



INVITATION TO TENDER

Ref.: OS/21-22/2439/PVLG/05/023

Date: 17.12.2021

Sub: **Fabrication of Main Fractionator Column at Lovagarden site of BHEL-HPVP, Visakhapatnam.**

Dear Sir,

Sealed tenders are invited for the subject work in **two part bid** system from Vendors who are experienced in fabrication of similar jobs and fulfil the eligibility criteria specified below in clause-1. Scope of work and techno-commercial terms and conditions are as follows.

1. ELIGIBILITY CRITERIA:

- 1.1 Average annual turnover of the bidder during the last 3 financial years ending 31st March 2021 should be at least Rs.150 Lakhs. Bidder shall enclose Turnover Certificate (duly certified by a practitioner CA), IT Returns and other necessary documents in support of the same. In case, financial accounts for FY 20-21 not yet finalized and ITR is not filed, avg. annual turnover of previous 3 financial years will be taken into consideration.
- 1.2 The bidder must have an experience of executing similar works of Fabrication of Higher Diameter i.e., **≥ 4 Meters** Columns/Pressure Vessels for process industries.

Note: Work Order and Work Completion Certificate / any other relevant document from the customer shall be enclosed in support of successful and satisfactory completion of the work with respect to point no. 1.2 above.

- 1.4 Bidder shall also have to enclose the documents of Registration of Firm/ Factory License/ Certificate of Incorporation, EPF, ESI, PAN, GSTIN, Udyam Registration Certificate (if registered with MSME) etc.
- 1.5 The works executed in the name of individual / firm will only be considered for eligibility criteria.

2. VENDOR'S SCOPE OF WORK: Detailed scope of the fabrication work will be as follows:

Fabrication of Main Fractionator Column (vessel Tag No. 111-C-2101: approx. weight of 700 MT) excluding Top Shell Sections I to VI of Carbon steel portion (15 M approx. length) consisting of CS portion of Top Main Shell & Dished end, LAS with SS clad portion of Middle & Bottom Main Shell, Toricone, Bottom Dished end, Skirt, Internals & External attachments including NDT, PWHT (Internal firing method), Hydro test, Pickling and Passivation of clad portion of shell & attachments etc., as per the approved drawings, QAP / ITP, WPS, Procedures, Specifications & Standards and cutting of complete column into two sections for transportation purpose after Final completion and loading of the column sections on trailers including deployment of Higher capacity crane.

The CS portion of the Main Shell i.e., Shell segments I to VI shall be issued in two sections fabricated by other agency excluding Dished End, internals & Externals.

Rolling and Forming of all individual shell sections has to be carried out at Lovagarden site – 2 near to Lovagarden site -1. The shell sections so formed including the already fabricated CS shell sections (Two Nos.) are to be shifted to Lovagarden site- 1 for forming of main sections of the Column. Transportation of the same from Lovagarden site -2 to Lovagarden site -1 including loading and unloading is in the scope of the Vendor.

It may be noted that the weight indicated above is tentative and may vary on both sides due to revision in the drawings, if any.

2.1 LAS with SS Clad Portion of Middle & Bottom Main Shell including Toricone and Bottom Dished End:

- 2.1.1 Collection of all free issue raw materials like Plates, Structural sections, Pipes, Pipe fittings, Flanges, BOC's etc., from HPVP Shops & Stores and Transportation to Lovagarden site including unloading at site.
- 2.1.2 Toricone shall be made in Petals and Bottom Dished end of vessel shall be made in Petals & Crown form by Dished End Vendors.
Cold Formed Petals of Toricone after Edge preparation, Trial Assembly, Match marking, dismantling into loose petals in different sections will be transported to Lovagarden site by the Toricone vendors.
Cold Formed Petals & Crown of Dish ends after Edge preparation, Trial Assembly, Match marking, dismantling into loose Petals & Crown will be transported to Lovagarden site by the dished end vendors.
Unloading of these Loose Petals & Crown at site received from Toricone & Dished End Vendors is in vendor's scope.
- 2.1.3 Forming of Toricone (Section-1 & 2) and Bottom Dished ends which involves assembly of the Petals & Crown segments, Fit-up, Welding, NDT etc. as per approved drawings / standards / specifications along with Production Test Coupons as per approved QAP.
- 2.1.4 100% RT of L-seam Welds & C-seam welds as per approved QAP.
- 2.1.5 Central Hole, if any, on the Dished End shall be plugged followed by 100% RT.
- 2.1.6 100% UT of Complete Dished End as per QAP.
- 2.1.7 Clad overlay over the L-seams and C-seams as per approved QAP.
- 2.1.8 100% PT on chipped back L-seam & C-seam Welds of Dished End, Tori-cone and Shell as per approved QAP.
- 2.1.9 After receipt of LAS clad plates at BHEL-HPVP Lovagarden site- Visakhapatnam, the inspection clearance of the same shall be obtained from HPVP (QC) / TPIA / EIL as per approved QAP.
- 2.1.10 **Rolling of all LAS + SS clad shell segments of varying thicknesses of 24+3mm thk., 26+3mm thk., 38+3mm thk., 46+3 mm thk., 74+3 mm thk. and 63mm thk. LAS skirt plate as per approved drawings / approved QAP and Rerolling as per requirement is in Vendor's scope.**
- 2.1.11 **Pressing of Insert Plates of 48 mm thk, 50 mm thk. CS plates and (128+4) mm Thick Clad plates in suitable segments shall be done by BHEL at HPVP shop including marking, cutting, Edge preparation and Clad removal. However, collection and Transportation including loading & unloading of these rolled shell plates from HPVP workshop to Lovagarden site is in vendor's scope.**
- 2.1.12 Marking, Squaring, Cutting, Weld Edge preparation / Beveling of the clad Shell plates including removal of clad at edges as per drawings & approved QAP. Test plates of clad material shall be arranged to BHEL-HPVP/ Welding Technology for establishing PQRs to release welding documents during fabrication.
- 2.1.13 Spot UT to check dis-bondment for rolled sections of Clad and Weld Overlay as per approved QAP/ Procedures.
- 2.1.14 MPI Test of all Weld Edges as per approved QAP.
- 2.1.15 UT of all Weld Edges shall be carried out prior to welding as per approved QAP / NDE procedures.
- 2.1.16 Profile of the rolled segments shall be maintained by temporary spiders/ profile plates. Raw materials will be free issue by BHEL.
- 2.1.17 Assembly, Fit-up, welding including Pre-heating, NDT & of L-seams of Shell sections as per drawings & approved QAP / ITP along with Production Test Coupons. **As MOC of the base shell is LAS Gr. 11 & Gr. 22, continuous preheating with Coils up to required temperature as per WPS has to be done before start of welding and suitable arrangements for the same are to be arranged by Vendor.**
- 2.1.18 Assembly, Fit-up, welding including Pre-heating, NDT & of C-seams of Shell to Shell, Shell to Tori-cone & Shell to Bottom Dished end as per drawings & approved QAP / ITP along with Production Test Coupons. **As MOC of the base shell is LAS Gr. 11 & Gr. 22, continuous preheating with coils up to required temperature as per WPS has to be done before start of welding and suitable arrangements for the same are to be arranged by Vendor.**

- 2.1.19 100% RT of C-seam Welds, L-seam Welds and Production Test Coupons as per approved QAP / Drawings.
- 2.1.20 CuSO₄ solution test after clad removal, Chemical Analysis of samples of clad restoration of Dished End, Main Shell and shell to Toricone / dished end as per approved QAP / NDE Procedure.
- 2.1.21 Prior to Weld overlay, MPT shall be carried out on the surfaces which are to be covered with Weld Overlay as per approved QAP/ Procedures.
- 2.1.22 Clad Restoration on L-seam & C-seam welds and 100% PT on Clad restoration / Weld Overlay of each layer as per approved QAP/ Procedures.
- 2.1.23 Ferrite check of clad overlay with a calibrated equipment as per approved QAP / NDE procedure.
- 2.1.24 Offering the job for stage wise inspection and obtaining stage wise inspection clearance, Final Inspection clearance from HPVP (QC) / TPIA / EIL as per approved QAP.
- 2.1.25 All NDT activities like DPT, MPT, RT, UT, etc., shall be carried out as per approved QAP/ drawings by NDT personnel qualified by BHEL as per BHEL Procedure No. BHEL: NDE: WP01.
- 2.1.26 NDT agency engaged by fabrication contractors shall have to ensure that their NDE personnel are qualified by BHEL in advance before starting of the job.
- 2.1.27 PMI Check for Clad Weld Overlay as per approved QAP / Procedures.
- 2.1.28 Production Test Coupons after RT to be tested as per approved QAP / Procedures.
- 2.1.29 Handing over of Production Test Coupons for PWHT / SR along with the Vessel.

2.2 CS Portion of Top Main Shell including Top Dished End and LAS Skirt:

- 2.2.1 Collection and Transportation of Free Issue materials like CS Plates for Skirt, Pipes, Pipe Fittings, BOCs, Structural items, Paints etc., from BHEL-HPVP stores/workshop to Lovagarden site including unloading at site.
- 2.2.2 **Top Carbon steel portion of the Column (14.9 M length) fabricated with L-seams & C-seams welded, NDT completed in two sections comprising of Sec-I to III and Sec IV to VI will be handed over to the Vendor at Lovagarden site.**

Balance works in the CS portion like assembly & welding of L-seams and C-seam of Top Dished end received in loose Petals & Crown form, assembly & welding of C-seam of the two Sections (Shell-I +II+III) and (Shell-IV +V+VI) to form single CS shell section, Assembly and welding of Top dished end with Shell section, assembly and Welding of CS shell with LAS shell section, applicable NDT of these balance works as per approved QAP, Drawings, Specifications etc.

Top Dished end will be received in loose petals and Crown from the Dished End Vendor. Cold Formed Petals & Crown after Edge preparation, Trial Assembly, Match marking, dismantling into loose petals & crown will be transported to Lovagarden site by the dished end vendors. Unloading of Loose Petals & Crown at Lovagarden site received from Dished End Vendors is in vendor's scope.

For Nozzle Mark-2 (O.H. vapour + Comp. flange) on Top Dished end and Nozzle Mark-1A/B (Feed) on Shell, the temporary spool pieces are to be fabricated for Hydro-testing of the column as per the drawing. The welding of temporary spool pieces with nozzles companion flanges and temporary Dished Ends shall be carried out by the vendor. After completion of Hydro-test of the column, the temporary Dished Ends along with spool pieces are to be cut and edge preparation on the Nozzles companion flanges shall be carried out. The temporary Dished Ends and the plate materials for fabrication of spool pieces shall be provided as free issue by BHEL-HPVP.

- 2.2.3 100% PT on root & final weld, chipped back L-seam & C-seam Welds of Shell, Skirt & Dished Ends as per approved QAP / NDE procedure.
- 2.2.4 After receipt of free issue materials at HPVP Lovagarden site- Visakhapatnam, the inspection clearance of the same shall be obtained from HPVP (QC) / TPIA / EIL as per approved QAP.
- 2.2.5 Marking, Squaring, Cutting, Weld Edge preparation / Beveling of skirt plates as per drawings & approved QAP.

2.2.6 Rolling of Skirt Segments (63 MM thk) as per approved drawings / QAP.

2.2.7 Profile of the rolled skirt segments shall be maintained by temporary spiders/ profile plates. Raw materials will be free issue by BHEL.

2.2.8 Assembly, Fit-up & Welding of L-seams of skirt as per drawings & approved QAP / ITP along with Production Test Coupons.

2.2.9 Assembly, Fit-up & Welding of C-seams of Shell to Dished end and skirt to Toricone as per drawings & approved QAP / ITP along with Production Test Coupons wherever required.

Welding of the skirt with Toricone involves weld build up using SMAW/ SAW which is to be carried out by the vendor as per detail given in the drawing. After the weld build up is completed, the groove on the weld as per radius mentioned in the drawing has to be maintained by Machining / Grinding. A detailed procedure to be submitted by the vendor along with the Technical bid on methodology of carrying out this activity.

2.2.10 100% RT of L-seam & C-Seam Welds of Shell, Skirt & Dished Ends of balance portion of CS portion as detailed above and Production Test Coupons as per approved QAP.

2.2.11 Dimensional inspection as per approved drawing & QAP.

2.2.12 Offering the job for stage wise inspection and obtaining stage wise inspection clearance, Final Inspection clearance from HPVP (QC) / TPIA / EIL as per approved QAP.

2.2.13 All NDT activities like DPT, MPT, RT, UT, etc., shall be carried out as per approved QAP by NDT personnel qualified by BHEL as per BHEL Procedure No. BHEL: NDE: WP01.

2.2.14 NDT agency engaged by fabrication contractors shall have to ensure that their NDE personnel are qualified by BHEL in advance before starting of the job.

2.2.15 Production Test Coupons after RT to be tested as per approved QAP / Procedures.

2.2.16 Handing over of Production Test Coupons to SR agency for PWHT / SR along with the Vessel.

2.3 Internals & External Attachments:

2.3.1 Fabrication, Marking, cutting, Assembly, Welding and NDT of

a) Externals like Compression & Base Rings, Trailing Lugs, Stiffener Rings, Pipe supports, Earthing Lugs, Insulation & Platform cleats, Fire proofing supports, Ladders, Platforms, Anchor chairs, Pipe Davit Assembly, Manhole Davit Assembly, Access Door, Lifting Trunnions, Sub-assemblies of Nozzles, Nozzle Internal Connections, Thermocouple Tappings, Instrument Tappings, RF Pads, Insert Plates, Transportation Saddles etc.,

b) Internals like Vac. Stiffeners, Steam Sparger, Coke Trap, Chimney trays, Support Rings, Tray supports, Pipe Supports, Wear Plate etc. as per approved drawings, QAP & NDE Procedures.

2.3.2 Nozzles in LAS+SS Clad portion:

Nozzles formed from Pipes & fittings: For sizes up to 6"dia., Bore cladding of Pipes will be done by BHEL-HPVP. Also, Weld overlay and Machining of Flanges/ Fittings of these Nozzles up to 6"dia. will be done by BHEL-HPVP.

However, for Nozzle sizes greater than 6"dia., Nozzles are to be formed from clad plates including Rolling of the clad plates, L-seam & C-seam welding and welding of the nozzle pipe with flanges along with Weld overlay & Machining on Flanges / fittings are to be done by the Vendor.

2.3.3 **Nozzles formed from Plates:** For plate formed nozzles with dia. less than 6" only, rolling of the plates to form Nozzles will be done in BHEL-HPVP shop. However, fit up, assembly, welding of L-seams & C-seams, NDT etc. are to be carried out by the Vendor.

For Nozzle sizes greater than 6"dia., Nozzles are to be formed from clad plates including Rolling of the clad plates, L-seam & C-seam welding and welding of the nozzle pipe with flanges along with Weld overlay & Machining on Flanges / fittings are to be done by the Vendor.

2.3.4 Fabrication of Nozzle Sub-assemblies involving Fit up & Welding of C-seams of Pipes, Elbows, Flanges, Nozzles including DPT of Weld Edges after root run & final weld, on weld overlay after each layer and RT on

C-seam welds, chemical analysis of weld overlay, Ferrite check of weld overlay as per approved drawings & QAP.

- 2.3.5 100% RT of Insert plate to Shell, Insert Plate to SR Nozzles and SR Nozzle to Shell as per approved QAP / NDE procedure.
- 2.3.6 100 % UT where attachments are welded directly to the cladding as per approved QAP / NDE procedure.
- 2.3.7 Marking & opening of Nozzles and Access / Man way openings on Shell & Dished end as per approved drawings & QAP.
- 2.3.8 Fit up & Welding of Nozzles / Sub-Assemblies on Shell & Dished ends including PT on Weld edges, on Root Run & on Final Welds, on chipped back welds, clad restoration on welds, chemical analysis, ferrite check as per approved drawings, QAP / NDE Procedure.
- 2.3.9 100% UT on the seam of Nozzle to Shell, Pipes & Dished ends as per approved QAP / NDE Procedure.
- 2.3.10 Fabrication of RF pads including Rolling / Pressing, Assembly & Welding with the Column and Pneumatic Test as per approved drawings, QAP / NDE Procedure.
- 2.4 Fabrication of Temporary Saddles for Stress Relieving of column sections, if required, and Transportation Saddles and Stools for Loading & Unloading of Finished column (2 sections) from / on Hydraulic trailers required for transportation of column as per approved drawings.
- 2.5 **PWHT of Column in sections along with Production test coupons has to be carried out by Vendor through a separate Specialized Agency. Specialized agency shall be identified in advance and credentials of agency & procedure for PWHT to be submitted to BHEL for approval. After according of BHEL approval only, the agency is to be engaged for PWHT job. PWHT specifications, SR cycle and other documents as required will be furnished by BHEL.**

The method of PWHT will be as follows:

- a) Internally by diesel Firing for different sections of suitable length of column and
- b) Local SR of C-seam joints after assembly & welding of different sections of column by Electrical Resistance method.

Supply of Diesel required for all the SR related activities of the Column is in the scope of the Vendor.

All assistance required for the Stress Relieving of the Vessels like preparation & fixing of Bulk Heads, Handling, Shifting & Placing the Vessels on Saddles, Rotation of the equipment, Welding of Thermocouples etc. as per the requirements of SR Agency are to be carried out by the vendor.

- 2.6 Production Test Coupons after RT & PWHT shall be handed over to BHEL QC Laboratory for testing.
- 2.7 Hardness shall be checked for all pressure joints on Welds / Heat Affected Zone / Parent Metal after PWHT as per approved QAP / NDE procedure.
- 2.8 RT on Pressure retaining welds after PWHT as per approved QAP / NDE procedure.
- 2.9 100% UT on Pressure retaining welds of clad portion of Dished End, Toricone and Hot formed shells after PWHT as per approved QAP / NDE procedure.
- 2.10 10% UT on Pressure retaining welds of balance clad portion of shells after PWHT as per approved QAP / NDE procedure.
- 2.11 Spot PT on all the internal & external welds after PWHT as per approved QAP / NDE procedure.
- 2.12 PMI check for SS & Alloy steel components, Final Dimensional inspection after PWHT as per approved QAP / NDE procedure.
- 2.13 Hydro-testing of Column at test pressure specified in drawing followed by Draining, Drying with Hot Air & inside Cleaning. Vendor shall arrange water for Hydro-testing of the column at his own cost. The Maximum chloride content shall be 25 ppm and the vendor has to submit the report for suitability of water tested at NABL approved laboratory before filling the column. Laying of necessary piping for filling has to be arranged by Vendor.
- 2.14 **MPT inspection of External and Internal surfaces of all welds shall be checked after Hydro-test of the vessel as per QAP / NDE procedure.**
- 2.15 Pickling & Passivation of Clad Surface of Shells, dished ends & weldments and Weld Overlays of Nozzles including cleaning & drying as per standards, approved procedure & QAP after Hydro testing of vessel. **An**

approved specialized agency shall be engaged by the Vendor for the Pickling & Passivation job. Specialized agency shall be identified in advance and credentials of agency & procedure for Pickling & Passivation to be submitted to BHEL for approval. After according of approval only by BHEL, the agency is to be engaged for Pickling & Passivation job.

- 2.16** Surface preparation by Blast Cleaning to Specification SSPC-SP-10 and Coating of Primer & Finish Paints as per approved Painting Schedule. All tests like Salt Contamination Test, Profile Gauge Check, Tape Adhesion Test, Holiday Check, Peel Off Test etc. required as per Job Specifications and BHEL Painting Procedure No. **SIP:H: PP:22**, Rev.0. shall be carried out by a qualified agency for testing of painting and obtaining stage wise inspection clearance from HPVP (QC) / TPIA / EIL as per approved QAP.
- 2.17** Painting is to be carried out only by Painters qualified by HPVP as per standard format.
- 2.18** All the nozzle openings shall be closed with suitable steel blind covers supplied by BHEL.
- 2.19** Match marking and Cutting of Complete column into two sections for Transportation and weld edge preparation for site weld as per approved drawings and QAP. Profile of the column at the open ends after cutting of the column shall be maintained by providing temporary spiders / profile plates for which raw materials will be provided by BHEL as Free Issue. The open ends of both the vessels are to be closed by welding of plates provided by BHEL as Free issue.
- 2.20** **Nitrogen filling is to be carried out in both the sections of the column as per drawings and approved QAP. Nitrogen shall be made available at one point by BHEL-HPVP as Free Issue. The filling of Nitrogen by laying of necessary piping, valves, manifolds, gauges etc., shall be arranged by the Vendor.**
- 2.21** Letter painting of Dispatch particulars in a prescribed / specified format on the sections of the column.
- 2.22** Vendor to provide all the assistance to Transportation contractor engaged by BHEL Logistics dept. for loading of these two Column sections on the Hydraulic Trailers like placing & fixing steel / wooden saddles, fixing of temporary supports, if required, on the trailer etc. Steel and wooden saddles will be free Issue by BHEL.

For assembly & handling of Column sections during complete formation and loading of Column sections after complete formation on the Hydraulic trailers, additional 300 MT capacity crane has to be mobilised in addition to 300 MT crane provided by BHEL and charges for the same are to be borne by the Vendor. Any delay in Mobilisation of crane will attract demurrage charges towards the Hydraulic Trailer deployed by The Transportation contractor and these charges will be deducted from the bills of the Vendor.

2.23 Work Instruction/ Procedures to be followed during fabrication:

- 2.23.1** Welding is to be carried out by ASME qualified welders only. Vendor shall arrange for Qualification of Welders at HPVP under the supervision of BHEL / WT dept. at their own cost. However, Test Coupons shall be provided by BHEL as free issue.
- 2.23.2** The consumables like gases, grinding wheels etc., required for fabrication are in the scope of the Vendor except all CS and LAS Welding consumables. **All CS and LAS welding consumables including Filler wires are Free Issue by BHEL-HPVP.** Any wastage or excess usage beyond BHEL assessed quantity shall be justified by the Vendor. Otherwise, the same shall be charged to the vendor's account at BHEL recovery rates.
- 2.23.3** Experienced Site-in-charge and Qualified Engineers & Supervisors shall be deployed for proper co-ordination of the job.
- 2.23.4** Vendors should deploy Experienced & Qualified QC personnel (Min. 02 Nos.) for carrying out the inspection activities in coordination with BHEL QC inspector / TPIA / EIL. **Non-deployment will attract penalty @ rate decided by BHEL and same will be deducted in RA Bills.**
- 2.23.5** Vendors should deploy Qualified NDT personnel (Level III / Level II) (Min. 02 Nos.) at site for carrying out the NDT inspection activities in coordination with BHEL QC –NDT / TPIA / EIL. Vendors shall have to engage sufficient man power and resources for fabrication to meet HPVP delivery schedules. **Non-deployment will attract penalty @rate decided by BHEL and same will be deducted in RA Bills.**

- 2.23.6 Vendor shall deploy sufficient no. of calibrated Welding machines, Main Ovens & Portable Ovens required for baking of electrodes etc., at site. All relevant documents shall also be made available for verification & approval by BHEL - HPVP (QC) / TPIA.
- 2.23.7 Vendor shall deploy all types of suitable Cranes for handling of the raw materials, plates/ shell segments required during the fabrication. However, for heavy components, BHEL will be deploying one no. of 75 T Crawler crane and one no. of 300 T Crawler Crane for handling of shell sections.
- 2.23.8 Diesel required for the operation of cranes and DG set will be Free Issue by BHEL. However, transportation of same from BHEL-HPVP to Lovagarden site has to be arranged by Vendor. DG set will be deployed by BHEL at Lovagarden site -1 only and for Lovagarden site -2 Vendor has to make own alternate arrangements in case of power failure at LG site -2.
- 2.23.9 Vendor has to provide exclusively 02 Nos. of Helpers i.e., 01 no. for 75 MT Crane and 01 no. for 300 MT DEMAG Crane for regular maintenance and for assistance to Crane operators during the entire contract period. **Non-deployment will attract penalty @rate decided by BHEL and same will be deducted in RA Bills.**
- 2.23.10 Sufficient No. of Rollers & Idlers required for fabrication of Column have to be arranged by the vendor. **Non-deployment in specified time will attract penalty @rate decided by BHEL and same will be deducted in RA Bills.**
- 2.23.11 Required tools & tackles like Measuring instruments like Tape, Fillet & Butt Weld Gauges, Plumb bobs with magnets, Thermal Chalks / Pyrometer, etc. shall be calibrated and valid calibration certificates must be presented, if required.
- 2.23.12 All the Scaffolding materials like Pipes, Clamps, Jallies etc. for temporary platform works required during the complete course of the fabrication are to be arranged by the Vendor.
- 2.23.13 Gate passes for the entry of Manpower, Materials, Trailers etc., inside Lovagarden site are to be taken care by the contractor.
- 2.23.14 Any modification work due to revision of drawings during fabrication is to be carried out by the vendor without any extra cost.
- 2.23.15 Submission of economic cutting plans for the plate materials and approval shall be obtained from BHEL-HPVP before taking up the same. Wherever fabrication is done without proper approved cutting plans, any loss of materials arising due to the same will be recovered as per BHEL recovery rates.
- 2.23.16 Vendors shall have to return the excess / balance materials including off-cuts and total scrap available with the vendors exclusive of process allowance & invisible wastage to HPVP Stores after material reconciliation but before submission of their final bill. In case the same are not returned by the vendor, Recovery shall be made as per BHEL Rates / MSTC rates plus applicable taxes, prevailing at the time of processing of the final bills.
- 2.23.17 Though not mentioned specifically, any other activity which is required for completion of the work is deemed to be included in the scope of work of vendor.

3. BHEL SCOPE: BHEL – HPVP shall provide the following as free issue:

- 3.1 Drawings, GMS, QAP, WPS, Painting Schedule, applicable Procedures, Standards & Specifications.
- 3.2 **Pressing of Insert Plates of 48 mm thk, 50 mm thk CS plates and (128+4) mm thk Clad plates** shall be done by HPVP at shop including marking, cutting, Edge preparation and Clad removal.
- 3.3 Raw materials like Plates (full / off-cuts), Pipes & Tubes, Round Bars, Structural items etc., and BOCs like Pipe Fittings, Nozzles, Flanges, Fasteners, Gaskets etc., as per GMS from HPVP stores.
- 3.4 **All types of CS & LAS welding consumables including Filler wires etc., required for total fabrication of Column as per the scope detailed above will be FREE issue by BHEL.**
- 3.5 Bore Cladding of Nozzle Pipes up to 6" Dia.
- 3.6 Section bending wherever required.
- 3.7 Blind Flanges, Gaskets and Fasteners required for Hydro-test.

- 3.8 All Paints as per requirement.
- 3.9 Testing of Production Test Coupons in HPVP QC laboratory.
- 3.10 300 MT – 01 No. & 75 MT – 01 No. cranes along with operator will be provided by BHEL free of charge for fabrication. Maintenance of the crane including spares shall also be in the scope of BHEL. However, Riggers required for handling the job shall have to be provided by the vendor. **DG set will be provided as a Standby during power breakdown at Lovagarden site -1 only.** However, experienced operator for DG set has to be arranged by the vendor. **Alternate arrangements in case of power failure at Lovagarden site -2 has to be made by the vendor.**
- 3.11 Diesel for operation of 300 MT & 75 MT cranes and also for DG set will be Free Issue by BHEL. However, transportation of same from BHEL-HPVP to Lovagarden site has to be arranged by Vendor.
- 3.12 Area required for fabrication, Site Office and Stores at Lovagarden site will be provided free of charge. Vendor to mobilize Office container preferably and temporary storage shed for storing their tools and tackles and also pipes, pipe fittings, gaskets, studs, bolts and Nuts etc., which are issued as FIM by BHEL.
- 3.13 Power & Water shall also be provided free of charge at one point inside the fabrication yard but further distribution to the desired location is in vendor's scope.
- 3.14 Vendor's scope shall include arranging Distribution Boards with suitable capacity Switch Fuse units as incomer, all outgoings with necessary safe trips like MCB, ELCB etc., as per the industrial safety norms and their installation, all outgoing cables from Distribution Board, termination at the distribution board, Working Area Lighting.

4. INSPECTION:

- 4.1 Inspection shall be carried out by M/s. BHEL-HPVP, Vizag / BHEL Authorized Inspection Agency (TPIA) / EIL / Customer as per approved QAP. Contractor shall have to offer for Stage wise and Final inspection as per approved QAP and obtain necessary stage wise & final clearances before proceeding for further operations.
- 4.2 Fabrication Vendor shall be solely responsible for preparation and submission of all Inspection Reports & documents duly certified by Inspection Authority along with the finished equipments.
- 4.3 All the documentation related to inspection clearance of M/s. BHEL / TPI / EIL / Customer, Generation of Inspection Reports, Preparation of Final Documents as per BHEL standard formats etc., are included in the scope of vendor and scanned copy as well as hard copy of the same is to be submitted to BHEL-QA.

Note: QAP with EIL comments enclosed with the tender document is tentative only and may be subject to revision due to incorporation of comments of the approving authority. Hence, the approved QAP issued to the vendor after ordering shall only be followed for execution and inspection of the job.

5. DELIVERY:

- 5.1 Complete Column along with inspection documents and all other certificates are to be handed over to HPVP **within 8 months from the date of issue of First consignment of free issue materials or 6 weeks from the date of issue of Last consignment of materials, whichever is later.**

Note: 1) In case the delivery period offered by the vendor is more than the tender delivery, Price quoted by the bidder shall be loaded for additional period @1/2 % per week or part thereof for the purpose of evaluation of Bidder Status.

