		6a		6b		7		8		9	
4		Temperature, Measurement & Visual		100%		--		Appd.Procedure		X		P V	
Critical		Temp & Time graph		100%		100%		Refer Note 03		X		P R	
Major		Measurement & Marking		One Sample / Heat / Size/ HT Batch		--		As per ASTM A370		X		P W	
1	2	3	5	6a	6b	7	8	9	D*	** 10	11		
2.4	Forming of fittings	Process parameters	Critical	Temperature, Measurement & Visual	100%	--	Appd.Procedure	Internal report	X	P V	V		
2.5	Post forming/forging Heat Treatment	Rate of Heating, Rate of Cooling & Soaking time	Critical	Temp & Time graph	100%	100%	Refer Note 03	HT Chart	X	P R	Refer Note 03		
2.6	Test Piece Marking	Selection of Test coupons	Major	Measurement & Marking	One Sample / Heat / Size/ HT Batch	--	As per ASTM A370	Internal report	X	P W	Refer Note 02 & Refer Note 07		
3.0 TESTS													
3.1	Chemical properties	Product Analysis	Major	Chemical Composition	One Sample / Heat / Size	One Sample / Heat / Size	ASME SA234WP91/ASTM A234WP92 ASME SA182F91/F92	Test Report	X	P W**	V W** : Witness by IBR		
3.2	Mechanical properties	YS, UTS, % Elongation (Mandatory)	Major	Tensile Strength,	One Sample / Heat / Size/ HT Batch	One Sample / Heat / Size/ HT Batch	ASME SA234WP91/ASTM A234WP92 ASME SA182F91/F92	Test Report	X	P W**	Refer Note 04		
3.3	Hardness test	Hardness	Major	Measurement	100%	100%	ASME SA234WP91/ASTM A234WP92 ASME SA182F91/F92	Test Report	X	P W	# : For dia>=200mm 100% witness by BHEL & 10% by NTPC		
3.4	NDE	(a) Volumetric Defect	Major	UT#	100%	100%	ASME SecVIII Div-2, Cl.3.3.4	Test Report	X	P W			
		(b) Sub-surface Defect	Critical	WET MPI	100%	100%	ASME B31.1 Cl. 136.4.3	Test Report	X	P W			
3.5	Photomicrographic test	Microstructure	Critical	Insitu Micro	One Sample / Heat / Size/ HT Batch	One Sample / Heat / Size/ HT Batch	No micro fissures. Microstructure shall show tempered martensite. Grain growth if any has to be examined further. For P92 : Delta Ferrite - 3%Max.	Test Report & Photomicrograph (Magnification at 500x minimum)	X	P W	Refer Note 08		
LEGEND: * RECORDS, IDENTIFIED WITH "TICK" (X) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER/SUB-SUPPLIER, C: THIRD PARTY INSPECTING AGENCY APPROVED BY IBR&BHEL, N: NTPC, P: PERFORM. W: WITNESS, V: VERIFICATION & R: REVIEW AS APPROPRIATE CHP: NTPC SHALL IDENTIFY IN COLOUR 'N' AS 'W' #: NTPC INSPECTION ENGINEER TO CHECK, APPROVAL DATE/REVISION NO. OF REF. DOCUMENTS AT THE TIME OF INSPECTION													
VIVEKANANDA YELLU Dy.Mgr/QA		PRADESHANKAR AGM/Q		NTPC FOR NTPC USE:									
MAIN-SUPPLIER		MAIN-SUPPLIER		REVIEWED BY APPROVED BY APPROVAL SEAL									
SIGNATURE		PAGE 02 OF 04											

CONTRACTOR'S NAME & ADDRESS BHEL PIPING CENTRE, CHENNAI		MANUFACTURING QUALITY PLAN				ITEM : SEAMLESS BW FITTINGS CONFORMING TO ASME SA234 WP91, ASTM A234WP92 & ASME SA182 F91/F92 (BOUGHT OUT ITEM) System : Power Cycle Piping		QPN No: 7313-QPC:19 Rev: 02 Dt: 21.05.2018		PROJECT : TELANGANA STPP PHASE-I (2X 800 MW) PACKAGE : SG Package CONTRACT No.: CS-9591-101-2 MAIN-SUPPLIER : BHEL, Piping centre		
S.No	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT #	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY	REMARKS		
1	2	3	4	5	M	C/N	6b	9	M	C	N	
3.6	First Off Trail (FOT)	Ovality, Thickening & other dimensions	Major	Measurement	100%	7	8	FOT Report	X	P	W	V
4.0	FINAL INSPECTION											
4.1	Dimensional Inspection	Surface check, Bend angle, Radius, End-to-end dimn, Ovality, Thickness, Wrinkles, d1 at ends, Edge preparation & other dimensions as per Drg.	Major	Measurement	100%	100%	ASME B16.9, BHEL Drg.. & P.O.	Report	X	P	W	W
4.2	Positive Material Identification	Chemical check	Critical	Spectro / X-ray fluorescence	100%	100%	ASME SA234WP91/ASTM A234WP92 ASME SA182F91/F92	Test Report	X	P	W	V
4.3	Marking & Identification	Marking / Color coding	Major	Visual	100%	100%	Refer Note 12	Report	X	P	V	V
4.4	Surface Protection & Painting	Appearance & DFT		Visual & Measurement	100%	100%	Project Specific NTPC approved Painting Scheme	Report	X	P	W	V
4.5	Preservation & Packing	End Protection	Major	Visual	100%	100%	Refer Note 13	Report	X	P	V	V
5.0	DOCUMENTATION											
5.1	Inspection clearance	(a) IBR Certification	Major	All tests as per IBR	100%	100%	IBR	FORM-IIIC	X	P	V	--
		(b) Documentation	Major	Verification	100%	100%	All reports as required in this QAP	Report	X	P	V	V
5.2	Despatch Clearance	Despatch Clearance	Major	Verification	100%	100%		MDCC	X	P	V	CHP Refer Note 11
 VIVEKANANDA YELLU Dy.Mgr /QA MAIN-SUPPLIER		 P. RAVI SHANKAR AGM/Q MAIN-SUPPLIER		NTPC LEGEND: * RECORDS, IDENTIFIED WITH "TICK" (X) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER/SUB-SUPPLIER, C: THIRD PARTY INSPECTING AGENCY APPROVED BY IBR&BHEL, N: NTPC, P: PERFORM, W: WITNESS, V: VERIFICATION & R: REVIEW AS APPROPRIATE CHP: NTPC SHALL IDENTIFY IN COLOUR 'N' AS 'W' #: NTPC INSPECTION ENGINEER TO CHECK, APPROVAL DATE/REVISION NO. OF REF. DOCUMENTS AT THE TIME OF INSPECTION				DOC. NO. 9591-102-102-QVM-Q-001A REV CAT ...		REVIEWED BY APPROVED BY APPROVAL SEAL		
SIGNATURE		PAGE 03 OF 04										

		CONTRACTOR'S NAME & ADDRESS BHEL PIPING CENTRE, CHENNAI		MANUFACTURING QUALITY PLAN ITEM : SEAMLESS BW FITTINGS CONFORMING TO ASME SA234 WP91, ASTM A234WP92 & ASME SA182 F91/F92 (BOUGHT OUT ITEM) System : Power Cycle Piping BHEL Customer No's : 7313, 7314, 7325 (MAIN BOILER) & 7315(AUX. BOILER)				PROJECT : TELANGANA STPP PHASE-I (EX 800 MW) PACKAGE : SG Package CONTRACT No.: CS-9591-101-2 MAIN-SUPPLIER : BHEL, Piping centre									
SUPPLIED BY NTPC APPROVED SUB-VENDORS		CHARACTERISTICS		CLASS		TYPE OF CHECK		REFERENCE DOCUMENT #		ACCEPTANCE NORMS		FORMAT OF RECORDS		AGENCY		REMARKS	
COMPONENT & OPERATIONS		3		4		5		7		8		9		D*		** 10	
2		3		4		5		7		8		9		D*		** 10	
1		3		4		5		7		8		9		D*		** 10	

NOTES:

- The raw materials shall be as per drawing and NTPC Technical Specifications and to be procured from NTPC approved vendors.
- Seal transfer on pieces to be cut shall be done by IBR inspector.
- POST FORMING / FORGING HEAT TREATMENT :-**
 Normalise at 1050 - 1080 deg C & Temper at 750-780 deg C
 Normalising and Tempering shall be carried out within 72 hours after completion of forming. The items shall be kept dry and stress free. The temperature shall be brought down to 0 to 100 deg C after hot forming before normalizing and also after normalizing before tempering. Normalising and tempering of Gr91/Gr92 shall be done encompassing the entire component. Soaking shall be 1 Hrs minimum.
- Chemical & Mechanical tests shall be performed at in-house or reputed laboratories.
- All NDE procedures shall be submitted to BHEL for review. NDE procedures shall have Level-III certified personnel approval in case of in-house. In case of non-availability of inhouse facility NDE shall be performed by reputed laboratories.
- Items shall be visually checked. No hard scales shall be present on inside & outside surfaces.
- Gas cutting & Plasma cutting are prohibited for Gr91/Gr92 material. Repair by welding is prohibited.
- Three replicas in one fitting. Actual magnification shall be indicated in the photomicrograph. Photomicrographs shall be provided as records for review & acceptance and future in-service reference. Delta Ferrite <or=3%, when measured as per VD TUV1272 for P92 fittings
- All items shall be inspected and cleared by BHEL, IBR authorities & NTPC.
- Necessary IBR Requirements shall be fulfilled and IBR documents to be submitted.
- ~~The Sub-Vendor shall co-ordinate with NTPC and obtain NTPC before despatch of finished material and same shall be furnished to BHEL.~~
- The finished components shall be punched with DU code (14 digit work order du details). Heat number, material specification, maker's emblem, Inspectors seal and Statutory authorities seal. In addition, the DU code, Heat no. and Material specification shall also be paint stencilled. **Colour Coding : Gr91 - Brown & Red, Gr92 - Brown & Blue**
- Surveillance of Surface preparation, adhesion, Painting process & DFT by NTPC inspector.
- Machined ends shall be well protected using end caps and suitably packed to avoid transit & other damages. Tack welding is prohibited.

VIVEKANANDA YELLU Dy. Mgr /QA		P RAVI SHANKAR AGM/Q		LEGEND: * RECORDS, IDENTIFIED WITH "TICK" (X) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER/SUB-SUPPLIER, C: THIRD PARTY INSPECTING AGENCY APPROVED BY IBR&BHEL, N: NTPC, P: PERFORM, W: WITNESS, V: VERIFICATION & R: REVIEW AS APPROPRIATE CHP: NTPC SHALL IDENTIFY IN COLOUR 'N' AS 'W' #: NTPC INSPECTION ENGINEER TO CHECK APPROVAL DATE/REVISION NO. OF REF DOCUMENTS AT THE TIME OF INSPECTION		NTPC		DOC. NO. 9591-102-102-QVM-Q-001A REV. CAT...	
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Bharat Heavy Electricals Limited- Trichy
QA/Piping

List of Raw material Manufacturer approved by NTPC for Piping Fabrication
with Vendor material

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Sl	Vendor Name	Location	Material	Remarks
A) PIPES (Seamless) : CS - Carbon steel ; AS - Alloy steel				
1	ARCELORMITTAL TUBULAR PRODUCTS ROMAN S.A	ROMANIA	CS	
2	BHEL SSTP	TRICHY	CS	
3	BENTELER STEEL/TUBE GMBH	GERMANY	OD UPTO160 MM FOR P-11, P-22, P-91, P-92	
4	Forgiatura Morandini S.R.L	ITALY	CS & AS P-11, P-22, P-91 & P-92	
5	Franchini Acciai S. p. A	ITALY	CS & AS P-12, P-22, P-91,P-92	
6	HMTL	INDIA	CS (HFS & CDS) 127mm OD X 21mm thickness AS up to grade 22 (HFS & CDS) 127mm OD X 21mm thickness SA 335 P91 CDS & HFS: OD76.2-127mm & WT 3.5-21mm	
7	IBF S.P.A	ITALY	CS & AS P-11, P-22, P-91 & P-92	
8	M/s Kirloskar Ferrous Industries Ltd. (Erstwhile M/s. ISMT Ltd)	Baramathi / Ahmednagar	CS & AS upto Gr. 22 HOT FINISHED: OD: 38.0 MM TO 273.0 MM WT: 3.5 MM TO 40.0 MM COLD FINISHED OD: 18.0 MM TO 140.0 MM WT: 1.5 MM TO 15.0 MM	
9	JFE STEEL CORPORATION	JAPAN	CS & AS P-11, P-22, P-91 & P-92	
10	JINDAL SAW LIMITED	NASHIK	CS & AS upto Gr. 22, SS HOT FINISHED OD: 33.4 MM TO 168.3 MM WT: 3.5 MM TO 21.95 MM; For CS only - OD: 33.4 MM TO 219.1 MM WT: 3.5 MM TO 14.2 MM COLD FINISHED OD: 6.0 MM TO 140.0 MM WT: 0.8 MM TO 15.0 MM	
11	MAHARASHTRA SEAMLESS LTD	RAIGAD	CS HOT FINISHED OD:219.1 MM TO 355.6 MM WT: 6.35 MM TO 35.1 MM COLD FINISHED OD:19.0 MM TO 88.9 MM WT: 1.0 MM TO 12.0 MM	
12	MAHARASHTRA SEAMLESS LTD	MANGOAN, RAIGARH	AS upto P-22 OD 21 MM TO 168.30MM & WALL THK 2.4MM TO 22MM	
13	NIPPON STEEL & SUMITOMO METAL CORPORATION	JAPAN	CS & AS P-11, P-22, P-91 & P-92	
14	OFAR S.P.A (Visano plant & Cividale Plant)	ITALY	SA106GRB/C Dia 273 mm to 1016 mm Thickness 35 mm to 124 mm SA335P12 Dia 168.3 mm to 558.8 mm Thickness 35 mm to 85 mm SA335P22 Dia 323.9 mm to 1016 mm Thickness 22 mm to 89 mm SA335P91 Dia 127 mm to 813 mm Thickness 18 mm to 100 mm SA335P92 Dia 168.3 mm to 813 mm Thickness 33 mm to 108 mm	
15	REMI METALS GUJARAT LTD	BHARUCH	CS & AS upto Gr. 22	



