

Form No.



**PRODUCT STANDARD
TC ENGINEERING
HYDERABAD**

TC 65207-23

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**SPECIFICATION FOR SEAL GAS BOOSTER
FOR
AMMONIA SERVICE**

Ref.
Doc

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1.0 SCOPE

This specification defines the scope of supply for a seal gas booster (s) that shall be used to ensure seal gas flow to centrifugal compressor dry seals during compressor start-up or when compressor is in pressurized shutdown. The seal gas booster (s) is realized as pneumatic driven, reciprocating (single or double acting) compressor. The booster (s) shall be suitable for horizontal or vertical mounting.

2.0 TECHNICAL REQUIREMENTS

- 2.1 The booster shall be suitable for operation of minimum 2000 hrs without any maintenance required.
- 2.2 The seal gas booster(s) shall be suitable for instant start-up without any lead time.
- 2.3 The booster material shall be SS316 / SS316L as a minimum.
- 2.4 The booster shall be supplied in completely assembled condition. BHEL shall connect the gas inlet & outlet lines, instrument connection. Vendor to inform accessories required (like air filter & regulator, SOV) etc. to be supplied by BHEL.
- 2.5 All the sizing, material selection, design etc. shall be in line with ASME standard for pressure equipment.

3.0 SPARES REQUIREMENT

- 3.1 Commissioning spares required for commissioning the offered equipment as per vendor recommendation for all pneumatic equipment shall be included in Vendor's scope of supply along with the main equipment. Vendor to submit a list of such spares required along with the offer.
- 3.2 Mandatory spares shall be as follows to be included in vendor's scope of supply. The word "TYPE" means the make, model no, range, size/length, rating, material as applicable.
 - 3.2.1 Pneumatic actuated booster:
 - Pneumatic circuit spares (as applicable): all wear & tear parts and seals including:
 - Pneumatic cylinder-01 no
 - Air filter reducer-01 no
 - Snubber-01 no
 - Pneumatic distributor-01 no
 - 3.2.2 Process side Booster spares: 01 set of all wear & tear parts and seals including:
 - Gaskets
 - Seals
 - O-Rings
 - Check Valve
 - 3.2.3 Special tools kits & tackles: As per vendor recommendation.

4.0 SEVERE SERVICE REQUIREMENTS

The wetted parts / metallurgy of booster, O-rings, gaskets etc. in contact with the process gas (Ammonia) shall be suitable for Ammonia Gas.

5.0 DESIGN STANDARDS (AS APPLICABLE)

- 5.1 European directive no 94/9/EC (ATEX)
- 5.2 European directive no 97/23/EC (PED)
- 5.3 ASME VIII Div. 1
- 5.4 ANSI B16.34
- 5.5 Gas Hazardous area classification: IEC Zone-1, Gas group II C, T3.

6.0 PIPING REQUIREMENTS**6.1 Piping Interface connections**

Description	Type
Process gas inlet	1" Threaded
Process gas outlet	1" Threaded

Vent / drain	Threaded / Vendor to specify
Instrument air inlet	Threaded / Vendor to specify

- 6.2 All the materials in contact with gas inlet / outlet and vent shall be of SS 316 / 316L or equivalent forging / casting materials.
- 6.3 All the materials in instrument airline shall be SS316 piping / tubing.
- 6.4 All Butt-welded joints shall be TIG welded and the welds shall be 100% radio graphed.
- 6.5 All the vent/ drain holes, if any shall be plugged with threaded plugs/caps.

7.0 DOCUMENTATION REQUIREMENTS

- 7.1 Along with technical offer, arranged in this sequence only:
- 7.1.1 Booster technical details.
 - 7.1.2 Booster Performance / operation graphs / curves.
 - 7.1.3 Booster Data sheets.
 - 7.1.4 Instrument air consumption.
 - 7.1.5 Recommended spares list along with special tools (if any).
 - 7.1.6 Signed & stamped copy of this specification.
 - 7.1.7 Filled in Check List.
 - 7.1.8 Filled in PTR.
 - 7.1.9 Filled in Deviation Format.
 - 7.1.10 Filled in Price Schedule marked 'QUOTED' for each item.
 - 7.1.11 Filled in Logistic Certificate.
- 7.2 Within 2 weeks of Placement of Order / LOI: Vendor shall submit following for approval for the documents as mentioned below within 2 weeks of Placement of PO /LOI:
- 7.2.1 General Arrangement drawing of seal gas booster giving overall dimensions. It shall show location / disposition of various equipment / Instruments on the booster and location of customer termination connection.
 - 7.2.2 Bill of Material of all the equipment, instruments, components etc. The Bill of Material should clearly show the make and model of each component, which are subjected to BHEL / CUSTOMER approval.
 - 7.2.3 Booster Data sheets.
 - 7.2.4 Instrument datasheets.
 - 7.2.5 Booster Performance / operation graphs / curves.
 - 7.2.6 Quality assurance plan.
 - 7.2.7 Spares list.
- 7.3 Final Documentation: Vendor shall furnish the following:
- 7.3.1 Documents mentioned 8.2.1 above.
 - 7.3.2 Instruction, Service and Maintenance manual
 - 7.3.3 Test and Inspection reports : 3 copies.
 - 7.3.4 Guarantee Certificates : 3 copies.
 - 7.3.5 Photographs for all views : 2 sets (In DVD, the digital photos shall be provided).