- 2) **Time schedule is very stringent and Vendor has to deliver the job as per Customer requirement and schedule which will be meticulously monitored by BHEL/ EIL/ Customer. All necessary steps to reduce the cycle time for the individual sub-activities and main activities will be mutually discussed and Vendor has to mobilize additional resources as per time to time requirement to achieve the same.**

6. SITE MOBILISATION:

- 6.1 Successful bidders shall have to complete site mobilization within 10 days from the date of receipt of order or from the date of intimation for the same by Outsourcing dept. whichever is later.

7. PRICE:

- 7.1 The price shall be quoted strictly as per the Schedule of Rates enclosed at Annexure – I for the detailed scope of work and the quoted price shall be inclusive of all applicable taxes & duties except GST.
- 7.2 The prices shall be fixed & firm without any escalation during the entire period of contract and till completion of the work.
- 7.3 GST shall be reimbursable to the vendor as detailed in Clause - 9 and as per Annexure – GST.
- 7.4 Income tax will be deducted at applicable rates from RA & Final bills.

8. PAYMENT TERMS:

- 8.1 Payment shall be made against RA Bills for **90% of the order value** for the following stages of supply and fabrication of the equipment:
 - a) After Rolling, L-Seams & C-seams of LAS Gr.11 clad portion of shell including NDE - 20% (On Pro-rata)
 - b) After Rolling, L-Seams & C-seams of LAS Gr.22 clad portion of shell including NDE - 30% (On Pro-rata)
 - c) After Completion of fabrication of complete column, PWHT, Hydro-Testing - 20%
 - d) After Pickling & Passivation and Painting - 10%
 - e) After Completion of cutting of column into two sections & Loading for transportation - 10%
- 8.2 Balance 10% payment shall be made after completion of the job in all respects including material reconciliation and handing over of the balance materials & returnable items, if any and submission of total documentation to BHEL (QC/QA).
- 8.3 The weight indicated in the tender is tentative and may be subject to increase or decrease after completion of detailed engineering. However, payment shall be made for the actual weights executed as per approved engineering drawings and documents with due certification by BHEL-HPVP site in-charge and QC.
This clause shall be read in conjunction with the clause 17.0 of Annexure – III i.e., General Terms & Conditions.

9. GOODS & SERVICES TAX (GST):

- 9.1 Bidders shall make a note of the following points of GST before submission of their offer:
 - a) Vendors shall have to mention their GSTIN no. (15 Digits) in their Technical Bid. If any specific exemption is available, a declaration with due supporting documents need to be furnished for considering the offer.
 - b) Semi-finished goods are to be delivered by the Vendors in BHEL, HPVP premises within a maximum period of one year from the date of issue of the material, failing which the whole transaction will be considered as Supply & Sale and GST is required to be paid along with interest (calculated @ SBI Base Rate + 6%) along with penalty, if any, from the date of Challan on the whole value of materials. Hence vendors shall have to ensure that materials issued to them are returned within 365 days.
 - c) After fabrication, the vendors shall have to deliver the Semi - finished Goods by fulfilling the following formalities:
 - i) GST invoice should be raised by the vendors by paying GST on job work charges at applicable rates and by incorporating the HPVP GSTIN no. in the invoice for availing the reimbursement of GST from HPVP.
 - ii) The vendor shall also have to enter in their GST Return -1 (GSTR-1) the details of invoice raised for payment of GST so as to enable HPVP to avail input credit.

10. REVERSE AUCTION:

- 10.1 BHEL shall be resorting to Reverse Auction (RA) for this tender. RA shall be conducted among the techno-commercially qualified bidders. Business Rules for Reverse Auction are given at Annexure – V and Guidelines for Reverse Auction are available on our website, www.bhel.com. → supplier registration → Guidelines for Reverse Auction 2021.
- 10.2 Sealed envelope / Electronic Price bids of all the techno-commercially qualified bidders shall be opened and the same shall be considered as initial bids of the bidders in RA. In case any bidder(s) do(es) not participate in

online Reverse Auction, their sealed envelope / Electronic price bid along with applicable loading, if any, shall be considered for ranking.

10.3 BHEL will inform bidders the details of service provider who will provide business rules, all necessary training and assistance before commencement of online bidding. The bidders participating in the Reverse Auction shall have to necessarily submit '**Process Compliance Form**' (PCF) to the designated Service Provider.

10.4 Bidders are advised to read the 'Business Rules' (Annexure – V) indicating details of RA event carefully, before reverse auction event.

11. Other Terms & Conditions, whichever applicable, shall be as per Annexure – III enclosed.

12. RISK PURCHASE:

In case the contractor fails to execute the work within the scheduled time or due to any other reasons, BHEL - HPVP reserves the right to get the same completed through some other party at the risk & cost of the contractor and any additional expenditure incurred due to the same shall be charged to the contractor.

13. VALIDITY OF OFFER:

The offer shall be valid for a period of **3 months** from the date of Reverse Auction.

14. GENERAL:

14.1 The bidders shall study the Tender documents, Drawings, Quality Documents and all other relevant documents in detail for understanding the scope of work and the processes involved before submission of offer. Bidders shall get clarifications, if any, from concerned officials on the scope of work, clarifications related to welding or any other details of the tender document, over phone between 09:00 AM and 04:00 PM on any working day or through e-mail.

14.2 Drawings, QAP, Clarifications related to Welding, other reference documents etc., shall be sent to the bidder's e-mail address upon their written/e-mail request.

14.3 **Conditional / Partial Price Bids** and any other deviations to the tender terms & conditions are not acceptable and BHEL reserves the right to reject such offers without further correspondence. Bidders shall confirm their acceptance to all the terms & conditions of the tender enquiry in the Techno-commercial Bids and any deviations mentioned in the Price Bids shall not be considered.

14.4 BHEL reserves the right to modify or cancel the tender enquiry at any stage without assigning any reasons thereof.

14.5 The General Terms & Conditions, if any, contradicting with the specific terms & conditions given in the tender, then specific terms & conditions shall only be considered.

15 The following documents shall form part of the tender enquiry:

- | | |
|---|---------------------|
| i) Schedule of Rates | : Annexure – I |
| ii) Details of Vessel to be fabricated | : Annexure – II (A) |
| iii) List of Reference Drawings & Documents | : Annexure – II (B) |
| iv) General Terms & Conditions | : Annexure – III |
| v) Acceptance to tender terms & conditions | : Annexure – IV |
| vi) Business Rules for Reverse Auction | : Annexure – V |
| vii) GST Compliance for Indigenous Suppliers | : Annexure – GST |
| viii) Integrity Pact | : Annexure - VI |
| ix) Applicable Drawings, Tentative QAP as per Annexure - II (B) | |

16 TENDER SUBMISSION (through E – Mail only):

16.1 Techno-commercial bids along with the tender document duly signed & stamped by the bidder on all pages along with a covering letter on Company's Letter Head addressed to DGM (Outsourcing), BHEL –HPVP, Visakhapatnam – 530 012 shall be sent through an e-mail only to the e-mail ID **technicalbid-hpvp@bhel.in**

16.2 **Tentative List of Man Power, Machinery, Tools & Tackles to be engaged by the vendor has to be attached to the Techno-Commercial Bid.**

16.3 Price bid shall also be sent separately through e-mail to another e-mail ID **pricebid-hpvp@bhel.in**

- 16.4 Offers completed in all respects along with all the supporting documents shall be sent to the above e-mails only latest by **14.00 Hrs. on 31.12.2021** duly mentioning the Name of Work, Tender Ref. No. & Date and Technical Bid / Price Bid in the subject of the e-mail.

Note: Don't mark CC and BCC while submitting your offer as the system is designed to reject the mails having more than one recipient. Max. file size of the attachment shall be 20 MB only. In case the file size is more, bidder can submit their offer through multiple mails within the due date and time.

- 16.5 Bidders shall ensure correctness of the e-mail addresses while submitting their offer. There shall be no other e-mail address at the receiving end while submission of the above bids otherwise the system will reject such mails. Bidder shall be solely responsible for non-receiving of such mails at the above mentioned e-mail addresses and no communication in this regard will be entertained.

- 16.6 **TENDERS RECEIVED AFTER THE DUE DATE & TIME ARE NOT ACCEPTABLE.**

- 16.7 **OFFERS SENT IN ANY OTHER FORM WILL BE TREATED AS INVALID AND WILL BE SUMMARILY REJECTED.**

17. TENDER OPENING:

- 17.1 Techno-commercial Bids will be opened at **14.00 Hrs. on 31.12.2021**. The bidders may depute their representatives at the time of opening of Technical bids.

- 17.2 After evaluation of the Techno-commercial Bids, intimation regarding date & time of opening of price bids of techno-commercially qualified bidders will be given later through an e-mail and the bidders may depute their representatives at the time of opening of Price bids.

18. INTEGRITY PACT:

- 18.1 IP is a tool to ensure that activities and transactions between the Company and its Bidders/ Contractors are handled in a fair, transparent and corruption free manner. A panel of Independent External Monitors (IEMs) have been appointed to oversee implementation of IP in BHEL.

The IP as enclosed with the tender is to be submitted (duly signed by authorized signatory who signs in the offer) along with techno-commercial bid. Only those bidders who have entered into such an IP with BHEL would be competent to participate in the bidding. In other words, entering into this Pact would be a preliminary qualification.

Details of IEM for this tender is furnished below:

Sl. No.	IEM	E-Mail ID
01	Shri Arun Chandra Verma, IPS (Retd.)	acverma1@gmail.com
02	Shri Virendra Bahadur Singh, IPS (Retd.)	vbsinghips@gmail.com

- 18.2 Please refer Section-8 of IP for Role and Responsibilities of IEMs. In case of any complaint arising out of the tendering process, the matter may be referred to any of the above IEMs.


Note:

No routine correspondence shall be addressed to the IEM (phone/ post/ email) regarding the clarifications, time extensions or any other administrative queries, etc. on the tender issued. All such clarification/ issues shall be addressed directly to the tender issuing (procurement) department.

For all clarifications/ issues related to the tender, please contact:

Name:	1. D N Murthy, Dy. Manager	2. Y V R Rao, DGM
Dept.:	Outsourcing Dept.	Outsourcing Dept.
Address:	BHEL – HPVP, Visakhapatnam - 12	BHEL – HPVP, Visakhapatnam - 12
Phone:	0891 – 668 1359 / 1358	0891 – 668 1332

For Bharat Heavy Electricals Limited,

 17/12/21
Y V R Rao
DGM (OS)

SCHEDULE OF RATES

Ref: OS/21-22/2439/PVLG/05/023

Date: 17.12.2021

Sub : Fabrication of Main Fractionator Column against S.O. no. 2439 at Lovagarden site of BHEL-HPVP, Visakhapatnam.

Sl. No.	S.O. No.	Description of Work	Unit	Qty.	Unit Rate (in ₹)	Total Amount (in ₹)
		Fabrication of Main Fractionator Column (Vessel Tag No. 111-C-2101: approx. weight of 700 MT) excluding Top Shell Sections I to VI of Carbon steel portion (15 M approx. length) consisting of CS portion of Top Main Shell & Dished end, LAS with SS clad portion of Middle & Bottom Main Shell, Toricone, Bottom Dished end, Skirt, Internals & External attachments including Rolling, Assembly, Fitup, Welding, NDT, PWHT (Internal firing method), Inspection, Hydro test, Pickling and Passivation of clad portion of shell & attachments, Blasting & Painting etc., as per the approved drawings, QAP / ITP, WPS, Procedures, Specifications & Standards and cutting of complete column into two sections for transportation purpose after Final completion and loading of the column sections on trailers including deployment of Higher capacity crane and also includes Collection of FIMs from HPVP stores / shops, transportation to Lova Garden site, Loading of equipments onto the trailers etc., completed in all respects as per the detailed scope of work mentioned in the tender document.				
1	2439	Main Fractionator Column - Eqpt. Tag No. 111-C-2101	MT	700		
Total Amount in words:						

Notes :

- 1) The quoted price shall be inclusive of all applicable taxes & duties except GST. Income Tax shall be deducted at applicable rates from RA & Final Bills and GST shall be reimbursable to the vendor as per applicable guidelines.
- 2) The prices shall be fixed & firm without any escalation during the entire period of contract and till completion of work.
- 3) The quantity and weights indicated above are approximate and may vary on both sides subject to revision or addition or deletion of drawings. However, payment shall be made for the actual weights as per the applicable drawings / BOM.
- 4) The bidders are advised to go through all the drawings & documents before quoting the tender.
- 5) The evaluation currency for this tender shall be **INR**.
- 6) Tenderer should quote the amount in figures & words. It may be noted that corrections, overwriting etc. are not allowed. If there is a discrepancy between amount in figures & words, the amount in words shall prevail unless the amount expressed in words is related to an arithmetic error, in which case the amount in figures shall prevail. If there is an error in the total corresponding to the addition or subtraction of sub-totals, the sub-totals shall prevail and total shall be corrected accordingly.
In case of mismatch between rate and amount in figures, rate in figures shall be taken into consideration for further evaluation and processing.

Signature of the Bidder with Stamp

Details of Vessel to be fabricated**Sub: Fabrication of Main Fractionator Column at Lovagarden site of BHEL-HPVP, Visakhapatnam****Ref: OS/21-22/2439/PVLG/05/023****Date:****17.12.2021**

Sl. No.	S.O.	PGMA	Equipment No.	Equipment Description	Qty. (No.)	Approx. Wt. (MT)	Eqpt. ID (mm)	Eqpt. Ht. / Overall Length (mm)	Remarks
1	2439	CL-010	111-C-2101	Main Fractionator Column	1	700	8000	58600	
				TOTAL	1	700			

Note : Dimensions & Weights indicated above are purely tentative and may be subject to revisions due to incorporation of comments of the approving authority in the drawings. Hence the approved drawings & documents issued to the vendor after ordering shall only be followed for execution & inspection of the job.

Ref: OS/21-22/2439/PVLG/05/023

Date: 17.12.2021

LIST OF REFERENCE DRAWINGS & DOCUMENTS

Sub : Fabrication of Main Fractionator Column at Lovagarden site of BHEL-HPVP, Visakhapatnam

Sl. No.	S.O. No.	PGMA	Eqpt. Name	Description of Drawings / Documents	Drawing / Document No.	Rev. No.	No. of Sheets
01	2439	CL-010	Main Fractionator Column (LAS with SS Clad) (Eqpt. Tag No. 111-C-2101)	General Assembly of Main Fractionator	1-CL-010-U0169	A	01
02				General Notes for Main Fractionator	1-CL-010-U0192	00	01
03				Details of Top Dished End	3-CL-010-U0218	A	01
04				Details of Bottom Dished End	3-CL-010-U0219	A	01
05				Details of Toricone	3-CL-010-U0220	A	01
06				Vessel Design data of Main Fractionator Column	B224-111-80-43-DS-3001 Sheet 1 of 7 to 7 of 7	A	07
07				QAP for Main Fractionator Column	CQP 2516 Dtd. 05.02.2021	00	16
08				EIL Comments on QAP			20
09				Procedure for Radiographic Examination	BHE-NDT-RT-07023	02	18
10				Procedure for Ultrasonic Examination	BHE-NDT-UT-07025	02	10
11				Procedure for Magnetic Particle Examination	BHE-NDT-MT-07024	02	13
12				Procedure for Liquid Penetrant Examination	BHE-NDT-PT-07026	02	09
13				Weld Overlay / Cladding Procedure		00	06
14				Surface Preparation & Painting Procedure	HPVP-2439-SP & PP	0	12
15				Hydro Test, Flushing & Dry out Procedure	HPVP-2439-HYD	0	5
16				Weld Details (For reference only)			01

Note : Drawings & Documents indicated above are purely tentative and may be subject to revisions due to incorporation of comments of the approving authority. Hence, the approved drawings and documents issued to the vendor after ordering shall only be followed for execution & inspection of the job.

GENERAL TERMS & CONDITIONS**1. TECHNICAL DELIVERY CONDITIONS:**

The work should conform to the technical data given in our drawings, GMS, Shipping List Specifications, QAP, WPS etc.

2. PARTY'S SCOPE:

The scope of the party shall be as follows: -

- a) All welding equipments, baking oven, tools, jigs and fixtures, measuring instruments duly calibrated, handling facilities, testing facilities etc.
- b) All materials other than those mentioned under "Free Issue Materials", which are required for completion of the work.
- c) All consumables such as electrodes, gases, grinding wheels etc.

Note: Electrodes of specification mentioned in the drawings / WPS and of BHEL approved brands only shall be used and MTCs of the same shall be submitted to BHEL for verification before use.

3. REVISION OF DRAWINGS:

There may be minor changes in the drawings during execution. In such a case, party should accommodate the same without any extra claim.

4. WELDING QUALIFICATION: Qualification of required number of Welders is party's responsibility at their cost.**5. X-RAY:**

All welding shall be of X-ray quality where specified on drawings. Inspection would specify the quantum of X-ray based on drawings / code requirement. Party should strictly follow the WPS and QAP issued by BHEL during welding. Getting the welds radiographed and getting them cleared by inspection is the responsibility of the party.

6. RECTIFICATIONS / REJECTIONS:

Any rectification due to defective work, if required, shall be done by the party free of charge with a suitable technology approved before hand by BHEL in writing. The cost of material, if any used for rectification work / rejection work, will be estimated by BHEL and the same shall be debited to party's account. In case any rectification / rework is to be carried out due to defective material supplied by BHEL, the replacement material and consumables will be supplied by BHEL free of Cost.

7. SECURITY DEPOSIT:

Vendors shall have to submit a Bank Guarantee for **10%** of the order value towards Security Deposit and safe custody of free issue materials within 15 days from the date of intimation by Outsourcing dept. The BG shall be valid for the entire contract period with a claim period of 12 months. This Bank Guarantee shall be released to the contractor after completion of work and on acceptance of the same by BHEL.

Bidder agrees to submit performance security required for execution of the contract within the time period mentioned above. In case of delay in submission of performance security, enhanced performance security which would include interest (SBI rate + 6%) for the delayed period, shall be submitted by the bidder. Further, if performance security is not submitted till such time the first bill becomes due, the amount of performance security due shall be recovered as per terms defined in NIT/contract, from the bills along with due interest.

8. PERFORMANCE BANK GUARANTEE:

Vendors shall have to submit Performance Bank Guarantee (claim period of 12 months) for 10% of the order value covering for the defects liability period. If PBG is not submitted, 10% of the order value shall be deducted towards PBG from the final bill and shall be refundable after performance guarantee period, if no defects are found during this period.

9. RAW MATERIALS ISSUE:

Raw materials shall be issued with appropriate processing allowance and invisible wastage over the theoretical requirement of raw materials (**Plates, Sheets, Sections and Pipes**).

10. TRANSFER / RETURN OF LEFT OVER MATERIALS:

Party should maintain proper records for receipt & use of all free issue materials. The left over materials & scrap as per the material accounting statement shall be returned to HPVP stores along with finished job. Material Transfer Vouchers (MTV) from one order to another or from one vendor to another and Material Return Vouchers should be submitted immediately after transfer / return. The material reconciliation statement shall be submitted by the contractor after verification and certification by BHEL along with the final bill **within 30 days from the date of completion of work**. Otherwise, recovery for the balance materials shall be made from any of their pending bills without further intimation.

11. MATERIAL RECONCILIATION:

Orders issued to the vendors have to be completed in all respects including Material Accounting within a maximum of **180 days** from the **date of issue of the first material** from BHEL - HPVP stores.

Maximum of 0.5 % on the requirement of materials (**Plates, Sections and Pipes**) is admitted towards **process allowance and invisible wastage**.

Scrap quantity is permissible up to a **maximum of 1% on Structural (Beams, Channels, Angles, Rods, Pipes etc.), 2% on Sheets, 3% for Plates** on the theoretical requirement of materials.

If wastage and scrap is beyond the above limits, it should be fully justified with cutting diagrams etc. which are to be approved in advance by BHEL. **Otherwise, the cost of raw materials beyond approved limits will be recovered from the contractor as per BHEL recovery rates including applicable taxes & duties.**

Material reconciliation including return of balance materials, off-cuts is to be completed within 20 days from the date of completion of the order. The material reconciliation statement shall be submitted by the contractor after verification and certification by BHEL-HPVP along with the final bill **within 30 days from the date of completion of work**. Otherwise, recovery for the balance materials shall be made from any of their pending bills without further intimation,

Repeated occurrence of inordinate delays in returning and settling the material accounting will entail BHEL the right to terminate the contract forthwith or impose a temporary suspension on further loading at the discretion of BHEL.

12. SCRAP & OFF-CUT NORMS:

Sl. No.	Description	Scrap Size (in mm)	Off-Cut (in MM)
1.	CS/AS Sheets & Plates	Below 500 × 250	500 × 250 & above
2.	Rolled sections Rod, angles etc. (other than -tubes, pipes)	Below 1000	1000 & above
3.	Tubes & Pipes	Below 500	500 & above
4.	Universal column	Below 1000	1000 & Above
5.	SS Sheets & Plates	Below 500 × 250	500 × 250 & above
6.	SS Structural, Rods, Tubes, Pipes	Below 250	250 & above
7.	Non – ferrous: sheets & plates, rods & tubes	Below 500 × 250 (S & PL), Below 250 (Rods & Tubes)	500 × 250 & above, 250 & above
8.	Big size Scrap	(2500 & above) × (150 to 249)	-

13. INSPECTION:

Party shall contact our Quality Control Dept. for stages of inspection before commencement of job and should strictly follow the stages of inspection as per QAP.

14. WORKMANSHIP GUARANTEE:

The vendors should give workmanship guarantee for fabricated items for a period of 18 months from the date of last delivery of the order. Any defects due to incomplete work, faulty workmanship found in the fabricated items after delivery during the defects liability period shall be rectified / replaced by the vendor free of cost. Otherwise, the expenditure incurred towards the same will be recovered from the pending bills of vendors.

15. WORK PROGRESS:

The fabricator shall furnish a weekly report on the progress of work along with the status of availability of free issue materials and requirement of further materials, if any.

Outsourcing dept. personnel will visit vendor's works from time to time to assess and review the work progress. Free access shall be provided to BHEL or its inspection agency at all reasonable times of the day / night.

In case the progress is not satisfactory or supplies are delayed abnormally beyond the contractual delivery date, BHEL-HPVP, Visakhapatnam reserves the right to cancel the order in part or full or get the balance job in as is where is condition completed elsewhere by another agency at the risk and cost of Fabricator. The value of the work carried out by the party will be assessed by BHEL and the same shall be final. No compensation will be given to the fabricator in case of cancellation of order or diversion of balance job even if the jobs have been processed partly.

16. DELIVERY:

Finished items should be handed over to BHEL-HPVP on party's delivery challans along with Job completion certificate / Final Inspection Report from inspection agency / HPVP-QC department.

17. PENALTY:

If delivery exceeds the stipulated delivery schedule, penalty 1/2 % of the total value of order per week or part there of subject to a maximum of 10% on the total value of the order will be levied. However, time taken for the following will not be considered as delay on the part of the Sub-Contractor.

- 1) Intermediate operations, if any, carried out by BHEL.
- 2) Waiting time for BHEL / Third party Inspection beyond a normal time of 3 days.

18. PAYMENT TERMS:

Payment shall be made against RA Bills within 45 days from the date of submission of Bill.

90% payment will be made after handing over of the finished equipments along with all inspection documents to HPVP shops / Logistics dept. / ADM site / Lova Garden site, duly inspected & cleared by Inspection authority. Balance 10% payment shall be made along with the Final Bill against completion of total order in all respects including documentation.

Vendors shall have to submit the bills in the formats specified by HPVP-Outsourcing and the bills submitted in the specified format along with necessary supporting documents are only admitted for processing. The following documents shall be submitted along with the Final Bill: -

1. No Claim Certificate from the contractor
2. No Dues Certificate from BHEL
3. Work Completion Certificate from BHEL
4. Material Reconciliation Statement submitted by the Contractor and certified by concerned authority of BHEL (if applicable)
5. Workmanship Guarantee certificate from the contractor

19. SECRECY:

All the documents of BHEL inclusive of Drawings, GMS and Standards made available to the fabricator should be kept in strict confidence and under no circumstance be made available to others or allow others to make use of them. Such documents shall be returned to BHEL on demand after completion of the job. This secrecy clause is binding on the employees of the fabricators also. Violation of the same may lead to suspension of business with the vendor and necessary legal action.

20. SUB-LETTING:

In general, sub-letting of jobs will not be permitted. But in special circumstances, this may be allowed. In such case, the party should obtain written approval from BHEL-HPVP, Visakhapatnam before sub-letting.

21. FACTORY RULES AND REGULATIONS:

Party shall abide by all the rules and statutory regulations in force from time to time as per factories act. It shall be party's responsibility to ensure the safety of their workmen and fulfilling the ESI, PF and other relevant statutory regulations.

22. SAFETY:

- a) Contractor shall adhere to safe construction practices, guard against hazardous & unsafe working conditions and shall comply with the safety rules of BHEL and local authorities. He shall maintain First Aid facilities for all his employees and labour. Contractor's responsibility includes supply of welder kit, all safety items such as safety belts, white and colour glasses, goggles, safety helmets, safety shoes etc.
- b) *Contractor and his employees shall follow all fire & safety, security regulations of BHEL.*

23. HOUSE KEEPING:

During execution of work, the contractor at all times keep the working place and storage area clean and free from accumulation of waste materials, rubbish etc.,

24. ACCIDENT / DAMAGE / CONDUCT ETC.:

Contractor will be held responsible for any disorderly conduct / misconduct, indiscipline, theft, smoking etc., on the part of his men. He will ensure summarily eviction of such men from his premises failing which BHEL would remove them from the factory on his responsibility. Any damage to and or loss of equipment, machinery, building etc., to BHEL or BHEL employees, visitors or other contractors resulting from his own or any of his men's negligence shall be liable to be made good by him. Contractor shall be solely responsible for any accident in which you or your men or your equipment may be involved during the execution of contract on account of any reason what so ever.

25. TERMINATION OF CONTRACT:

In the event of any failure on the part of the contractor, BHEL reserves the right to terminate the contract by giving a notice of 2 weeks for any of the following lapses and contractual violations: -

- a) Failure to make labour payments in time as per the rules
- b) Failure to progress the job according to the agreed schedule
- c) Failure to mobilize adequate man power, tools & tackles and consumables in time
- d) Failure to adhere to Quality Standards of BHEL
- e) Refused to co-operate with other agencies working in the same area
- f) Failure to resolve labour disputes like strikes etc., within 7 days of occurrence
- g) Failure to comply with statutory regulations applicable at BHEL

BHEL shall also be free to intervene and take necessary remedial measures. All costs incurred with interest and overheads shall be recovered from contractor by such foreclosing or off-loading any part of the contract work.

26. DISPUTES:

Head of BHEL- HPVP Unit will be the final authority for any disputes arising out of this contract. The disputes / arbitration / settlement of contractual or legal issues shall be under the Jurisdiction of Visakhapatnam Court.

- 27.** For this procurement, Public Procurement (Preference to Make in India), Order 2017 dated 15.06.2017 & 28.05.2018 and subsequent Orders issued by the respective Nodal Ministry shall be applicable even if issued after issue of this NIT but before finalization of Contract / PO / WO against this NIT.

In the event of any Nodal Ministry prescribing higher or lower percentage of purchase preference and / or local content in respect of this procurement, same shall be applicable.

- 28.** 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.

Signature of the Bidder with Stamp

Acceptance to Tender Terms & Conditions

I / We hereby confirm that the Tender documents, Drawings, Quality documents etc. have been studied in detail and we have fully understood the scope of work.

I / We accept to all the Terms and Conditions of the Tender Enquiry and the prices quoted are in accordance with the same.

I / We give our acceptance to participate in reverse auction for this tender.

Tender documents **duly signed & stamped on all the pages** by the Owner / authorized representative of the bidder are attached herewith.

Signature of the Bidder with Stamp

BUSINESS RULES FOR REVERSE AUCTION (RA)

This has reference to tender no. **OS/21-22/2439/PVLG/05/023 dated 17.12.2021**. BHEL shall finalize the Rates for **Fabrication of Main Fractionator Column at Lovagarden site of BHEL-HPVP, Visakhapatnam** through Reverse Auction mode. BHEL has made arrangement with an authorized Service provider (details will be shared before reverse auction) for conducting RA. Bidders should go through the instructions given below and submit acceptance of the same.

The technical & commercial terms are as per (a) BHEL Tender Enquiry No. **OS/21-22/2439/PVLG/05/023 dated 17.12.2021**, (b) Bidders' technical & commercial bid (in case of two-part bid) and (c) subsequent correspondences between BHEL and the bidders, if any.

1. Procedure of Reverse Auctioning:

- i) Price bids of all the techno-commercially qualified bidders shall be opened.
- ii) **Reverse Auction:** The 'bid decrement' will be decided by BHEL.
- iii) The lowest bidder in sealed envelope price bid shall be shown as current L1 automatically by the system and no acceptance of that price is required. System shall have the provision to indicate this bid as current L1.
- iv) Bidders by offering a minimum bid decrement or the multiples thereof can displace a standing lowest bid and become "L1" and this continues as an iterative process. However, no bidder shall be allowed to lower its bid below the current L1 by more than 5 decrements at one go.
- v) After the completion of the reverse auction, the Closing Price shall be available for further processing.
- vi) Wherever the evaluation is done on total cost basis, after Reverse Auction, prices of individual line items shall be reduced on pro-rata basis.