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Sl	Vendor Name	Location	Material	Remarks
16	RINGMILL SPA	ITALY	CS OD UP TO 914 MM & WT UP TO 102 MM ; AS UPTO P-91; SA335P92 OD 168.3 mm to 812.8 mm Thickness 35 mm to 108 mm	
17	TENNARIS GLOBAL SA, URUGUAY	NKK TUBES, ITALY	CS & AS P-11, P-22, P-91	
18	TENNARIS GLOBAL SERVICES SA, URUGUAY	NKK TUBES, JAPAN	CS & AS P-11, P-22, P-91	
19	TENNARIS GLOBAL SERVICES SA, URUGUAY	DALMINE, ITALY	CS & AS P-11, P-22, P-91	
20	TENNARIS GLOBAL SERVICES SA, URUGUAY	SILCO, ROMANIA	Dia upto 159 mm for CS,AS,P-11, P-22, P-91	
21	TUBACEX	SPAIN	SS	
22	Tubos Reunidos Group SLU, SPAIN (TRG Producto Mill & TRG Tubos Mill)	SPAIN	CS & AS P-11, P-22, P-91 For P-92 pipes: Dia 168.3 mm to 813 mm Thickness 33 mm to 108 mm	
23	VALCONVY TRUB CHOMUTOV,	CZECH REPUBLIC	CS & P-12 & P-22	
24	VALLOUREC & MANNESMANN TUBES	FRANCE,GERMANY	CS & AS P-11, P-22, P-91,P-92	
25	WAYMAN GORDAN	USA	CS & AS P-11, P-22, P-91,P-92	
26	HENGYANG VALIN STEEL TUBE Co. LTD.	China*	CS & AS P-12, P-22, P-91	* For CHINA Vendors, BHEL/sub-vendor shall comply all the contract provisions/conditions and GOI regulations including policies on the procurement from countries sharing land border with India and public procurement (preference to Make in India).
27	VALLOUREC CHANGZHOU CO. LTD	China*	For sizes upto ID 540 mm and thickness 120 mm - CS & AS P-11, P-22, P-91,P-92	
28	YANGZHOU CHENGDE STEEL PIPE CO. LTD.	China*	CS & AS P-11, P-22, P-91,P-92	
29	YANGZHOU LONTRIN STEEL TUBE CO. LTD.	China*	CS & AS P-11, P-22, P-91,P-92	
30	ZHEJIANG GROSS SEAMLESS STEEL	China*	CS & AS P-11, P-22, P-91	
31	JIANGSU CHENGDE STEEL TUBE SHARE CO.LTD	China*	For sizes upto OD 219.1 mm - CS & AS P-11, P-22, P-91,P-92	
32	BAOSHAN IRON & STEEL CO LTD PRECISION STEEL TUBE FACTORY	China*	CS-SCHEDULED PIPE UPTO OD 88.9 mm	

B) FITTINGS (GRADE 91/92)

1	ALLIED INT. (TACTUBI RACCORDI SPA, VIA ROMA 150, 29027 PODENZANO)	ITALY	Formed Fittings (Elbows, Tees, Reducers etc.) - 91 & 92 Grade	
2	BASSI LUIGI SPA	ITALY	P-91 FORGED/WELDED	
3	BGH EDELSTAHL SIEGEN GMBH	GERMANY	MANUFACTURE AND SUPPLY OF FORGED FITTINGS OF CS, AS AND SS GRADES	
4	BHARAT FORGE	PUNE	GRADE 92 FORGED FITTINGS (REDUCERS, TEES & YPIECES) Seamless Forged Fittings (Hemispherical Dished Ends) of SA234 WP91	
5	BOKOYOUNG METAL CO.	SOUTH KOREA	FORGED FITTINGS AS PER SA-182 F92 GRADE (REDUCERS, NOZZLE, HALF COUPLING ETC.)	
6	BRUCK STRASSE 16 ENSHEIM	GERMANY	P-91 FORGED/WELDED	
7	CHW FORGE	GHAZIABAD	Grade 91 fittings like Reducers(250/219.1dia,35/61thk/max), Nozzles(360dia/90thk/max), DeSH Nozzle Holders (94dia/max), DeSH Pos. Rods (97.1dia/max), DeSH Pos. Sup. Bolts (50dia/max), DeSH Pos. Rings (70dia/20thk/max) Forged Fittings(Hemispherical Dished Ends) of Gr 91 Forged Fitting Gr. 91/92 upto size Dia 711 X WT 146 mm	



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Sl	Vendor Name	Location	Material	Remarks
8	DEE DEVELOPMENT ENGINEERS LTD	Faridabad	<p>Formed Fittings - Gr. 91 A. Elbow – 38" B. Tee – 38" C. Reducer – 30" D. End Cap- 12"</p> <p>Formed Fittings - Gr. 92 A. Elbow – up to ID 630 mm B. Tee – up to DN 750 mm C. Reducer – up to DN 850 mm D. Cap- up to DN 630 mm</p> <p>Forged Fittings (only machining and testing at M/s. Dee Development) up to F91 grade and up to OD 2"</p>	
9	ERNE FITTINGS GMBH	AUSTRIA	P-91 FORMED	
10	FLASH FORGE PVT LTD	Vizag	<p>Gr. P91 FORMED/FORGED UPTO Elbows - Upto 610 OD & THICK 100 MM Reducers - Upto 610 OD & THICK 80 MM Tees - Upto 610 OD & THICK 106 MM Dished Ends - Upto 762 OD & THICK 91 MM</p>	
11	Forge Monchieri spa	Italy	Grade 91 forgings (hollow forgings/matching piece 508 mm OD X 121 mm thickness, stubs with OD 245 mm and flanges up to 100 NB)	
12	FORGITAL	ITALY	MANUFACTURING AND SUPPLY OF GRADE 91 FORGINGS (HOLLOW FORGINGS/MATCHING PIECES WITH 508MM DIA X 75MM THICKNESS STUBS WITH OD 245MM.	
13	FORGIATURA MORANDINI SRL	ITALY	GRADE 92 FORGED FITTINGS(REDCERS, TEES & Y PIECES)	
14	GAM RACCORDI SPA	ITALY	P-91 FORMED	
15	Goodluck Engineering Co.	Dadri	Forged Fittings (91/92 grade)	
16	GUJARAT INFRAPIPES PVT. LTD.,	BARODA	<p>1. formed fittings Gr.91 Tee/Elbow/Reducer –OD up to 600 mm and thickness up to 38 mm</p> <p>2. Seamless formed fittings Gr.92 A. Elbow OD813x90mm, B. Tee: OD864x93mm C. Reducer: OD914x135mm</p>	
17	IBF SPA	ITALY	FORMED AND FORGED FITTINGS/P92 GRADE	
18	K. S. PIPE FITTINGS PVT.LTD	FARIDABAD.	<p>Formed Fittings - SA 234WP91 Type-I 1. Elbow sizes up to 32" (813 mm) OD of thickness 80 mm. 2. Reducers up to 32" (813 mm) OD of thickness 40 mm 3. Tee up to 22" (559 mm) OD of thickness 85 mm</p>	
19	MEGA SPA	ITALY	92 GRADE FITTINGS (FORGED)	
20	Metal Forgings Pvt. Ltd.	New Delhi	FORGING OF CS/SS/ AS UPTO F91 & WEIGHT UPTO 2TON.	
21	PETROL RACCORD SPA	ITALY	FORMED AND FORGED FITTINGS 91/92 GRADE	
22	SUNGKWANG BEND CO LTD	SOUTH KOREA	FITTINGS OF P91 AND OF MATERIAL OTHER THAN P91 OF BOILER	
23	SHANGHAI CHANGQIANG INDUSTRIAL	SHANGHAI *	<p>GRADE 92 FORGED FITTINGS (REDUCERS, TEES & YPIECES)</p> <p>GRADE 91 FORGED FITTINGS (ELBOWS AND DISHED ENDS)</p>	* For CHINA Vendors, BHEL/sub-vendor shall comply all the contract provisions/conditions and GOI regulations including policies on the procurement from countries sharing land border with India and public procurement (preference to Make in India).
24	Tianjin Jinding Piping Co. Ltd.	China *	FORMED FITTINGS (ELBOW, TEES, REDUCERS) OF 91 GRADE.	
25	TECHNO FORGE SPA	ITALY	P-91 FORMED	



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Sl	Vendor Name	Location	Material	Remarks
26	TF TECH CO. LTD	SOUTH KOREA	FORGED FITTINGS AS PER SA-182 F92 GRADE (REDUCERS, NOZZLE, HALF COUPLING ETC.)	
27	TK CORPN.	SOUTH KOREA	FORMED FITTINGS (ELBOW, TEES, REDUCERS ETC.) OF 92 GRADE.	
28	VIAR SPA	ITALY	SEAMLESS FORGED Y-PIECE UP TO GRADE 91	

C) PIPES (Welded): SA 672 , SA 691

1	LALIT PIPES AND PIPES LIMITED	Thane	A672 (Max. OD 1626 mm X Thk 16mm) A691 (Max. OD 1626 mm X Thk 16mm) A672 (Max. OD 1219 mm X Thk 28mm) A691 (Max. OD 1219 mm X Thk 28mm)	
2	MUKAT TANKS AND VESSELS PVT LTD	MUMBAI	A672 (Max. OD 1829 mm X Thk 16mm) A691 (Max. OD 1118 mm X Thk 28 mm)	
3	RATNAMANI METALS & TUBES LTD.,	Chhatral, Gujarat	A672 (Max. OD 1219 mm X Thk 28mm) A691 (Max. OD 1219 mm X Thk 28mm)	
4	RATNAMANI METALS & TUBES LTD.,	Kutch, Gujarat	A672 (Max. OD 1626 mm X Thk 16mm) A691 (Max. OD 1626 mm X Thk 35mm)	

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Reviewed and Approved By
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Packaging Instructions for Piping Components	Doc. No PC: PKG:01	
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PACKAGING INSTRUCTIONS FOR PIPING COMPONENTS

PC: PKG: 01

Revision summary


Rev No	Revision Details	Issued on
00	Fresh issue	28-05-2014

Prepared by	Reviewed & Approved by
	
S.ARUN KUMAR	K.VEDAPRASAD

Bharat Heavy Electricals Ltd., Piping Centre, Chennai – 600 017		
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1. Scope
2. Packaging
3. Criteria for Selection of Packaging
4. Types of packaging
5. Sling protections
6. Marking and Labelling
7. Packing list
8. General Instructions for packaging
9. Reference drawings
10. Cautionary symbols
11. Packing reference table
12. Check list

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1. SCOPE

This procedure elicits the general requirements to be complied with for packaging of piping components. The packaging is intended to preserve and protect the contents.

The handling, storage, cleaning, packaging, and preservation of items shall be controlled to prevent damage or loss and to minimize deterioration.

2. PACKAGING

This procedure contains requirements for packaging of items for protection against corrosion, contamination, physical damage, or any effect that would lower the quality or cause the components to deteriorate during the time they are shipped and stored at sites.

Items shall be inspected for cleanliness immediately before packaging. Dirt, oil, residue, metal chips or other forms of contamination shall be removed.


Adequate protection shall be provided against mechanical damage and atmospheric corrosion in transit and, for equipment suitable for outside storage, for prolonged storage at the site prior to installation.

Water proof barrier material – high density polythene shall be used as a resistant to grease and water; it shall protect items from airborne and windblown soils.

Desiccants like silica gel to be used inside pipe components. Silica gel shall conform to IS 3401. The gel is to be packed in sachets placed at different positions inside the components for absorbing moisture. The quantity of silica gel shall be adequate for storage period of one year.

Components to be placed in such a way that metal to metal contact is avoided.

For mechanical components, (1) all openings shall be covered or plugged with substantial (1/2 inch minimum thick) one piece plywood or metal closures, securely fastened and suitable for prolonged exposure prior to final installation; (2) all tapped openings in equipment shall be plugged with plastic plugs to protect internal threads; and (3) all welding end connections shall be provided with adequate weld bevel protectors to protect from corrosion and physical damage.

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Austenitic stainless steel and nickel-based alloy materials shall be handled in such a manner that they are not in direct contact with carbon steel materials or with materials containing halogen, sulphur, zinc and lead.

Each components/item of stainless steel materials should be wrapped with high density polythene.

All equipment shall be packed, securely anchored (skid mounted when required) and weather protected for the shipment method adopted.

Temporary bracing or supports, marked and tagged for removal after equipment installation, shall be provided to prevent damage during shipment and shall be painted bright, fluorescent yellow.

3. Criteria for Selection of Packaging:

Packages are to be made according to categories listed in Table-6 (see page – 24), depending on the type of materials and size.

4. TYPES OF PACKAGING:

4.1 CRATES

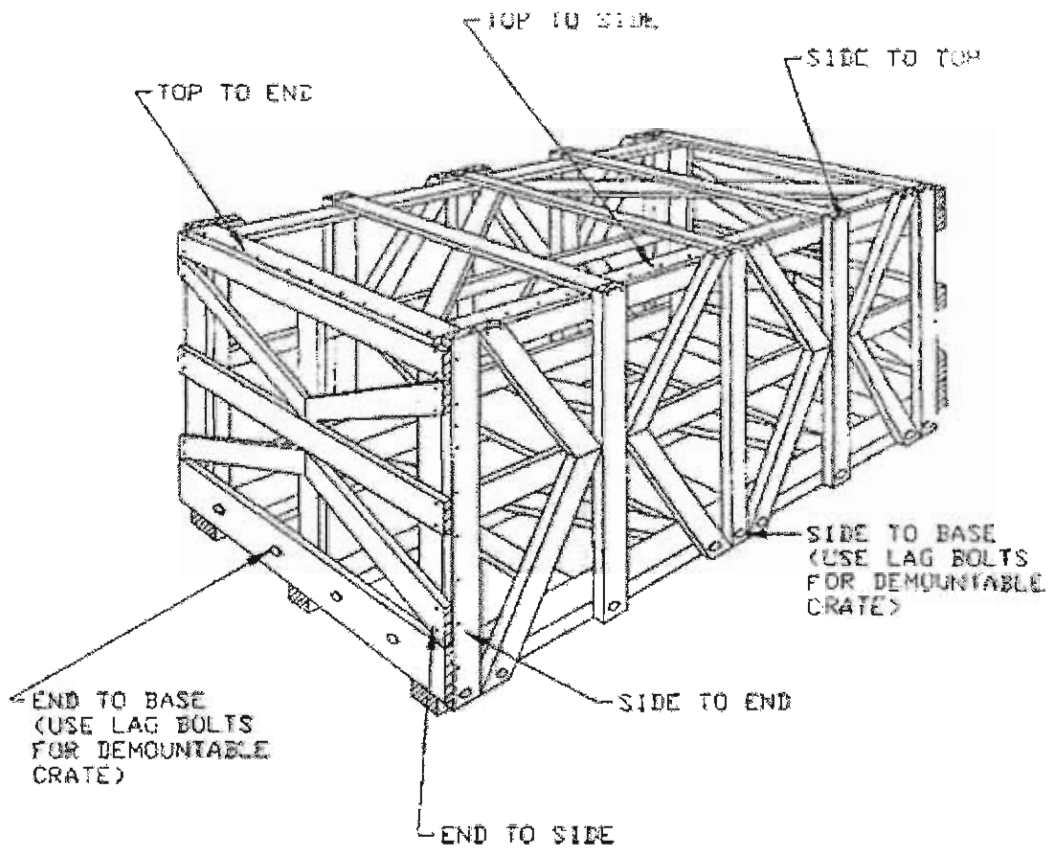
- These are to be made of seasoned wood and are intended for packaging heavy materials Viz., straight pipes and pipes with attachments.
- The crates are to be lined with hi-density polythene, to prevent entry of moisture.
- The dimensions of the crates are to be restricted to 20 x5x5 feet.
- Pipes up to OD 350mm are to be crated.
- Pipes are to be stacked inside the crate so that the weight of the pipe does not rest on branch stubs or carrier plates.
- Contents of the crate should not come in contact with each other or with the crating, and should be adequately cushioned to preserve the painting.
- The gross weight of the crate should not exceed 2 Tons.
- For further instructions refer ASTM D6039 Standard Specification for Open and Covered wood Crates.

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WOODEN CRATE



Max Net Load (KGS)	Length (mm)	Width (mm)	Height (mm)
2000	6096	1524	1524

All the dimensions shown in the above table are maximum inside dimensions.