8.0 EQUIPMENT QUALIFICATION CRITERIA (EQC)

Seal Gas Booster shall be identical in frame size and identical or validly similar in terms of application (seal gas supply to compressor seals), Type of drive, inlet and discharge pressures, inlet temperatures, flow, number and materials etc. as compared to at least two units designed, manufactured, tested and supplied from the proposed manufacturing plant in last fifteen years at least one of these units shall have been operating satisfactorily in the field for at least 8000 hours without any major problems as on the date of issue of enquiry.

Vendor shall furnish complete reference list / details (Proven track record) along with the offer. These details shall include Plant name, year of commissioning, number of operating hours completed and name of contact person(s) etc. for the seal gas booster similar to one being offered.

9.0 PROVEN TRACK RECORD

Vendor shall submit filled in PTR as per EQC listed in above clause.

10.0 INSPECTION AND TESTING REQUIREMENTS

All the equipment shall be subject to inspection and witness tests by a Third Part Inspection Agency (TPI). **Vendor to select and inform the applicable TPI from the list of TPI's specified by BHEL Purchase department.** The schedule of quality checks shall be furnished by the vendor in the quality plan which is subject to the approval of BHEL. The minimum shall be as indicated in below table.

Quality Plan (ITP)

Sl. No.	Description	Type of check Quantum of check 100%	Ref. Documents	Type of Inspection	Agency
1	Assembly of Booster	-Location of equipment - Correctness of flow Schematics - Overall dimensions	Approved GA drawing	Physical check	TPI
2	Welding (if applicable)	Type	Manufacturing drawings.	-Review of Radiograph certificate -Welding efficiency of 1	TPI
3	Booster	Material Certification	-BHEL Specification - Approved drgs / docs.	Verification of test report / certificate	TPI
4	Gas leak test	- Leakage with HELIUM	--Do--	Witness	TPI
5	Name Plates	- Correctness	--Do--	Physical check	TPI
6	Performance test	-performance	Booster shall be tested to verify pressure & flow parameters	Witness	TPI

11.0 MARKING AND SHIPPING

11.1 Name plates: The Individual components shall be provided with Nameplates giving important details like make, model etc. Each component shall be provided with stainless steel Tag plates duly punching Tag Nos. as applicable on it.

11.2 Preparation for Shipment:

11.2.1 Equipment shall be suitably prepared for shipment. The preparation shall make the equipment suitable for 6 months of outdoor storage from the date of shipment.

11.2.2 Seal gas booster assembly shall be marked with details like, drawing no, job number, PO No. etc. at a convenient location.

11.2.3 Lifting Points and lifting lugs shall be clearly identified.

11.2.4 All Loose supplied items like flanges, nut-bolt, gaskets etc. if any, shall be listed out separately in the packing list.

11.2.5 Adequate amount of silica gel or equivalent shall be provided in the box before dispatch for the removal of moisture till installation.

11.2.6 All safety instructions for storage and handling shall be indicated on external surface of the box.

12.0 DEVIATIONS

Bidder shall submit duly filled deviation format along with technical offer, otherwise, it will be presumed that there are no deviations from this specification. Offer without this deviation list will

not be evaluated & shall be considered for rejection. If, there are no deviations, bidder shall submit signed copy of deviation format, mentioning "No Deviations".

13.0 GUARANTEE

The Seal Gas Booster and each component of the unit shall be guaranteed for 18 months of trouble free performance from the date of shipment or 12 months from the date of commissioning whichever is earlier.

14.0 TENDER EVALUATION CRITERIA

- 14.1 The total price for the complete package i.e. Main System, Mandatory spares, Supervision of erection & commissioning charges shall be considered for L1 evaluation.
- 14.2 Duly signed & stamped un-priced price schedule and unit prices shall be submitted along with technical offer by bidder as a token of concurrence that all items are quoted without which the offer will not be evaluated. For unpriced bid bidder to fill 'Quoted' for each item and submit (refer PRICE SCHEDULE format).

15.0 TENDER REJECTION

Non-compliance to inclusion of any the following documents with technical offer shall lead to rejection of the bids.