2. Schedule for reverse auction: The Reverse Auction schedule will be intimated to all the eligible techno-commercially qualified bidders at a later stage.**3. Auction extension time:** If a bidder places a bid in the last 5 minutes of closing of the Reverse Auction and if that bid gets accepted, then the auction's duration shall get extended automatically for another 5 minutes, for the entire auction (i.e. for all the items in the auction), from the time that bid comes in. Please note that the auto-extension will take place only if a bid comes in those last 5 minutes and if that bid gets accepted as the lowest bid. If the bid does not get accepted as the lowest bid, the auto-extension will not take place even if that bid might have come in the last 5 minutes. In case, there is no bid in the last 5 minutes of closing of Reverse Auction, the auction shall get closed automatically without any extension. However, bidders are advised not to wait till the last minute or last few seconds to enter their bid during the auto-extension period to avoid complications related with internet connectivity, network problems, system crash down, power failure, etc.

The above process will continue till completion of Reverse Auction.

Complaints/ Grievances, if any, regarding denial of service or any related issue should be given in writing thru e-mail/ fax to M/s. {Service provider} with a copy to BHEL within 15 minutes prior to initial closing time of Reverse Auction.

4. Bid price: The Bidder has to quote the {.....} Price **except GST** but inclusive of Packing & Forwarding charges, all the routine & type tests as per tender scope, taxes, duties, freight and insurance as specified in tender document including loading (if indicated by BHEL due to deviations in technical/ commercial terms) for the Items specified. Details are as shown in Excel Sheet for calculation of total cost to BHEL (To be specified by Unit as per NIT conditions).**5. Bidding currency and unit of measurement:** Bidding will be conducted in **Indian Rupees per Unit** of the material as per the specifications mentioned in the tender.

In case of foreign currency bids, exchange rate (TT selling rate of State Bank of India) as on scheduled date of tender opening (Part-I bid) shall be considered for conversion in Indian Rupees. If the relevant day happens to be a Bank holiday, then the forex rate as on the previous bank (SBI) working day shall be taken.

6. **Validity of bids:** Price shall be valid for 3 months from the date of reverse auction. These shall not be subjected to any change whatsoever.
7. **Lowest bid of a bidder:** In case the bidder submits more than one bid, the lowest bid at the end of Reverse Auction will be considered as the bidder's final offer to execute the work.
8. Unique user IDs shall be used by bidders during bidding process. All bids made from the Login ID given to the bidders will be deemed to have been made by the bidders/ bidders' company.
9. **Post auction procedure:** BHEL will proceed with the Lowest Bid in the Reverse Auction for further processing.
10. Any commercial/ technical loading shall be separately intimated to respective bidders prior to RA. The excel sheet provided in this regard shall cover all these aspects. Commercial/ technical loading if any, shall be added by the respective bidder in its price during Reverse Auction.
Modalities of loading & de-loading shall be separately intimated to the bidders. The responsibility for correctness of total cost to BHEL shall lie with the bidders.
11. Reverse auction shall be conducted by BHEL (through M/s {Service Provider}), on pre-specified date, while the bidders shall be quoting from their own offices/ place of their choice. Internet connectivity shall have to be ensured by bidders themselves.

During the RA process if a bidder is not able to bid and requests for extension of time by FAX/ email/ phone then time extension of additional 15 minutes will be given by the service provider provided such requests come before 5 minutes of auction closing time. However, only one such request per bidder can be entertained.

In order to ward-off contingent situation of connectivity failure bidders are requested to make all the necessary arrangements/ alternatives whatever required so that they are able to circumvent such situation and still be able to participate in the reverse auction successfully. Failure of power or loss of connectivity at the premises of bidders during the Reverse auction cannot be the cause for not participating in the reverse auction. On account of this, the time for the auction cannot be extended and neither BHEL nor M/s. {Service provider} is responsible for such eventualities.

12. **Proxy bids:** Proxy bidding feature is a pro-bidder feature to safe guard the bidder's interest of any internet failure or to avoid last minute rush. The proxy feature allows bidders to place an automated bid in the system directly in an auction and bid without having to enter a new amount each time a competing bidder submits a new offer. The bid amount that a bidder enters is the minimum that the bidder is willing to offer. Here the software bids on behalf of the bidder. This obviates the need for the bidder participating in the bidding process until the proxy bid amount is decrementally reached by other bidders. When proxy bid amount is reached, the bidder (who has submitted the proxy bid) has an option to start participating in the bidding process.

The proxy amount is the minimum amount that the bidder is willing to offer. During the course of bidding, the bidder cannot delete or change the amount of a proxy bid.

Bids are submitted in decrements (decreasing bid amounts). The application automates proxy bidding by processing proxy bids automatically, according to the decrement that the auction originator originally established when creating the auction, submitting offers to the next bid decrement each time a competing bidder bids, regardless of the fact whether the competing bids are submitted as proxy or standard bids. However, it may please be noted that if a manual bid and proxy bid are submitted at the same instant manual bid will be recognized as the L1 at that instant.

In case of more than one proxy bid, the system shall bid till it crosses the threshold value of 'each lowest proxy bid' and thereafter allow the competition to decide the final L1 price.

Proxy bids are fed into the system directly by the respective bidders. As such this information is privy only to the respective bidder(s).

13. Bidders are advised to get fully trained and clear all their doubts such as refreshing of Screen, quantity being auctioned, tender value being auctioned etc. from M/s. {Service provider}.

14. M/s. {Service provider}, shall arrange to demonstrate/ train the bidder or bidder's nominated person(s), without any cost to bidders. M/s. {Service provider}, shall also explain the bidders, all the business rules related to the Reverse Auction. Bidders are required to submit their acceptance to the terms/ conditions/ modalities before participating in the Reverse Auction in the process compliance form as enclosed. Without this, the bidder will not be eligible to participate in the event.
15. Successful bidder shall be required to submit the final prices (L1) in prescribed format (Annexure – VI) for price breakup, quoted during the Reverse Auction, duly signed and stamped as token of acceptance without any new condition (other than those already agreed to before start of auction), after the completion of auction to M/s. {Service provider} besides BHEL within two working days of Auction without fail.
16. Any variation between the final bid value and that in the confirmatory signed price breakup document will be considered as tampering the tender process and will invite action by BHEL as per extant guidelines for suspension of business dealings (as available on www.bhel.com).
17. Bidders' bid will be taken as an offer to execute the work/ supplies the item as per enquiry no. **OS/21-22/2439/PVLG/05/023 dated 17.12.2021**. Bids once made by the bidder, cannot be cancelled/ withdrawn and bidder shall be bound to execute the work as mentioned above at bidder's final bid price. Should bidder back out and not execute the contract as per the rates quoted, BHEL shall take action as per extant guidelines for suspension of business dealings (as available on www.bhel.com).
18. Bidders shall be able to view the following on their screen along with the necessary fields during Reverse Auction:
 - a. Leading (Running Lowest) Bid in the Auction (only total price of package)
 - b. Bid Placed by the bidder
 - c. Start Price
 - d. Decrement value
 - e. Rank of their own bid during bidding as well as at the close of auction.
19. BHEL's decision on award of contract shall be final and binding on all the Bidders.
20. BHEL reserves the right to extend, reschedule or cancel the Reverse Auction process at any time, before ordering, without assigning any reason, with intimation to bidders.
21. BHEL shall not have any liability to bidders for any interruption or delay in access to the site irrespective of the cause. In such cases, the decision of BHEL shall be binding on the bidders.
22. Other terms and conditions shall be as per bidder's techno-commercial offers and other correspondences, if any, till date.
23. If there is any clash between this business document and the FAQ available, if any, in the website of M/s. {Service provider}, the terms & conditions given in this business document will supersede the information contained in the FAQs. Any changes made by BHEL/ service provider (due to unforeseen contingencies) after the first posting shall be deemed to have been accepted if the bidder continues to access the portal after that time.
24. Bidder shall not divulge either his Bids or any other exclusive details of BHEL to any other party. If the Bidder or any of his representatives are found to be involved in Price manipulation/ cartel formation of any kind, directly or indirectly by communicating with other bidders, action *as per extant BHEL guidelines for suspension of business dealings (as available on www.bhel.com)*, shall be initiated by BHEL.

Signature of the Bidder with Stamp

GST COMPLIANCE FOR INDIGENOUS SUPPLIERS

1. In Response to Tenders for Indigenous supplier will be entertained only if the vendor has a valid GSTIN which should be clearly mentioned in the offer. If any specific exemption is available, a declaration with due supporting documents need to be furnished for considering the offer.
2. Supplier shall mention their GSTIN in all their invoices and invoices shall be in the format as specified/prescribed under GST laws. Invoices shall necessarily contain Invoice number (in case of multiple numbering system is being followed for billing like SAP invoice no, commercial invoice no etc., then the Invoice No which is linked/uploaded in GSTN network shall be clearly indicated), item description as per PO, Quantity, Rate, Value, applicable taxes with nomenclature (like IGST, SGST, CGST & UTGST) separately, HSN/ SAC Code, etc.
3. All invoices shall bear the HSN Code for each item separately (Harmonized System of Nomenclature)/ SAC code (Services Accounting Code).
4. A declaration to the effect that all invoice particulars are/were uploaded in the GSTN network/ portal & all tax liability as per GST rules and regulations have been and will be discharged, shall be mentioned in the invoice. If not mentioned in the invoice, a separate declaration shall be submitted as per the requirement of BHEL.
5. All documents like Test Certificate, LR copy, Guarantee/Warranty certificate, work completion certificate, any other document mentioned in PO, shall be sent along with the vehicle/consignment where ever applicable. For all consignments received within the calendar month, input credit will be availed within that month in line with monthly returns filing cycle. In case of any discrepancy in the document or non-submission of documents mentioned in the PO, then BHEL will not be able to accept or account the material, in such case availing of tax credit will be deferred to next month or so.
6. In case of discrepancy in the data uploaded by supplier in the GSTN portal or in case of any shortages or rejection in the supply, then BHEL will not be able to avail the tax credit and will notify the supplier of the same. Supplier has to rectify the data discrepancy in the GSTN portal or issue credit note (details to be uploaded in GSTN portal) for the shortages or rejections in the suppliers, within the calendar month notified by BHEL.
7. For any such delay in availing of tax credit for reasons attributable to supplier (as mentioned above), interest (calculated @ SBI Base Rate + 6%) along with penalty if any will be deducted for the delayed period i.e. from the month of receipt till the month tax credit is availed, from the running bills.
8. Under GST regime, BHEL has to discharge GST liability on LD recovered from suppliers/contractors. Hence applicable GST shall also be recoverable from suppliers/contractors on LD amount. For this Debit note will be issued by BHEL indicating the respective supply invoice number.
9. This is to inform that GST portion of invoice, shall be released only upon Vendor declaring such invoice in his GSTR-1 and receipt of goods and Tax invoice by BHEL and Confirmation of payment of GST thereon by vendor on GSTN portal. Alternatively, BG of appropriate value may be obtained from vendor which shall be valid At least one month after the confirmation of date of payment of GST by vendor on GSTN portal and receipt of Tax invoice and receipt of goods, whichever is later. Above is subject to receipt of goods/service and tax invoice thereof along with vendor declaring invoice in his return and paying GST within timeline prescribed for availing ITC by BHEL.
10. That in case vendor delays Declaring such invoice in his return and GST credit availed by BHEL is denied or reversed subsequently as per GST law, GST amount paid by BHEL towards such ITC reversal as per GST law shall be recoverable from vendor/contractor along with interest levied/ leviable on BHEL.

Note: The above will be followed strictly for processing vendor payments to ensure GST Compliance.

Signature of the Bidder with Stamp

INTEGRITY PACT**Between**

Bharat Heavy Electricals Ltd. (BHEL), a company registered under the Companies Act 1956 and having its registered office at "BHEL House", Siri Fort, New Delhi - 110049 (India) hereinafter referred to as "The Principal", which expression unless repugnant to the context or meaning hereof shall include its successors or assigns of the ONE PART

and

_____, (description of the party along with address), hereinafter referred to as "The Bidder/ Contractor" which expression unless repugnant to the context or meaning hereof shall include its successors or assigns of the OTHER PART

Preamble

The Principal intends to award, under laid-down organizational procedures, contract/s for _____

_____. The Principal values full compliance with all relevant laws of the land, rules and regulations, and the principles of economic use of resources, and of fairness and transparency in its relations with its Bidder(s)/ Contractor(s).

In order to achieve these goals, the Principal will appoint Independent External Monitor(s), who will monitor the tender process and the execution of the contract for compliance with the principles mentioned above.

Section 1- Commitments of the Principal

1.1 The Principal commits itself to take all measures necessary to prevent corruption and to observe the following principles:-

1.1.1 No employee of the Principal, personally or through family members, will in connection with the tender for, or the execution of a contract, demand, take a promise for or accept, for self or third person, any material or immaterial benefit which the person is not legally entitled to.

1.1.2 The Principal will, during the tender process treat all Bidder(s) with equity and reason. The Principal will in particular, before and during the tender process, provide to all Bidder(s) the same information and will not provide to any Bidder(s) confidential/ additional information through which the Bidder(s) could obtain an advantage in relation to the tender process or the contract execution.

1.1.3 The Principal will exclude from the process all known prejudiced persons.

1.2 If the Principal obtains information on the conduct of any of its employees which is a penal offence under the Indian Penal Code 1860 and Prevention of Corruption Act 1988 or any other statutory penal enactment, or if there be a substantive suspicion in this regard, the Principal will inform its Vigilance Office and in addition can initiate disciplinary actions:

Section 2 - Commitments of the Bidder(s)/ Contractor(s)

- 2.1 The Bidder(s)/ Contractor(s) commit himself to take all measures necessary to prevent corruption. He commits himself to observe the following principles during his participation in the tender process and during the contract execution.
- 2.1.1 The Bidder(s)/ Contractor(s) will not, directly or through any other person or firm, offer, promise or give to the Principal or to any of the Principal's employees involved in the tender process or the execution of the contract or to any third person any material, immaterial or any other benefit which he/ she is not legally entitled to, in order to obtain in exchange any advantage of any kind whatsoever during the tender process or during the execution of the contract.
- 2.1.2 The Bidder(s)/ Contractor(s) will not enter with other Bidder(s) into any illegal or undisclosed agreement or understanding, whether formal or informal. 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.
- 2.1.3 The Bidder(s)/ Contractor(s) will not commit any penal offence under the relevant Indian Penal Code (IPC) and Prevention of Corruption Act; further the Bidder(s)/ Contractor(s) will not use improperly, for purposes of competition or personal gain, or pass on to others, any information or document provided by the Principal as part of the business relationship, regarding plans, technical proposals and business details, including information contained or transmitted electronically.
- 2.1.4 Foreign Bidder(s)/ Contractor(s) shall disclose the name and address of agents and representatives in India and Indian Bidder(s)/ Contractor(s) to disclose their foreign principals or associates. The Bidder(s)/ Contractor(s) will, when presenting his bid, disclose any and all payments he has made, and is committed to or intends to make to agents, brokers or any other intermediaries in connection with the award of the contract.
- 2.2 The Bidder(s)/ Contractor(s) will not instigate third persons to commit offences outlined above or be an accessory to such offences.
- 2.3 The Bidder(s)/ Contractor(s) shall not approach the Courts while representing the matters to IEMs and will await their decision in the matter.

Section 3 - Disqualification from tender process and exclusion from future contracts

If the Bidder(s)/ Contractor(s), before award or during execution has committed a transgression through a violation of Section 2 above, or acts in any other manner such as to put his reliability or credibility in question, the Principal is entitled to disqualify the Bidder(s)/ Contractor(s) from the tender process or take action as per the separate "Guidelines on Banning of Business dealings with Suppliers/ Contractors", framed by the Principal.

Section 4 - Compensation for Damages

- 4.1 If the Principal has disqualified the Bidder from the tender process prior to the award according to Section 3, the Principal is entitled to demand and recover the damages equivalent Earnest Money Deposit/ Bid Security.
- 4.2 If the Principal has terminated the contract according to Section 3, or if the Principal is entitled to terminate the contract according to section 3, the Principal shall be entitled to

demand and recover from the Contractor liquidated damages equivalent to 5% of the contract value or the amount equivalent to Security Deposit/ Performance Bank Guarantee, whichever is higher.

Section 5 - Previous Transgression

- 5.1 The Bidder declares that no previous transgressions occurred in the last 3 years with any other company in any country conforming to the anti-corruption approach or with any other Public Sector Enterprise in India that could justify his exclusion from the tender process.
- 5.2 If the Bidder makes incorrect statement on this subject, he can be disqualified from the tender process or the contract, if already awarded, can be terminated for such reason.

Section 6 - Equal treatment of all Bidders/ Contractors / Sub-contractors

- 6.1 The Principal will enter into agreements with identical conditions as this one with all Bidders and Contractors. In case of sub-contracting, the Principal contractor shall be responsible for the adoption of IP by his sub-contractors and shall continue to remain responsible for any default by his sub-contractors.
- 6.2 The Principal will disqualify from the tender process all bidders who do not sign this pact or violate its provisions.

Section 7 - Criminal Charges against violating Bidders/ Contractors /Subcontractors

If the Principal obtains knowledge of conduct of a Bidder, Contractor or Subcontractor, or of an employee or a representative or an associate of a Bidder, Contractor or Subcontractor which constitutes corruption, or if the Principal has substantive suspicion in this regard, the Principal will inform the Vigilance Office.

Section 8 - Independent External Monitor(s)

- 8.1 The Principal appoints competent and credible Independent External Monitor for this Pact. The task of the Monitor is to review independently and objectively, whether and to what extent the parties comply with the obligations under this agreement.
- 8.2 The Monitor is not subject to instructions by the representatives of the parties and performs his functions neutrally and independently. He reports to the CMD, BHEL.
- 8.3 The Bidder(s)/ Contractor(s) accepts that the Monitor has the right to access without restriction to all contract documentation of the Principal including that provided by the Bidder(s)/ Contractor(s). The Bidder(s)/ Contractor(s) will grant the monitor, upon his request and demonstration of a valid interest, unrestricted and unconditional access to his contract documentation. The same is applicable to Sub-contractor(s). The Monitor is under contractual obligation to treat the information and documents of the Bidder(s)/ Contractor(s) / Sub-contractor(s) with confidentiality in line with Non- disclosure agreement.
- 8.4 The Principal will provide to the Monitor sufficient information about all meetings among the parties related to the contract provided such meetings could have an impact on the contractual relations between the Principal and the Contractor. The parties offer to the Monitor the option to participate in such meetings.

- 8.5 The role of IEMs is advisory, would not be legally binding and it is restricted to resolving issues raised by an intending bidder regarding any aspect of the tender which allegedly restricts competition or bias towards some bidders. At the same time, it must be understood that IEMs are not consultants to the Management. Their role is independent in nature and the advice once tendered would not be subject to review at the request of the organization.
- 8.6 For ensuring the desired transparency and objectivity in dealing with the complaints arising out of any tendering process, the matter should be examined by the full panel of IEMs jointly as far as possible, who would look into the records, conduct an investigation, and submit their joint recommendations to the Management.
- 8.7 The IEMs would examine all complaints received by them and give their recommendations/ views to CMD, BHEL, at the earliest. They may also send their report directly to the CVO and the Commission, in case of suspicion of serious irregularities requiring legal/ administrative action. IEMs will tender their advice on the complaints within 10 days as far as possible.
- 8.8 The CMD, BHEL shall decide the compensation to be paid to the Monitor and its terms and conditions.
- 8.9 IEM should examine the process integrity, they are not expected to concern themselves with fixing of responsibility of officers. Complaints alleging mala fide on the part of any officer of the organization should be looked into by the CVO of the concerned organisation.
- 8.10 If the Monitor has reported to the CMD, BHEL, a substantiated suspicion of an offence under relevant Indian Penal Code/ Prevention of Corruption Act, and the CMD, BHEL has not, within reasonable time, taken visible action to proceed against such offence or reported it to the Vigilance Office, the Monitor may also transmit this information directly to the Central Vigilance Commissioner, Government of India.
- 8.11 The number of Independent External Monitor(s) shall be decided by the CMD, BHEL.
- 8.12 The word 'Monitor' would include both singular and plural.

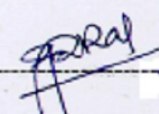
Section 9 - Pact Duration

- 9.1 This Pact shall be operative from the date IP is signed by both the parties till the final completion of contract for successful bidder and for all other bidders 6 months after the contract has been awarded. Issues like warranty / guarantee etc. should be outside the purview of IEMs.
- 9.2 If any claim is made/ lodged during currency of IP, the same shall be binding and continue to be valid despite the lapse of this pact as specified above, unless it is discharged/ determined by the CMD, BHEL.

Section 10 - Other Provisions

- 10.1 This agreement is subject to Indian Laws and jurisdiction shall be registered office of the Principal, i.e. New Delhi.

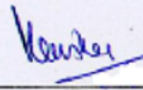
- 10.2 Changes and supplements as well as termination notices need to be made in writing. Side agreements have not been made.
- 10.3 If the Contractor is a partnership or a consortium, this agreement must be signed by all partners or consortium members.
- 10.4 Should one or several provisions of this agreement turn out to be invalid, the remainder of this agreement remains valid. In this case, the parties will strive to come to an agreement to their original intentions.
- 10.5 Only those bidders / contractors who have entered into this agreement with the Principal would be competent to participate in the bidding. In other words, entering into this agreement would be a preliminary qualification.


For & On behalf of the Principal
Y.V.R. RAO
By. Manager (OS)
Bharat Heavy Electricals Ltd.
HPVP, VISAKHAPATNAM-17
(Office Seal)

For & On behalf of the Bidder/
Contractor
(Office Seal)

Place: _____

Date: _____


Witness: _____
(Name & Address)
P. N. MURTHY
By. Manager (OS)
Bharat Heavy Electricals Ltd.
HPVP, Visakhapatnam-530 012

Witness: _____
(Name & Address) _____



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ELEVATION


DETAIL-A


35	1	LO STRIPPER VAP. RET.	12"	323.8	-- 25THK.	160 x 25	150	W.N./R.F.	4230	
32 I-J	2	DP TYPE LEVEL TRANSMITTER	3"	88.9	160 11.13	45 x 25	150	W.N./R.F.	4230	
31 A-C	3	PRESSURE CONNECTION	2"	60.3	160 8.74	--	300	W.N./R.F.	4180	
30 A-C	3	THERMOWELLS + (LIQUID SHIELD)	2 I/O*	50.8 (I.D.)	13.6	--	300	L.W.N./R.F.	4180	
25 A-D-K	5	MANHOLE + B.F. + DAWT	24"	610	-- 25THK.	300 x 25	150	W.N./R.F.	4280	
14	1	LCO PA RETURN	16"	406.4	-- 25THK.	200 x 25	150	W.N./R.F.	4280	
13	1	LCO STRIPPER VP. RET.	6"	168.3	80 10.97	85 x 25	150	W.N./R.F.	4230	
12A-B	2	LEAN OIL DRAW + VORTEX BREAKER	8"	219.1	80 12.70	110 x 25	150	W.N./R.F.	4230	
11	1	RICH OIL RETURN	14"	355.6	-- 25THK.	175 x 25	150	W.N./R.F.	4250	
9	1	VENT	2"	60.3	160 8.74	--	150	W.N./R.F.	SEE DRG.	
3	1	REFLUX IN	8"	219.1	80 12.70	110 x 25	150	W.N./R.F.	4230	
2	1	O.H. VAPOR+COMP. FLG.	96"	2438.4	50THK. SCH. 40	48THK.(MIN.) R.F.PAD WITH ± THK	--	W.N./R.F.	SEE DRG.	INSERT PL #4800 48THK MIN.
MARK NO.	QTY.	SERVICE	N.P.S.	O.D.	SCH. THK.	RATING WIDTH ± THK	CLASS	TYPE / FACE	PROJE.	REMARKS
NOZZLES (CS+HIC & NACE ZONE)										

TABLE OF NOZZLES AND FLANGESENGINEERING STANDARDS / SPECIFICATIONS / REFERENCE DRAWINGS

3	3-CL-010-U0216	DETAILS OF ANCHOR BOLTS FOR MAIN FRACTIONATOR(111-C-2101)
39	1-CL-010-U0205	DETAILS OF FOUNDATION TEMPLATE FOR MAIN FRACTIONATOR(111-C-2101)
38	1-CL-010-U0204	DETAILS OF ACCESS LADDERS FOR MAIN FRACTIONATOR(111-C-2101)
37	1-CL-010-U0203	DETAILS OF ACCESS LADDERS OF MAIN FRACTIONATOR(111-C-2101)
36	1-CL-010-U0202	GRATING DETAILS OF MAIN FRACTIONATOR(111-C-2101)
35	1-CL-010-U0201	GRATING DETAILS FOR MAIN FRACTIONATOR(111-C-2101)
34	1-CL-010-U0200	DETAILS OF PLATFORMS IN P22 SECTION FOR MAIN FRACTIONATOR(111-C-2101)
33	1-CL-010-U0199	DETAILS OF PLATFORMS IN P11 SECTION FOR MAIN FRACTIONATOR(111-C-2101)
32	1-CL-010-U0198	DETAILS OF PLATFORMS IN BQ SECTION FOR MAIN FRACTIONATOR(111-C-2101)
31	1-CL-010-U0197	DETAILS OF TRANSPORTATION OF MAIN FRACTIONATOR(111-C-2101)
30	1-CL-010-U0196	LIST OF SPARES OF MAIN FRACTIONATOR(111-C-2101)
29	1-CL-010-U0195	DETAILS OF PIPE DAVIT OF MAIN FRACTIONATOR(111-C-2101)
28	1-CL-010-U0194	DETAILS OF ACCESS OPENING OF MAIN FRACTIONATOR(111-C-2101)
27	1-CL-010-U0193	DETAILS OF NAME PLATE OF MAIN FRACTIONATOR(111-C-2101)
26	1-CL-010-U0192	GENERAL NOTES OF MAIN FRACTIONATOR(111-C-2101)
25	1-CL-010-U0191	ORIENTATION DETAILS OF MAIN FRACTIONATOR(111-C-2101)
24	1-CL-010-U0190	LIFTING DETAILS OF MAIN FRACTIONATOR(111-C-2101)
23	1-CL-010-U0189	ANCHOR CHAIR DETAILS OF MAIN FRACTIONATOR(111-C-2101)
22	0-CL-010-U0011	SHELL DEVELOPMENT OF P22 SECTION OF MAIN FRACTIONATOR(111-C-2101)
21	1-CL-010-U0188	MH Davit Details on P22 Section of Main Fractionator(111-C-2101)
20	1-CL-010-U0187	INSULATION & FIREPROOFING DETAILS ON P22 SECTION OF MAIN FRACTIONATOR(111-C-2101)
19	1-CL-010-U0186	PLATFORM CLEAT DETAILS ON P22 SECTION OF MAIN FRACTIONATOR(111-C-2101)
18	1-CL-010-U0185	PIPE SUPPORT CLEAT ON P22 SECTION OF MAIN FRACTIONATOR(111-C-2101)
17	1-CL-010-U0184	INTERNAL DETAILS IN P22 SECTION OF MAIN FRACTIONATOR(111-C-2101)
16	1-CL-010-U0183	ASSEMBLY DETAILS OF P22 SECTION OF MAIN FRACTIONATOR(111-C-2101)
15	0-CL-010-U0010	SHELL DEVELOPMENT OF P11 SECTION OF MAIN FRACTIONATOR(111-C-2101)
14	1-CL-010-U0182	MH DAVIT DETAILS ON P11 SECTION OF MAIN FRACTIONATOR(111-C-2101)
13	1-CL-010-U0181	INSULATION CLEAT DETAILS ON P11 SECTION OF MAIN FRACTIONATOR(111-C-2101)
12	1-CL-010-U0180	PLATFORM CLEAT DETAILS ON P11 SECTION OF MAIN FRACTIONATOR(111-C-2101)
11	1-CL-010-U0179	PIPE SUPPORT CLEAT ON P11 SECTION OF MAIN FRACTIONATOR(111-C-2101)
10	1-CL-010-U0178	INTERNAL DETAILS IN P11 SECTION OF MAIN FRACTIONATOR(111-C-2101)
9	1-CL-010-U0177	ASSEMBLY DETAILS OF P11 SECTION OF MAIN FRACTIONATOR(111-C-2101)
8	0-CL-010-U0009	SHELL DEVELOPMENT OF BQ SECTION OF MAIN FRACTIONATOR(111-C-2101)
7	1-CL-010-U0176	MH DAVIT DETAILS ON BQ SECTION OF MAIN FRACTIONATOR(111-C-2101)
6	1-CL-010-U0175	INSULATION CLEAT DETAILS ON BQ SECTION OF MAIN FRACTIONATOR(111-C-2101)
5	1-CL-010-U0174	PLATFORM CLEAT DETAILS ON BQ SECTION OF MAIN FRACTIONATOR(111-C-2101)
4	1-CL-010-U0173	PIPE SUPPORT CLEAT ON BQ SECTION OF MAIN FRACTIONATOR(111-C-2101)
3	1-CL-010-U0172	INTERNAL DETAILS IN BQ SECTION OF MAIN FRACTIONATOR(111-C-2101)
2	1-CL-010-U0171	ASSEMBLY DETAILS OF BQ SECTION OF MAIN FRACTIONATOR(111-C-2101)
1	1-CL-010-U0170	ASSEMBLY DETAIL OF MAIN FRACTIONATOR(111-C-2101)

