



BHARAT HEAVY ELECTRICALS LIMITED | TIRUCHIRAPPALLI

OUTSOURCING

NIT: 2026OSB039

SECTION I D

SCOPE OF WORK: RS01 & RS02

1	COLLECTION OF RAW MATERIALS FROM BHEL STORES AT TRICHY. Material will be issued as block (with minimum 10 mm tolerance on each side) cut out from pipes.
2	Machining of UT Ref Block / Calibration Blocks as per BHEL drawings. ID / OD machining need not be done.
3	Completed blocks are to be calibrated at NABL approved metrology lab as per BHEL drawings
4	After calibration all machined surfaces are to be coated with suitable rust preventive as per BHEL drawing.
5	OFFERING THE FINISHED ITEMS FOR INSPECTION BY BHEL OR BHEL AUTHORISED INSPECTION AGENCY
6	Handing over of finished goods to BHEL, Trichy/Logistics for RS01 and NDT Lab-Ward-16 for RS02 with relevant IR & DC documents.
7.1	NOTE 1: AS – ALLOY STEEL REFERRED IS P11, P12 & P22 / F11, F12 & F22 / GR11, GR12 & GR-22, GR-91/92
7.2	NOTE 2: All suitable tools, gauges required for components machining & inspection shall be arranged by Vendor and measuring instruments to be used shall be calibrated from NABL accredited lab.
7.3	NOTE 3: Comprehensive measurement of all dimensions for each block shall be supplied by the vendor from a NABL (or equivalent) certified laboratory.
7.4	NOTE 4: Methods such as replica, CMM measurements or suitable methods with code backup for UT calibration block measurements shall be used.