- 15.1 Filled in Check List not included.
- 15.2 Filled in PTR not included.
- 15.3 Filled in Dev Format not included.
- 15.4 Filled in Price Schedule marked 'QUOTED' for each item not included.
- 15.5 Filled in Logistic Certificate not included.

16.0 SPECIAL NOTES

- 16.1 Vendor shall confirm that the bill of material furnished along with offer is only indicative and the final BOM, which shall be furnished during detailed Engineering (after order placement) for the approval of BHEL. The additional items, if any required at later stage for complying BHEL specification or for the satisfactory working of the seal gas booster shall be supplied by vendor without any price/delivery implications
- 16.2 Vendor should bring out in his offer clause wise deviations if any, with respect to proposed supply along with price adder for withdrawing the deviation to comply with specification. Failure to highlight the same will be construed as acceptance on the part of the vendor to meet the requirement of this specification totally.
- 16.3 Vendor shall provide the relevant technical information and supporting documents whenever asked for by the customer/ consultant.
- 16.4 Vendor to clearly bring out any additional requirements which are essential for proper functioning of the Seal Gas Booster. This shall be included in the offer.

17.0 Check List

(To be filled by the vendor and submitted along with the offer without which offer will not be considered)

Sl. No	Description	Vendor Confirmation (Yes/No)
1	Booster technical details, catalog included.	
2	Booster Performance / operation graphs / curves included.	
3	Booster Data sheets included.	

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Sl. No	Description	Vendor Confirmation (Yes/No)
4	Instrument air consumption included.	
5	Commissioning spares list included. (As per vendor recommendation)	
6	Mandatory spares list included.	
7	Special tools (if any) included.	
8	Signed & stamped copy of this specification included.	
9	Filled in Check List included.	
10	Filled in PTR included.	
11	Filled in Deviation Format included.	
12	Filled in Price Schedule marked 'QUOTED' for each item included.	
13	Filled in Logistic Certificate included.	

VENDOR SIGNATURE WITH SEAL

18.0 PTR Format

- 18.1 Name of the Bidder
18.2 Whether manufacturer & supplier:
18.3 Whether System Integrator & Supplier:
18.4 Name of Packager:

Sl.No	PTR Requirement	Ref-1	Ref-2	Ref-3	Ref-4
1	Description of item as manufactured & Supplied/ engineered (identify bidder's scope of work)				
2	Plant / Purchaser's name, address, Tel no, Fax no, email and contact person				
3	Application (seal gas supply to compressor seals)				
4	Type of drive,				
5	Inlet and discharge pressures, flow				
6	Material				
7	Make & model no of the booster supplied.				
8	Date of order placed				

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9	Contractual completion date				
10	Actual completion date/ month & year of commissioning				
11	Number of operating hours completed				
12	Reasons of delay if any				
13	Details of major break down till date.				

VENDOR SIGNATURE WITH SEAL

Vendor to furnish the complete exhaustive reference list separately for our review.

19.0 Devaition Format

Sl.No	Clause No. of Specification	Deviation	Reason for deviation	Deviation category	
				Product/design limitation	Optimization

VENDOR SIGNATURE WITH SEAL

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20.0 Logistic support certificate:

CERTIFICATE FOR LOGISTIC SUPPORT

(TO BE SIGNED BY **VENDOR'S PRINCIPAL** (Original equipment manufacturer) CORPORATE LEVEL SIGNATORY ON COMPANY LETTERHEAD)

I, ON BEHALF OF M/s, ----- CONFIRM THAT THE SEAL GAS BOOSTER QUOTED BY M/s -----FOR <PROJECT NAME OF BHEL / BHEL CUSTOMER> (INDIA) SHALL CONTINUED TO BE SUPPORTED BY US AND QUOTED SYSTEM SHALL NOT BE WITHDRAWN FROM "INDIAN" MARKET AS A MATTER OF CORPORATE POLICY.

I, FURTHER CONFIRM THAT IN CASE OF PLACEMENT OF ORDER ON US, <BHEL / BHEL CUSTOMER> (INDIA) SHALL BE SUPPORTED IN PROVIDING BACK-UP ENGINEERING, MAINTENANCE SUPPORT AND SPARE PART SUPPORT FOR A PERIOD OF NOT LESS THAN TEN (10) YEARS FROM THE DATE OF PLACEMENT OF ORDER.