**इंजीनियर्स
इंडिया लिमिटेड**
(भारत सरकार का उपक्रम)

 **ENGINEERS
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	CODE 031						
TITLE <div>GENERAL ASSEMBLY OF MAIN FRACTIONATOR (ITEM NO. 111-C-2101)</div>						DRAWING NO : 1-CL-010-U0169	REV A

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FORM NO. 0425/2

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ENGINEERS INDIA LIMITED

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इंजीनियर्स इंडिया लिमिटेड

ENGINEERS INDIA LIMITED

(भारत सरकार का उपक्रम)

(A Govt. of India Undertaking)

Customer :
HPCL Rajasthan Refinery Limited
Barmer

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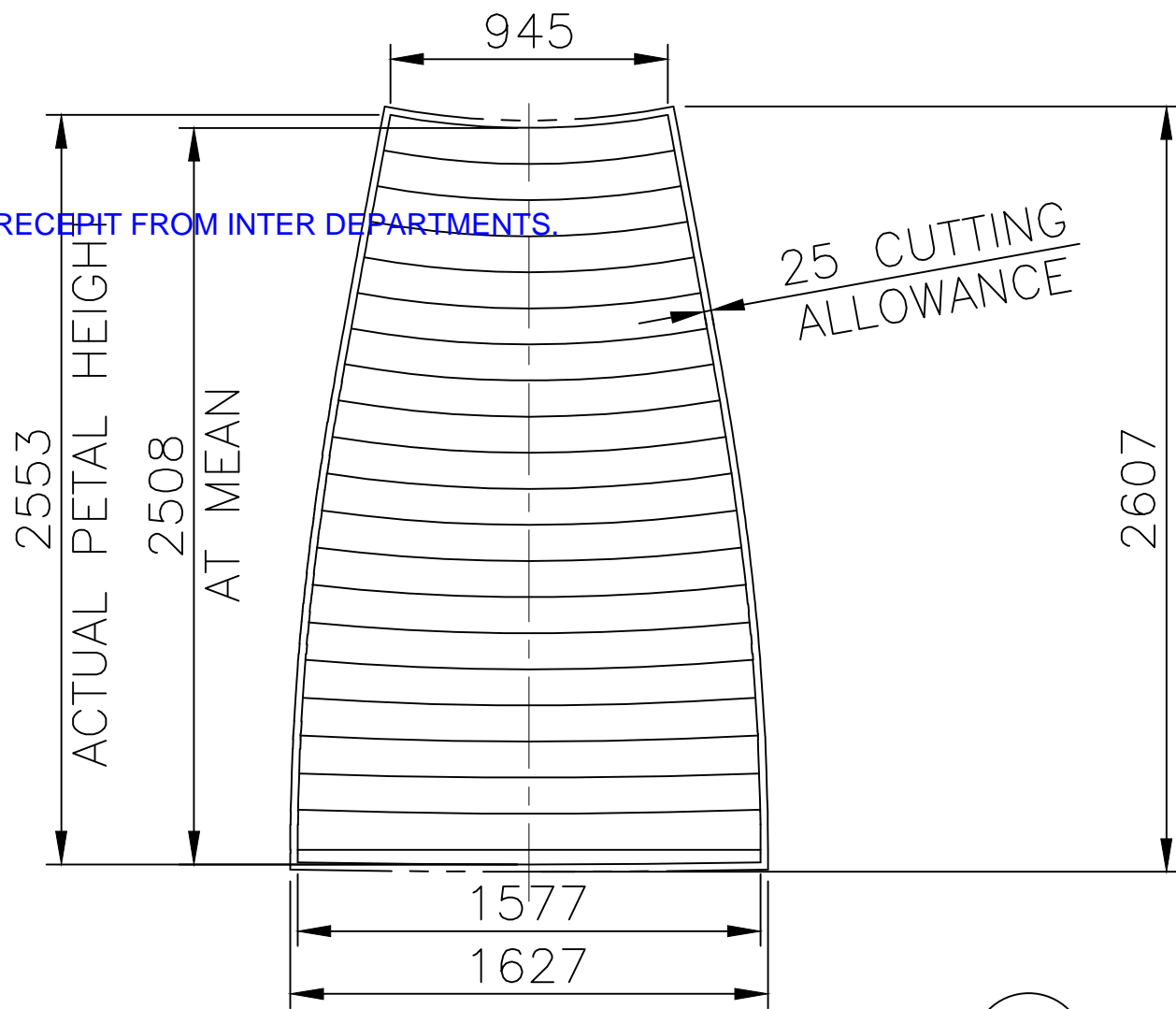
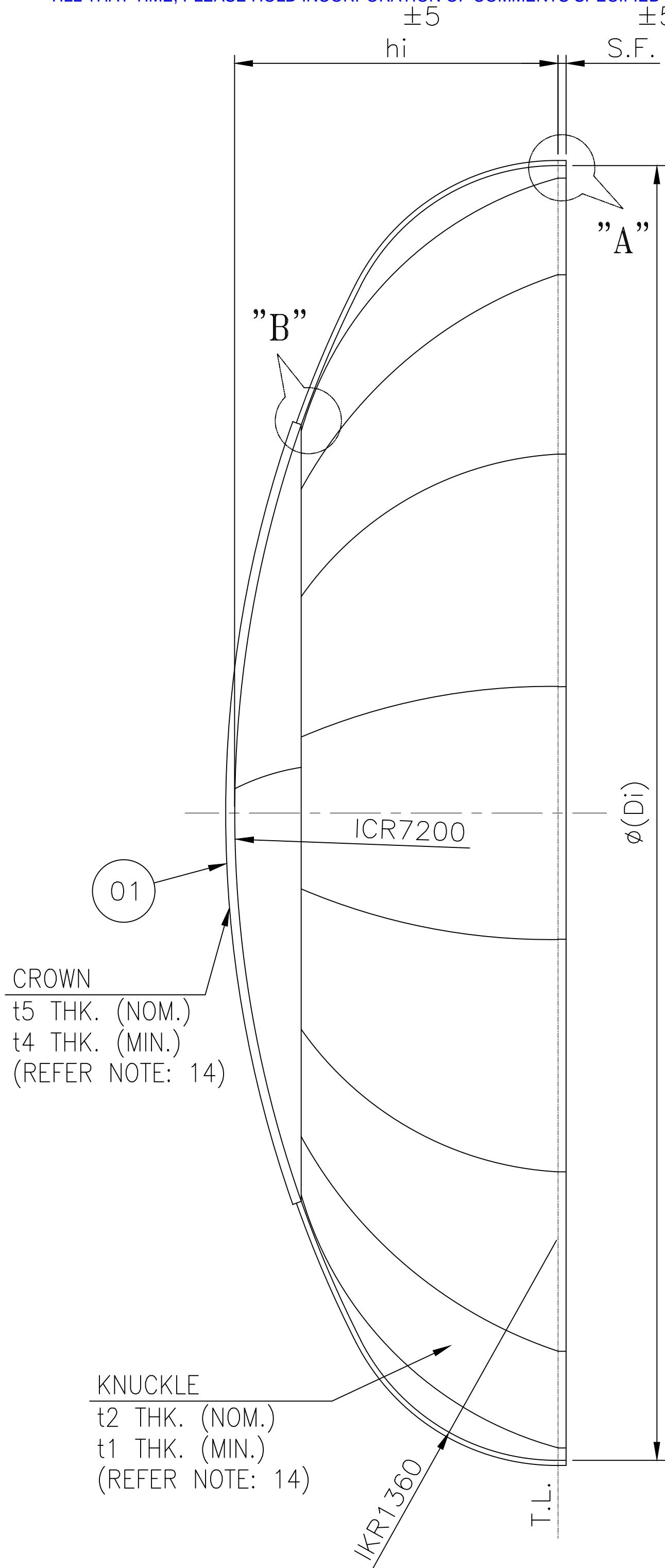
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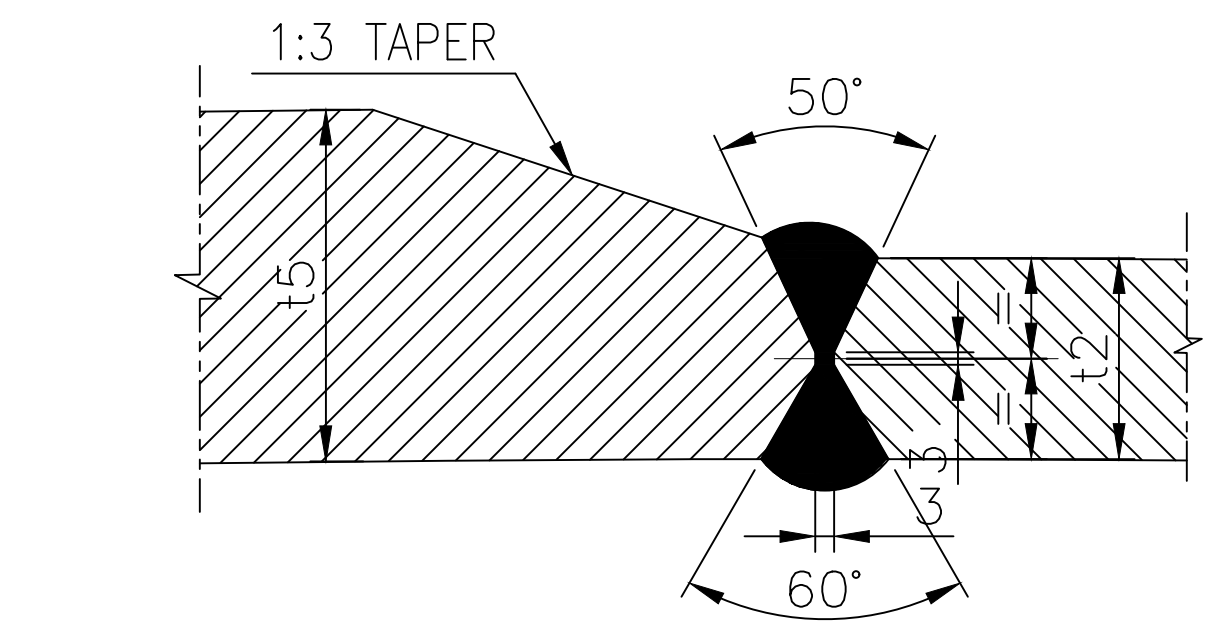
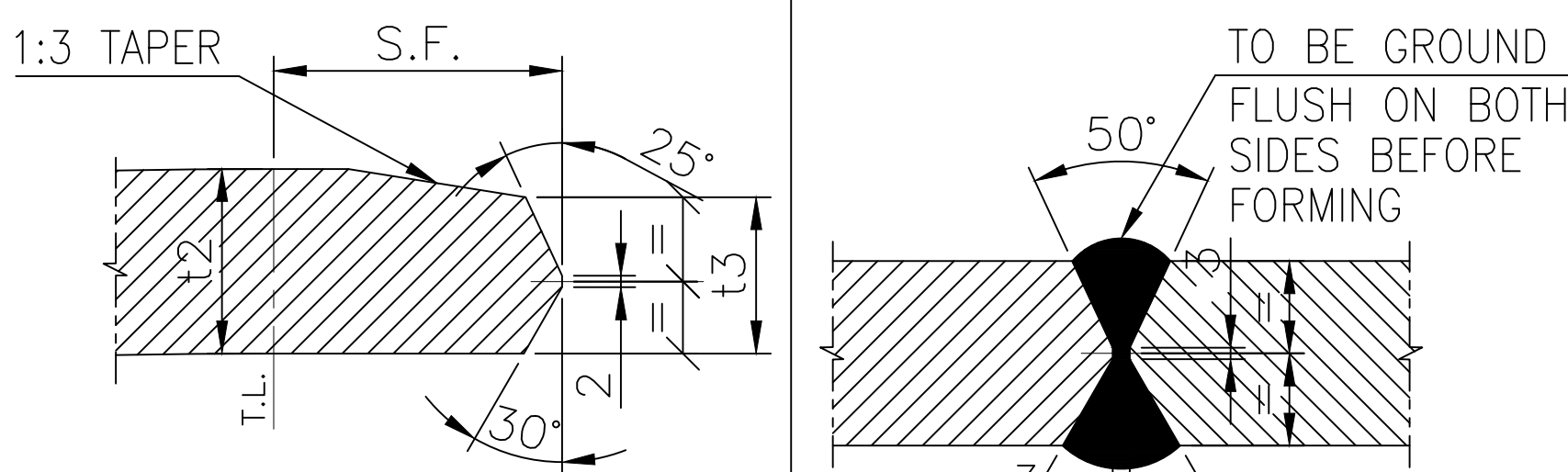
81Z0N-010-7C-3

ON DRAWING

DRG. IS SHARED TO INTER DEPRATMENTS OF BHEL-HPVP. COMMENTS (IF ANY) WILL BE SHARED AFTER RECEIPT FROM INTER DEPARTMENTS.
TILL THAT TIME, PLEASE HOLD INCORPORATION OF COMMENTS SPECIFIED HERE.



DETAIL OF PETAL (16 NOS.)
SCALE- 1:1



NOTES:-

- MATERIAL TO BE SA 516 Gr.60 (HIC+NACE) OF ASME SEC-II PART-A; 2017.
- DISHED END TO BE PREPARED USING COLD FORMED PETALS WITH FOLLOWING SCOPE OF WORK.
 - AT THE WORKS OF BHEL: PLATE TO BE SUPPLIED TO DISHED END VENDOR IN RECTANGULAR FORM (SUFFICIENT FOR MAKING THE PETALS.). BLANK IN CIRCULAR FORM (INCLUDING WELDING IF ANY) FOR MAKING THE TOP DISH (i.e. CROWN) ALSO TO BE SUPPLIED TO DISHED END VENDOR.
 - AT THE WORKS OF DISHED END VENDOR:
 - DETAIL DRAWING SHOWING THE DEVELOPMENT OF EACH PETAL, TOP DISH AND OTHER DETAILS INCLUDING ALL ASSOCIATED DIMENSIONS (MEETING THE END DIMENSION) TO BE FURNISHED TO BHEL FOR APPROVAL BEFORE PROCEEDING FOR MANUFACTURING. SKETCH OF PETAL AS SHOWN HERE IS FOR REFERENCE ONLY. BUT NO. OF PETALS AND CROWN DIA OF TOP DISHED END TO BE KEPT SAME AS ALREADY SHOWN.
 - PROCEDURE DULY APPROVED BY BHEL TO BE REFEREED FOR MATERIAL HANDLING, MARKING, MATERIAL CUTTING, PROTECTION WHILE FORMATION OF PETALS / DISH (IF ANY).
 - CUTTING OF PETALS FROM THE RECTANGULAR PLATES (AS RECEIVED FROM BHEL), FORMING OF PETALS & TOP DISH BY COLD FORMING.
 - EDGE PREPARATION OF PETALS, CROWN SHALL BE DONE AS SPECIFIED IN WLED DETAILS. WELD EDGE SHALL BE DP TESTED.
 - AFTER FORMING, ALL PETALS & TOP DISH TO BE 100% UT AS PER SA 578 LEVEL-B.
 - TRIAL ASSEMBLY TO CHECK THE FINISHED DIMENSIONS. INSPECTION REPORT SHOULD INDICATE THE PETAL IDENTIFICATION NOS. (SERIAL WISE) INCLUDING TOP DISH FOR A PARTICULAR DISHED END.
 - AFTER SUCCESSFUL TRIAL ASSEMBLY, EACH PETALS & TOP DISH TO BE IDENTIFIED WITH UNIQUE IDENTIFICATION NO. SO AS TO AVOID ANY AMBIGUITY AFTER GETTING IT RECEIPT AT BHEL FOR PROCESSING FURTHER (i.e. WELDING OF PETALS) TO MEET THE END DIMENSION.
 - INSPECTION AND NDT SHALL BE CARRIED OUT AS PER APPLICBALE QAP / ITP.
 - AT THE WORKS OF BHEL:
 - ARRANGING OF PETALS IN SEQUENCE INCLUSIVE OF TOP DISH TO MEET THE END DIMENSION.
 - WELDING SHALL BE CARRIEDOUT AS PER APPROVED WPS.
 - INSPECTION AND NDT SHALL BE CARRIED OUT AS PER ITP / QAP.
 - PMI TEST SHALL ALSO REQUIRED TO BE CARRIED OUT TO ENSURE CHEMICAL PROPERTIES OF THE WELD.
 - PERFORMING OF HEAT TREATMENT AS PER THE APPROVED PROCEDURE. SEE NOTE-3 BELOW ALSO.
 - COMPLETE DISHED END TO BE 100% UT AS PER SA 578 LEVEL-B.
 - EDGE PREP. AT SF IS REQUIRED AS PER DETAIL 'A' SHOWN.
 - INSIDE & OUTSIDE OF KNUCKLE AND EDGE PREPARATION TO BE DP TESTED FOLLOWED BY 100% RT FOR WELD SEAM.
- HEAT TREATMENT: (AT VENDOR WORKS)
 - DISHEND COMPONETS (PEALS & CROWN) SHALL BE SRESS RELIVED AFTER FORMING.
 - UT SHALL BE CARRIED OUT ON DISHEND COMPONENTS AFTER PFHT.
 - ACTUAL PFHT CYCLE WILL BE PROVIDED DURING DRAWING APPROVAL STAGE.
 - FOR TENDER PURPOSE, PFHT CYCLE SHALL BE CONSIDERED AS PER UCS-56 OF ASME SEC.VIII, DIV.1
- CENTER HOLE IF ANY ON DISHED END TO BE PLUGGED FOLLOWED BY 100% RT (TO BE DONE BY BHEL).
- PAINTING AFTER SURFACE CLEANING FOR PETALS & TOP DISHED END: ONE COAT OF RUST PREVENTIVE PAINT ON INSIDE & OUT SIDE SURFACE LEAVING 50 MM FROM EDGE.
- TOLERANCE: I) OVIALITY SHOULD NOT EXCEED 16MM OF DISHED END ID. (DIFFERENCE MAX. & MIN. I.D.).
II) MEASURED CIRCUMFERENCE SHOULD BE ± 0.8 OF CALCULATED CIRCUMFERENCE BASED ON I.D. SPECIFIED.
- CODE OF CONSTRUCTION ASME SECTION VIII DIV. 1; 2017.
- INSPECTION BY M/S BHEL / BHEL APPOINTED TPIA AND END CUSTOMER (IF ANY).
- WELDING SHALL BE AS PER APPROVED WPS:
- MATERIAL IDENTIFICATION NO. TO BE MAINTAINED AT D'END SUPPLIER'S END BEFORE DURING & AFTER FORMING OPERATION.
- DISHED END SUPPLIER TO FURNISH TEST CERTIFICATES INCLUDING (a) METHOD OF FORMING. CARRIED OUT IF ANY, (c) DIMENSIONAL REPORT INCLUDING MINIMUM THICKNESS, (d) NDE REPORTS & TRIAL ASSEMBLY CHECK. QAP DULY APPROVED BY BHEL SHALL ALSO REQUIRED TO BE REFERRED FOR OTHER DOCUMENTS.
- D'END SUPPLIER SHALL CONFIRM THAT THE PETALS AND THE TOP DISHED (AS SHALL BE SUPPLIED) SHALL MEET THE END DIMENSION AS SHOWN.
- $hi = Di / 4$.
- DP TEST & RT ALWAYS SHALL BE CARRIED OUT AS PER APPENDIX-B & UW-51 RESPECTIVELY OF ASME SECTION VIII DIVISION-I; 2017.

For Information: No need to blank, since, 96 Inch Nozzle is present at this location.

	02	TOP DISHED END KNUCKLE PETAL 32 THK. x 1627 x 2600		—		156021230000	KG	17048		
						SA 516 GR.60 (HIC + NACE)	NOS	16		
	01	TOP DISHED END CROWN PL. 56 THK. x B.D. 4913		—		1560 2122 0000	KG	8338		
						SA 516 GR.60 (HIC + NACE)	NOS	1		
NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO VAR NO	MATERIAL CODE	A/C/P	UNIT	UNIT WEIGHT	CS
						MATERIAL SPECN	D1	QUANTITY		

इंजीनियर्स
इंडिया लिमिटेड
(भारत सरकार का उपक्रम)


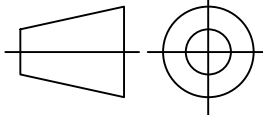
ENGINEERS
INDIA LIMITED
(A Govt. of India Undertaking)

Customer :



HPCL Rajasthan Refinery Limited
Barmer

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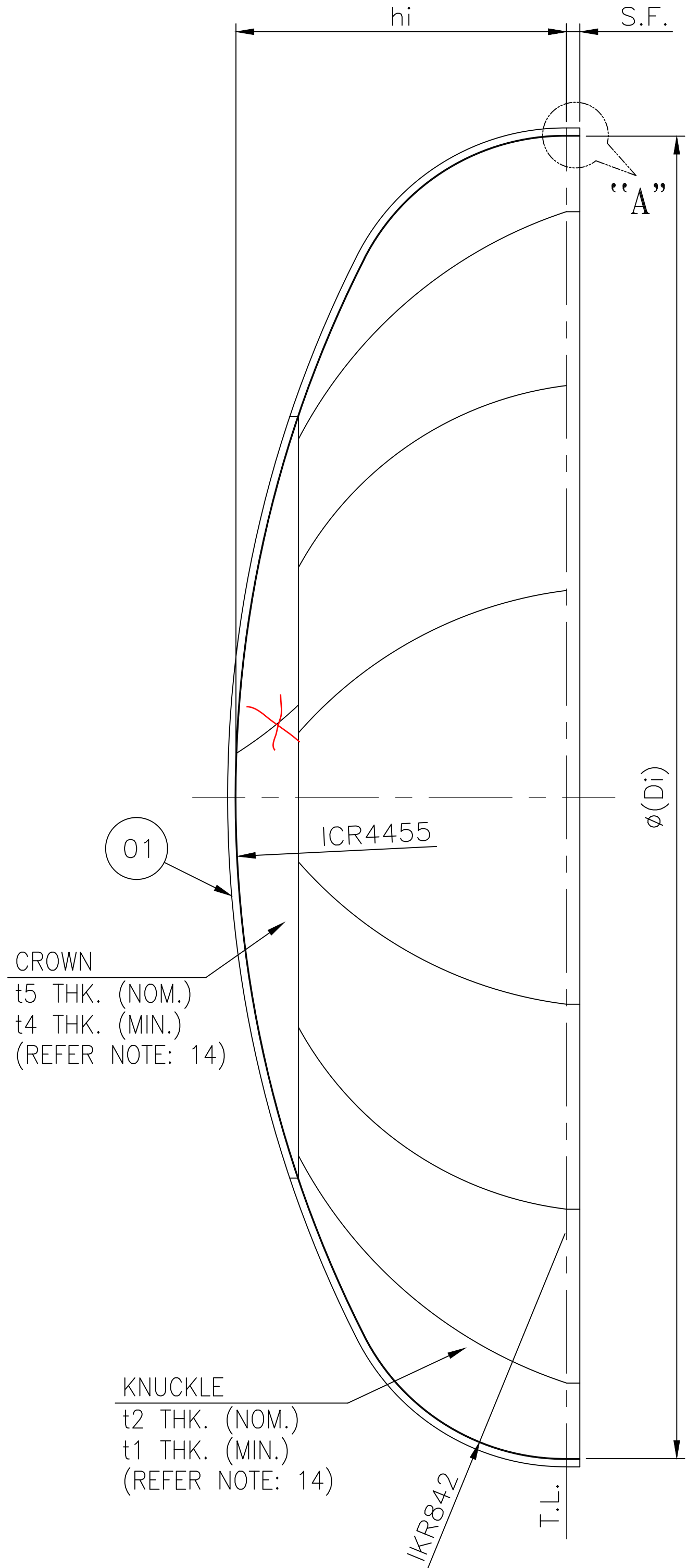
		Bharat Heavy Electricals Ltd UNIT: HEAVY PLATES & VESSELS PLANT VISAKHAPATNAM-530012			NAME		DATE
					DRN	GS.ENC	30.03.21
					CHD	D.SATISH	30.03.21
					APPD	D.SATISH	30.03.21
DEPT PP ENGG	ALL DIMENSIONS ARE IN MM		SCALE 1 : 50 & N.T.S	WEIGHT (Kg) —	REF TO ASSY / OLD DWG — —		
CODE 031							
TITLE <u>DETAIL OF TOP D'END FOR MAIN FRACTIONATOR (111-C-2101)</u>					DRAWING NO : 3-CL-010-U0218		REV A

01	111-C-2101	8000	26	32	50	25	-	-	~25386	1	$\phi 4800$	48	56	16
SR. NO.	EQUIPMENT NO.	ϕDi	t1 (MIN.)	t2 (NOM.)	SF	t3	X1	X2	WEIGHT (Kg.)	QTY.	CROWN ~ I.D.	t4 (MIN.)	t5 (NOM.)	~NO.OF PETALS
REV										DATE	DESCRIPTION	PPD	CHKD	APPD

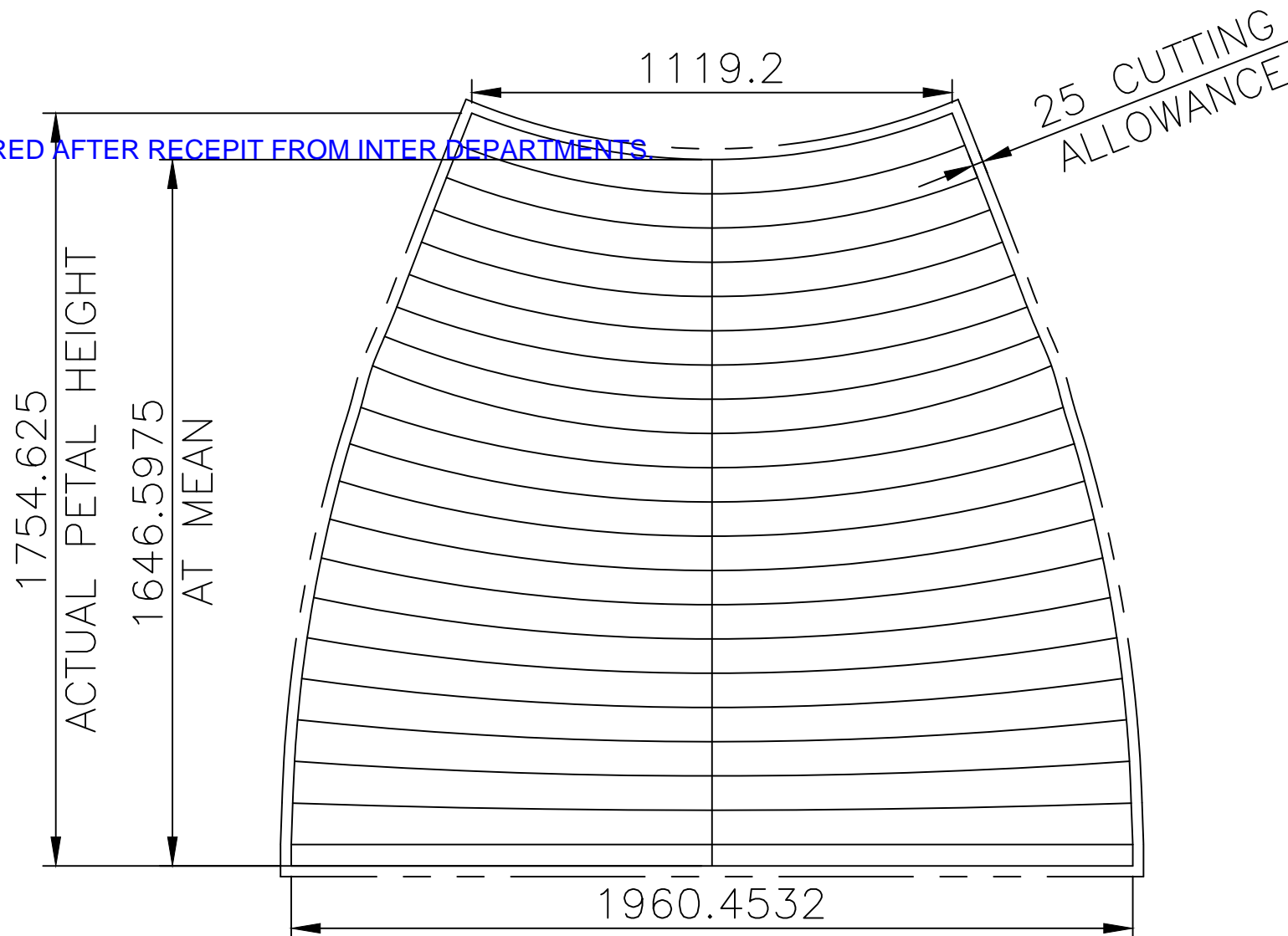
FORM NO. 0425/2

61200-010-70-2
DRAWING NO.