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4.3 SADDLES

- Saddles are defined as profiled supports made of wood, and are used to cradle and support Tanks, pipe bends and pressure vessels.
- Ensure that the end chamfering of the bends are duly protected for the transit.
- Tanks are to be completely drained and dried.
- Adequate amount of the specified desiccant is to be placed inside the tank/ vessel.
- Ensure that all openings are covered and /or plugged.

4.4 CASES

- Other components such as fittings and Mitres are to be packed inside wooden cases.
- The insides of the cases are to be lined with hi-density polythene.
- Air vents to be provided in the cases for ventilation.
- Components to be placed in such a way that metal to metal contact is avoided.
- Small components like Fasteners, gaskets are to be packed in high density polythene covers and placed inside the wooden cases.
- Holes to be provided in the case floor to act as drains.

4.5 BUNDLES

- Bundles are transportable units where a large number of straight pipes of the same diameter and even lengths are arranged securely and are fit to be lifted by cranes and also stacked.
- Pipe ends should be covered fully with plastic end caps.
- Pipes can be bundled only when they can bear the stack compression load without additional support.
- Clamps made of wood or steel clamps with wooden inserts are to be used.
- Clamps must be locked firmly so that the pipes cannot slide out of bundle.
- Bundle must be held together by at least three sets of clamps as indicated in the diagram.

**Packaging Instructions for Piping
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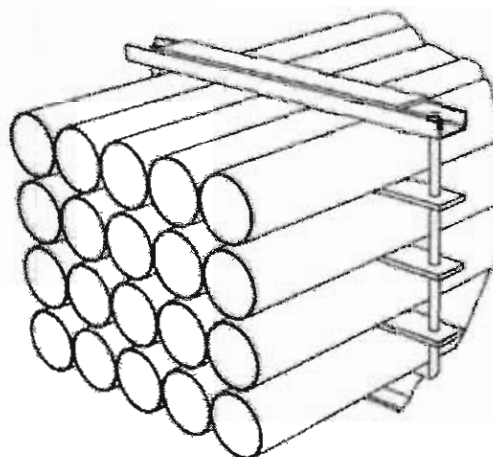
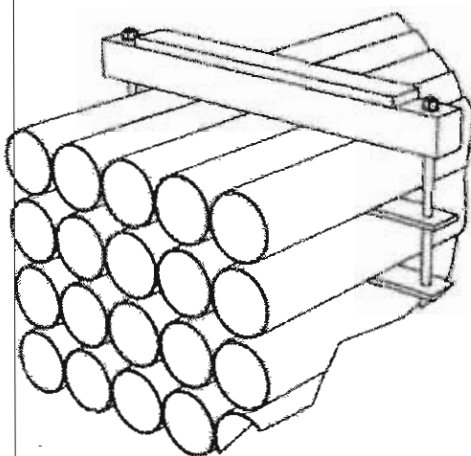
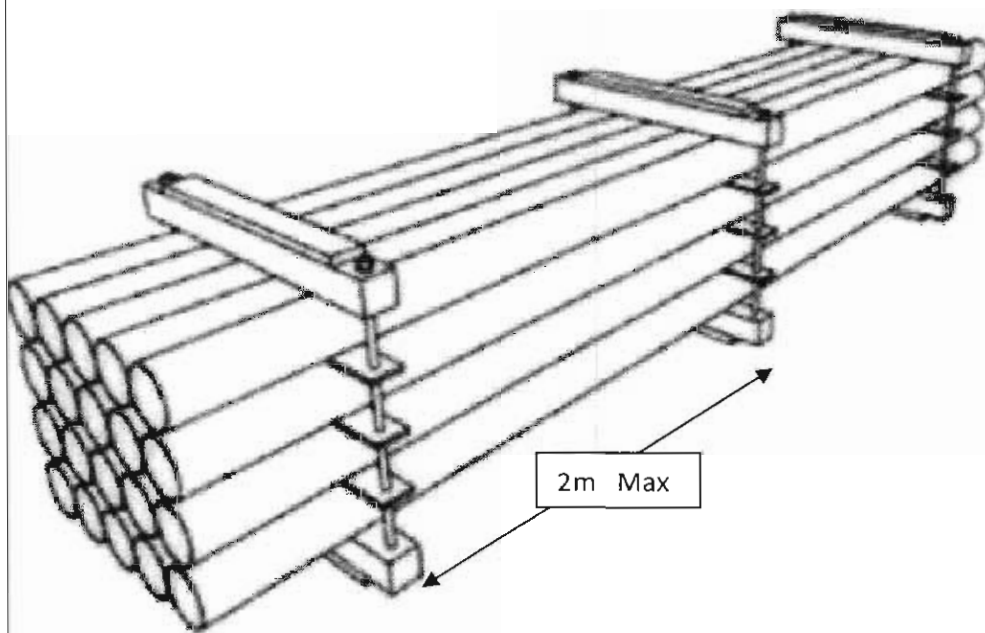
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5. SLING PROTECTIONS

The lifting points of the case or crate or bundle must be equipped with sling protections suitable to the respective package gross weight.


6. MARKING AND LABELLING

Components and their containers shall be identified by marking. Shipping marks shall be on all sides of package. The shipping marks shall be at least 3 inches high where space permits. Markings are to be in black paint or ink depending on shade of the package surface.

Cautionary symbols to be stencilled in red waterproof paint or ink.

7. PACKING LIST

One complete packing list inside a watertight envelope must be affixed outside of each package and be covered by sheet metal. One more copy of the packing slip wrapped in polyethylene bag is to be kept inside the box at the pertinent place.

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8. General Instructions for packaging

- The quantity of Slides / Runners is selected depending upon the weight and over-all dimension of the Load, to be carried. Table-1 and 2 details out the number of Slides, length and cross sections of the Slides to be provided with their carrying capacity.
- The construction of bottom frame is as shown in the Figure-2.
- The construction of the top frame is, as shown in the figure -3.
- Thickness of the boards, used for sheathing for the top, sides and end panels, shall be 25 mm.
- The top of the Box consist of Beam supported on top traverse bar and sheathing, as shown in the figure- 3.
- The dimension of items 1, 2 f figure -3 shall be as table -3.
- Diagonal braces shall be used in packing cases with height, exceeding 600 mm as shown in the figure- 4.
- The angle between the lower (or) upper horizontal supports and diagonal braces, shall be in the range of 20° to 60° and if possible, this angle preferably be kept at 45°.
- If the height of the box exceeds more than 1400 mm the diagonal braces, shall cross each other and when this dimension exceeds 1800mm additional horizontal supports shall be provided as shown in figure-5 and figure- 6.
- Size of upper and lower horizontal supports and vertical supports, shall be as per Table 4 refer figure 7, 8, 9 & 10 for the arrangement.
- The cross section of end traverses bar (item -1) and thickness of bottom boards (item-2), shall be used as per table - 5.
- All boxes measuring more than 600 mm height shall be constructed by assembling end, side and top shook's on a bottom, forming a complete enclosed Box (refer figure-11).
- Angle iron cleats shall be used for strengthening the joints, as indicated in figure -12.
- Boxes will be strengthened by steel bands to withstand transit damages.

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9. Reference drawings

1. SLIDE
2. LONGITUDINAL UNDER
SLIDE BOARD.
3. BOTTOM BOARD
4. CARRIER TRAVERSE BAR
5. INTERMEDIATE VERTICAL SUPPO
6. HORIZONTAL BRACING
7. DRAINAGE HOLES
8. BATTEN
9. SLING PLATE
10. NUT BOLT WASHER
11. END TRAVERSE BAR
12. WATER PROOF LINING OF
BITUMANISED PAPER
13. VERTICAL SUPPORTS
14. END SHEETING BOARD
15. SIDE SHEATING BOARD
16. TOP SHEATING BOARD
17. LONGITUDINAL SUPPORT
18. TOP HORIZONTAL BEAM
19. TOP SHEATING BOARD
20. TOP CORNER STRIPS
(FOR STRENGTHENING)
21. OUT SIDE DOCUMENTS
CONTAINER.

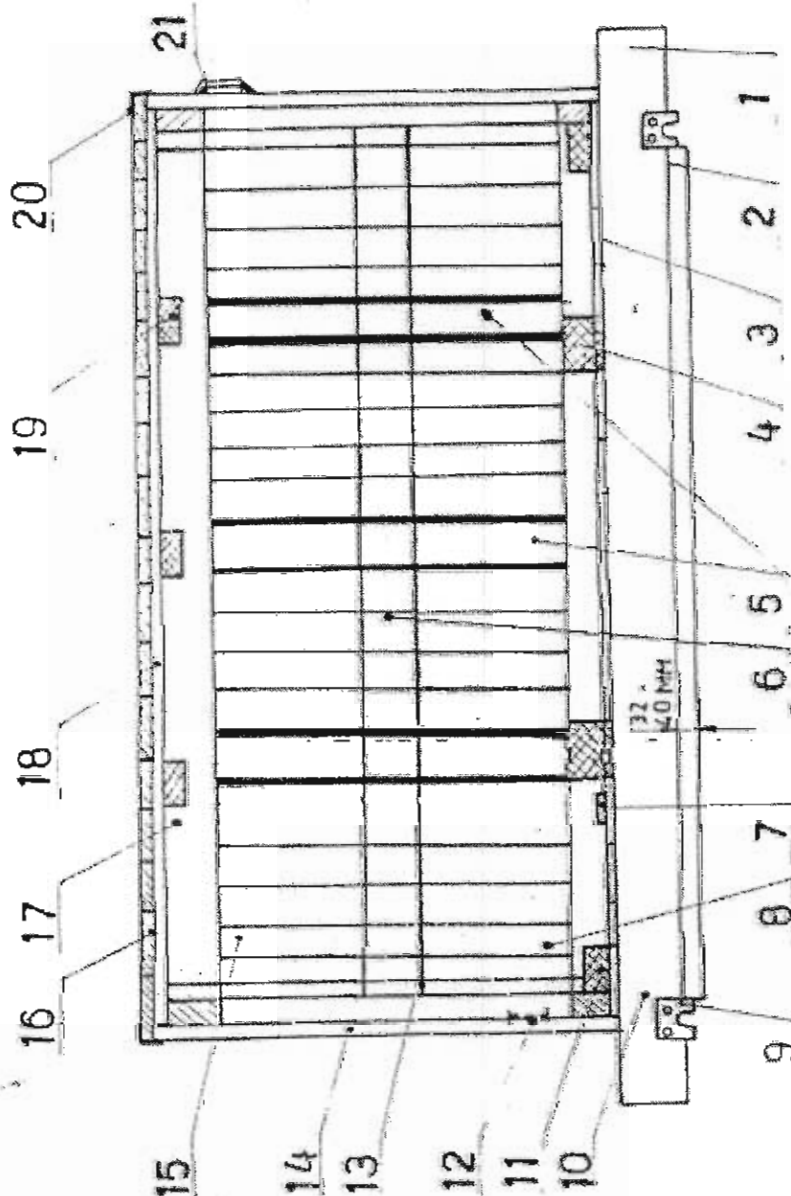


Fig. 1

NOMENCLATURE OF PARTS OF PACKING

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BOTTOM FRAME ARRANGEMENTS FOR TYPES
633, 654, 966, 1296, 1122, 1144, 1399, 1577

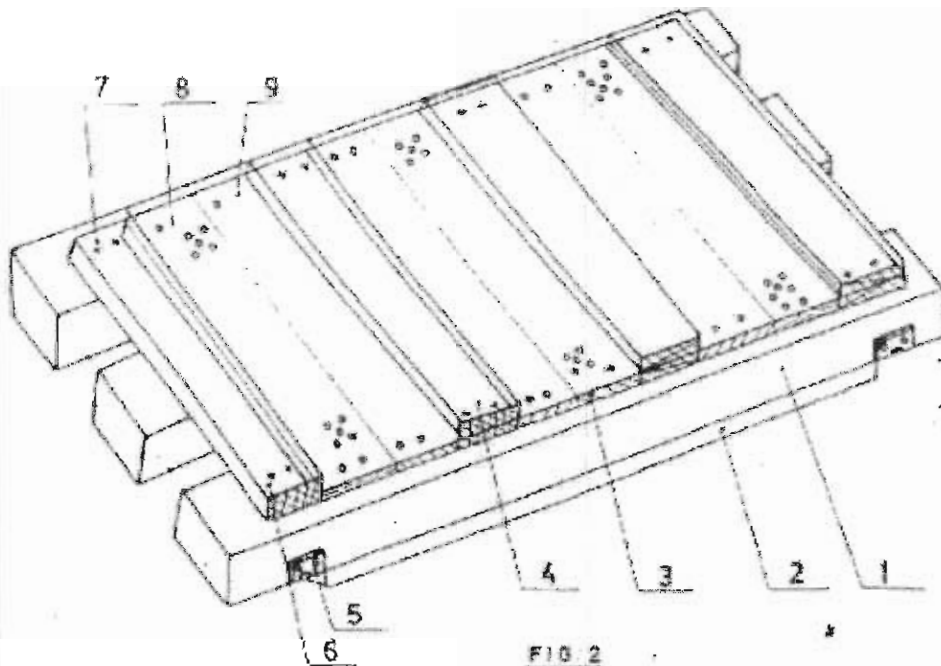


FIG. 2

- 1. SLIDE
- 2. UNDER SLIDE BOARD
- 3. BOTTOM BOARD
- 4. CARRIER TRAVERSE BAR
- 5. SLING PLATE
- 6. TRAVERSE BAR
- 7. BOLT, NUT & WASHER
- 8. DRAINAGE HOLES
- 9. NAILS

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TOP FRAME ARRANGEMENT FOR TYPES
633, 654, 966, 1296, 1122, 1144, 1399 & 1577

