

BHEL HYDERABAD	PRODUCT STANDARD TURBINES & COMPRESSORS	TC 41009
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Specification for Rate Contract of Steam Turbine Castings

1.0 SCOPE :

This specification covers the Supply of Steam Turbine Castings as per specification HY19570 & HY19573.

The scope includes Rough Machined Steam Turbine Castings as per drawings, Specification and BOM given in the P.O.

Refer Spec for details against following:

Manufacturing

Dimensions, Tolerances and Surface Finish

Quality Requirements

Inspection at Supplier works

Test Certificates/ Log Sheets

Documents to be Furnished

This Rate contract is for the annual requirement of the steam turbine castings.

The total annual requirement is as given below.

Matl Grade/ Spec	Annual requirement in Kgs
GP240GH / HY19570	250,000
G17CrMoV510/ HY19573	150,000

Once the rate contract is finalized on the per kg rate, As per the requirement purchase order shall be placed for Steam Turbine Castings as per drawings, Specification and BOM given in the P.O.

The casting weight mentioned against the material code at the time of order placement shall be considered as final.

This rate contract shall be valid for 2years from the date of finalization of the RC or till the weight mentioned in the RC is exhausted.

The per kg rate quoted by vendor shall not include Pattern cost.

Pattern cost of Rs 100/kg shall be considered for all the new orders where the pattern is new.

Pattern cost shall not be reconsidered for the orders with in the rate contract period or where ever there are minor modifications (<15% modifications).

As per the customer requirement QAP may be approved by the end customer.

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Once the rate contract weights are consumed new rate contract shall be initiated as per BHEL requirement.

If the last order exceeds the rate contract weight, then the last order shall be placed and new rate contract shall be initiated as per BHEL requirement.

In case of poor quality or any other reason BHEL reserves right to cancel the rate contract.

Outer casing assembly comprises of

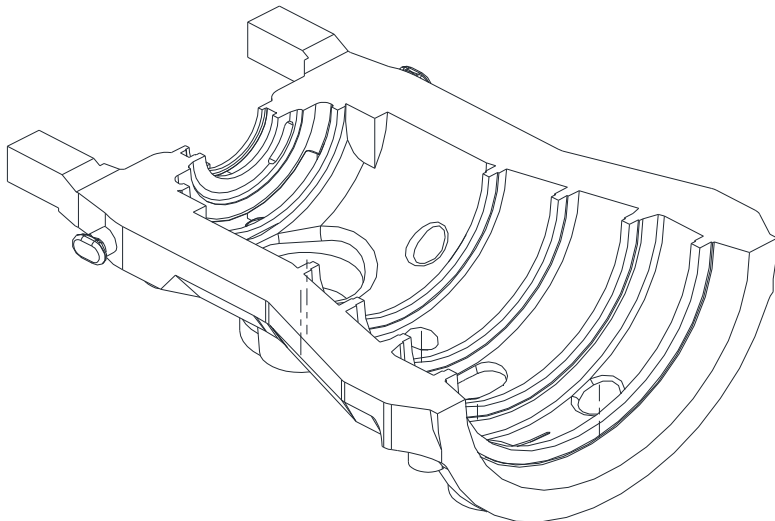
a) Outer Casing Upper part to which stop valve body casting is welded, based on the project requirement outer casing can have one or two stop valves.

b) Outer casing Lower part.

As per the project requirement the Outer casing upper part may have control valves and outer casing lower half may have piped branches or pipe welded on to the casing. All these are clearly brought out in the assembly drawing and corresponding Bill of Materials. A typical outer casing Assembly drawing and bill of materials (Drg no. 13010110376-Rev 00) may be referred for Understanding.

Typical isometric view of Outer Casing is shown below:

OUTER CASING LOWER PART



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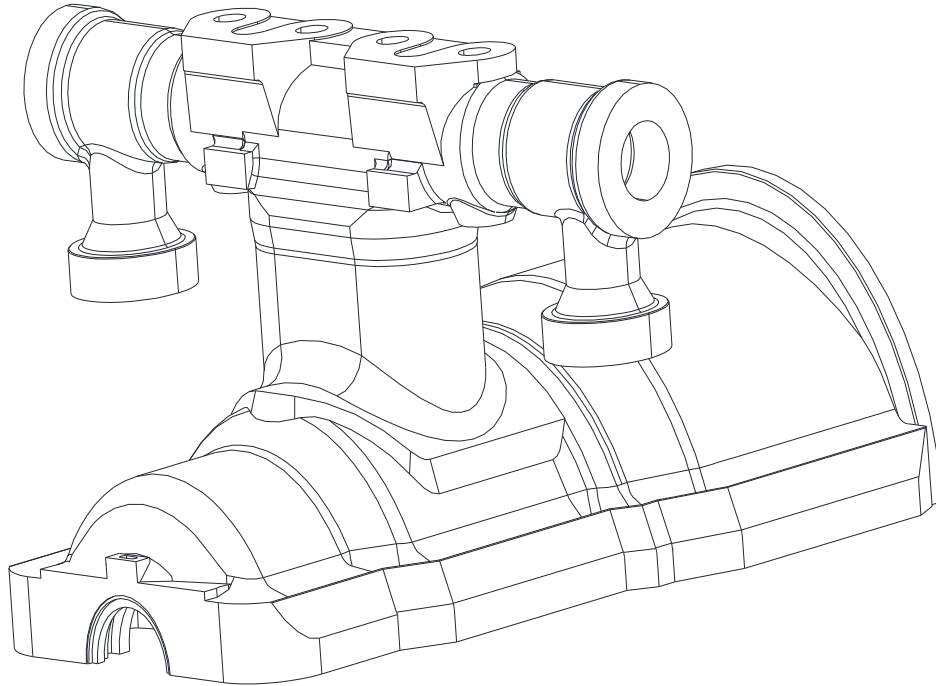
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OUTER CASING UPPER PART



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