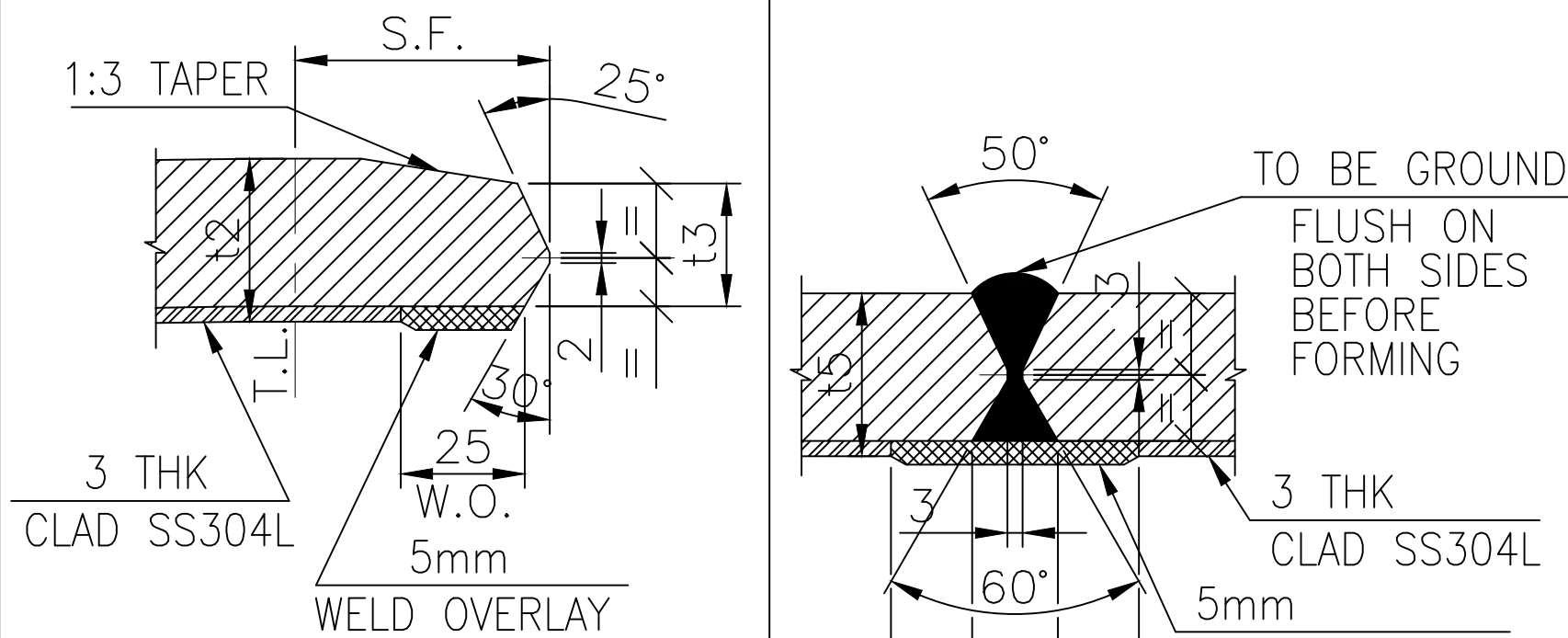
DRG. IS SHARED TO INTER DEPRATMENTS OF BHEL-HPVP. COMMENTS (IF ANY) WILL BE SHARED AFTER RECEIPT FROM INTER DEPARTMENTS. TILL THAT TIME, PLEASE HOLD INCORPORATION OF COMMENTS SPECIFIED HERE.



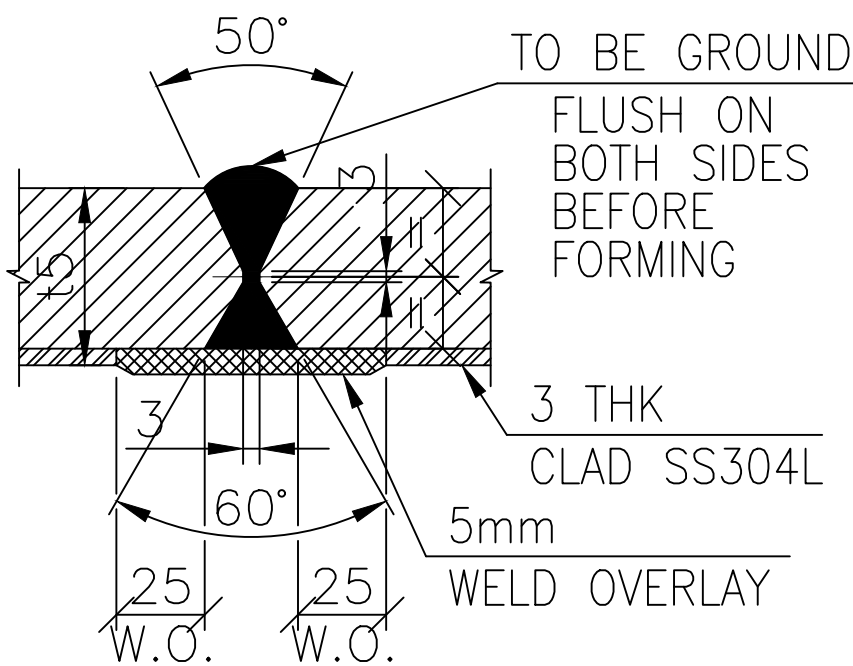
2:1 ELLIPSOIDAL D'END



DETAIL OF PETAL (8 NOS.)
SCALE- 1:1



DETAIL-\"A\"
WELD DETAIL FOR
DISH TO SHELL



WELD DETAIL OF PETAL
WELD DETAIL
DISH TO CROWN

01	111-C-2101	4950	24+3	28+3	50	24+3	—	—	~8702	1	ø2850	24+3	28+3	8	
SR. NO.	EQUIPMENT NO.	øDi	t1 (MIN.)	t2 (NOM.)	SF	t3	X1	X2	WEIGHT (Kg.)	QTY.	CROWN ~ I.D.	t4 (MIN.)	t5 (NOM.)	~NO.OF PETALS	
								REV	DATE	DESCRIPTION				PPD	C

NOTES:-

- MATERIAL TO BE SA 387 Gr.11 CL.2+3mm CLAD SS304L OF ASME SEC-II PART-A; 2017.
- DISHED END TO BE PREPARED USING COLD FORMED PETALS WITH FOLLOWING SCOPE OF WORK.
 - AT THE WORKS OF BHEL: PLATE TO BE SUPPLIED TO DISHED END VENDOR IN RECTANGULAR FORM (SUFFICIENT FOR MAKING THE PETALS.). BLANK IN CIRCULAR FORM (INCLUDING WELDING IF ANY) FOR MAKING THE BOTTOM DISH (i.e. CROWN) ALSO TO BE SUPPLIED TO DISHED END VENDOR.
 - AT THE WORKS OF DISHED END VENDOR:
 - DETAIL DRAWING SHOWING THE DEVELOPMENT OF EACH PETAL, BOTTOM DISH AND OTHER DETAILS INCLUDING ALL ASSOCIATED DIMENSIONS (MEETING THE END DIMENSION) TO BE FURNISHED TO BHEL FOR APPROVAL BEFORE PROCEEDING FOR MANUFACTURING. SKETCH OF PETAL AS SHOWN HERE IS FOR REFERENCE ONLY. BUT NO. OF PETALS AND CROWN DIA OF BOTTOM DISHED END TO BE KEPT SAME AS ALREADY SHOWN.
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 - CUTTING OF PETALS FROM THE RECTANGULAR PLATES (AS RECEIVED FROM BHEL), FORMING OF PETALS & BOTTOM DISH BY COLD FORMING.
 - EDGE PREPARATION OF PETALS, CROWN SHALL BE DONE AS SPECIFIED IN WLED DETAILS. WELD EDGE SHALL BE DP TESTED.
 - AFTER FORMING, ALL PETALS & BOTTOM DISH TO BE 100% UT AS PER SA 578 LEVEL-B.
 - TRIAL ASSEMBLY TO CHECK THE FINISHED DIMENSIONS. INSPECTION REPORT SHOULD INDICATE THE PETAL IDENTIFICATION NOS. (SERIAL WISE) INCLUDING BOTTOM DISH FOR A PARTICULAR DISHED END.
 - AFTER SUCCESSFUL TRIAL ASSEMBLY, EACH PETALS & BOTTOM DISH TO BE IDENTIFIED WITH UNIQUE IDENTIFICATION NO. SO AS TO AVOID ANY AMBIGUITY AFTER GETTING IT RECEIPT AT BHEL FOR PROCESSING FURTHER (i.e. WELDING OF PETALS) TO MEET THE END DIMENSION.
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 - FOR TENDER PURPOSE, PFTH CYCLE SHALL BE CONSIDERED AS PER UCS-56 OF ASME SEC.VIII, DIV.1
- CENTER HOLE IF ANY ON DISHED END TO BE PLUGGED FOLLOWED BY 100% RT (TO BE DONE BY BHEL).
- PAINTING AFTER SURFACE CLEANING FOR PETALS & TOP DISHED END: ONE COAT OF RUST PREVENTIVE PAINT ON INSIDE & OUT SIDE SURFACE LEAVING 50 MM FROM EDGE.
- TOLERANCE: i) OVALITY SHOULD NOT EXCEED 10MM OF DISHED END ID. (DIFFERENCE MAX. & MIN. I.D.).
ii) MEASURED CIRCUMFERENCE SHOULD BE -0 OF CALCULATED CIRCUMFERENCE BASED ON I.D. SPECIFIED.
- CODE OF CONSTRUCTION ASME SECTION VIII DIV. 1; 2017;⁶
- INSPECTION BY M/S BHEL / BHEL APPOINTED TPIA AND END CUSTOMER (IF ANY).
- WELDING SHALL BE AS PER APPROVED WPS:
- MATERIAL IDENTIFICATION NO. TO BE MAINTAINED AT D'END SUPPLIER'S END BEFORE DURING & AFTER FORMING OPERATION.
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- hi = Di / 4.
- DP TEST & RT ALWAYS SHALL BE CARRIED OUT AS PER APPENDIX-B & UW-51 RESPECTIVELY OF ASME SECTION VIII DIVISION-I; 2017.

NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO VAR NO	MATERIAL CODE MATERIAL SPECN	A/C/P D1	UNIT QUANTITY	GS
02		BOTTOM DISHED END KNUCKLE PETAL 28+3 THK.(CLAD) x 1812 x 2010	-			1560 2117 0000 SA387 Gr.11 CL.2+3mm CLAD SS304L	KG NOS	7090 8	
01		BOTTOM DISHED END CROWN PL. 28+3 THK.(CLAD) x B.D. 2900	-			1560 2117 0000 SA387 Gr.11 CL.2+3mm CLAD SS304L	KG NOS	1612 1	


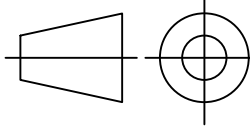
इंजीनियर्स
इंडिया लिमिटेड
(भारत सरकार का उपक्रम)

ENGINEERS
INDIA LIMITED
(A Govt. of India Undertaking)

Customer :

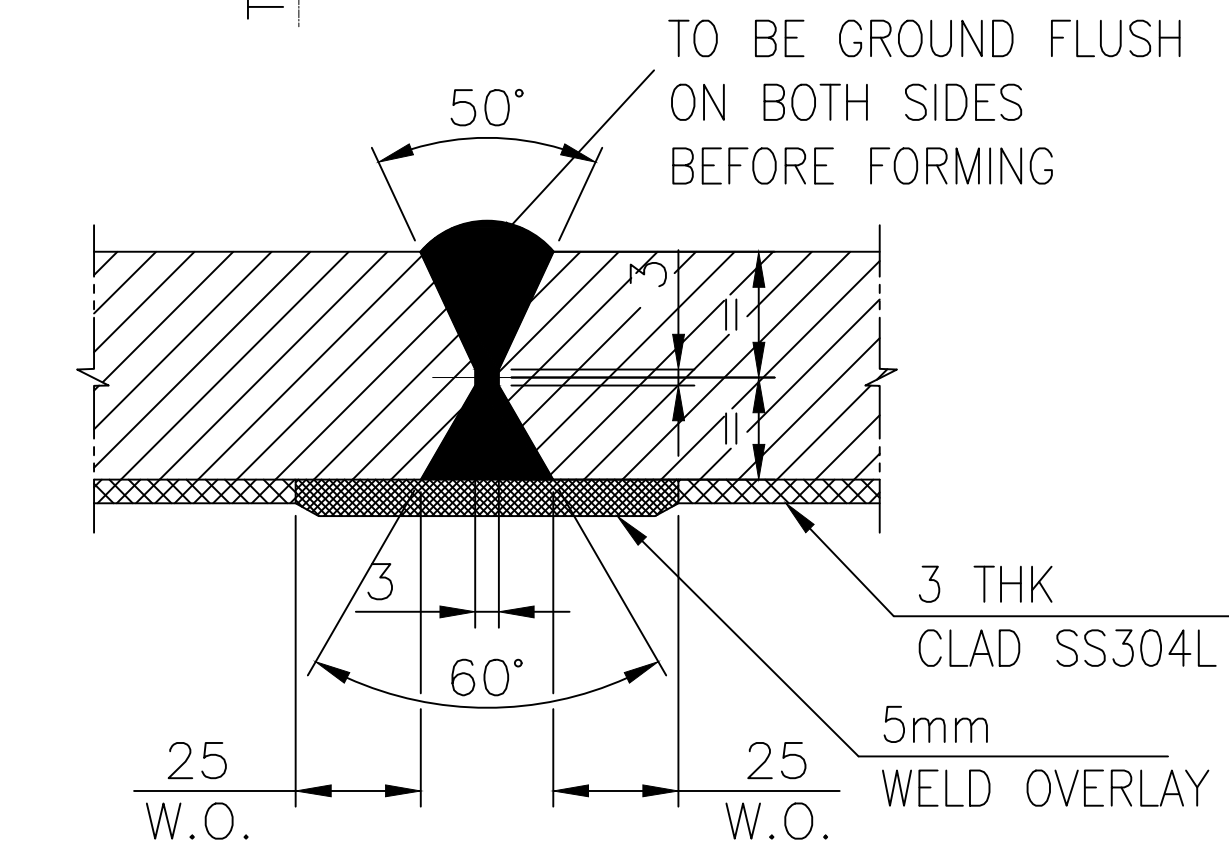
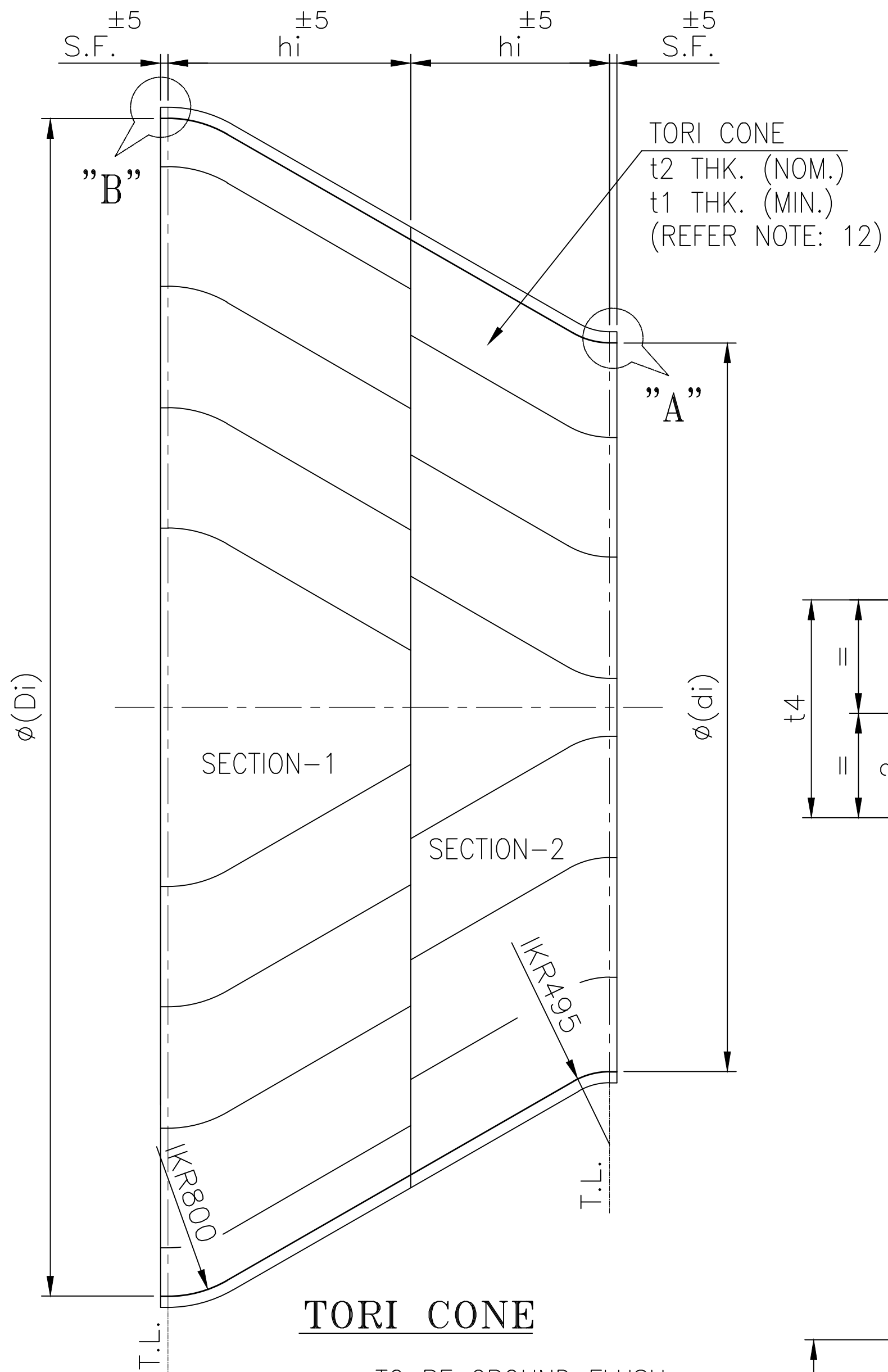
HPCL Rajasthan Refinery Limited
Barmer

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	Bharat Heavy Electricals Ltd					NAME		DATE
	UNIT: HEAVY PLATES & VESSELS PLANT VISAKHAPATNAM-530012					DRN	GS.ENC	30.03.21
						CHD	D.SATISH	30.03.21
						APPD	D.SATISH	30.03.21
DEPT PP ENGG	ALL DIMENSIONS ARE IN MM		SCALE 1 : 30 & N.T.S	WEIGHT (Kg) —	REF TO ASSY / OLD DWG			
CODE 031					—			
TITLE					DRAWING NO :		REV	
<u>DETAIL OF BOTTOM D'END FOR MAIN FRACTIONATOR (111-C-2101)</u>					3-CL-010-U0219		A	

3-CL-010-U0220

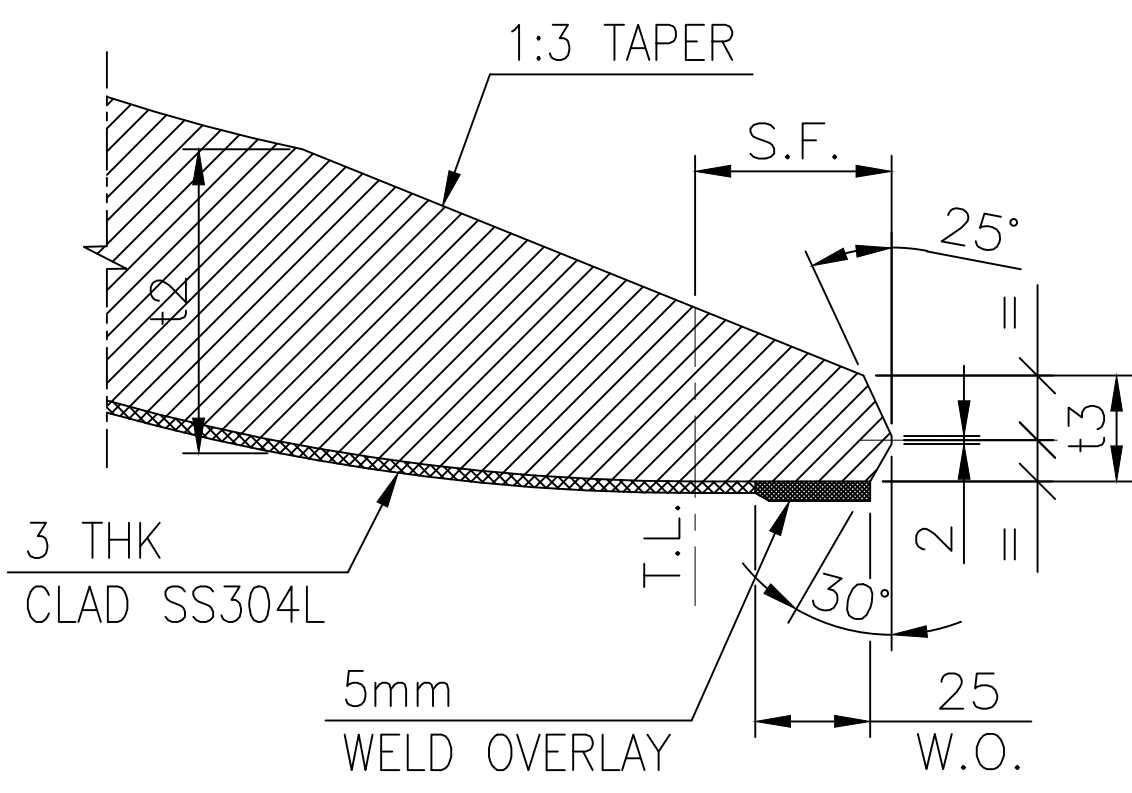
DRAWING NO.



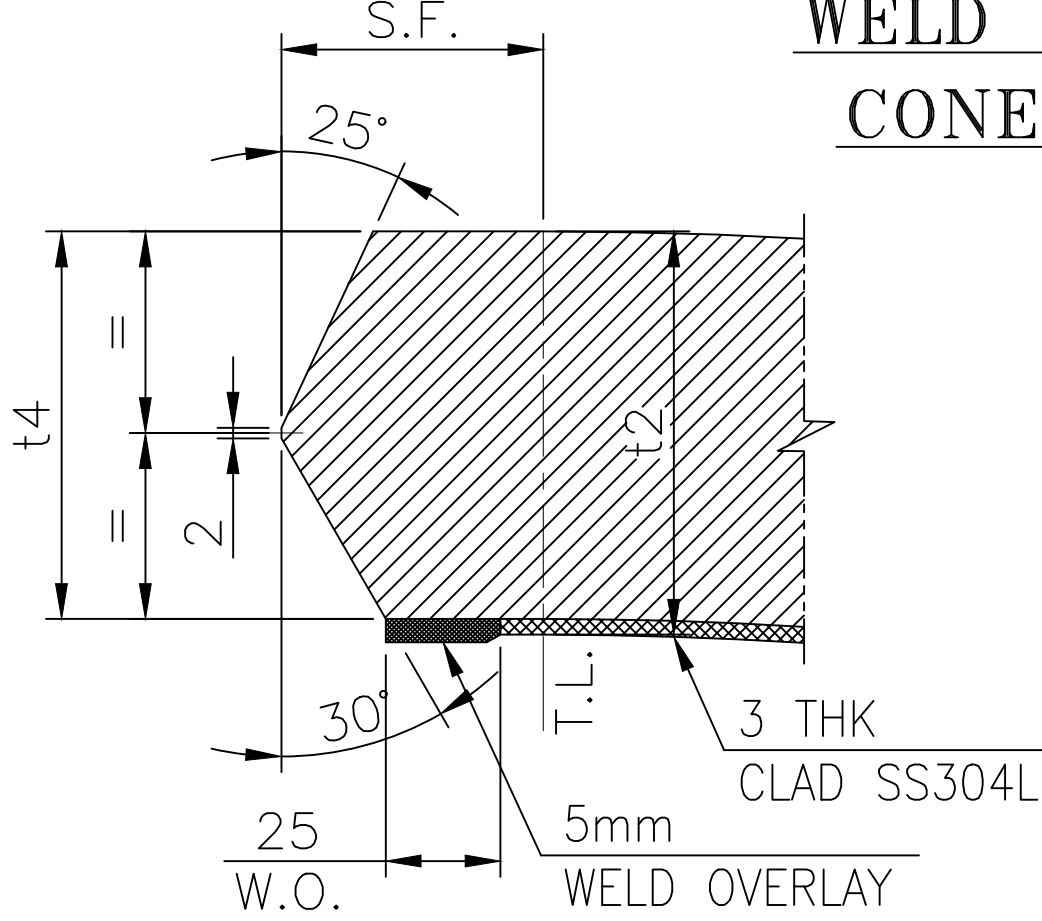
WELD DETAIL OF PETAL

02	111-C-2101	6350	4950	1350	60+3	74+3	160	24+3	74+4	20009	1	-	10
01	111-C-2101	8000	6350	1650	60+3	74+3	50	24+3	74+4	31356	1	16	-
SR. NO.	EQUIPMENT NO.	øDi	ødi	hi	t1 (MIN.)	t2 (NOM.)	SF	t3	t4	WEIGHT (Kg.)	QTY.	~NO.OF PETALS (SECTION-1)	~NO.OF PETALS (SECTION-2)

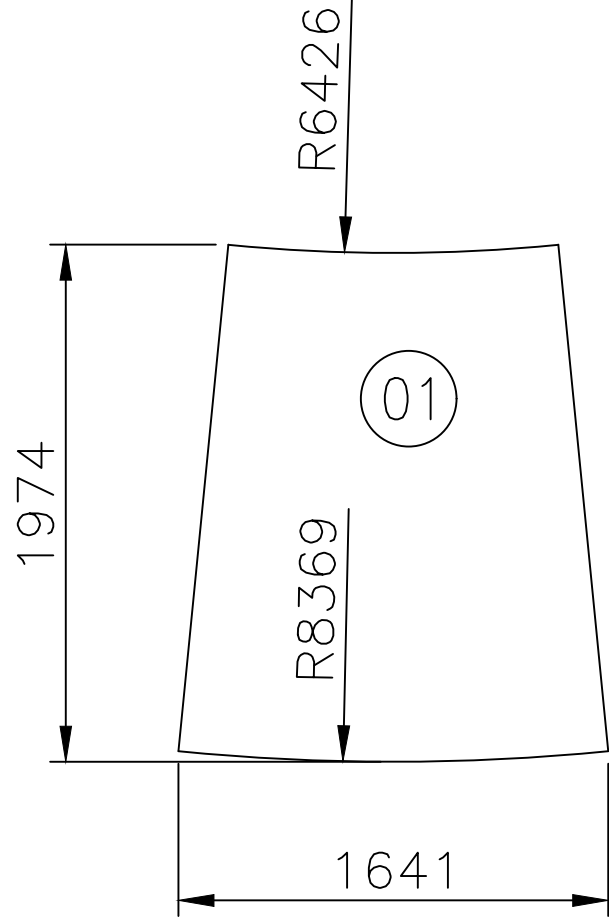
REV	DATE	DESCRIPTION	PPD	CHKD	APPD
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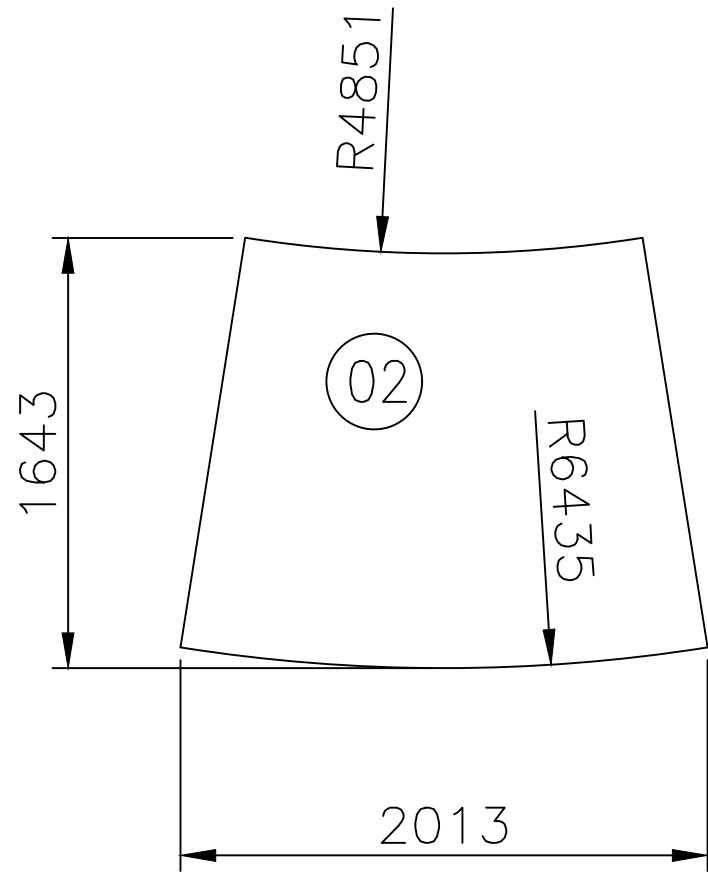
DETAIL-A
WELD DETAIL FOR
CONE TO SHELL



DETAIL-B
WELD DETAIL FOR
CONE TO SHELL



SECTION-1 PETAL
QTY.-16 NOS.



SECTION-2 PETAL
QTY.-10 NOS.