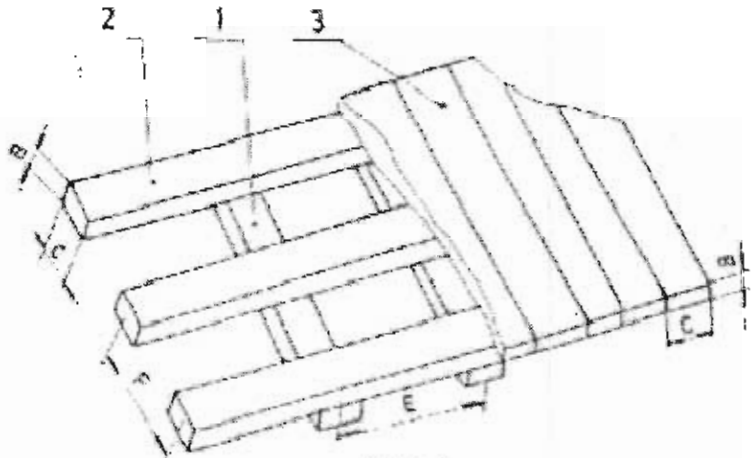


FIG-3

- 1 - Traverse Bars
- 2 - Horizontal Scans
- 3 - Top Board

PROVISION OF DIAGONAL BRACING ARRANGEMENT



FIG-4

**Packaging Instructions for Piping
Components**

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ARRANGEMENT OF DIAGONAL BRACING &
HORIZONTAL SUPPORT

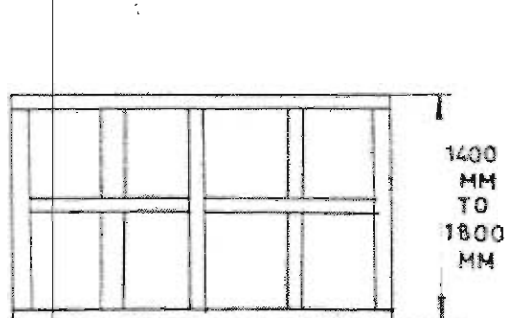


FIG. 5

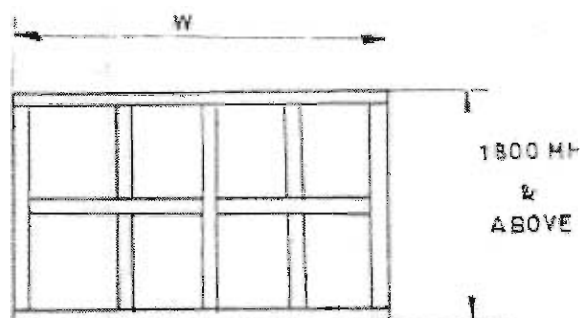


FIG. 6

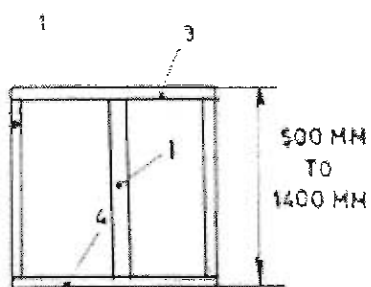


FIG. 7

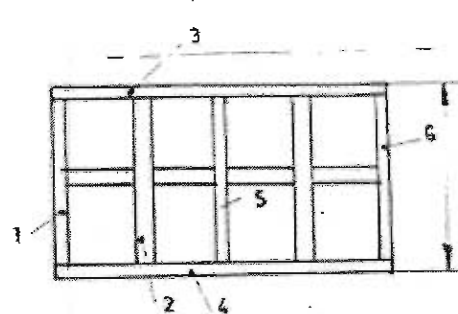


FIG. 8

1. VERTICAL SUPPORT


1, 2, 5, 6 - VERTICAL SUPPORT

3. UPPER HORIZONTAL SUPPORT

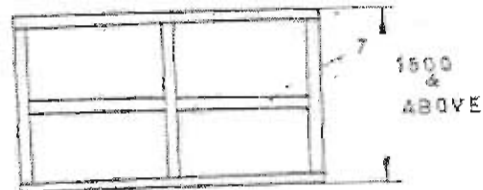
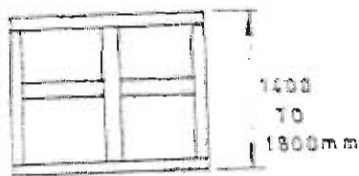
3 - UPPER HORIZONTAL SUPPORT

4. LOWER HORIZONTAL SUPPORT


4 - LOWER HORIZONTAL SUPPORT

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ARRANGEMENT OF DIAGONAL BRACING AND HORIZONTAL SUPPORT



7-MIDDLE HORIZONTAL SUPPORT

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ARRANGEMENT OF PACKING CASE

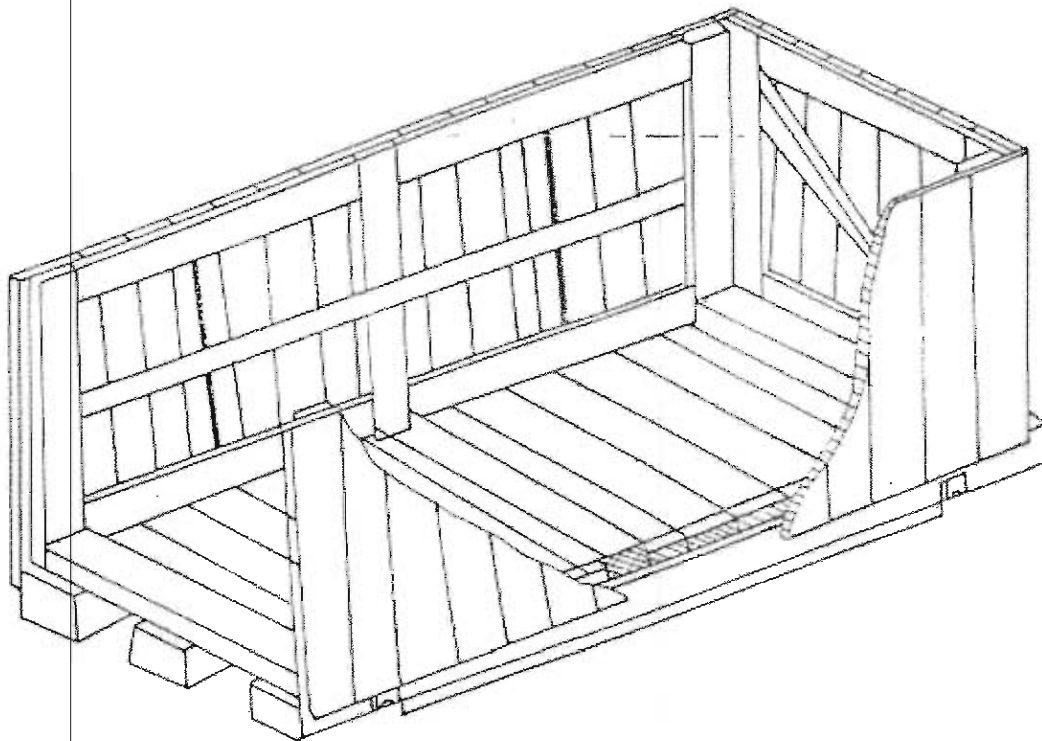


FIG : 11

**Packaging Instructions for Piping
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ARRANGEMENT OF ANGLE IRON CLEATS

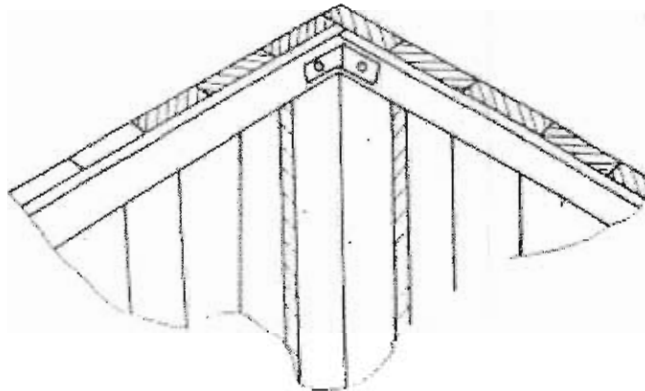


FIG:12

ARRANGEMENT OF C-CLAMPS AROUND CASES

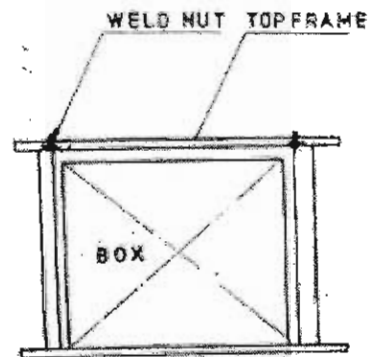
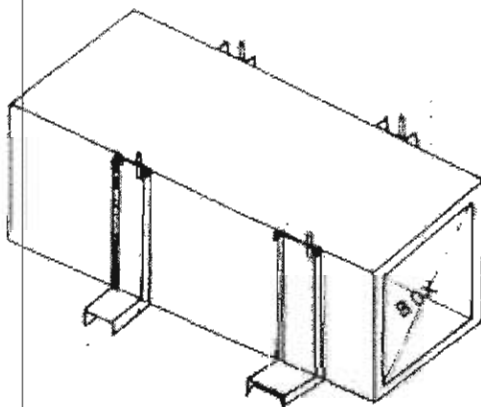


FIG:13

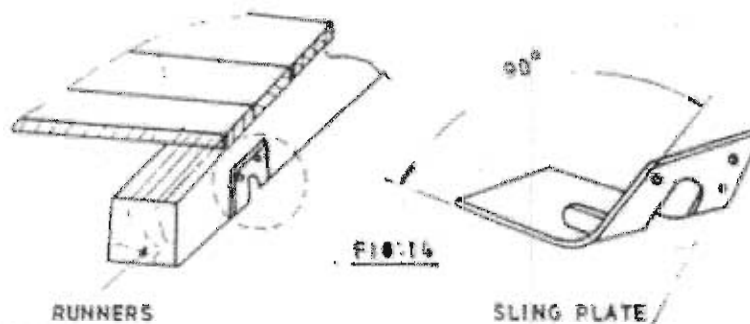
**Packaging Instructions for Piping
Components**

Doc. No
PC: PKG:01

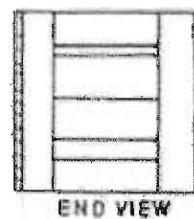
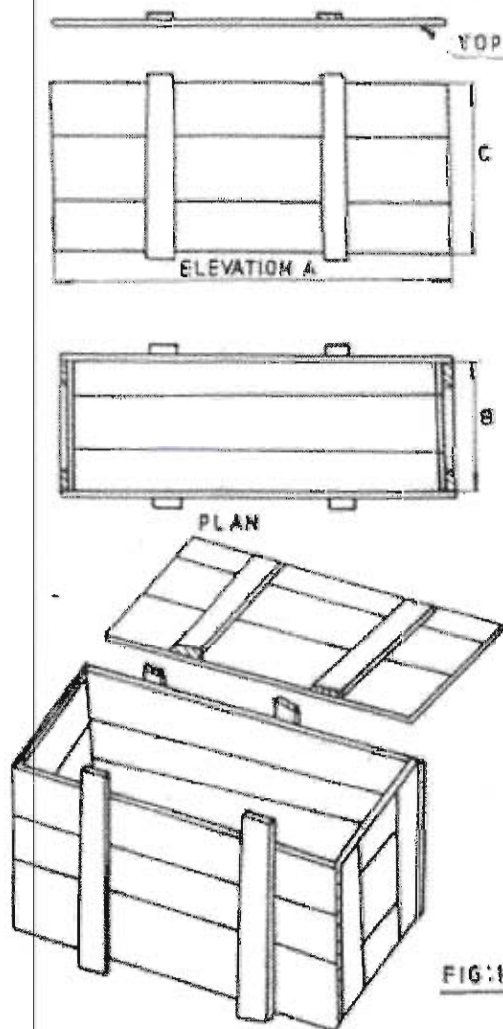
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**ARRANGEMENT OF SLING - PLATE ON
CASES**



ARRANGEMENT OF SMALL CASES




TYPE 654, 633

DMS TYP	A	B	C
654	600	500	400
633	600	300	300

IN MM ONLY

1. BOTTOM BOARD
 2. CROSS TRAVERS BOARD
- A. UNIFORMLY DISTRIBUTED
B. CONCENTRATED LOAD

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The sizes of boxes given below are indicative. Actual sizes may vary according to size and positioning of component inside.

ANNEXURE – A
WOODEN BOXES

TYPE	L X B X H (MM)	CARRYING CAPACITY IN KGS
633	600x300x300	200
654	600x500x400	500
966	900x600x600	1000
1296	1200x900x600	2000
1122	100x200x200	300
1144	110x400x400	300
1399	1300x900x900	2500
1577	1500 X 700 X 700	1500

TABLE - 1

No. of slides	Length of slides	Weight in (kgs)	Types of loading
2	600 - 1800 mm	0 - 1000	Two slides for central loading near the ends or uniformly distributes load.
3	1801 - 2500 mm	1001 - 5000	Three slides with load concentrates near the end or uniformly distributed load.


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TABLE - 2

LOAD	Length of slides						
	600	800	1000	1200	1300	1500	2000
	CROSS SECTION						
	B x C		c				
			b				
500	30 x 100	30 x 100	30 x 100	30 x 100	30 x 100	30 x 100	30 x 100
800	30 x 100	30 x 100	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100
1000	30 x 100	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100
1500	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100
2000	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100
2500	100 x 100	100 x 100	100 x 100	100 x 100	100 x 100	120 x 150	120 x 150
3000	100 x 100	120 x 150	120 x 150	120 x 150	120 x 150		

TABLE – 3

Distance between top horizontal scans dim 'f'	Distance between the axis of the traverse bar dimension 'E' in fig -3				
	500	600	700	800	900
	Size b x c				
700 – 1000 mm	30 x 100	30 x 100	30 x 100	30 x 100	30 x 100


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TABLE-4

End and side panels	Width of the panels	Distance Between Longitudinal Support DIM 'D'						
		600	800	1000	1200	1400	1600	1800
		Cross section (b x c) Item 1 to 7						
Fig - 7	600 to 1200	30 x 100	30 x 100	30 x 100	30 x 130	30 x 130	30 x 130	30 x 130
Fig - 8	1201 to 1600	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130
Fig - 9	1601 to 2000	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130
Fig - 10	2001 to 3000	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130	30 x 130	40 x 150
	3001 to 4000	30 x 130	30 x 130	40 x 150	40 x 150	40 x 150	40 x 150	40 x 150


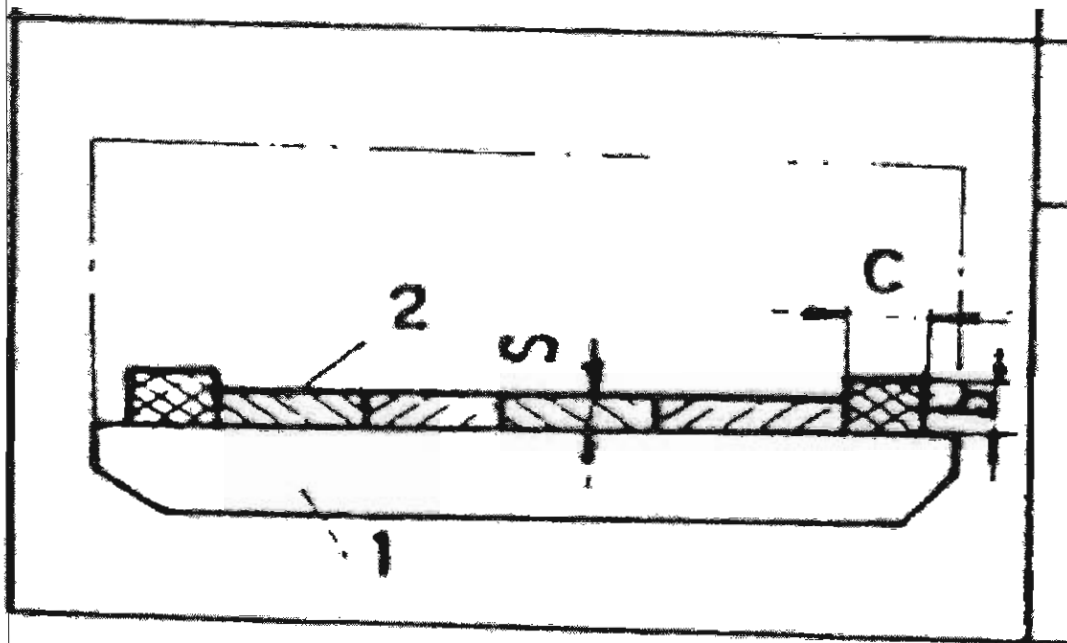

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TABLE-5

BOTTOM TRAVERSE:



Cross section of end traverse bar item 1 fig. X and thickness of bottom board (item – 2)			
Load in kg	Width of the box	Cross section	S
Up to 3000	Above 1000 mm	100 x 100	25

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10. Cautionary symbols



FRAGILE, HANDLE WITH CARE



PROTECT FROM HEAT AND RADIOACTIVE SOURCES



USE NO HOOKS

NOTE: The design of heavy goods packages cannot always resist top lifting by grabhooks.