(SIGNATURE WITH SEAL)

CERTIFICATE FOR LOGISTIC SUPPORT

(TO BE SIGNED BY **VENDOR'S CORPORATE** (Bidder for the enquiry) LEVEL SIGNATORY ON COMPANY LETTERHEAD)

I, ON BEHALF OF M/s -----CONFIRM THAT THE SEAL GAS BOOSTER QUOTED BY US FOR <PROJECT NAME OF BHEL / BHEL CUSTOMER> (INDIA), SHALL CONTINUE TO BE SUPPORTED BY US AND OUR PRINCIPAL M/S -----

I, FURTHER CONFIRM THAT IN CASE OF PLACEMENT OF ORDER ON US WE SHALL CONTINUE TO SUPPORT M/S <BHEL / BHEL CUSTOMER> (INDIA) IN PROVIDING BACK-UP ENGINEERING, MAINTENANCE SUPPORT AND SPARE PART SUPPORT FOR A PERIOD OF NOT LESS THAN TEN (10) YEARS FROM THE DATE OF PLACEMENT OF ORDER.

(SIGNATURE WITH SEAL)

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CERTIFICATE FOR LOGISTIC SUPPORT

_(TO BE SIGNED BY "Bidders **VENDOR**" CORPORATE LEVEL SIGNATORY ON COMPANY LETTERHEAD)

Applicable for all major sub-systems bought-out by the bidder

I, ON BEHALF OF M/s, ----- CONFIRM THAT THE -----
QUOTED BY THROUGH M/S----- FOR <PROJECT NAME OF BHEL /
BHEL CUSTOMER> (INDIA), SHALLCONTINUE TO BE SUPPORTED BY US AND OUR
PRINCIPAL M/S -----

I, FURTHER CONFIRM THAT IN CASE OF PLACEMENT OF ORDER ON US, WE SHALL
CONTINUE TO SUPPORT M/S <BHEL / BHEL CUSTOMER> (INDIA) IN PROVIDING BACK-
UP ENGINEERING, MAINTENANCE SUPPORT AND SPARE PART SUPPORT FOR A PERIOD
OF NOT LESS THAN TEN (10) YEARS FROM THE DATE OF PLACEMENT OF ORDER.

(SIGNATURE WITH SEAL)

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21.0 PROJECT SPECIFIC BOOSTER TECHNICAL DATA & PRICE SCHEDULE:**21.1 PROJECT SPECIFIC TECHNICAL DATA BOOSTER#1050:****21.1.1 Utility:** Instrument Air (for pneumatic drive)

SL NO	PARAMETER	MIN	NOR	MAX	MECH. DESIGN
a	Pressure (kg/cm ² g)	4.5	6.5	7.0	10
b	Temperature (°C)	35	40	45	65

21.1.2 Design conditions-Process

SL NO	PARAMETER	VALUE
a	Design Pressure	25.0 kg/cm ² g
b	Design Temperature (Max)	170 °C
c	Gas leak test Pressure (HELIUM)	37.5 kg/cm ² g

21.1.3 Operating conditions:

SL NO	PARAMETER	VALUE				
		ST-1	ST-2	SOP-1	SOP-2	SOP-2
a	Operating case					
b	Inlet Pressure (Kg/Cm ² g)	4.5	6.5	4.5	3.0	10.0
c	Inlet Temperature (deg C)	40	40	40	0.0	100
d	Gas Mol Wt.	28.01 (N ₂)	28.01 (N ₂)	28.01 (N ₂)	17.03 (NH ₃)	17.03 (NH ₃)
e	Flow (ACM3/Hr)-required	10	10	10	10	10
f	Pressure increase (ΔP required, Kg/Cm ²)	2.0	5.0*	2	2	2
g	QTY of Booster (vendor to indicate)					
h	Maximum Flow (ACM3/Hr) possible with selected booster					
i	Maximum Flow (Kg/Hr) possible with selected booster					

* Vendor to indicate if 5 Kg/Cm² pressure increase is possible.

** For all operating cases, vendor to inform the maximum gas flow possible from selected booster.

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21.2 PRICE SCHEDULE: : SEAL GAS BOOSTER#1050

- 21.2.1 Offer ref no.:
21.2.2 Offer date:
21.2.3 Enquiry ref. no:
21.2.4 Enquiry date:

Sl. No.	DESCRIPTION	Qty	PRICE
1	Seal Gas booster#1050 (TC9765207239) along with commissioning spares / special tools (as per vendor recommendation clause 3.1 & 3.2.3)	1 set	
2	Seal Gas Booster spares#1050 (TC9765207247) as listed in clause 3.2.1 & 3.2.2	1 set	
3	Additional price to withdraw the deviations if any taken by vendor for respective clause of BHEL specification.	Clause wise	
	Total Price for L1 Evaluation • 1+2+3		

Notes:

- The price for the spares against sl no 02 above is valid for one year.
- Any additional requirements which are essential for proper functioning of the seal gas booster but not indicated in specification are included in the offer.
- Vendor shall submit UNIT PRICE for all spare items for the booster.

VENDOR SIGNATURE WITH SEAL

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