NOTES:-

- MATERIAL TO BE SA 387 Gr.22 CL.2+3mm CLAD SS304L OF ASME SEC-II PART-A; 2017.
- TORI CONE TO BE PREPARED USING COLD FORMED PETALS WITH FOLLOWING SCOPE OF WORK.
 - AT THE WORKS OF BHEL: PLATE TO BE SUPPLIED TO TORI CONE VENDOR IN RECTANGULAR FORM (SUFFICIENT FOR MAKING THE PETALS.).
 - AT THE WORKS OF TORI CONE VENDOR:
 - DETAIL DRAWING SHOWING THE DEVELOPMENT OF EACH PETAL FOR TORI CONE OTHER DETAILS INCLUDING ALL ASSOCIATED DIMENSIONS (MEETING THE END DIMENSION) TO BE FURNISHED TO BHEL FOR APPROVAL BEFORE PROCEEDING FOR MANUFACTURING. SKETCH OF PETAL AS SHOWN HERE IS FOR REFERENCE ONLY. BUT NO. OF PETALS OF TORI CONE TO BE KEPT SAME AS ALREADY SHOWN.
 - PROCEDURE DULY APPROVED BY BHEL TO BE REFERRED FOR MATERIAL HANDLING, MARKING, MATERIAL CUTTING, PROTECTION WHILE FORMATION OF PETALS FOR TORI CONE (IF ANY).
 - CUTTING OF PETALS FROM THE RECTANGULAR PLATES (AS RECEIVED FROM BHEL), FORMING OF PETALS FOR TORI CONE BY COLD FORMING.
 - EDGE PREPARATION OF PETALS SHALL BE DONE AS SPECIFIED IN WLED DETAILS. WELD EDGE SHALL BE DP TESTED.
 - AFTER FORMING, ALL PETALS OF TORI CONE TO BE 100% UT AS PER SA 578 LEVEL-B.
 - TRIAL ASSEMBLY TO CHECK THE FINISHED DIMENSIONS. INSPECTION REPORT SHOULD INDICATE THE PETAL IDENTIFICATION NOS. (SERIAL WISE) FOR TORI CONE ASSEMBLY.
 - AFTER SUCCESSFUL TRIAL ASSEMBLY, EACH PETALS OF TORI CONE TO BE IDENTIFIED WITH UNIQUE IDENTIFICATION NO. SO AS TO AVOID ANY AMBIGUITY AFTER GETTING IT RECEIPT AT BHEL FOR PROCESSING FURTHER (i.e. WELDING OF PETALS) TO MEET THE END DIMENSION.
 - INSPECTION AND NDT SHALL BE CARRIED OUT AS PER APPLICBALE QAP / ITP.
 - AT THE WORKS OF BHEL:
 - ARRANGING OF PETALS OF TORI CONE IN SEQUENCE TO MEET THE END DIMENSION.
 - WELDING SHALL BE CARRIEDOUT AS PER AAPROVED WPS.
 - INSPECTION AND NDT SHALL BE CARRIED OUT AS PER ITP / QAP.
 - PMI TEST SHALL ALSO REQUIRED TO BE CARRIED OUT TO ENSURE CHEMICAL PROPERTIES OF THE WELD.
 - PERFORMING OF HEAT TREATMENT AS PER THE APPROVED PROCEDURE. SEE NOTE-3 BELOW ALSO.
 - COMPLETE TORI CONE TO BE 100% UT AS PER SA 578 LEVEL-B.
 - EDGE PREP. AT SF IS REQUIRED AS PER DETAIL 'A' SHOWN.
 - INSIDE & OUTSIDE OF KNUCKLE AND EDGE PREPARATION TO BE DP TESTED FOLLOWED BY 100% RT FOR WELD SEAM.
- HEAT TREATMENT: (AT VEDNOR WORKS)
 - TORI CONE COMPONETS (PEALS) SHALL BE SRESS RELIVED AFTER FORMING.
 - UT SHALL BE CARRIED OUT ON TORI CONE COMPONENTS AFTER PFHT.
 - ACTUAL PFHT CYCLE WILL BE PROVIDED DURING DRAWING APPROVAL STAGE.
 - FOR TENDER PURPOSE, PFTH CYCLE SHALL BE CONSIDERED AS PER UCS-56 OF ASME SEC.VIII, DIV.1
- PAINING AFTER SURFACE CLEANING FOR PETALS & TOP DISHED END: ONE COAT OF RUST PREVENTIVE PAINT ON INSIDE & OUT SIDE SURFACE LEAVING 50 MM FROM EDGE.
- TOLERANCE: I) OVALITY SHOULD NOT EXCEED 10MM OF TORI CONE ID. (DIFFERENCE MAX. & MIN. I.D.).
II) MEASURED CIRCUMFERENCE SHOULD BE $\begin{matrix} -0 \\ +6 \end{matrix}$ OF CALCULATED CIRCUMFERENCE BASED ON I.D. SPECIFIED.
- CODE OF CONSTRUCTION ASME SECTION VIII DIV. 1; 2017.
- INSPECTION BY M/S BHEL / BHEL APPOINTED TPIA AND END CUSTOMER (IF ANY).
- WELDING SHALL BE AS PER APPROVED WPS:
- MATERIAL IDENTIFICATION NO. TO BE MAINTAINED AT D'END SUPPLIER'S END BEFORE DURING & AFTER FORMING OPERATION.
- TORI CONE SUPPLIER TO FURNISH TEST CERTIFICATES INCLUDING (a) METHOD OF FORMING. CARRIED OUT IF ANY, (c) DIMENSIONAL REPORT INCLUDING MINIMUM THICKNESS, (d) NDE REPORTS & TRIAL ASSEMBLY CHECK. QAP DULY APPROVED BY BHEL SHALL ALSO REQUIRED TO BE REFERRED FOR OTHER DOCUMENTS.
- TORI CONE SUPPLIER SHALL CONFIRM THAT THE TORI CONE (AS SHALL BE SUPPLIED) SHALL MEET THE END DIMENSION AS SHOWN.
- DP TEST & RT ALWAYS SHALL BE CARRIED OUT AS PER APPENDIX-B & UW-51 RESPECTIVELY OF ASME SECTION VIII DIVISION-I; 2017.

	02	TORI CONE SECTION-2 PETAL	-		156021210000		20009			
		74+4 THK. x 2013 x 1643			SA387 Gr.22 CL.2+3mm CLAD SS304L		10			
	01	TORI CONE SECTION-1 PETAL	-		156021210000		31356			
		74+4 THK. x 1641 x 1974			SA387 Gr.22 CL.2+3mm CLAD SS304L		16			
VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO	MATERIAL CODE	A/C/P	UNIT	UNIT WEIGHT	GS
					VAR NO	MATERIAL SPECN		D1	QUANTITY	


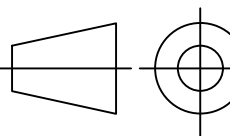


ENGINEERS INDIA LIMITED
(A Govt. of India Undertaking)

Customer :



HPCL Rajasthan Refinery Limited
Barmar

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.			Bharat Heavy Electricals Ltd UNIT: HEAVY PLATES & VESSELS PLANT VISAKHAPATNAM-530012			DRN	NAME	DATE
						CHD	D.SATISH	30.03.21
						APPD	D.SATISH	30.03.21
	DEPT PP ENGG	ALL DIMENSIONS ARE IN MM		SCALE 1 : 60 & N.T.S	WEIGHT (Kg) —	REF TO ASSY / OLD DWG — —		
CODE 031								
TITLE <u>DETAIL OF TORI CONE FOR MAIN FRACTIONATOR (111-C-2101)</u>						DRAWING NO : 3-CL-010-U0220		REV A

FORM NO. 0425/2



JOB NO: कार्य सख्या	B224	UNIT NO: युनिट सख्या	1
CLIENT : क्लाईट	 M/S HRRL, RAJASTHAN		
PLANT : प्लांट	RAJASTHAN REFINERY PROJECT		

A	23.08.2019	ISSUED FOR ENGG/BIDS		AKP	NNM/RKM	KJH
REV	DATE	REVISION		BY	CHECKED	APPROVED

DESIGN DATA		डिजाइन डेटा		DRAWING NUMBER		REV	
MAIN FRACTIONATOR		मेन फ्रैक्शनेटर		डाईंग नम्बर			
				B224-111-80-43-DS-3001		A	
ITEM NO. : 111-C-2101		आइटम नम्बर : 111-सी-2101		SHEET 1 OF 7			

@ 5 mm MINIMUM SS 304L WELD OVERLAY
(FOR MIN. 3 mm UNDILUTED SS304L
CHEMISTRY)

FORMAT NO.3-1646-0113 REV.2 (20.09.2011) A3-420 X 297

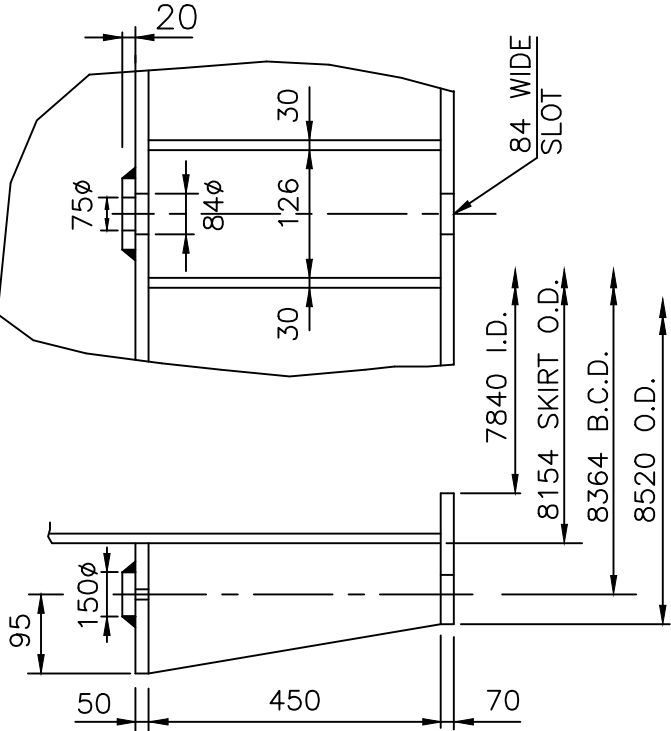
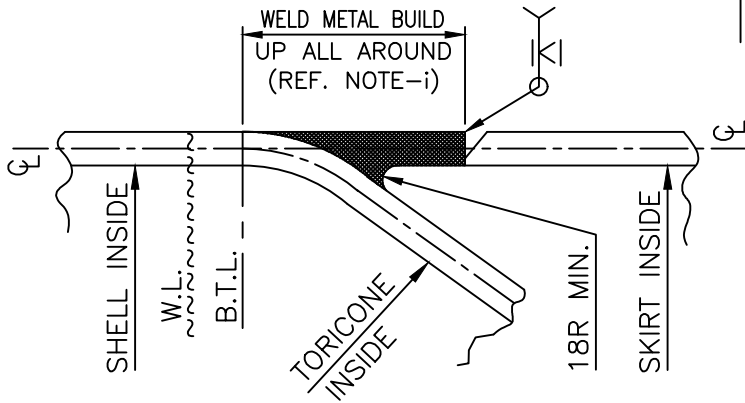
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NOZZLES AND CONNECTIONS (नोजल व कनेक्शन) (2.25 Cr.+1 MO+CLAD ZONE)										GENERAL NOTES (जनरल नोट्स)				SPECIFICATIONS (स्पेसिफिकेशन्स)				DESIGN DATA (डिजाइन डेटा)			
MARK	QTY	NOM. DIA (INCH)	SCH./THK.	FLANGES			PROJECTION NOTE-4	PAD WxT	SERVICE	UNLESS STATED OTHER WISE				X DENOTES APPLICABILITY		CODE		ASME SEC.VIII DIV.-1 (LATEST)			
मार्क	क्वांटिटी	नॉमिनल डायामिटर (इंच)	शेड्यूल व थिकनेस	क्लास	टाइप	फेसिंग	प्रोजेक्शन	पैड	सर्विस												
1 A-B	2	72		REFER SHT.-7						FEED (NOTE-24 & 37)+COMP. FLG.+SPACER/ BLIND											
20	1	6	REF. SHT.-7	300	SRWN	RF	REF. SHT.-7	-	QUENCH RETURN												
25I	1	24	REF. SHT.-7	300	SRWN	RF	REF. SHT.-7	-	MANHOLE + B.F. + DAVIT												
30J-L	3	3 I/D	@	300	SRLWN	RF	REF SHT.7	-	THERMOWELLS (LIQUID SHIELD)												
31H	1	3 I/D	@	300	SRLWN	RF	REF SHT.7	-	PRESSURE CONNECTION (NOTE-42)												

FILE NAME : B224-111-80-43-DS-3001-4-A

NOTE:-

- (i) THE JOINT BETWEEN THE SUPPORT SKIRT & BOTTOM HEAD SHALL HAVE THE SMOOTH STREAMLINE GEOMETRY AS SHOWN. THE JOINT DETAIL SHALL BE MADE BY WELD METAL BUILD UP ALL AROUND (REF. NOTE-i) WELDS SHALL BE GROUND OR MACHINED TO A SMOOTH, FLUSH CONTOUR. 100% MAGNETIC PARTICLE EXAMINATION OF ALL WELD SURFACES (INSIDE & OUTSIDE) SHALL BE PERFORMED AFTER FINAL POST WELD HEAT TREATMENT. 100% ULTRASONIC EXAMINATION SHALL BE CARRIED OUT ON WELD BUILT-UP AFTER COMPLETION AND AFTER FINAL PWHT.

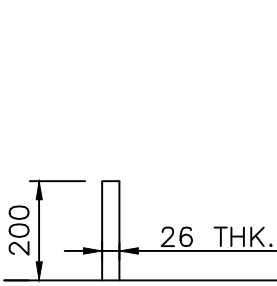
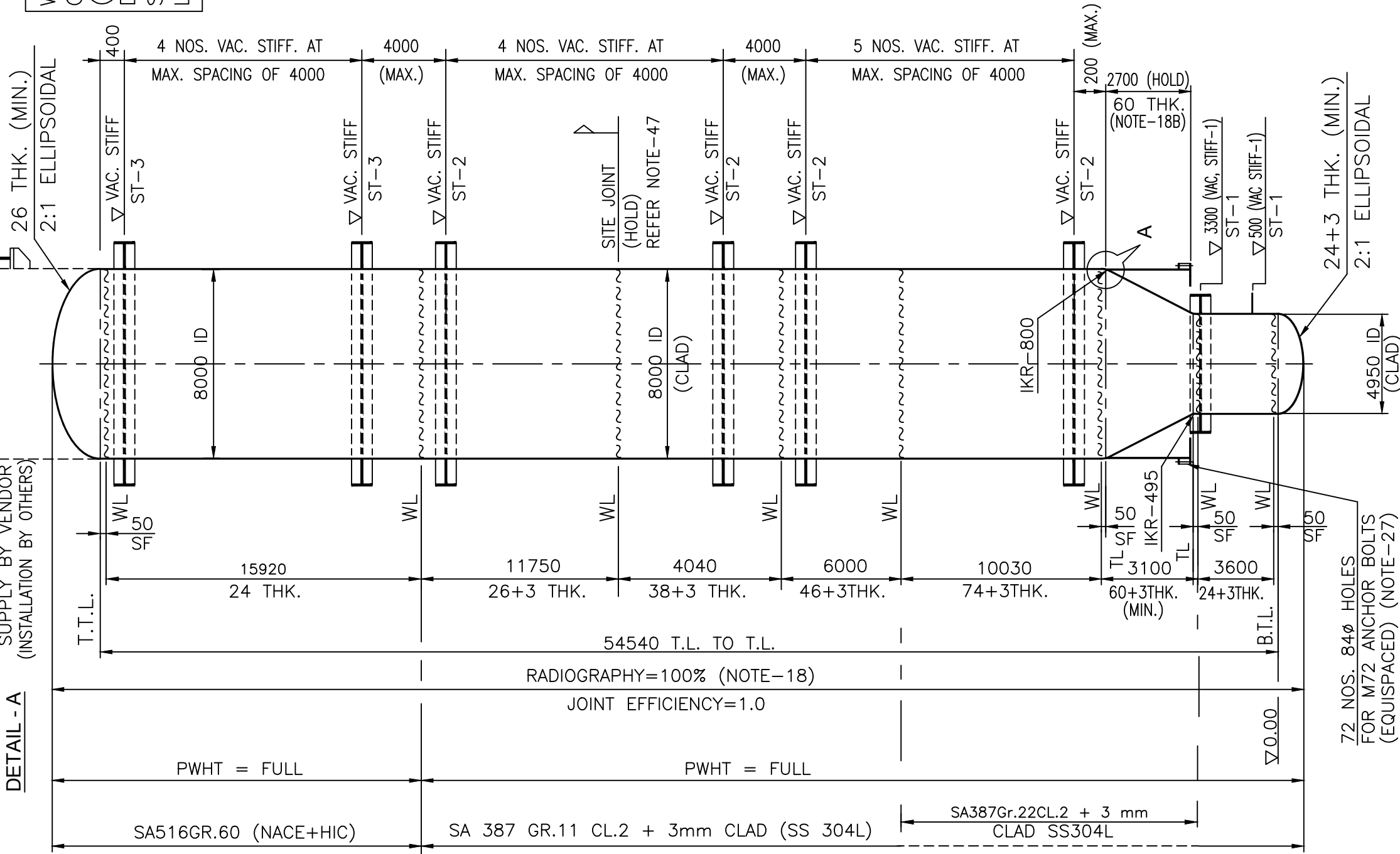


SKIRT BASE DETAIL

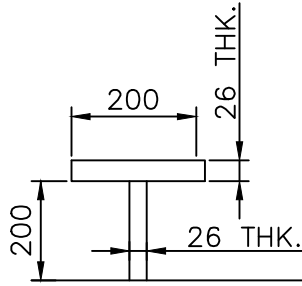
STRUCTURE
SUPPLY BY VENDOR
(INSTALLATION BY OTHERS)

DETAIL - A

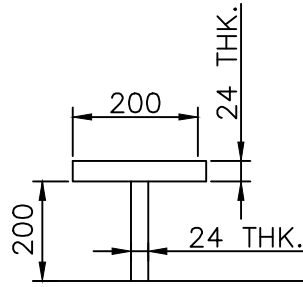
WFMT SHALL BE CARRIED OUT ON ALL WELD SEAMS OF CS (NACE+HIC) SECTION & TOP DISH HEAD INCLUDING L & C SEAM OF CS (NACE+HIC) AND LAS+CLAD SECTION AFTER PWHT.



DETAIL OF STIFFENERS (TYP.)
(ST-1)



DETAIL OF STIFFENERS (TYP.)
(ST-2)



DETAIL OF STIFFENERS (TYP.)
(ST-3)

OSLksy fMtkbu MkVl



ENGINEERS INDIA LIMITED
NEW DELHI

JOB NO. : B224, UNIT NO. : 111
CLIENT : HRRL, RAJASTHAN
PLANT : RAJASTHAN REFINERY PROJECT

REV.	DATE	REVISION	BY	CHK	APPROVED	APPROVED	
A	23.08.2019	ISSUED FOR ENGG/BIDS	AKP	NNM/RKM	KJH		

VESSEL DESIGN DATA
MAIN FRACTIONATOR
TEM NO. : 111-C-210

मेन फ्रैक्शनैटर
आइटम नम्बर : 111-सी-2101

DRAWING NO.

B224-111-80-43-DS-3001 A

SHEET 4 OF 7

REV.



ENGINEERS INDIA LIMITED
NEW DELHI

JOB NO. : B224, UNIT NO. : 111
CLIENT : HRRL, RAJASTHAN
PLANT : RAJASTHAN REFINERY PROJECT

REV.	A	23.08.2019	ISSUED FOR ENGG./BIDS	REVISION	BY	AKP	NNM/RKM	KJH	APPROVED	APPROVED

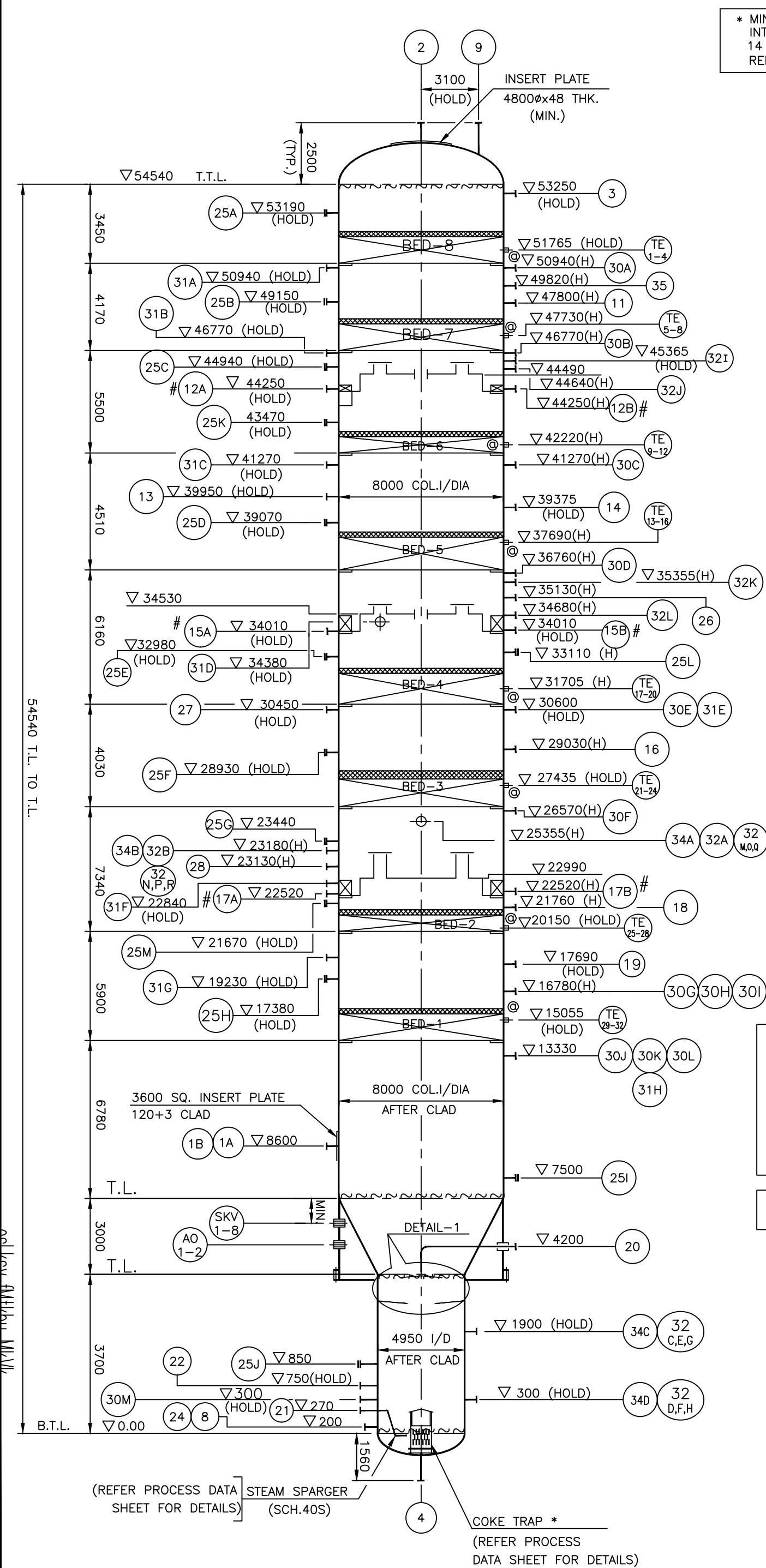
VESSEL DESIGN DATA
MAIN FRACTIONATOR

ITEM NO. 111-C-2101
B224-111-80-43-DS-3001 A

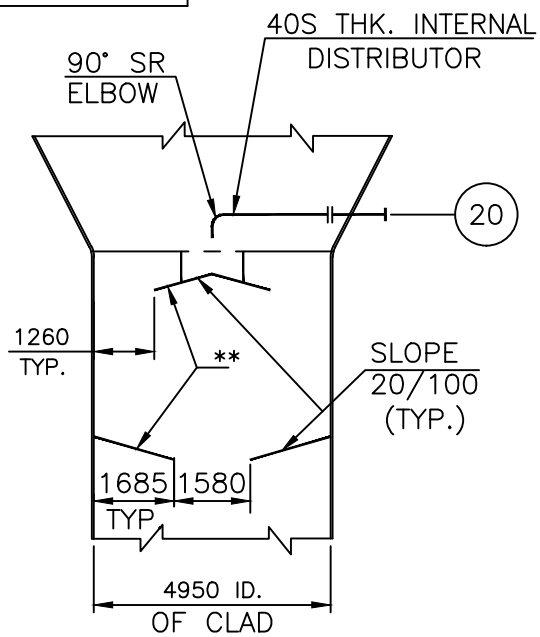
DRAWING NO. REV.
SHEET 5 OF 7

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FILE NAME : B224-111-80-43-DS-3001-5-A



* MIN. THK. OF SS304L
INTERNALS SHALL BE
14 THK.
REFER NOTE-22



DETAIL-1
** REFER PROCESS DATA SHEET

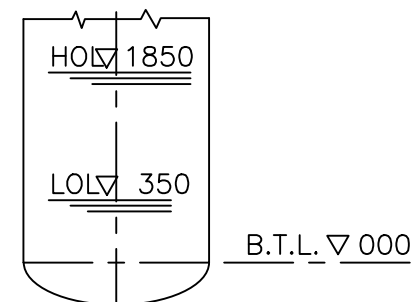
@ 1/2" STUD BOLT & 1 1/2" 3000#
NPT HALF COUPLING FOR 32NOS.
SKIN THERMOCOUPLES WITH FOUR
INSTALLATION AT EACH BED
(REFER DETAIL ON SHEET-6).

INVERT INSIDE OF WITHDRAWAL NOZZLE
TO BE FLUSH WITH TOP OF DRAW-OFF
PAN SUPPORT RING.