KEEP DRY

NOTE: Not all cases have waterproof internal liners; plywood used in the construction may not have a waterproof gluing.



THIS WAY UP

NOTE: Certain designs of small cases make it difficult to distinguish top from bottom.



CENTRE OF GRAVITY

NOTE: This should be stencilled as a minimum on the two longest case sides (this information will normally be supplied by the manufacturer of the item(s) packed).



KEEP AWAY FROM HEAT

... kg max.



STACKING LIMITATION

NOTE: The maximum load in kilograms should be marked above the arrow.



International 'slings here' symbol



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11. Packing Reference Table

TABLE-6

No	Packing Method ->	Wooden Crates	Bundles	Saddle supports	HD Polythene Sheet Wrapping	Wooden boxes (Cases)	Spider	Remarks
	Description							
1	Straight Pipes	✓	✓					Crates for random length
2	Pipes with attachments	✓						
3	Pipes with Fittings	✓						
4	Tanks			✓				
5	Mitre bends			✓		✓		Saddle or cases to be used
6	Fasteners					✓		
7	Hanger components					✓		
8	Clamps					✓		
9	Fittings >nb200/ Flanges					✓		Fittings <200 shall be packed in boxes
10	Plates(Cut to size)					✓		
11	SS Pipes		✓		✓			Wrap SS pipes before bundling
12	SS fittings / Flanges	✓				✓		Fittings <200 shall be packed in boxes
15	SS Fasteners					✓		
16	CW piping(>900mm)						✓	To maintain circularity of pipes
17	CW fittings(>900mm)						✓	
18	CW fittings(<900mm)							
19	Structurals(<200mm)		✓					

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12. CHECK LIST

S No	VENDOR TO PROVIDE DETAILS	
1	<p>On despatch of components/items , vendor has to provide the following information for each package of despatched items:</p> <ol style="list-style-type: none"> 1. Contents of package (Packing list) 2. Corrosion Prevention: Rust-preventive coating /protective painting/Silica gel/ other corrosion inhibitors (please mention) 3. Lifting Instructions: Crane using slings/Fork lift/any other means (please mention) 4. Dimensions (LxBxH) mm: 5. Gross Weight (Kgs): 6. Net Weight (kgs): 	
S No	VENDOR TO CONFIRM	
1	Where ever items are despatched as a bundle, they should be clamped together with bolted timber block clamps or bolted steel section clamps with timber block inserts. Adequate number of clamps should be provided along the length of the bundle with sufficient projection of the clamps beyond the width and height of the bundle.	
2	Only such materials which can withstand corrosion and environmental conditions are allowed to be packed in wooden crates or bundles.	
3	In case of wooden packing, planks of 20-25 mm thick and 100-150mm wide needs to be suitably placed at close intervals for giving rigidity to packing appropriately.	
4	Wood used for packing should be seasoned & shall be free of termites.	
5	Damages, if any, resulting due to improper/inadequate packing will be to vendors account. It will be the responsibility of the vendor to identify suitable and adequate packing for his supplies to protect it from damage and/or deterioration during storage, stacking, transport and handling.	
6	All packing should be suitable for loading/unloading by cranes/forklifts & suitable for transport by road. Suitable marking should be made on the packing indicating the lifting positions.	

PQR: GR 91 & 92:

Date: 08.09.2025

Pre-qualification requirements (PQR) for the procurement of SA234WP91 / SA182F91 or SA234WP92 / SA182F92 Fittings through Open Tender (as per TDC: 102 Latest revision)

<u>S.No</u>	<u>Pre-qualification Conditions</u>	<u>Bidders Confirmation</u>
A)	<u>Organizational Capability:</u>	
1	Manufacturers having Fittings manufacturing facilities are only eligible to participate. Offer from traders, fabricators and stockists are not acceptable and will not be considered for evaluation. Vendor to indicate the nature of the firm. Product catalogue shall be submitted.	
2	Suppliers shall submit list of machineries, testing facilities & valid calibration certificate for heat treatment facilities that are available in-house. Suppliers without basic manufacturing facilities in-house, shall not be considered for evaluation. In-house facilities for Heat treatment are mandatory requirement for consideration of the offer.	
3	If the supplier is not having steel making facility, then source of raw material for the manufacturing shall be from IBR approved well known steel maker or certified by IBR approved inspecting authority (Form -IV to be attached). The supplier shall confirm that the raw material test certificate/s will be furnished along with product test certificate/s.	
4	Chemical, Mechanical testing shall be done in house or at Labs certified as per ISO 17025 or Government approved labs.	
5	Suppliers shall submit a valid ISO 9001 certificate or Quality management system certificate or Written down procedure.	
6	BHEL/End customer reserve the right to inspect the item ordered at any stage at vendor's works and if found not meeting the stipulated conditions, material is liable for rejection.	
B)	<u>Technical Competence:</u>	
1	Point by point confirmation to the TDC requirements is mandatory for consideration of offer and signed TDC shall be submitted.	
2	Supply of Fittings shall be as per BHEL TDC, BHEL QP, applicable BHEL Drawings and Specification / Standard.	

PQR: FIT92

C)	<u>Past Experience/ Performance:</u>	
1	Suppliers shall have supplied fittings in the tendered specifications or Equivalent Specification.	
2	Bidder must have qualified Design Proof Test (Burst Test) for the quoted product. (Elbow, Tee, Reducer) as per ASME B16.9. Bids of only those products (Elbow, Tee, Reducer) that qualify design proof test only will be considered.	
3	Copy of Design Proof Test report issued / witnessed by any Third Party Agency / End Customers. Details of Design Proof Test shall be indicated in Annexure 1 to PQR.	
4	Details of supplies made in recent past detailing the quantity, Specification, size & customer details, year wise along with the unpriced PO copies, proof of supply (such as invoice, bill of lading copies and test certificates) specification either in SA234WP91 / SA182F91 or SA234WP92 / SA182F92 shall be submitted.	
D)	<u>Financial Soundness:</u>	
1	Indigenous suppliers shall submit Audited copies of annual reports (Balance Sheets), Profit & Loss statement for last 3 years (or from date of incorporation whichever is less). Proprietary and partnership firms shall submit IT returns for last 3 years (or from date of incorporation whichever is less).	

- Necessary supporting documents shall be submitted for meeting each of the above Pre-Qualification Criteria for evaluation of the offers.
- BHEL reserves the right to consider/Not-consider the offers based on the evaluation of documents submitted for the above Pre-Qualification Criteria. BHEL also reserves the right to have on-site assessment of the facilities at supplier's works during the bid evaluation.
- Acceptance of bids is subject to customer approval.

NAGA
RAJU
VURITLA

Digitally signed
by NAGA RAJU
VURITLA
Date: 2025.09.08
10:05:07 +05'30'

M
MANOJ
PANDI

DN: cn=M MANOJ
PANDI, o=BHEL-
HPBP, TRICHY,
ou=PIPING
QUALITY,
email=manojpan
di@bhel.in, c=US

**BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPPALLI-620 014.**

Buyer Added Bid Specific Additional Terms & Conditions (ATC)

Note: This Annexure has to be mandatorily filled & signed by the manufacturer (or) mill and submitted along with Technical bid.

Any deviation to the below mentioned terms shall be stated specifically in the comments column for each term and also in case of acceptance to our terms, it will be construed that the whole term is understood and agreed in totality without any deviation. (If otherwise mentioned).

SI No	BHEL Requirements	Supplier Comments
01	<p>Pre-Qualification Criteria:</p> <p>1.1 Organisational, Technical & Previous Experience: As defined in <u>PQR</u></p> <p>1.2 Financial: As defined in <u>PQR</u>:</p> <p>1.3 Integrity Pact: Not Applicable.</p> <p>1.4 Bidder must not be admitted under Corporate Insolvency Resolution Process or Liquidation as on date, by NCLT or any adjudicating authority/authorities, and shall submit undertaking (Annexure-4) to this effect.</p> <p>1.5 Customer Approval: Applicable. The bid(s) are subjected to acceptance by the end customer. Post evaluation of PQR and Techno-Commercial acceptance, qualified bidders will be taken up for customer approval. Bidders will be required to submit credentials as and when requested by BHEL for taking up customer approval. Bids of PQR qualified, Techno-Commercially accepted and customer approved bidders alone will be considered for Part II evaluation.</p> <p>Explanatory Notes for the PQR:</p> <p>i. 'Supplied' in PQR means, bidder should have delivered the <u>PQR: Fittings</u>. Bidder shall submit the relevant documents against the above PQRs inclusive of Purchase order (wherein PO no., date, etc. is legible) along with proof of supply (i.e. - Completion Certificate/ Copy of Invoices / LR Copies/ Store Receipt Vouchers/ Payment Advice etc.) in the respective attachments in their offer in support of PQR. The "Contract" referred in Technical PQR may be Rate Contract/ Framework Agreement/ Purchase Order/ Work Order.</p> <p>ii. Bidder to submit Audited Balance Sheet and Profit and Loss Account for the respective years as indicated against Financial Turnover PQR above along with all annexures.</p> <p>iii. In case of audited Financial Statements have not been submitted for all the three years as indicated against Financial Turnover PQR above, then the applicable audited statements submitted by the bidders against the requisite three years, will be averaged for three years i.e. total divided by three.</p> <p>iv. If Financial Statements are not required to be audited statutorily, then instead of audited Financial Statements, Financial Statements are required to be certified by Chartered Accountant.</p> <p>v. Credentials furnished by the bidder against "PRE-QUALIFYING CRITERIA" shall be verified from the issuing authority for its authenticity. In case, any credential (s) is/are found to be spurious, offer of the bidder is liable to be rejected. BHEL reserves the right to initiate any further action as per extant guidelines for Suspension of Business Dealings as applicable in BHEL.</p> <p>vi. Price Bids of only those bidders shall be opened who stand qualified after compliance of PQR</p>	
02	<p>Scope of Supply:</p> <p>Supply of <u>Fittings</u> shall be to the addresses mentioned in Annexure-A, on F.O.R. Destination Basis. Unloading of materials shall be in BHEL's scope.</p>	
03	<p>PRICE BASIS:</p> <p>Price in INR should be quoted for F.O.R. Destination Basis.</p>	

04 TAXES & DUTIES:

4.1 The Supplier/Vendor shall pay all (save the specific exclusions as enumerated in this clause) taxes, fees, license, charges, deposits, duties, tools, royalty, commissions, other charges, etc. which may be levied on the input goods & services consumed and output goods & services delivered in course of his operations in executing the contract. In case BHEL is forced to pay any of such taxes/duties, BHEL shall have the right to recover the same from his bills or otherwise as deemed fit along with the applicable overheads @5% and interest on the total value (i.e. amount paid by BHEL + overhead).

However, provisions regarding **GST** on output supply (goods/service) and TDS/TCS as per Income Tax Act shall be as per following clauses.

4.2 GST (Goods and Services Tax)

4.2.1 Rate quoted in GeM portal should be on FOR destination basis inclusive of all taxes, P&F, freight etc.; therefore, contractor's price/rates shall be **inclusive** of GST. Reimbursement of GST is subject to compliance of following terms and conditions. BHEL shall have the right to deny payment of GST and to recover any loss to BHEL on account of tax, interest, penalty etc. for non-compliance of any of the following condition.

4.2.2 The admissibility of GST, taxes and duties referred in this chapter or elsewhere in the contract shall be limited to direct transactions between BHEL & its Supplier/Vendor. BHEL shall not consider GST on any transaction other than the direct transaction between BHEL & its Supplier/Vendor.

4.2.3 Supplier/Vendor shall obtain prior written consent of BHEL before billing the amount towards such taxes. Where the GST laws permit more than one option or methodology for discharging the liability of tax/levy/duty, BHEL shall have the right to adopt the appropriate one considering the amount of tax liability on BHEL/Client as well as procedural simplicity with regard to assessment of the liability. The option chosen by BHEL shall be binding on the Contractor for discharging the obligation of BHEL in respect of the tax liability to the Supplier/Vendor.

4.2.4 Supplier/Vendor has to submit GST registration certificate of the concerned state. Supplier/Vendor also needs to ensure that the submitted GST registration certificate should be in active status during the entire contract period.

4.2.5 Supplier/Vendor has to issue Invoice/Debit Note/Credit Note indicating HSN/SAC code, Description, Value, Rate, applicable tax and other particulars in compliance with the provisions of relevant GST Act and Rules made thereunder.

4.2.6 Supplier/Vendor has to submit GST compliant invoice within the due date of invoice as per GST Law. In case of delay, BHEL reserves the right of denial of GST payment if there occurs any hardship to BHEL in claiming the input thereof. In case of goods, Supplier/Vendor has to provide scan copy of invoice & GR/LR/RR to BHEL before movement of goods starts to enable BHEL to meet its GST related compliances. Special care should be taken in case of month end transactions.

4.2.7 Supplier/Vendor has to ensure that invoice in respect of such services which have been provided/completed on or before end of the month should not bear the date later than last working day of the month in which services are performed.

4.2.8 Subject to other provisions of the contract, GST amount claimed in the invoice shall be released on fulfilment of all the following conditions by the Supplier/Vendor:

-

- a) Supply of goods and/or services have been received by BHEL.
- b) Original Tax Invoice has been submitted to BHEL.
- c) Supplier/Vendor has submitted all the documents required for processing of bill as per contract/ purchase order/ work order.
- d) In cases where e-invoicing provision is applicable, Supplier/Vendor is required to submit invoice in compliance with e-invoicing provisions of GST Act and Rules made thereunder.

- e) Supplier/Vendor has filed all the relevant GST return (e.g. GSTR-1, GSTR-3B, etc.) pertaining to the invoice submitted and submit the proof of such return along with immediate subsequent invoice. In case of final invoice/ bill, contractor has to submit proof of such return within fifteen days from the due date of relevant return.
- f) Respective invoice has appeared in BHEL's GSTR - 2A for the month corresponding to the month of invoice and in GSTR-2B of the month in which such invoices has been reported by the contractor along with status of ITC availability as "YES" in GSTR-2B. Alternatively, BG of appropriate value may be furnished which shall be valid at least one month beyond the due date of confirmation of relevant payment of GST on GSTN portal or sufficient security is available to adjust the financial impact in case of any default by the Supplier/Vendor.
- g) Supplier/Vendor has to submit an undertaking confirming the payment of all due GST in respect of invoices pertaining to BHEL.

4.2.9 Any financial loss arises to BHEL on account of failure or delay in submission of any document as per contract/purchase order/work order at the time of submission of Tax invoice to BHEL, shall be deducted from Supplier/Vendor's bill or otherwise as deemed fit.

4.2.10 TDS as applicable under GST law shall be deducted from Supplier/Vendor's bill.

4.2.11 Supplier/Vendor shall comply with the provisions of e-way bill wherever applicable. Further wherever provisions of GST Act permits, all the e-way bills, road permits etc. required for transportation of goods needs to be arranged by the contractor.

4.2.12 Supplier/Vendor shall be solely responsible for discharging his GST liability according to the provisions of GST Law and BHEL will not entertain any claim of GST/interest/penalty or any other liability on account of failure of Supplier/Vendor in complying the provisions of GST Law or discharging the GST liability in a manner laid down thereunder.