LOCATE THERMOWELLS IN

- VAPOUR SPACE BELOW PACKING : NOZZLES 30A-F
- BOTTOM LIQUID : NOZZLE 30M
- FEED ZONE/SLURRY BED TOP AT 120° SPACING : NOZZLES 30G, 30H, 30I, 30J, 30K, 30L

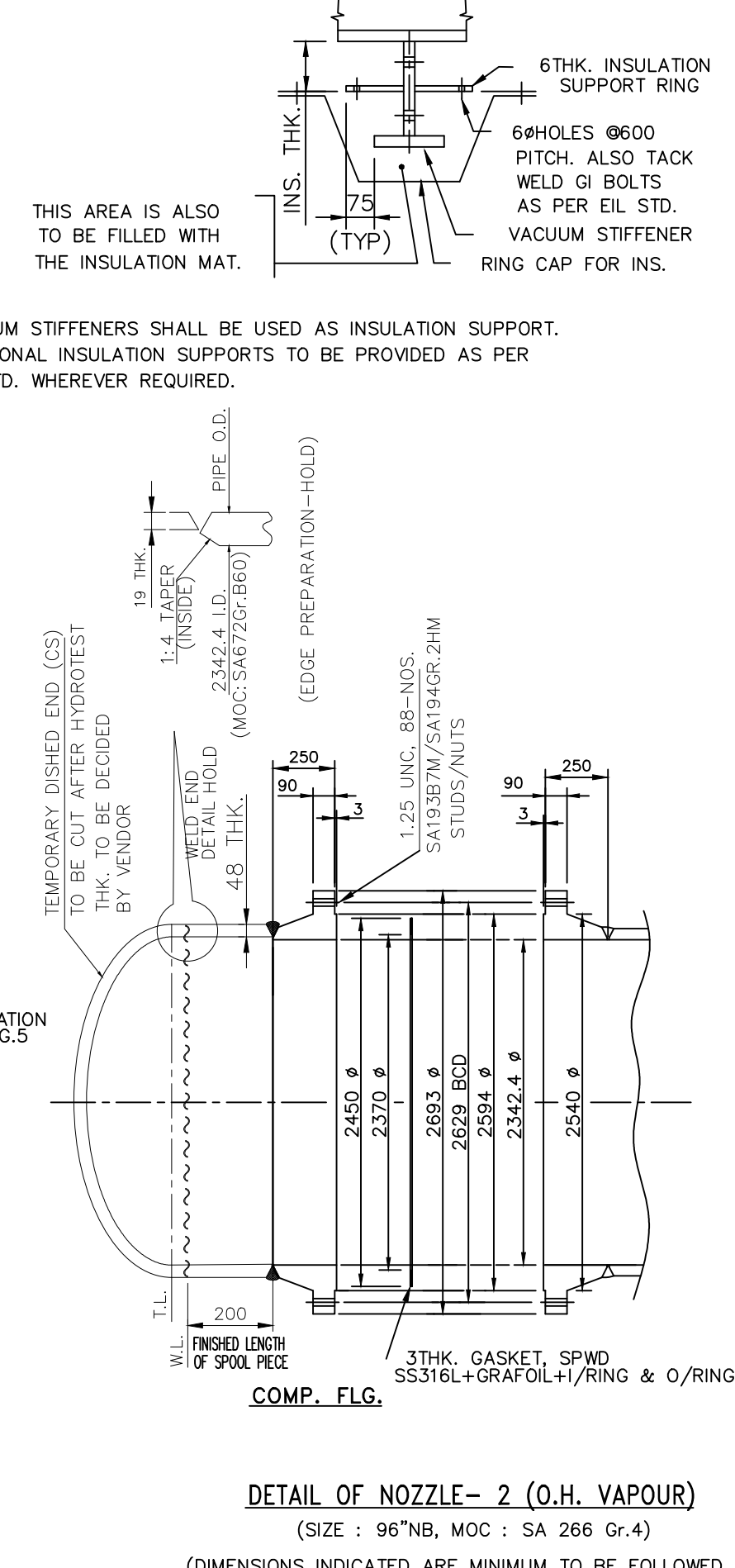
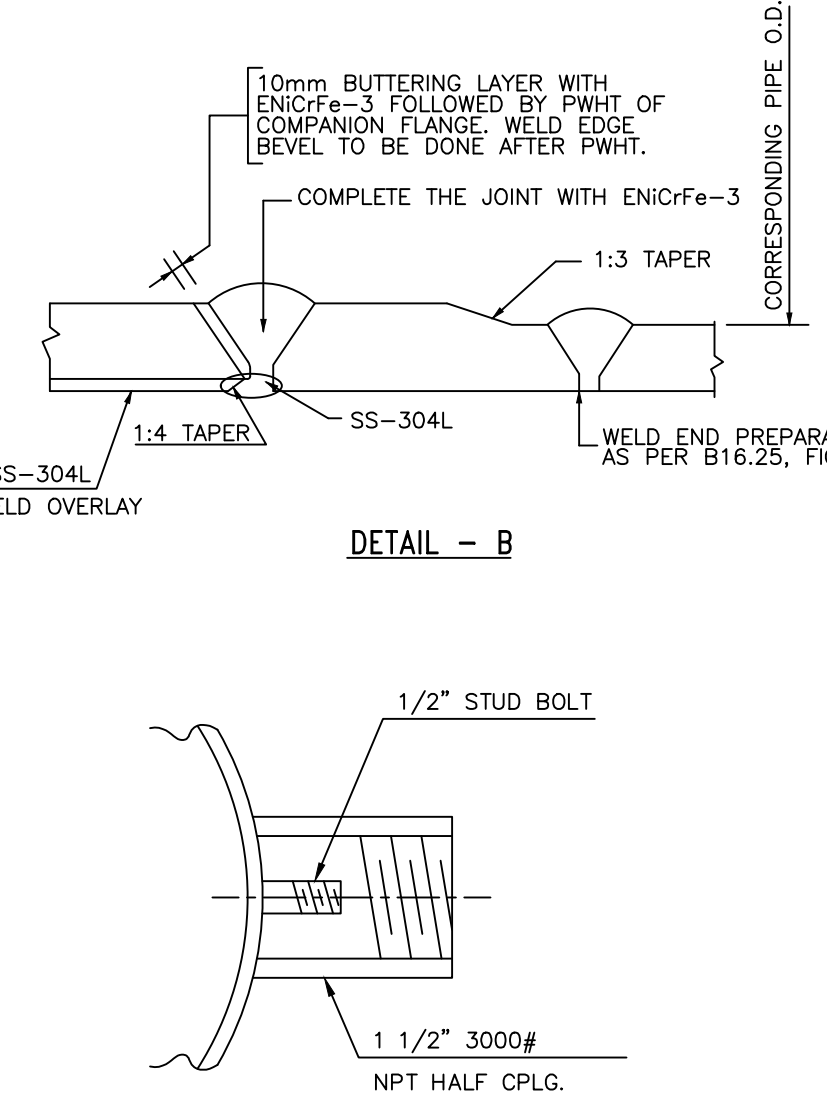
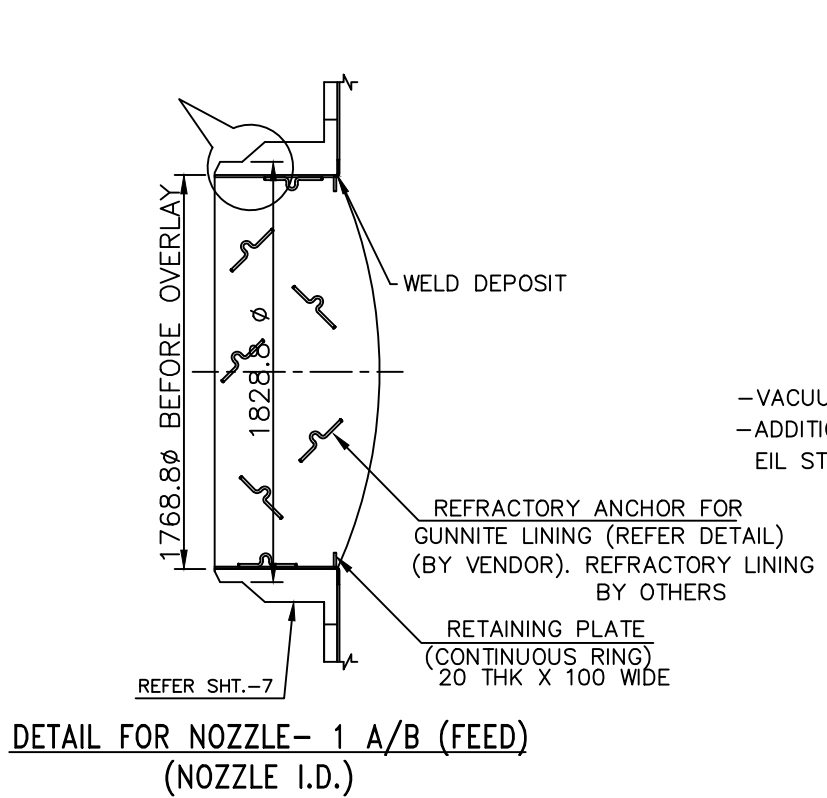
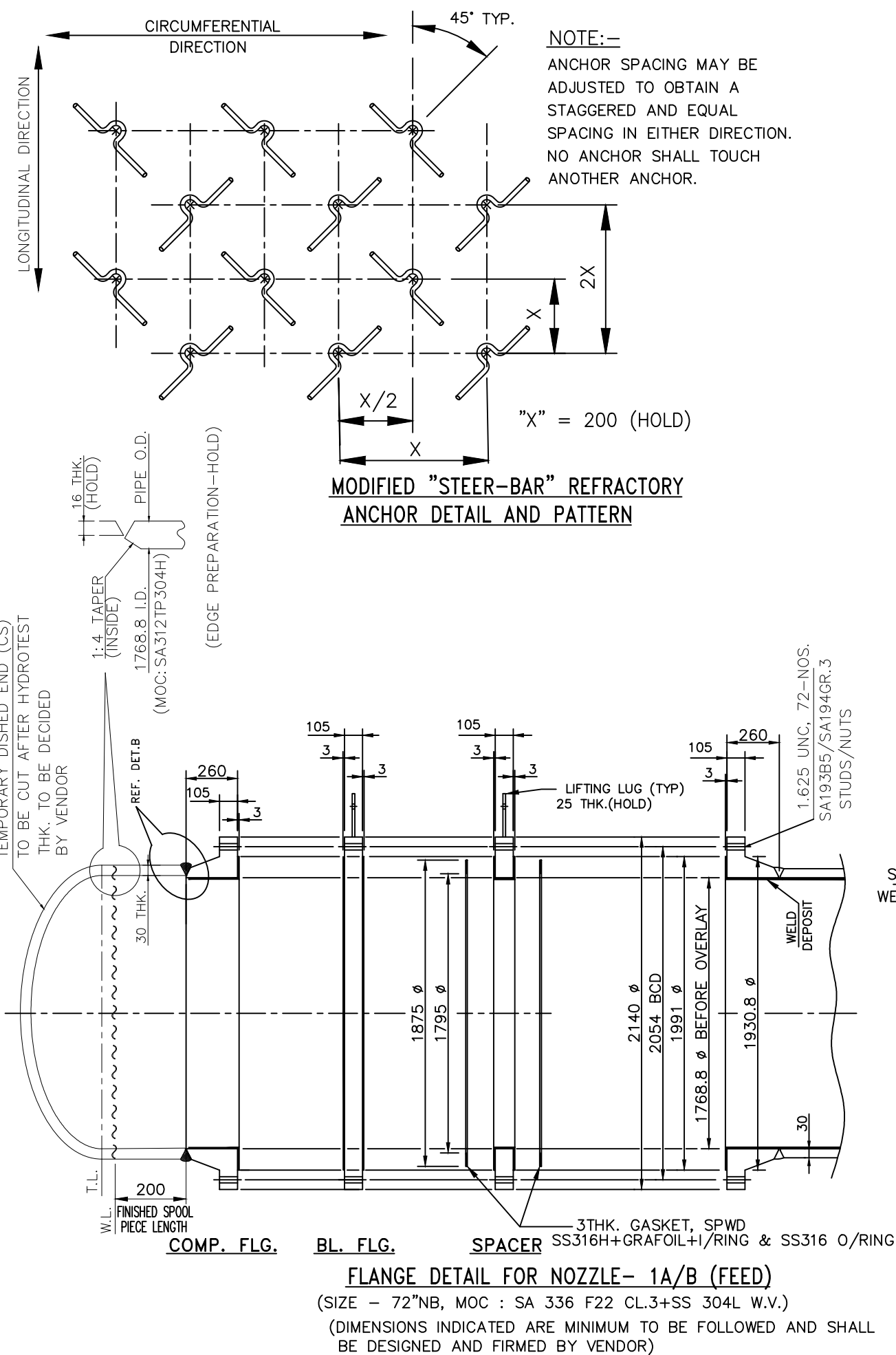
LOCATE PRESSURE INSTRUMENT IN VAPOUR SPACE



LIQUID LEVEL
DETAILS

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FILE NAME : B224-111-80-43-DS-3001-6-A



oslsksy fMtkbu MkVv



ENGINEERS INDIA LIMITED
NEW DELHI

JOB NO. : B224, UNIT NO. : 111 (FCCU)
CLIENT : HRRL, RAJASTHAN
PLANT : RAJASTHAN REFINERY PROJECT

A	23.08.2019	ISSUED FOR ENGG/BIDS	AKP	NNM/RKM	KJH		
REV.	DATE	REVISION	BY	CHK	APPROVED	APPROVED	

VESSEL DESIGN DATA
MAIN FRACTIONATOR
ITEM NO. 111-C-2101

मेन फ्रैक्शनेटर
आइटम नम्बर : 111-सी-2101

DRAWING NO. 224-111-80-43-DS-3001 A
REV. 1
SHEET 6 OF 7

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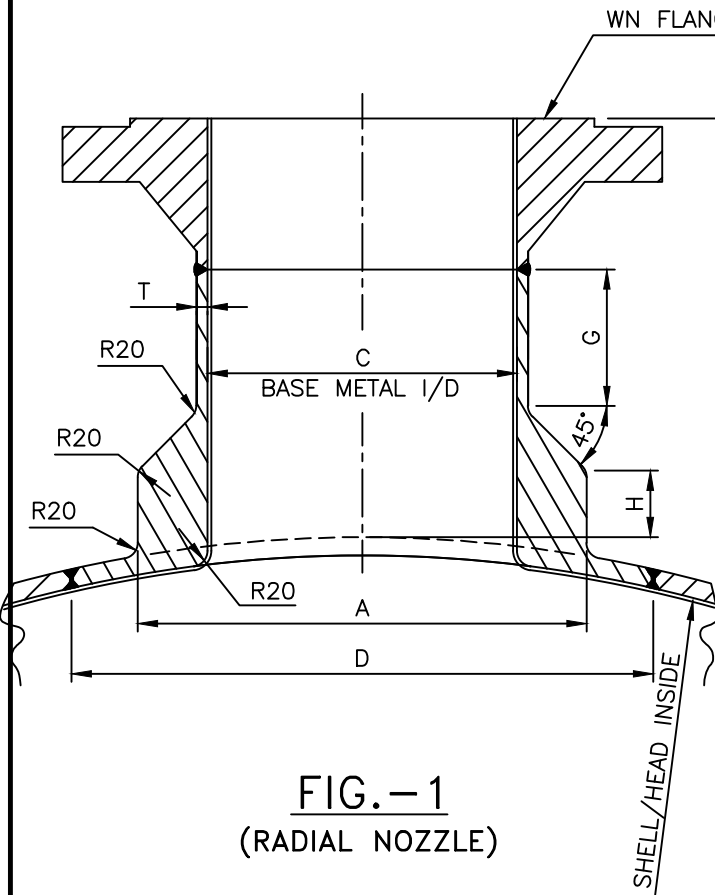


FIG.-1
(RADIAL NOZZLE)

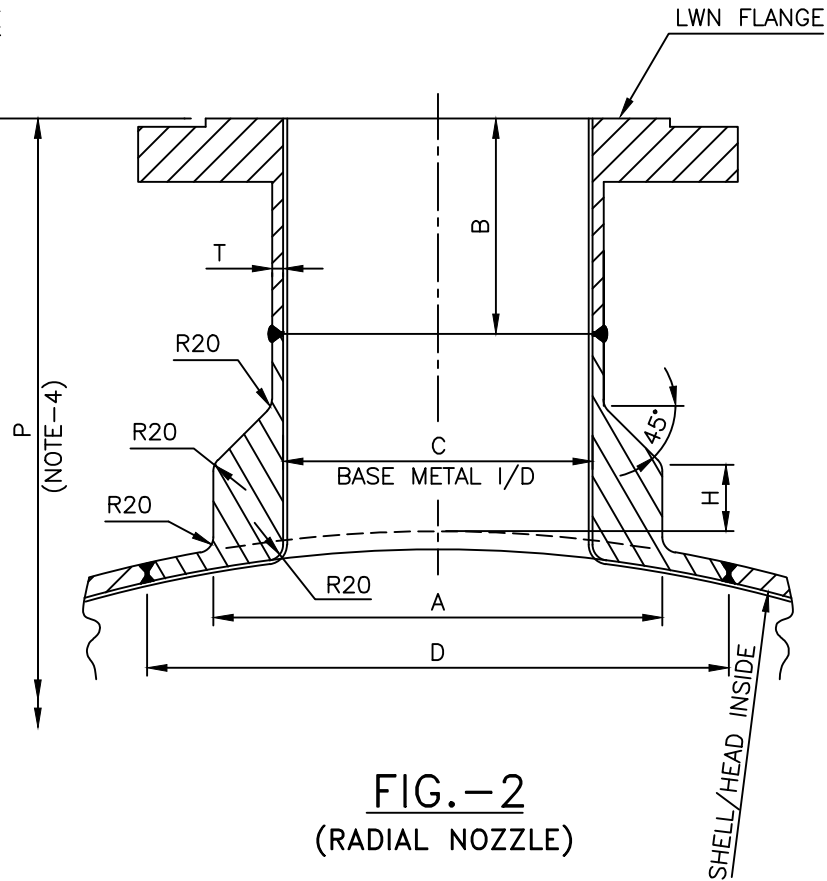


FIG.-2
(RADIAL NOZZLE)

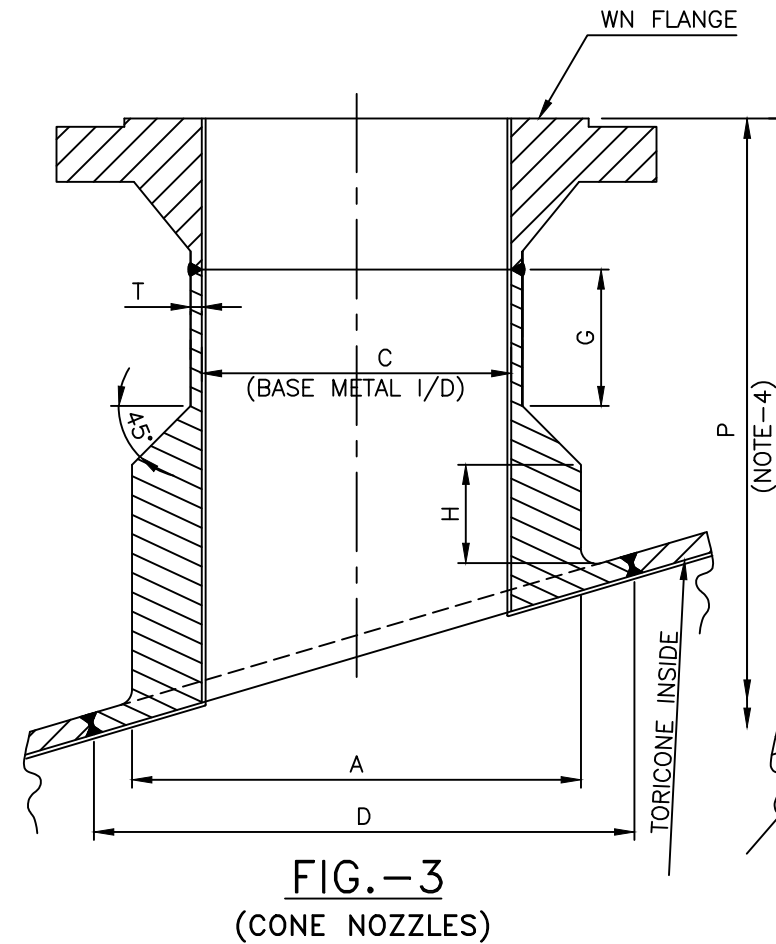


FIG.-3
(CONE NOZZLES)

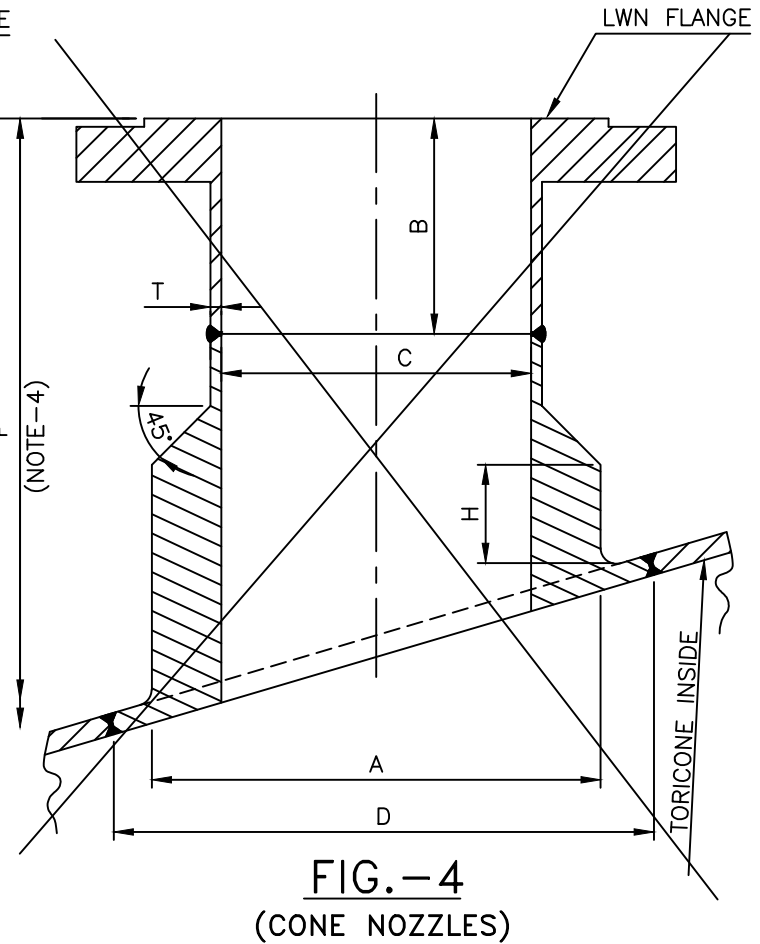
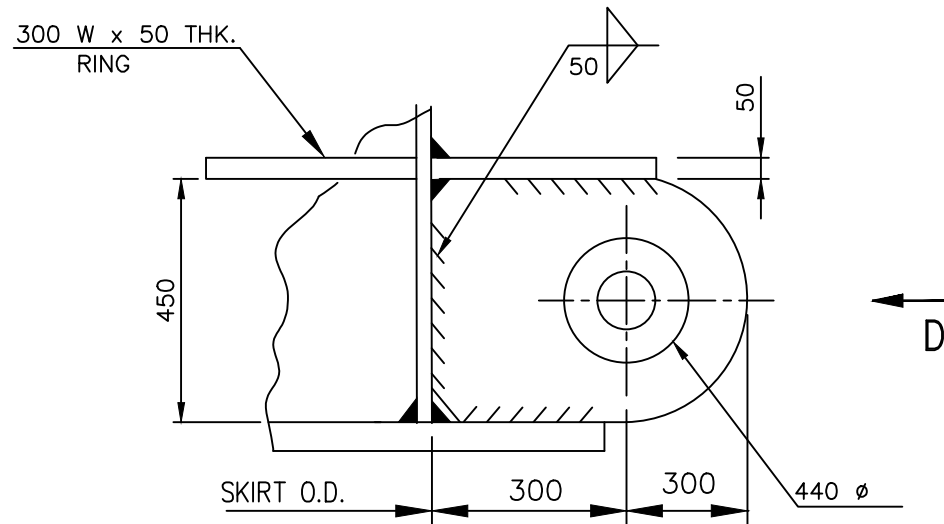


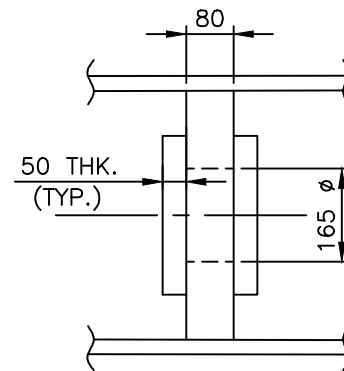
FIG.-4
(CONE NOZZLES)

NOZZLE MARK	SIZE (INCH)	P (MM)	A (MM)	C (MM)	H (MM)	T (MM)	G (MM) (MIN.)	B (MM) (MIN.)	D (MM)	FIG.
1A/B	72	4800	2270	1768.8	180	30	-	-	2370	1
25 I	24	4600	850	549.6	150	30	-	-	950	1
20	6	4400	230	128.3	100	20	-	-	330	3
31H,30J/K/L	3	4350	200	76.2	50	20.5	-	-	300	2

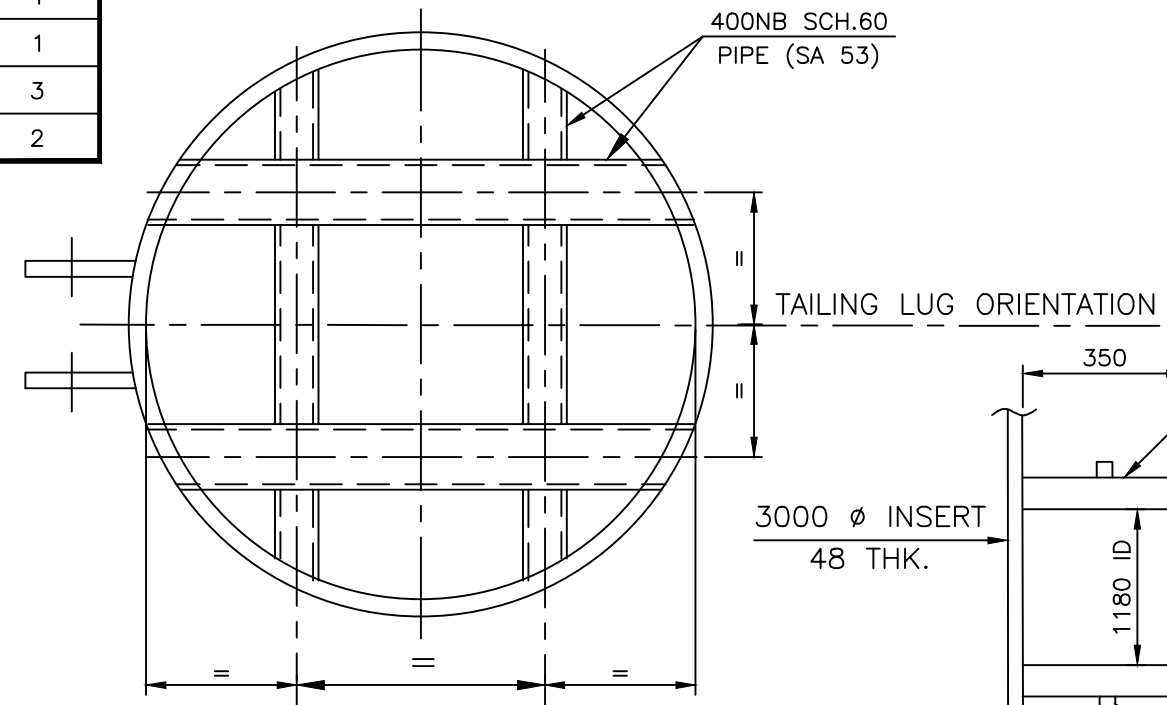
DETAIL OF SELF REINFORCED NOZZLE



2 NOS OF TAILING LUG DETAIL
(DESIGN BY VENDOR-DIMENSIONS ARE MIN. TO BE FOLLOWED)



VIEW-D



STIFFENING DETAIL OF SKIRT
(DESIGN BY VENDOR)

LIFTING TRUNION DETAIL

(DIMENSIONS ARE MINIMUM TO BE FOLLOWED)
(DESIGN BY VENDOR)



ENGINEERS INDIA LIMITED
NEW DELHI


JOB NO. : B224, UNIT NO. : 111 (FCCU)
CLIENT : HRRL, RAJASTHAN
PLANT : RAJASTHAN REFINERY PROJECT

REV.	DATE	REVISION	BY	CHK	APPROVED
A	23.08.2019	ISSUED FOR ENGG/BIDS	AKP	NNM/RKM	KJH

VESSEL DESIGN DATA
MAIN FRACTIONATOR
ITEM NO. 111-C-2101

मेन फ्रैक्शनरेटर
आइटम नम्बर : 111-सी-2101

DRAWING NO. 224-111-80-43-DS-3001 A
REV. 1
SHEET 7 OF 7



	MANUFACTURER'S NAME & ADDRESS BHEL-VISAKHAPATNAM OR APPROVED SUB-CONTRACTORS	QUALITY ASSURANCE PLAN FOR MAIN FRACTIONATOR COLUMN		Customer: HPCL Rajasthan Refinery Limited (HRRL), Barmer. Consultant: Engineers India Limited(EIL) BHEL Sale Order No: 2439 Customer LOA Ref: HRRL/LOA/2020/25 Dt:29.09.2020
		Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)	QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 1 of 16	

Code of Construction: ASME Section VIII Div.1, Edition 2017

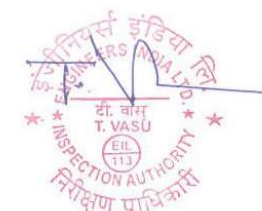
Sl. No.	Item Description	Tag Number
1.	Main Fractionator Column	111-C-2101


To be resubmitted with resolution of comments



 P. Gopi Kishore/Mgr/QA/BHEL	 A.K. Mandal/AGM/Q & BE /BHEL	
Prepared By	Reviewed By	Approved by

Approved with comments
Refer attached Comment sheets for comments



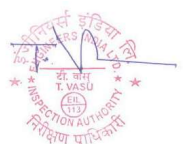
		QUALITY ASSURANCE PLAN FOR MAIN FRACTIONATOR COLUMN		Customer: HPCL Rajasthan Refinery Limited (HRRL), Barmer. Consultant: Engineers India Limited(EIL) BHEL Sale Order No: 2439 Customer LOA Ref: HRRL/LOA/2020/25 Dt:29.09.2020					
MANUFACTURER'S NAME & ADDRESS : BHEL-VISAKHAPATNAM OR APPROVED SUB-CONTRACTORS		Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 2 of 16					
SL NO	ACTIVITY	REFERENCE DOCUMENT	CHARACTERISTIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	Remarks
C1	C2	C3	C4	C5	C6	Prod	Qua	C9	EIL C10 C11
1.0 R1	Design & Drawings approval	ASME Sec VIII Div.1 Ed 2017, MDS	Approved Drawings & Calculations	ASME Sec VIII Div.1 Ed 2017	Approved Drawings	-	H	R	
2.0 R2	Inspection & Test Plan	ASME Sec VIII Div.1 Ed 2017 & Approved Drawings, PR	Documents & inspection stages	ASME Sec VIII Div.1 Ed 2017 & Approved Drg & PR	ITP	-	H	R	
3.0	Review of Procedures								
3.1 R3	All Manufacturing, Test procedures (NDE, Surface Preparation & Painting, Forming & Heat Treatment)	ASME SEC.V, ASME Sec IX & Sec VIII Div.1 1 Ed 2017, PR, APPROVED DRAWING, PR Specifications.	Compliance to ASME CODES & PR	ASME SEC.V, ASME Sec IX & Sec VIII Div.1 1 Ed 2017, PR, APPROVED DRAWING	Procedures	-	H	R	To be submitted for information
3.2 R4	Welding Process	WPS/PQR/WPQ (shall be within 5 years)	Compliance to ASME CODES & PR.	ASME SEC.V, ASME Sec IX & Sec VIII Div.1 1 Ed 2017, PR, APPROVED DRAWING	WPS/PQR/W PQ	-	H	R / W	R-for existing; W-for New.
4.0	Raw materials								
4.1 R5	Plates, Pipes & Forgings at sourcing locations	Approved Drawings & Purchase Order, PR	As per PR and ASME Sec IIA Ed 2017	As per PR and ASME Sec IIA Ed 2017	Test Certificates	-	H	*	*Refer Note -9


All CS materials shall meet the requirements of EIL Specification, 6-12-0011, 6-79-0013. Plates shall be procured with HIC test as per TM-02-84 and shall meet the requirements of specification

All Low alloy steel materials shall meet the requirements 6-12-0017, 6-12-0018, clad plates 6-12-0015, stain less steel plates 6-12-0020 with respect to C, CE, Composition, NDT, Simulation HT, hardness, impact, mechanical properties etc

Approved with comments

**Refer attached Comment sheets
for comments**




		MANUFACTURER'S NAME & ADDRESS : BHEL-VISAKHAPATNAM OR APPROVED SUB-CONTRACTORS	QUALITY ASSURANCE PLAN FOR MAIN FRACTIONATOR COLUMN					Customer: HPCL Rajasthan Refinery Limited (HRRL), Barmer. Consultant: Engineers India Limited(EIL) BHEL Sale Order No: 2439 Customer LOA Ref: HRRL/LOA/2020/25 Dt:29.09.2020				
			Item: Main Fractionator Column		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 3 of 16							
Project: Rajasthan Refinery Project (RRP)												
SL NO	ACTIVITY	REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks			
C1	C2	C3	C4	C5	C6	Prod	Qua	C8	C9	C10 C11		

4.2	Raw materials after receipt								
4.2.1 R6	Plates for shells, PTC and dished ends, All parts welded to Pr parts + All process wetted parts	Approved Drawings & Purchase Order, PR	As per PR and ASME Sec IIA Ed 2017	As per PR and ASME Sec IIA Ed 2017	Test Certificates	-	H	H	
4.2.2 R7	Nozzles, forgings, pipes & flanges, and Fittings.	Approved Drawings & Purchase Order	As per TDC and ASME Sec IIA Ed 2017 & PR	As per TDC and ASME Sec IIA Ed 2017 & PR	Test Certificates	-	H	H	
4.2.3 R8	Non-Pressure parts	Approved Drawings & Purchase Order	As per material specification	As per material specification	Test Certificates	-	H	R	
4.2.4 R9	Welding consumables	Purchase Order	As per ASME Sec IIC Ed 2017 & PR	As per ASME Sec IIC Ed 2017 & PR	Test Certificates	-	H	R	
4.2.5 R10	Fasteners and Gaskets	Approved Drawings & Purchase Order	As per TDC and ASME Sec IIA Ed 2017	As per TDC and ASME Sec IIA Ed 2017	Test Certificates	-	H	R	
4.2.6 R11	Base Ring Template	Approved Drawings & Purchase Order	As per TDC and ASME Sec IIA Ed 2017	As per TDC and ASME Sec IIA Ed 2017	Test Certificates	P	H	R	.