4.2.13 In case declaration of any invoice is delayed by the vendor in his GST return or any invoice is subsequently amended/alterd/deleted on GSTN portal which results in any adverse financial implication on BHEL, the financial impact thereof including interest/penalty shall be recovered from the Supplier/Vendor's due payment.

4.2.14 Any denial of input credit to BHEL or arising of any tax liability on BHEL due to non-compliance of GST Law by the Supplier/Vendor in any manner, will be recovered along with liability on account of interest and penalty (if any) from the payments due to the Supplier/Vendor.

4.2.15 In the event of any ambiguity in GST law with respect to availability of input credit of GST charged on the invoice raised by the contractor or with respect to any other matter having impact on BHEL, BHEL's decision shall be final and binding on the Supplier/Vendor.

4.2.16 Variation in Taxes & Duties:

Any upward variation in GST shall be considered for reimbursement provided supply of goods and services are made within schedule date stipulated in the contract or approved extended schedule for the reason solely attributable to BHEL. However downward variation shall be subject to adjustment as per actual GST applicability.

In case the Government imposes any new levy/tax on the output service/goods after price bid opening, the same shall be reimbursed by BHEL at actual. The reimbursement under this clause is restricted to the direct transaction between BHEL and its Supplier/Vendor only and within the contractual delivery period only.

In case any new tax/levy/duty etc. becomes applicable after the date of Bidder's offer but before opening of the price Bid, the Bidder/ Supplier/Vendor must convey its impact on his price duly substantiated by documentary evidence in support of the same before opening of price bid. Claim for any such impact after opening the price bid will not be considered by BHEL for reimbursement of tax or reassessment of offer.

	<p>4.3 Income Tax:</p> <p>TDS/TCS as applicable under Income Tax Act, 1961 or rules made thereunder shall be deducted/collected from Supplier/Vendor's bill.</p> <p>4.4 Supplier HSN Code & Applicable GST % (To be filled by Supplier)</p>	
05	<p>MATERIAL DISPATCH CLEARANCE CERTIFICATE (MDCC):</p> <p>MDCC shall be issued by BHEL. No material shall be dispatched by supplier unless and until Material Dispatch Clearance Certificate (MDCC) issued by BHEL Site. In case any material is dispatched without MDCC and any loss is incurred by Supplier/Vendor for any reason whatsoever, BHEL shall not be responsible in any manner to compensate the supplier in this regard.</p>	
06	<p>INSPECTION / INSPECTION & TESTING AT SUPPLIERS WORKS:</p> <p>Pre-dispatch Inspection at Seller Premises by IBR / IBR authorized TPI, BHEL / BHEL authorized TPI and Customer (if applicable).</p> <p>Post Receipt Inspection at consignee before acceptance of stores: By BHEL.</p> <p>BHEL reserves the right to inspect the material during manufacturing and also to get tested the material under dispatch from third party. The test results of third party test shall be final and binding on the Supplier/Vendor.</p> <p>BHEL will reserve the right to inspect/test the material during/after manufacturing at suppliers' works, and/or at BHEL Site. In case of rejection at any stage, Supplier/Vendor shall be liable to replace the materials at his own cost.</p>	
07	<p>DELIVERY:</p> <p>The delivery of all the schedules shall be to the addresses mentioned in Annexure-A. Delivery period shall be 120 days from the date of GeM Contract date. Delivery period indicated above is inclusive of transit time till material receipt at destination.</p> <p>NOTE:</p> <p>a) If the delivery of supply as detailed above gets delayed beyond the delivery period, the Supplier/Vendor shall request for a delivery extension and BHEL at its discretion may extend the Contract. However, if any 'Delivery extension' is granted to the Supplier/Vendor for completion of supply, due to backlog attributable to the Supplier/Vendor, then it shall be without prejudice to the rights of BHEL to impose LD for the delays attributable to the Supplier/Vendor.</p> <p>b) In case BHEL increase the quantity during currency of the contract in line with quantity variation clause (GeM Option Clause), delivery extension shall be given for supply of these additional quantity.</p>	
08	<p>TRANSIT INSURANCE:</p> <p>For the materials which are destined to Project site, transit Insurance of materials is in BHEL scope.</p> <p>For the materials which are destined to Ward 8, transit Insurance of materials is in Supplier scope.</p>	
09	<p>PAYMENT TERMS:</p> <p>a) FOR NON MSME Bidders, 100% payment shall be released within 90 days from Site Acknowledgment Date, subject to submission of billing documents as mentioned in sl. no. 10 below.</p> <p>b) FOR MSME Bidders, 100% payment shall be released within 45 days from Site Acknowledgment Date, subject to submission of billing documents as mentioned in sl. no. 10 below.</p>	

	<p>c) FOR MEDIUM ENTERPRISES Bidders, 100% payment shall be released within 60 days from Site Acknowledgment Date, subject to submission of billing documents as mentioned in sl. no. 10 below.</p> <p>However, GST amount shall be reimbursed in line with compliance to Cl. No. 4 (Taxes & Duties) above.</p> <p>NO INTEREST PAYABLE TO CONTRACTOR No interest shall be payable on the security deposit or any other money due to the Supplier.</p>	
10	<p>DOCUMENTS REQUIRED FOR BILL PROCESSING:</p> <p>The following documents are required to be sent with Material Dispatch/Billing Documents:</p> <ul style="list-style-type: none"> • Original Tax Invoice (As per Cl. No. 4 above). • Delivery Challan / Packing list • Warranty Certificate • Original Inspection Report (IR) and original quality documents • Duplicate for Transporter • Original Consignee copy of LR • Stores acknowledged Lorry Way Bill & E Way bill • GeM Invoice <p>Note:</p> <p>Suppliers are required to upload their invoice and other relevant documents to the BHEL Trichy Material Management System. To do so, they must visit this web page https://trichy.bhel.com/mm/index.jsp and log in using their vendor code (provided by BHEL Trichy) as their username.</p> <p>If a supplier does not have the necessary login credentials, they should contact BHEL Purchase for assistance. A step-by-step guide for uploading invoices is available on the portal for reference. BHEL internal SAP purchase order (PO) number, required for document uploading, will be shared with the successful supplier upon the placement of the GeM contract.</p> <p><u>Key Points for Supply / Works / Service Invoices in SUVIDHA</u></p> <ol style="list-style-type: none"> 1. Registration of all supply / works / service invoices, irrespective of the invoice amount, is mandatory in SUVIDHA. 2. For net invoice amount exceeding ₹5 lakhs (including taxes): <ul style="list-style-type: none"> ○ Upload of Class 3 Digitally Signed Tax Invoice is mandatory. ○ All other documents as per the PO checklist must also be uploaded. ○ However, if any other digitally signed document is specified in the PO checklist, then Class 3 Digitally Signed document is mandatory for uploading 3. For net invoice amount up to ₹5 lakhs (including taxes): <ul style="list-style-type: none"> ○ Upload of all documents as per the PO checklist is mandatory. ○ All Documents can be uploaded without a digital signature. <p>However, if a digitally signed document is specified in the PO checklist but a non-digitally signed version is uploaded, the hard copy must be submitted.</p> <p><u>Grievance Redressal Mechanism:</u></p>	

	<p>To promote transparency and ensure fair treatment of all bidders, a structured Grievance Redressal Mechanism is in place to address any concerns or issues arising during the tendering process or in subsequent business dealings with the company. Suppliers/Contractors are requested to follow the below escalation process for grievance resolution:</p> <ol style="list-style-type: none"> 1. First Level: Any grievance should initially be addressed to the designated Dealing Officer, whose contact details are provided in the Notice Inviting Tender (NIT)/Contract. 2. Second Level: If the issue remains unresolved, it may be escalated by lodging a formal grievance through the SUVIDHA Portal: https://suvidha.bhel.in/suvidha/. Responses will be provided in accordance with the defined escalation matrix. 	
11	<p>BREACH OF CONTRACT, REMEDIES AND TERMINATION:</p> <p>11.1 The following shall amount to breach of contract:</p> <ol style="list-style-type: none"> I. Non-supply of material/ non-completion of work by the Supplier/Vendor within scheduled delivery/ completion period as per contract or as extended from time to time. II. The Supplier/Vendor fails to perform as per the activity schedule and there are sufficient reasons even before expiry of the delivery/ completion period to justify that supplies shall be inordinately delayed beyond contractual delivery/ completion period III. The Supplier/Vendor delivers equipment/ material not of the contracted quality. IV. The Supplier/Vendor fails to replace the defective equipment/ material/ component as per guarantee clause. V. Withdrawal from or abandonment of the work by the Supplier/Vendor before completion as per contract. VI. Assignment, transfer, subletting of Contract by the Supplier/Vendor without BHEL's written permission resulting in termination of Contract or part thereof by BHEL. VII. Non-compliance to any contractual condition or any other default attributable to Supplier/Vendor. VIII. Any other reason(s) attributable to Vendor towards failure of performance of contract. In case of breach of contract, BHEL shall have the right to terminate the Purchase Order/ Contract either in whole or in part thereof without any compensation to the Supplier/Vendor. IX. Any of the declarations furnished by the contractor at the time of bidding and/ or entering into the contract for supply are found untruthful and such declarations were of a nature that could have resulted in non-award of contract to the contractor or could expose BHEL and/ or Owner to adverse consequences, financial or otherwise. X. Supplier/Vendor is convicted of any offence involving corrupt business practices, antinational activities or any such offence that compromises the business ethics of BHEL, in violation of the Integrity Pact entered into with BHEL has the potential to harm the overall business of BHEL/ Owner. <p>Note- Once BHEL considers that a breach of contract has occurred on the part of Supplier/Vendor, BHEL shall notify the Supplier/Vendor by way of notice in this regard. Contractor shall be given an opportunity to rectify the reasons causing the breach of contract within a period of 14 days. In case the contractor fails to remedy the breach, as mentioned in the notice, to the satisfaction of BHEL, BHEL shall have the right to take recourse to any of the remedial actions available to it under the relevant provisions of contract.</p> <p>11.2 Remedies in case of Breach of Contract.</p> <ol style="list-style-type: none"> i. Wherein the period as stipulated in the notice issued under clause 11.1 has expired and Supplier/Vendor has failed to remedy the breach, BHEL will have the right to terminate the contract on the ground of "Breach of Contract" without any further notice to contractor. 	

- ii. Upon termination of contract, BHEL shall be entitled to recover an amount equivalent to 10% of the Contract Value for the damages on account of breach of contract committed by the Supplier/Vendor. This amount shall be recovered by way of encashing the security instruments like performance bank guarantee etc available with BHEL against the said contract. In case the value of the security instruments available is less than 10% of the contract value, the balance amount shall be recovered from other financial remedies (i.e. available bills of the Supplier/Vendor, retention amount, from the money due to the Supplier/Vendor etc. with BHEL) or the other legal remedies shall be pursued.
- iii. wherever the value of security instruments like performance bank guarantee available with BHEL against the said contract is 10% of the contract value or more, such security instruments to the extent of 10% contract value will be encashed. In case no security instruments are available or the value of the security instruments available is less than 10% of the contract value, the 10% of the contract value or the balance amount, as the case may be, will be recovered in all or any of the following manners:
- iv. In case the amount recovered under sub clause (a) above is not sufficient to fulfil the amount recoverable then; a demand notice to deposit the balance amount within 30 days shall be issued to Supplier/Vendor.
- v. If Supplier/Vendor fails to deposit the balance amount within the period as prescribed in demand notice, following action shall be taken for recovery of the balance amount:
 - a) from dues available in the form of Bills payable to defaulted Supplier/Vendor against the same contract.
 - b) If it is not possible to recover the dues available from the same contract or dues are insufficient to meet the recoverable amount, balance amount shall be recovered from any money(s) payable to Supplier/Vendor under any contract with other Units of BHEL including recovery from security deposits or any other deposit available in the form of security instruments of any kind against Security deposit or EMD.
- vi. In-case recoveries are not possible with any of the above available options, Legal action shall be initiated for recovery against defaulted supplier/Vendor.
- vii. It is an agreed term of contract that this amount shall be a genuine pre-estimate of damages that BHEL would incur in completion of balance contractual obligation of the contract through any other agency and BHEL will not be required to furnish any other evidence to the Supplier/Vendor for the purpose of estimation of damages.
- viii. In addition to the above, imposition of liquidated damages, debarment, termination, de-scoping, short-closure, etc., shall be applied as per provisions of the contract.

Note:

1) The defaulting Supplier/Vendor shall not be eligible for participation in any of the future enquiries floated by BHEL to complete the balance work. The defaulting contractor shall mean and include:

- (a) In case defaulted Supplier/Vendor is the Sole Proprietorship Firm, any Sole Proprietorship Firm owned by same Sole Proprietor.
- (b) In case defaulted Supplier/Vendor is The Partnership Firm, any firm comprising of same partners/ some of the same partners; or sole proprietorship firm owned by any partner(s) as a sole proprietor.

LD against delay in executed supply in case of Termination of Contract:

LD against delay in executed supply shall be calculated in line with LD clause no. 15.0 below, for the delay attributable to Supplier/Vendor. For limiting the maximum value of LD, contract value shall be taken as Executed Value of supply till termination of contract.

Method for calculation of "LD against delay in executed supply in case of termination of contract" is given below.

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	<p>This shall be treated as LD Mode PV 0.5% of Undelivered value subject to a maximum of 10% of total contract value.</p> <p>Site Acknowledgment date will be considered for Date of reckoning LD.</p>	
16	INTEGRITY PACT (IP): Applicable /Not Applicable	
17	<p>PREFERENCE TO MAKE IN INDIA:</p> <p>For this procurement, the local content to categorize a Supplier/Vendor as a Class I local supplier/ Class II local Supplier/Non-Local Supplier and purchase preferences to Class I local supplier, is as defined in Public Procurement (Preference to Make in India), Order 2017 dated 04.06.2020 issued by DPIIT. In case of subsequent orders issued by the nodal ministry, changing the definition of local content for the items of the GeM Bid, the same shall be applicable even if issued after issue of this GeM Bid, but before opening of Part-II bids against this GeM Bid.</p> <p>17.1 Compliance to Restrictions under Rule 144 (xi) of GFR 2017:</p> <p>I. Any bidder from a country which shares a land border with India will be eligible to bid in this tender only if the bidder is registered with the Competent Authority. The Competent Authority for the purpose of this Clause shall be the Registration Committee constituted by the Department for Promotion of Industry and Internal Trade (DPIIT).</p> <p>II. "Bidder" (including the term 'tenderer', 'consultant' or 'service provider' in certain contexts) means any person or firm or company, including any member of a consortium or joint venture (that is an association of several persons, or firms or companies), every artificial juridical person not falling in any of the descriptions of bidders stated hereinbefore, including any agency branch or office controlled by such person, participating in a procurement process.</p> <p>III. "Bidder from a country which shares a land border with India" for the purpose of this Clause means: -</p> <ol style="list-style-type: none"> An entity incorporated established or registered in such a country; or A subsidiary of an entity incorporated established or registered in such a country; or An entity substantially controlled through entities incorporated, established or registered in such a country; or An entity whose beneficial owner is situated in such a country; or An Indian (or other) agent of such an entity; or A natural person who is a citizen of such a country; or A consortium or joint venture where any member of the consortium or joint venture falls under any of the above. <p>IV. The beneficial owner for the purpose of (III) above will be as under:</p> <ol style="list-style-type: none"> In case of a company or Limited Liability Partnership, the beneficial owner is the natural person(s), who, whether acting alone or together or through one or more juridical person, has a controlling ownership interest or who exercises control through other means. <p>Explanation</p> <ol style="list-style-type: none"> "Controlling ownership interest" means ownership of or entitlement to more than twenty-five per cent of shares or capital or profits of the company. "Control" shall include the right to appoint majority of the directors or to control the management or policy decisions including by virtue of their shareholding or management rights or shareholders' agreements or voting agreements. <ol style="list-style-type: none"> In case of a partnership firm, the beneficial owner is the natural person(s) who, whether acting alone or together, or through one or more juridical person, has ownership of entitlement to more than fifteen percent of capital or profits of the partnership. 	

	<ol style="list-style-type: none"> 3. In case of an unincorporated association or body of individuals, the beneficial owner is the natural person(s), who, whether acting alone or together, or through one or more juridical person has ownership of or entitlement to more than fifteen percent of the property or capital or profits of the such association or body of individuals. 4. Where no natural person is identified under (1) or (2) or (3) above, the beneficial owner is the relevant natural person who holds the position of senior managing official; 5. In case of a trust, the identification of beneficial owner(s) shall include identification of the author of the trust, the trustee, the beneficiaries with fifteen percent or more interest in the trust and any other natural person exercising ultimate effective control over the trust through a chain of control or ownership. <ol style="list-style-type: none"> (i) The bidder shall provide undertaking for their compliance to this Clause, in the format provided in Annexure-13. (ii) Registration of the bidder with Competent Authority should be valid at the time of submission of bids and at the time of acceptance of the bids 	
18	<p>Settlement of Dispute:</p> <p>If any dispute or difference of any kind whatsoever shall arise between BHEL and the Supplier/Vendor, arising out of the contract for the performance of the work whether during the progress of contract termination, abandonment or breach of the contract, it shall in the first place referred to Designated Engineer for amicable resolution by the parties. Designated Engineer (to be nominated by BHEL for settlement of disputes arising out of the contract) who within 60 days after being requested shall give written notice of his decision to the contractor. Save as hereinafter provided, such decision in respect of every matter so referred shall forthwith be given effect to by the Supplier/Vendor who shall proceed with the work with all due diligence, whether he or BHEL desires to resolve the dispute as hereinafter provided or not.</p> <p>If after the Designated Engineer has given written notice of this decision to the party and no intention to pursue the dispute has been communicated to him by the affected party within 30 days from the receipt of such notice, the said decision shall become final and binding on the parties. In the event the Supplier/Vendor being dissatisfied with any such decision or if amicable settlement cannot be reached then all such disputed issues shall be resolved through conciliation in terms of the BHEL Conciliation Scheme 2018 as per Clause 18.1</p> <p>18.1 Conciliation:</p> <p>Any dispute, difference or controversy of whatever nature howsoever arising under or out of or in relation to this Agreement (including its interpretation) between the Parties, and so notified in writing by either Party to the other Party (the "Dispute") shall, in the first instance, be attempted to be resolved amicably in accordance with the conciliation procedure as per BHEL Conciliation Scheme 2018. The proceedings of Conciliation shall broadly be governed by Part-III of the Arbitration and Conciliation Act 1996 or any statutory modification thereof and as provided in - "Procedure for conduct of conciliation proceedings" (as available in www.bhel.com)).</p> <p>Note: Ministry of Finance has issued OM reference No. 1/2/24 dated 03.06.2024 regarding "Guidelines for Arbitration and Mediation in Contracts of Domestic Public Procurement. In the said OM it has been recommended that Government departments/ Entities/agencies are to encourage mediation under the Mediation Act. 2023. The said Act has not yet been notified by the Government. Therefore, the clause "Settlement of Disputes" shall be modified accordingly as and when the Mediation Act 2023 gets notified.</p> <p>18.2 ARBITRATION:</p> <p>18.2.1 Except as provided elsewhere in this Contract, in case Parties are unable to reach amicable settlement (whether by Conciliation to be conducted as provided in Clause 14.1 herein above or otherwise) in respect of any dispute or difference; arising out of the formation, breach, termination, validity or execution of the Contract; or, the</p>	

respective rights and liabilities of the Parties; or, in relation to interpretation of any provision of the Contract; or, in any manner touching upon the Contract (hereinafter referred to as the 'Dispute'), then, either Party may, refer the disputes to **Madras High Court, Arbitration Centre (MHCAC)** and such dispute to be adjudicated by Sole Arbitrator appointed in accordance with the Rules of said Arbitral Institution.

18.2.2 A party willing to commence arbitration proceeding shall invoke Arbitration Clause by giving notice to the other party in terms of section 21 of the Arbitration & Conciliation Act, 1996 (hereinafter referred to as the 'Notice') before referring the matter to arbitral institution. The Notice shall be addressed to the Head of the Unit, BHEL, executing the Contract and shall contain the particulars of all claims to be referred to arbitration with sufficient detail and shall also indicate the monetary amount of such claim including interest, if any.

18.2.3 After expiry of 30 days from the date of receipt of aforesaid notice, the party invoking the Arbitration shall submit that dispute to the Arbitral Institution- **Madras High Court, Arbitration Centre (MHCAC)**- and that dispute shall be adjudicated in accordance with their respective Arbitration Rules. The matter shall be adjudicated by a Sole Arbitrator who shall necessarily be a Retd Judge having considerable experience in commercial matters to be appointed/nominated by the respective institution. The cost/expenses pertaining to the said Arbitration shall also be governed in accordance with the Rules of the respective Arbitral Institution. The decision of the party invoking the Arbitration for reference of dispute to **Madras High Court, Arbitration Centre (MHCAC)**- for adjudication of that dispute shall be final and binding on both the parties and shall not be subject to any change thereafter. The institution once selected at the time of invocation of dispute shall remain unchanged.

18.2.4 The fee and expenses shall be borne by the parties as per the Arbitral Institutional rules.

18.2.5 The Arbitration proceedings shall be in English language and the seat of Arbitration shall be **Trichy**.

18.2.6 Subject to the above, the provisions of Arbitration & Conciliation Act 1996 and any amendment thereof shall be applicable. All matters relating to this Contract and arising out of invocation of Arbitration clause are subject to the exclusive jurisdiction of the Court(s) situated at **Trichy**.

18.2.7 Notwithstanding any reference to the Designated Engineer or Conciliation or Arbitration herein, a. the parties shall continue to perform their respective obligations under the Contract unless they otherwise agree. Settlement of Dispute clause cannot be invoked by the Contractor, if the Contract has been mutually closed or 'No Demand Certificate' has been furnished by the Contractor or any Settlement Agreement has been signed between the Employer and the Contractor.

18.2.8 It is agreed that Mechanism of resolution of disputes through arbitration shall be available only in the cases where the value of the dispute is less than Rs. 10 Crores.

18.2.9 In case the disputed amount Claim, Counter claim including interest is Rs. 10 crores and above, the parties shall be within their rights to take recourse to remedies other than Arbitration, as may be available to them under the applicable laws after prior intimation to the other party. Subject to the aforesaid conditions, provisions of the Arbitration and Conciliation Act, 1996 and any statutory modifications or re-enactment thereof as amended from time to time, shall apply to the arbitration proceedings under this clause.

18.2.10 In case, multiple arbitrations are invoked (whether sub-judice or arbitral award passed) by any party to under this contract, then the cumulative value of claims (including interest claimed or awarded) in all such arbitrations shall be taken in account while arriving at the total claim in dispute for the subject contract for the purpose of clause 11.2. Disputes having cumulative value of less than 10 crores shall be resolved through arbitration and any additional dispute shall be adjudicated by the court of competent jurisdiction.

	<p>18.3 In case of Contract with Public Sector Enterprise (PSE) or a Government Department, the following shall be applicable:</p> <p>In the event of any dispute or difference relating to the interpretation and application of the provisions of commercial contract(s) between Central Public Sector Enterprises (CPSEs)/ Port Trusts inter se and also between CPSEs and Government Departments/Organizations (excluding disputes concerning Railways, Income Tax, Customs & Excise Departments), such dispute or difference shall be taken up by either party for resolution through AMRCD (Administrative Mechanism for Resolution</p>	
19	<p>JURISDICTION</p> <p>Subject to clause 18 of this contract, the Civil Court having original Civil Jurisdiction at Tiruchirappalli, Tamilnadu shall alone have exclusive jurisdiction in regard to all matters in respect of the Contract.</p> <p>GOVERNING LAWS</p> <p>The contract shall be governed by the Law for the time being in force in the Republic of India.</p>	
20	<p>FORCE MAJEURE</p> <p>20.1 "Force Majeure" shall mean circumstance which is:</p> <ol style="list-style-type: none"> beyond control of either of the parties to contract, either of the parties could not reasonably have provided against the event before entering into the contract, having arisen, either of the parties could not reasonably have avoided or overcome, and not substantially attributable to either of the parties and Prevents the performance of the contract, such circumstances include but shall not be limited to: <ol style="list-style-type: none"> War, hostilities, invasion, act of foreign enemies. Rebellion, terrorism, revolution, insurrection, military or usurped power, or civil war. Riot, commotion or disorder by persons other than the contractor's personnel and other employees of the contractor and sub-contractors. Strike or lockout not solely involving the contractor's personnel and other employees of the contractor and sub-contractors. Encountering munitions of war, explosive materials, ionizing radiation or contamination by radio-activity, except as may be attributable to the contractor's use of such munitions, explosives, radiation or radio- activity. Natural catastrophes such as earthquake, tsunami, volcanic activity, hurricane or typhoon, flood, fire, cyclones etc. Epidemic, pandemic etc. <p>20.2 The following events are explicitly excluded from Force Majeure and are solely the responsibilities of the non-performing party: a) any strike, work-to-rule action, go-slow or similar labour difficulty (b) late delivery of equipment or material (unless caused by Force Majeure event) and (c) economic hardship.</p> <p>20.3 If either party is prevented, hindered or delayed from or in performing any of its obligations under the Contract by an event of Force Majeure, then it shall notify the other in writing of the occurrence of such event and the circumstances thereof within 15 (fifteen) days after the occurrence of such event.</p> <p>20.4 The party who has given such notice shall be excused from the performance or punctual performance of its obligations under the Contract for so long as the relevant event of Force Majeure continues and to the extent that such party's performance is prevented, hindered or delayed. The Time for Completion shall be extended by a period of time equal to period of delay caused due to such Force Majeure event.</p> <p>20.5 Delay or non-performance by either party hereto caused by the occurrence of any event of Force Majeure shall not</p> <p>i) Constitute a default or breach of the Contract.</p>	

	<p>ii) Give rise to any claim for damages or additional cost expense occasioned thereby, if and to the extent that such delay or non-performance is caused by the occurrence of an event of Force Majeure.</p> <p>20.6 BHEL at its discretion may consider short closure of contract after 1 year of imposition of Force Majeure in line with extant guidelines. In any case, Supplier/Vendor cannot consider deemed short-closure after 1 year of imposition of Force Majeure.</p>			
21	<p>Non-Disclosure Agreement: The bidders shall enter into the Non-disclosure agreement separately. (Annexure 7 attached).</p>			
22	<p>Cartel Formation The Bidder declares that they will not enter into any illegal or undisclosed agreement or understanding, whether formal or informal with other Bidder(s). This applies in particular to prices, specifications, certifications, subsidiary contracts, submission or non-submission of bids or any other actions to restrict competitiveness or to introduce cartelization in the bidding process. In case, the Bidder is found having indulged in above activities, suitable action shall be taken by BHEL as per extant policies/guidelines.</p>			
23	<p>Fraud Prevention Policy Bidder along with its associate /collaborators /sub-contractors /sub-vendors / consultants / service providers shall strictly adhere to BHEL Fraud Prevention Policy displayed on BHEL website http://www.bhel.com and shall immediately bring to the notice of BHEL Management about any fraud or suspected fraud as soon as it comes to their notice.</p>			
24	<p>Suspension of Business Dealings with Suppliers / Contractors: The offers of the bidders who are under suspension as also the offers of the bidders, who engage the services of the banned firms / principal / agents, shall be rejected. The list of banned firms is available on BHEL website www.bhel.com.</p> <p>If any bidder / supplier / contractor during pre-tendering / tendering / post tendering / award /execution / post-execution stage indulges in any act, including but not limited to, mal-practices, cheating, bribery, fraud or and other misconduct or formation of cartel so as to influence the bidding process or influence the price or tampers the tendering process or acts or omits in any manner which tantamount to an offence punishable under any provision of the Indian Penal Code, 1860(Bhartiya Nyaya Samhita 2023) or any other law in force in India, or does anything which is actionable under the Guidelines for Suspension of Business dealings, action may be taken against such bidder / supplier / contractor as per extant guidelines of the company available on www.bhel.com and / or under applicable legal provisions. Guidelines for suspension of business dealings is available in the webpage: http://www.bhel.com/vender_registration/vender.php.</p>			
25	<p>Bid should be free from correction, overwriting, using corrective fluid, etc. Any interlineation, cutting, erasure or overwriting shall be valid only if they are attested under full signature(s) of person(s) signing the bid else bid shall be liable for rejection. In the event of any Technical or Commercial queries, the same may please be addressed to the following BHEL concerned before Part I opening-</p> <table><tr><td>Ms. M. Kurinjarasi Manager / MM / Purchase 4th Floor, 24 Building, HPBP BHEL Trichy 620014. 0431-257-7597 kurinji@bhel.in</td><td>Mr. R Meganathan Sr Manager / MM / Purchase 4th Floor, 24 Building, HPBP BHEL Trichy 620014. 0431-257-5458 rmega@bhel.in</td></tr></table>	Ms. M. Kurinjarasi Manager / MM / Purchase 4th Floor, 24 Building, HPBP BHEL Trichy 620014. 0431-257-7597 kurinji@bhel.in	Mr. R Meganathan Sr Manager / MM / Purchase 4 th Floor, 24 Building, HPBP BHEL Trichy 620014. 0431-257-5458 rmega@bhel.in	
Ms. M. Kurinjarasi Manager / MM / Purchase 4th Floor, 24 Building, HPBP BHEL Trichy 620014. 0431-257-7597 kurinji@bhel.in	Mr. R Meganathan Sr Manager / MM / Purchase 4 th Floor, 24 Building, HPBP BHEL Trichy 620014. 0431-257-5458 rmega@bhel.in			
26	<p>Order of Precedence: In the event of any ambiguity or conflict between the Tender Documents, the order of precedence shall be in the order below:</p> <p>a. Amendments/Clarifications/Corrigenda/Errata etc. issued in respect of the tender documents by BHEL. b. Buyer Added Bid Specific ATC c. GeM Bid Technical Conditions of Contract (TCC) d. GeM GTC</p>			

27	<p>Note:</p> <ol style="list-style-type: none"> 1. In the event of our customer order covering this tender being cancelled /placed on hold /otherwise modified, BHEL would be constrained to accordingly cancel / hold / modify the tender at any stage of execution. 2. BHEL may negotiate the L1 rate, if not meeting our budget / estimated cost. BHEL may re-float the tender opened, if L1 price is not acceptable to BHEL even after negotiation. Any deviation from the conditions specified in TECHNO-COMMERCIAL TERMS AND CONDITIONS, will lead to rejection of offer. 3. Any change in applicable rates of Tax or any other statutory levies (Direct / Indirect) or any new introduction of any levy by means of statute and its corresponding liability for the deliveries beyond the agreed delivery date for reasons not attributable to BHEL will be to vendors account. BHEL will not reimburse the same and any subsequent claim in this respect will be summarily rejected. 4. BHEL reserves its right to reject an offer due to unsatisfactory past performance by the respective Vendor in the execution of any contract to any BHEL project / Unit. 5. The offers of the bidders who are under suspension and also the offers of the bidders, who engage the services of the banned firms /principal/agents, shall be rejected. The list of banned firms is available on BHEL web site www.bhel.com. 6. Recovery / deduction as applicable as per Direct and Indirect taxes as notified by Govt. Of India from time to time will be made and information/certificate for such deduction/recoveries shall be provided by BHEL to the vendor. 	
28	<p>Enclosure:</p> <p>Annexure-1: Check List. Annexure-3: No Deviation Certificate Annexure-4: Declaration regarding Insolvency/ Liquidation/ Bankruptcy Proceedings Annexure-6- Declaration by Authorised Signatory regarding Authenticity of submitted documents Annexure-7: Non-Disclosure Certificate Annexure-10: Declaration reg. Related Firms & their areas of Activities Annexure-11: Declaration for relation in BHEL Annexure-12: Declaration reg. minimum local content in line with revised public procurement Annexure-13: Declaration regarding compliance to Restrictions under Rule 144 (xi) of GFR 2017 Annexure- 20: Treatment of cases regarding conflict of interest</p>	
<p><u>SIGNED BY MANUFACTURER / MILL</u></p>		

Check List

Note: - Suppliers are required to fill in the following details in their Letterhead and no column should be left blank.

A	Name and Address of the Supplier		
B	GSTN No. the Supplier (Place of Execution of Contract / Purchase Order)		
C	Details of Contact person for this Tender (Supplier)		
D	EMD Details	<u>Not applicable</u>	
E	Description	Applicability (By BHEL)	Enclosed by Bidder
i.	Whether Pre - Qualification Criteria is understood and provided proper supporting documents	Applicable / Not Applicable	Yes / No
ii.	Whether all pages of the Tender documents including annexures, appendices etc are read and understood	Applicable / Not Applicable	Yes / No
iii.	Audited Balance Sheet and profit & Loss Account for the last three years	Applicable / Not Applicable	Yes / No
iv.	Copy of PAN Card & GST registration	Applicable / Not Applicable	Yes / No
v.	Submission of MSE Udyam certificate as specified in Tender	Applicable / Not Applicable	Yes / No
vi.	Offer forwarding letter / tender submission letter as per Annexure 2	Applicable / Not Applicable	Yes / No
vii.	Submission of Certificate of No Deviation as per Annexure 3	Applicable / Not Applicable	Yes / No
viii.	Declaration regarding Insolvency / Liquidation / Bankruptcy Proceedings as per Annexure 4	Applicable / Not Applicable	Yes / No
ix.	Declaration by Authorized Signatory as per Annexure 5	Applicable / Not Applicable	Yes / No

x.	Declaration by Authorized Signatory regarding Authenticity of submitted documents Annexure 6	Applicable / Not Applicable	Yes / No
xi.	Submission of Non-Disclosure Certificate as per Annexure 7	Applicable / Not Applicable	Yes / No
xii.	Submission of Integrity Pact as specified in Tender as per Annexure 8	Applicable / Not Applicable	Yes / No
xiii.	Declaration confirming knowledge about Site Conditions as per Annexure 9	Applicable / Not Applicable	Yes / No
xiv.	Declaration reg. Related Firms & their areas of Activities as per Annexure 10	Applicable / Not Applicable	Yes / No
xv.	Declaration for relation in BHEL as per Annexure 11	Applicable / Not Applicable	Yes / No
xvi.	Declaration reg. minimum local content in line with revised public procurement as per Annexure 12	Applicable / Not Applicable	Yes / No
xvii.	Declaration regarding compliance to Restrictions under Rule 144 (xi) of GFR 2017 as per Annexure 13	Applicable / Not Applicable	Yes / No
xviii.	Bank Account Details for E-Payment as per Annexure 14	Applicable / Not Applicable	Yes / No
xix.	Power of Attorney for submission of tender as per Annexure 15	Applicable / Not Applicable	Yes / No
xx.	Proforma of Bank Guarantee for Earnest Money as per Annexure 16	Applicable / Not Applicable	Yes / No
Xxi.	Treatment of cases regarding conflict of interest as per Annexure – 20	Applicable / Not Applicable	Yes / No

Note: Strike off 'Yes' or 'No', as applicable. Tender not accompanied by the prescribed **above applicable documents** are liable to be summarily rejected.

Date:

**Sign. of the Authorised Signatory
(With Name, Designation and Company seal)**

CERTIFICATE OF NO DEVIATION

(To be Typed & submitted in the Letter Head of the Company/Firm of Bidder)

To,
BHEL HPBP Tiruchirappalli,
Tiruchirappalli, Tamil Nadu 620 014.

Dear Sir,

Subject: **No Deviation Certificate**

Ref: 1) Enquiry No
2) All other pertinent issues till date

We hereby confirm that we have not changed/ modified/materially altered any of the tender documents as downloaded from the website/ issued by BHEL and in case of such observance at any stage, it shall be treated as null and void.

We also hereby confirm that we have neither set any Terms and Conditions and nor have we taken any deviation from the Tender conditions together with other references applicable for the above referred enquiry.

We further confirm our unqualified acceptance to all Terms and Conditions, unqualified compliance to Tender Conditions.

We confirm to have submitted offer in accordance with tender instructions and as per aforesaid references.

Thanking you,

Yours faithfully,

(Signature, date & seal of authorized representative of the bidder)

Date:

Place:

UNDERTAKING

(To be typed and submitted in the Letter Head of the Company/Firm of Bidder)

To,

BHEL HPBP Tiruchirappalli,
Tiruchirappalli, Tamil Nadu 620 014.

Dear Sir/Madam,

Sub: DECLARATION REGARDING INSOLVENCY/ LIQUIDATION/ BANKRUPTCY PROCEEDINGS

Ref: Enquiry No:

I/We,

_____ declare
that, I/We am/are not admitted under insolvency resolution process or liquidation under Insolvency and Bankruptcy Code, 2016, as amended from time to time or under any other law as on date, by NCLT or any adjudicating authority/authorities.

Sign. of the AUTHORISED SIGNATORY
(With Name, Designation and Company seal)

Place:

Date:

Declaration by Authorised Signatory of Bidder
(To be typed and submitted in the Letter Head of the Company/Firm of Bidder)

To,

BHEL HPBP Tiruchirappalli,
Tiruchirappalli, Tamil Nadu 620 014.

Dear Sir,

Sub : Declaration by Authorised Signatory regarding Authenticity of submitted documents.

Ref : 1) Enquiry No & Date:

2) All other pertinent issues till date

I/We, hereby certify that all the documents submitted by us in support of possession of “Qualifying Requirement” are true copies of the original and are fully compliant required for qualifying / applying in the bid and shall produce the original of same as and when required by Bharat Heavy Electricals Limited.

I / We hereby further confirm that no tampering is done with documents submitted in support of our qualification as bidder. I / We understand that at any stage (during bidding process or while executing the awarded contract) if it is found that fake / false / forged bid qualifying / supporting documents / certificates were submitted, it would lead to summarily rejection of our bid / termination of contract. BHEL shall be at liberty to initiate other appropriate actions as per the terms of the Bid / Contract and other extant policies of Bharat Heavy Electricals Limited.

Yours faithfully,

(Signature, Date & Seal of Authorized
Signatory of the Bidder)

Place:

Date:

NON-DISCLOSURE CERTIFICATE

(To be Typed & submitted in the Letter Head of the Company/Firm of Bidder)

I/We understand that BHEL Trichy is committed to Information Security Management System as per their Information Security Policy.

Hence, I/We _____ M/s _____,
who are submitting offer for supplying goods to BHEL Trichy against Enquiry No _____
Hereby undertake to comply with the following in line with Information Security Policy of BHEL Trichy

- To maintain confidentiality of documents & information which shall be used during the execution of the Contract.
- The documents & information shall not be revealed to or shared with third party which shall not be in the business interest of BHEL Trichy

(Signature, date & seal of Authorized
Signatory of the bidder)

Date:

DECLARATION**(To be Typed & submitted in the Letter Head of the Company/Firm of Bidder)**

To,

BHEL HPBP Tiruchirappalli,
Tiruchirappalli, Tamil Nadu 620 014.

Dear Sir/ Madam,

Sub: Details of related firms and their area of activities

Please find below details of firms owned by our family members that are doing business/ registered for same item with BHEL, _____ (NA, if not applicable)

1	Material Category/ Work Description	
	Name of Firm	
	Address of Firm	
	Nature of Business	
	Name of Family Member	
	Relationship	
2	Material Category/ Work Description	
	Name of Firm	
	Address of Firm	
	Nature of Business	
	Name of Family Member	
	Relationship	

Note: I certify that the above information is true and I agree for penal action from BHEL in case any of the above information furnished is found to be false.

Regards,

(_____)

From: M/s _____

Supplier Code: _____

Address: _____

DECLARATION FOR RELATION IN BHEL

(To be typed and submitted in the Letter Head of the Company/Firm of Bidder failing which the offer of Bidder is liable to be summarily rejected)

To,

BHEL HPBP Tiruchirappalli,
Tiruchirappalli, Tamil Nadu 620 014.

Dear Sir,

Sub: Declaration for relation in BHEL

Ref: 1) Enquiry No _____

I/We hereby submit the following information pertaining to relation/relatives of Proprieter/Partner(s)/ Director(s) employed in BHEL

Tick (✓) any one as applicable

1. The Proprieter, Partner(s), Director(s) of our Company/Firm DO NOT have any relation or relatives employed in BHEL

OR

2. The Proprieter, Partner(s), or Director(s) of our Company/Firm HAVE relation/relatives employed in BHEL and their particulars are as below:
 - i.
 - ii.

(Signature, Date & Seal of Authorized
Signatory of the Bidder)

Note:

1. Attach separate sheet, if necessary.
2. If BHEL Management comes to know at a later date that the information furnished by the Bidder is false, BHEL reserves the right to take suitable against the Bidder/Contractor.

**DECLARATION REGARDING MINIMUM LOCAL CONTENT IN LINE WITH
REVISED PUBLIC PROCUREMENT (PREFERENCE TO MAKE IN INDIA), ORDER 2017 DATED
04TH JUNE, 2020 AND SUBSEQUENT ORDER(S)**

(To be typed and submitted in the Letter Head of the Entity/Firm providing certificate as applicable)

To,

BHEL HPBP Tiruchirappalli,
Tiruchirappalli, Tamil Nadu 620 014.

Dear Sir,

Sub: Declaration reg. minimum local content in line with Public Procurement (Preference to Make in India), Order 2017-Revision, dated 04th June, 2020 and subsequent order(s).

Ref: 1) Enquiry No: _____

2) All other pertinent issues till date

We hereby certify that the items offered by _____ (specify the name of the organization here) has a local content of _____ % and this meets the local content requirement for Class I local Supplier / Class II local supplier ** as defined in Public Procurement (Preference to Make in India), Order 2017-Revision dated 04.06.2020 issued by DPIIT and subsequent order(s).

The details of the location(s) at which the local value addition is made are as follows:

1. _____ 2. _____

3. _____ 4. _____

Thanking you,

Yours faithfully,

(Signature, Date & Seal of Authorized Signatory of the Bidder)

** - Strike out whichever is not applicable.

Note:

1. Bidders to note that above format, duly filled & signed by authorized signatory, shall be submitted along with the techno-commercial offer.
2. In case the bidders quoted value is in excess of Rs 10 Crores, the authorized signatory for this declaration shall necessarily be the statutory auditor or cost auditor of the company (in the case of companies) or a practising cost accountant or practicing chartered accountant (in respect of suppliers other than companies).
3. In the event of false declaration, actions as per the above order and as per BHEL Guidelines shall be initiated against the bidder.

**DECLARATION REGARDING COMPLIANCE TO RESTRICTIONS UNDER RULE 144 (xi) OF GFR
2017**

(To be typed and submitted in the Letter Head of the Entity/ Firm providing certificate as applicable)

To,

BHEL HPBP Tiruchirappalli,
Tiruchirappalli, Tamil Nadu 620 014.

Dear Sir,

Sub: Declaration regarding compliance to Restrictions under Rule 144 (xi) of GFR 2017

Ref: 1) Enquiry No: _____

2) All other pertinent issues till date

I have read the clause regarding restrictions on procurement from a bidder of a country which shares a land border with India. I certify that _____ (SPECIFY THE NAME OF THE ORGANIZATION HERE), is not from such a country/ ~~has been registered with the Competent Authority (attach valid registration by the Competent Authority, i.e., the Registration Committee constituted by the Dept. for Promotion of Industry and Internal Trade (DPIT)).~~

I hereby certify that we fulfil all requirements in this regard and is eligible to be considered.

Thanking you,

Yours faithfully,

(Signature, Date & Seal of
Authorized Signatory of the Bidder)

Note: Bidders to note that in case above certification given by a bidder, whose bid is accepted, is found to be false, then this would be a ground for immediate termination and for taking further action in accordance with law and as per BHEL guidelines.

ANNEXURE 20

TREATMENT OF CASES REGARDING CONFLICT OF INTEREST

The bidder notes that a conflict of interest would said to have occurred in the tender process and execution of the resultant contract, in case of any of the following situations:

- i) If its personnel have a close personal, financial, or business relationship with any personnel of BHEL who are directly or indirectly related to the procurement or execution process of the contract, which can affect the decision of BHEL directly or indirectly;
- ii) The bidder (or his allied firm) provided services for the need assessment/ procurement planning of the Tender process in which it is participating;
- iii) Procurement of goods directly from the manufacturers/ suppliers shall be preferred. However, if the OEM/Principal insists on engaging the services of an agent, such agent shall not be allowed to represent more than one manufacturer/ supplier in the same tender. Moreover, either the agent could bid on behalf of the manufacturer/ supplier or the manufacturer/ supplier could bid directly but not both. In case bids are received from both the manufacturer/ supplier and the agent, bid received from the agent shall be ignored. However, this shall not debar more than one Authorised distributor (with/ or without the OEM) from quoting equipment manufactured by an Original Equipment Manufacturer (OEM) in procurements under a Proprietary Article Certificate.
- iv) A bidder participates in more than one bid in this tender process. Participation in any capacity by a Bidder (including the participation of a Bidder as a partner/ JV member or sub-contractor in another bid or vice-versa) in more than one bid shall result in the disqualification of all bids in which he is a party. However, this does not limit the participation of an entity as a sub-contractor in more than one bid if he is not bidding independently in his own name or as a member of a JV.

The Bidder declares that they have read and understood the above aspects, and the bidder confirms that such conflict of interest does not exist and undertakes that they will not enter into any illegal or undisclosed agreement or understanding, whether formal or informal with other Bidder(s), in this regard. This applies in particular to prices, specifications, certifications, subsidiary contracts, submission or non-submission of bids or any other actions to restrict competitiveness or to introduce cartelization in the bidding process. **In case, the Bidder is found having indulged in above activities, the same will be considered as a violation of the tender conditions, and suitable action shall be taken by BHEL as per extant policies/ guidelines.**

(Signature, Date & Seal of Authorized
Signatory of the Bidder)