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			Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 4 of 16					
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks
C1	C2		C3	C4	C5	C6	Prod C7	Qua C8	C9	C10 C11

5.0	Fabrication of Dished ends								
5.1 R12	Transfer of marking and heat number	As per Material test certificates	Heat no and material specification	Approved drawing	-	P	H	W	
5.2 R13	Fit up & welding of long seam	Approved Drawings	Offset & weld geometry	Approved drawing & WPS	Fit up report	P	H	W	
5.3 R14	100 % PT on root & final weld, chipped back LS weld, Cu SO4 solution test after clad removal \$ (typ)	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	RW	
5.4 R15	100 % RT of completed LS weld	Approved Drawings	Detection of flaws	Approved RT Procedure	RT Films	P	H	R	
5.5 R16	Clad restoration on Long seam \$	Approved Drawings	Parameters as per WPS, Welder Qualification	WPS	-	P	H	-	
5.6 R17	100 % PT on clad restoration after each pass \$	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	RW	
5.7 R18	Chemical analysis of clad (2 samples) per seam \$	ASME Sec IIC & Clad procedure	As per specification	As per specification	Analysis report (Note-3)	-	H	R	Per WPS/ Welder basis

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SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL	Remarks
C1	C2		C3	C4	C5	C6	Prod	Qua	C9	C10	C11

<div>R19</div>	5.8	Forming of dished end	Approved Drawings ASME Sec VIII Div. 1	Visual & Dimensional check, Template check	Approved Drawings	Dimension Report	P	H	-	
<div>R20</div>	5.9	100 % PT of knuckle area (Note-2)	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	W	
<div>R21</div>	5.10	100% UT on Crown , Knuckle, WEP and straight face	Approved procedures	Thickness measurement & Dis-bondment check \$	Approved Drawing, procedures	UT report	P	H	W	
<div>R22</div>	5.11	Visual & Final Dimensions including Dished end profile checking with Template	Approved Drawing ASME Sec VIII Div. 1	Dimensions	Approved Drawing	Dimension Report	P	H	W #	# Trial Assembly & fit- up in case of Crown & Petal construction
	6.0	Fabrication of Main shell along with PTC								
<div>R23</div>	6.1	Plate marking & cutting	Approved drawing & cutting plan	Dimensions	Approved Drawings	-	P	-	-	Refer Note-6
<div>R24</div>	6.2	Shell rolling	Approved drawing & cutting plan	Dimensions	Approved Drawings	-	P	H	-	
<div>R25</div>	6.3	Long seam fit up & welding along with test coupon	Approved Drawings	Offset & weld geometry	Approved drawing & WPS	Fit up report	P	H	W	

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			Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 6 of 16						
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL	Remarks
C1	C2		C3	C4	C5	C6	Prod C7	Qua C8	C9	C10	C11

R26	6.4 100 % PT on root & final weld ,chipped back LS weld	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	R	
R27	6.5 RT of completed LS weld & test coupon	Approved drawings	Detection of flaws	Approved RT Procedure	RT Films	P	H	R	
R28	6.6 Clad restoration on Long seam & test coupon \$	Approved Drawings	Parameters as per WPS	WPS	-	P	-	-	
R29	6.7 100 % PT on clad restoration each layer \$	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	RW	
R30	6.8 Chemical analysis of clad (2 samples) per seam \$	ASME Sec IIC & Clad procedure	As per specification & PR	As per specification & PR	Analysis report (Note-3)	-	H	W	Per welder / WPS/ shell course basis
R31	6.9 Ferrite check of clad overlay (2 spots per seam) \$	ASME Sec IIC Ed 2017	Ferrite content	As per drawing	Ferrite Report	-	H	RW	
R32	6.10 UT on Rolled sections of clad and weld overlay \$	Approved procedures	Disbondment	Approved procedures,	UT report	P	H	W	
R33	6.11 Testing of test coupon	ASME Sec VIII Div.1 Ed 2017	Tensile & Hardness	ASME Sec VIII Div.1 Ed 2017	Test reports	-	H	RW	

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SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks	
C1	C2		C3	C4	C5	C6	Prod	Qua	C9	C10	C11

7.0	Shell to Shell to Circular seam fabrication								
7.1 R34	CS fit up & welding	Approved Drawings	Offset & weld geometry	Approved drawing & WPS	Fit up report	P	H	W	
7.2 R35	100 % PT on root & final weld, chipped back CS weld	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	R	
7.3 R36	RT of completed CS weld	Approved drawings	Detection of flaws	Approved RT Procedure	RT Films	P	H	R	
7.4 R37	Clad restoration on C- seam \$	Approved Drawings	Parameters as per WPS	WPS	-	P	-	-	
7.5 R38	100 % PT on clad restoration after each pass \$	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	RW	
7.6 R39	Chemical analysis of clad (2 samples) per seam \$	ASME Sec IIC & Clad procedure	As per specification & PR	As per specification & PR	Analysis report (Note-3)	-	H	RW	
7.7 R40	Ferrite check of clad overlay (2 spots per seam) \$	ASME Sec IIC Ed 2017	Ferrite content	As per drawing	Ferrite Report	-	H	RW	

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			Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 8 of 16							
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks		
C1	C2		C3	C4	C5	C6	Prod C7	Qua C8	C9	C10	C11	

8.0	Shell to Dished end circular seam fabrication									
8.1 R41	CS fit up & welding	Approved Drawings	Offset & weld geometry	Approved drawing & WPS	Fit up report	P	H	W		
8.2 R42	100 % PT on root & final weld, chipped back CS weld	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	R		
8.3 R43	RT of completed CS weld	Approved Drawings	Detection of flaws	Approved RT Procedure	RT Films	P	H	R		
8.4 R44	Clad restoration on C- seam \$	Approved Drawings	Parameters as per WPS	WPS	-	P	H	-		
8.5 R45	100 % PT on clad restoration after each pass \$	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	RW		
8.6 R46	Chemical analysis of clad (2 samples) per seam \$	ASME Sec IIC & Clad procedure	As per specification & PR	As per specification & PR	Analysis report (Note-3)	-	H	RW		
8.7 R47	Ferrite check of clad overlay (2 spots per seam) \$	ASME Sec IIC Ed 2017	Ferrite content	As per drawing	Ferrite Report	-	H	RW		

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				Item: Main Fractionator Column		QAP No: CQP 2516 Rev 0 Date: 05.02.2021					
				Project: Rajasthan Refinery Project (RRP)		Page 9 of 16					
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks	
C1	C2		C3	C4	C5	C6	Prod C7	Qua C8	C9	C10	C11

9.0	Weld overlay of Nozzles, Pipes, Elbows and blind flanges								
9.1 R48	Weld overlay \$	Approved drawings	Welding parameters	Adherence to WPS	-	P	-	-	
9.2 R49	Weld overlay thickness from inside the nozzles \$	Approved drawings	Thickness	Approved drawings	Inspection Report	-	H	W	
9.3 R50	Chemical analysis of weld overlay (1 sample per size representing manual weld overlays of Nozzles, Pipes, Fittings) per seam \$	ASME Sec IIC & Clad procedure	As per specification	As per specification	Analysis report (Note-3)	-	H	RW	RW-by TPIA is applicable during sample collection only.
9.4 R51	Ferrite check of weld overlay(2 spots per weld overlay) (1 sample per size representing manual weld overlays of Nozzles, Pipes, Fittings) \$	ASME Sec IIC Ed 2017	Ferrite content	As per drawing	Ferrite Report	-	H	RW	
9.5 R52	100 % PT of weld overlay after each pass \$	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	R	

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			Item: Main Fractionator Column		QAP No: CQP 2516 Rev 0 Date: 05.02.2021			Page 10 of 16				
			Project: Rajasthan Refinery Project (RRP)									
SL NO	ACTIVITY	REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks			
C1	C2	C3	C4	C5	C6	Prod	Qua	C9	C10	C11		

10.0	Fabrication of Nozzle Assemblies									
10.1 R53	Fit up & welding of C-seams of pipes/ elbows/ flanges / nozzle neck, internal pipes	Approved Drawings	Offset & weld geometry	Approved drawing & WPS	Fit up report	P	H	R	Functional test for Davit.	
10.2 R54	RT of completed CS weld & L-seam of rolled nozzles	Approved Drawings	Detection of flaws	Approved RT Procedure	RT Films	P	H	R		
10.3 R55	Clad restoration on C-seam \$	Approved Drawings	Parameters as per WPS	WPS	-	P	-	-		
10.4 R56	100 % PT of weld overlay after each pass \$, nozzle to flange root welds	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	RW		
10.5 R57	Chemical analysis of weld overlay(2 samples) per seam \$	ASME Sec IIC & Clad procedure	As per specification	As per specification	Analysis report (Note-3)	-	H	RW	RW-by TPIA is applicable during sample collection only.	
10.6 R58	Ferrite check of weld overlay (2 spots per seam (1 sample per size representing Nozzles, Pipes, Fittings) \$	ASME Sec IIC Ed 2017	Ferrite content	As per drawing	Ferrite Report	-	H	RW		

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		Item: Main Fractionator Column	QAP No: CQP 2516 Rev 0		Date: 05.02.2021				
		Project: Rajasthan Refinery Project (RRP)	Page 11 of 16						
SL NO	ACTIVITY	REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks
C1	C2	C3	C4	C5	C6	Prod	Qua	C9	C10 C11

11.0	Nozzle to shell/dished end fabrication								
11.1 R59	Marking and openings of nozzles on shells	Approved Drawings	Location and orientation	Approved Drawings	-	P	H	R	
11.2 R60	PT on gas cut edges	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	R	
11.3 R61	Fit up & welding of nozzles on shells or dished ends	Approved Drawings	Offset & weld geometry	Approved drawing & WPS	Fit up report	P	H	RW	
11.3. R62	Pneumatic test on RF Pads	Approved Drawing	Detection of leakage	Approved Drawing	Approved Drawing	P	H	RW	
11.4 R63	100 % PT on chipped back CS weld	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	R	
11.5 R64	Clad restoration on welds \$	Approved Drawings	Parameters as per WPS	WPS	-	P	-	-	
R65 11.6	100 % PT of weld overlay after each pass \$	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	RW	
R66 11.7	Chemical analysis of weld overlay(2 samples) per seam \$	ASME Sec IIC & Clad procedure	As per specification	As per specification	Analysis report (Note-3)	-	H	RW	RW-by TPIA is applicable during sample collection only.
R67 11.8	Ferrite check of weld overlay (2 spots per seam) \$	ASME Sec IIC Ed 2017	Ferrite content	As per drawing	Ferrite Report	-	H	RW	
R68 11.9	100 % UT for nozzle to shells and nozzle to pipe	Approved Drawings	Detection of flaws	Approved UT Procedure	UT Report	P	H	W	

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			Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 12 of 16							
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks		
C1	C2		C3	C4	C5	C6	Prod C7	Qua C8	C9	C10	C11	

12.0	Skirt fabrication, assembly and Final Inspection									
12.1 R69	Fit up & welding of Skirt, Skirt with Vessel	Approved Drawings	Dimensions & weld geometry	Approved drawing & WPS	Fit up report	P	H	W		
12.2 R70	RT of C-seam & L-seam	Approved Drawings	Detection of flaws	Approved RT Procedure	RT Films	P	H	R		
12.3 R71	100 % PT of welds (including root and final welds as applicable)	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	W		
12.4 R72	Dimensional inspection of Skirt	Approved Drawings	Dimensions	Approved Drawings	Report	P	H	W		
12.5 R73	Marking of Internal and external cleats, supports	Approved Drawings	Dimensions	Approved Drawings	Report	P	H	R		
13.0 R74	100% UT of attachments welded directly to cladding	Approved procedures	Detection of flaws	Approved procedures	UT report	P	H	R	Refer Note-12	
14.0 R75	Pneumatic test on RF Pads	Approved Drawing	Detection of leakage	Approved Drawing	Approved Drawing	P	H	RW		
15.0 R76	Visual & Final dimensional inspection before PWHT including internals	Approved Drawings	Dimensions, orientations	Approved Drawings	Dimensional report	P	H	H		

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			Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 13 of 16						
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL	Remarks
C1	C2		C3	C4	C5	C6	Prod	Qua	C8	C9	C10 C11

R77	15.1	Internals inside the column	Approved Drawings	Dimension, Orientation and 1) Ovality in Column ID 2) Support Ring Levelness	Approved Drawings, & EIL Standard 7-12-0001	Dimensional report	P	H	H	
R78	16.0	PWHT of equipment along with PTC	PWHT procedure	Calibration of thermocouples/ Recorders	PWHT procedure	HT Chart review	P	H	H for release	
R79	17.0	Testing of test coupons (PTC)	ASME Sec VIII Div. 1Ed 2017 See comment 1	Tensile & Hardness See comment 2	ASME Sec VIII Div. 1Ed 2017	Test Reports	P	H	W	
R80	18.0	NDE after PWHT 100% UT on pressure retaining weld	Approved Drawings See comment 3	Detection of flaws	Approved UT Procedures	UT Report	P	H	W	
R81	19.0	Spot PT on internal & external welds.	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	W	
R82	20.0	Hardness check of all pressure part joints on weld / HAZ / PM	ASME Sec VIII Div. 1Ed 2017 6-12-0003, 6-12-0002 6-12-0007 MR-01-03, 6-79-0013	Hardness	ASME Sec VIII Div. 1Ed 2017 & PR	Test report	P	H	RW	
R83	21.0	Final dimensional inspection after PWHT	Approved Drawings	Dimensions, orientations	Approved Drawings	Dimensional report	P	H	H	

Comment 1: 6-12-0002 para 4.4, 6-12-0003 para 7, 6-12-0007 para 6.5

Comment 2: Tensile, side bend, hardness, macro/ micro, IGC tests


Comment 3: (a) Radiography required after PWHT. (b) UT in lieu of Radiography requires PMC approval ref. para 5.4.8 of 6-12-0001 (c) Clad dished end, toricone, hot formed shells require 100% UT, 10% rest clad for bond integrity

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			Item: Main Fractionator Column		QAP No: CQP 2516 Rev 0 Date: 05.02.2021							
			Project: Rajasthan Refinery Project (RRP)		Page 14 of 16							
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks		
C1	C2		C3	C4	C5	C6	Prod C7	Qua C8	C9	C10	C11	

R84	22.0	PMI Check (only for SS , Alloy Steels)	PR Specification	As per ASME Sec IIC Ed 2017	ASME Sec IIA Ed 2017.	PMI report	P	H	RW	
R85	23.0	Shop Hydro test & Draining, drying, inside cleaning.	Approved Drawings	No pressure drop or leaks	Approved hydro test procedure; draining & drying procedure	Test report	P	H	H	Chloride content in hydro testing water to be as specified in PR
R86	24.0	Pickling & passivation of weld overlay of nozzles, clad surface of shells, dished ends and further cleaning and drying	Approved Drawings	Visual examination	Approved Drawings & PR	Report	P	H	RW	
R87	25.0	Surface preparation & Primer painting,	Approved Drawings	Visual examination & DFT check	Approved Drawings	Report	P	H	RW	
R88	26.0	Primer Paint application	Approved Drawings	Visual & DFT	Approved Drawings	Report	P	H	R	
R89	27.0	Cutting of Complete Vessel into sections & Weld edge preparation for site weld	Approved drawing / cutting plan	Dimensions	Approved Drawings	-	P	H	W	Refer Note-6
R90	28.0	Trial assembly of cut sections, match marking	Approved drawing / cutting plan	Dimensions	Approved Drawings	-	P	H	W	
R91	29.0	Issue of IRN & clearance for dispatch	Approved drawings	All stages as per this approved ITP	-	Release Note	-	-	H	

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			Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)		QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 15 of 16					
SL NO	ACTIVITY		REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	EIL Remarks
C1	C2		C3	C4	C5	C6	Prod C7	Qua C8	C9	C10 C11

30.0	Site fabrication								
R92	Weld edge, CS fit up & welding	Approved Drawings	Visual, Offset & weld geometry	Approved drawing & WPS	Fit up report	P	H	W	
R93	100 % PT on root & final weld, chipped back CS weld	Approved Drawings	Detection of flaws	Approved PT Procedure	PT Report	P	H	R	
R94	RT of completed CS weld	approved drawings	Detection of flaws	Approved RT Procedure	RT Films	P	H	R	For site weld in Pressure part
R95	Local PWHT for the column	PWHT procedure	Calibration of thermocouples/ Recorders	PWHT procedure	HT Chart review	P	H	H for release	
R96	Local Box Type Hydro test (as specified in drawing)	Approved Drawings	No pressure drop or leaks	Approved hydro test procedure; draining & drying procedure	Test report	P	H	H	
R97	Surface preparation & Primer painting	Approved Drawings	Visual examination & DFT check	Approved Drawings	Report	P	H	RW	Only where touch up is applicable
R98	Issue of site IRN	Approved drawings	All stages as per this approved ITP	-	Release Note	-	-	H	
R99	Manufacturer's Data Report & Final documentation	Approved drawings & this ITP	Completeness	Approved drawings & this ITP	Reports	-	H	H	QAP sign off by TPIA

Approved with comments
Refer attached Comment sheets
for comments



		MANUFACTURER'S NAME & ADDRESS : BHEL-VISAKHAPATNAM OR APPROVED SUB-CONTRACTORS	QUALITY ASSURANCE PLAN FOR MAIN FRACTIONATOR COLUMN				Customer: HPCL Rajasthan Refinery Limited (HRRL), Barmer. Consultant: Engineers India Limited(EIL) BHEL Sale Order No: 2439 Customer LOA Ref: HRRL/LOA/2020/25 Dt:29.09.2020			
			Item: Main Fractionator Column Project: Rajasthan Refinery Project (RRP)	QAP No: CQP 2516 Rev 0 Date: 05.02.2021 Page 16 of 16						
SL NO	ACTIVITY	REFERENCE DOCUMENT	CHARACTERISITIC TO BE VERIFIED	ACCEPTANCE NORMS	VERIFYING DOCUMENTS /RECORDS	BHEL		TPIA	Remarks	
						Prod	Qua			

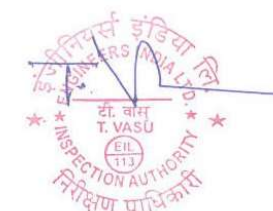
Notes:

(a) Low alloy steels: All weld edges shall be checked by MPI (b) UT of weld edges shall be done as per specification 6-12-0003

- For qualification any new WPS, or new WPQ, witness of TPIA is envisaged.
- In case, the bevel edges are made with gas cutting, the edges shall be 100 % PT tested.
- Wherever chemical analysis of weld metal overlay shall be measured, it shall be at a depth of 2/3rd of the cladding thickness from top of the finished overlay surface.
- Weld over lay thickness cannot be more than 3 mm over and above the required clad thickness.
- All specifications as available in drawings shall be complied.
- In case site weld is required to be done in line to drawing, suitable extra dimensions are to be provided such that complete equipment after shop hydro test is cut into pieces and transported to site followed by seam welding at site.
- All requirements as per PR (Purchase Requisition) shall be met.
- For weld overlay, electrode for barrier layer E309MoL shall be used in line with EIL Spec. No. 6-12-0007.
- Witness by TPIA for indigenous clad plates during explosion bonding activity of base plate with stainless steel plate followed by identification. Witness by TPIA for imported plate material.
- Extent of RT will be in line to approved drawings.
- EIL Spec 6-12-0007 Rev 5 Cl. No. 5.1.5: For welding of clad piping components such as pipe to pipe / pipe fitting from single side where approach from clad side is not accessible, shall be done with a welding consumable matching the clad material followed by an intermediate layer of pure iron (ARMCO/KARDO Iron) welding filler material and then by a welding consumable matching the base material.
- EIL Spec 6-12-0007 Rev 5 Cl. No. 6.1.4: 100% UT shall be carried out of areas where attachments are to be welded directly to the cladding. The above areas shall include 50mm width of adjacent areas on both sides of attachment.
- \$ These stages are applicable for Clad zone only.

Legends:

P: Perform	WPS: Welding procedure specification	DFT: Dry film thickness	LS: Longitudinal Seam welding
R: Review	WPQ: Welder performance Qualification	HT Chart: Heat Treatment chart	CS-Circular Seam welding
H: Hold	RT: Radiographic testing	PR-Purchase Requisition	Approved with comments
W: Witness	UT: Ultrasonic testing	Prod: Production	Refer attached Comment sheets
RW: Random Witness	PT: Dye penetrant testing	Qua: Quality	for comments
	MPT: Magnetic particle testing	IRN: Inspection release note issued by TPIA	



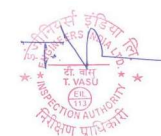
EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
1	1 Of 16	N.A.	Top Right Corner	Addition	N.A.	EIL Ref. B224/2025
2	1 Of 16	N.A.	Under Code of Construction	Addition	N.A.	Basic Reference Documents : (1) EIL Purchase Requisition (PR) No. : B224-111-CC-PR-6006/2025 REV.0 DT.21-OCT-2020 (2) EIL Latest Approved Drawings
3	1 Of 16	N.A.	Top Middle Section	Modification	Rajasthan Refinery Project (RRP)	Petrochemical FCC Unit (PFCCU) for Rajasthan Refinery Project (RRP)
4	1 Of 16	N.A.	Top Left Corner	Modification	OR Approved Sub-Contractors	Delete it.
5	1 Of 16	N.A.	Under Main Fractionator Column in Item Description (Table)	Addition	N.A.	CS/LAS + SS304L Cladded [8 m ID X 56.96 M Overall length X 664 MT Erection Weight]
6	1 Of 16	N.A.	Under Main Fractionator Column in Item Description (Table)	Addition	N.A.	[With One Site Joint]
7	1 Of 16	N.A.	Under Main Fractionator Column in Item Description (Table)	Addition	N.A.	Column RT : 100% Butt Weld Joints including Skirt C & L Seams PWHT : Yes, Complete Column
8	1 Of 16	N.A.	At appropriate Location	Addition	N.A.	Scope of Supply / Work by BHEL : Column, Internals, Site Joint work at site, Installtion of Internals at site, Foundation Template, Platform and Ladder Structures, Anchor Bolts & Mandatory spares
9	1 Of 16	N.A.	Top Right Corner [Below Consultant]	Addition	N.A.	EPC Contractor : M/s L&T Hydrocabon Engineering (LTHE) Ltd.
10	1 Of 16	N.A.	Top Right Corner [Below Consultant]	Addition	N.A.	Process Licensor : M/s Technip FMC
11	1 Of 16	N.A.	Top Right Corner [Below Consultant]	Addition	N.A.	Column Internals Manufacturer : M/s Sulze India Ltd., Pune
12	1 Of 16	N.A.	Top Right Corner [Below Consultant]	Addition	N.A.	TPIA [Appointed by BHEL as per Contract] : M/s CEIL, Mumbai
13	1 Of 16	N.A.	Top Right Corner [Below Consultant]	Addition	N.A.	External Inspection By : TPIA & EIL
14	1 Of 16	N.A.	Bottom Right	Modification	Approved By	Space separately for Approved by(TPIA) and Approved by(EIL)
15	2 To 16	N.A.	Header in all pages	N.A.	N.A.	Header in all pages to be uniform after incorporation of EIL Comments in the header of 1st Page.
16	2 To 16	N.A.	Header in all pages	Addition	N.A.	New Column for EIL to be added after TPIA in all pages
17	2 Of 16	1.0	R1 C3	Modification	MDS	To be replaced with " EIL PR "
18	2 Of 16	1.0	R1 C4	Modification	Approved Drawings	Approved Drawings at all locations of all pages to be replaced with " EIL Approved Drawing (Latest Revision)"
19	2 Of 16	1.0	R1 C8	Modification	H	Design & Drawings approval activitiy is under the perview of Engg., But not QA. Hence to be corrected as H (By Engg.)
20	2 Of 16	1.0	R1 C10	Addition	N.A.	H (By Engg.) under EIL Column (C10)
21	2 Of 16	1.0	R1 C9	Modification	R	TPIA has no ole in review of Design & Drawings approval activitiy.
22	2 Of 16	2.0	R2 C2	Modification	Inspection & Test Plan	To be replaced with " Quality Assurance Plan" Which is in-line with documnt title.

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
23	2 Of 16	2.0	R2 C3	Modification	PR	The word " PR " shall be replaced with " EIL PR " at all locations of all pages
24	2 Of 16	2.0	R2 C6	Modification	ITP	To be replaced with " QAP "
25	2 Of 16	2.0	R2 C10	Addition	N.A.	"R" under EIL Column (C10)
26	2 Of 16	3.1	R3 C2	Addition	N.A.	Cladding Procedure, Weld-overlay Procedure (To be freshly qualified specific to this order requirements), Hydrostatic test procedure for shop test & site test, Pickling & Passivation Procedure for SS Parts, Column Sliding Procedure, Transportation Methodology, Transportation Route Survey, Column Internals Packing, Marking & Shipping Procedure and Column Internals Installation Procedure to be reviewed by TPIA & EIL.
27	2 Of 16	3.1	R3 C11	Modification	To be submitted for information	To be submitted for information / review of TPIA & EIL as few are for information and few are for review.
28	2 Of 16	3.1	R3 C10	Addition	N.A.	"R" under EIL Column (C10)
29	2 Of 16	3.2	R4 C11	Modification	R-for existing	Previously qualified existing welding Procedure Qualification Record (PQR) under EIL, CEIL, Lloyds, DNV ,TUV and Bureau Veritas Which are not older than 5 years are only acceptable, Else new qualification under witness of CEIL / EIL to be established. Note-1 in Page.16 Of 16 to be modified accordingly.
30	2 Of 16	3.2	R4 C10	Addition	N.A.	"R/W" under EIL Column (C10)
31	2 Of 16	4.1	R5 C2	Addition	N.A.	Nozzle Fittings like SR Neck, LWNRF etc, Flanges, Fittings, Internals, Fasteners, Gaskets & Anchor Bolts
32	2 Of 16	4.1	R5 C3, R5 C4 & R5 C5	Addition	N.A.	Manufacturer's QAP approved by BHEL, TPIA & EIL for all raw materials Plates, Pipes, Forgings, Nozzle Fittings like SR Neck, LWNRF etc, Flanges, Fittings, Internals, Fasteners & Gaskets
33	2 Of 16	4.1	R5 C9	Modification	* (Refer Note-9)	Scope of TPIA (R5 C9) shall be as per relevant item mfr's QAP approved by BHEL, TPIA & EIL
34	2 Of 16	4.1	R5 C10	Addition	N.A.	Scope of EIL (R5 C10) shall be as per relevant item mfr's QAP approved by BHEL, TPIA & EIL
35	2 Of 16	4.1	R5 C11	Modification	Note-9	Shall be replaced with " All items shall be procured with TPIA inspection at source only i.e. With EN 10204 3.2 certification by TPIA as per EIL PR " and " All imported components, If any, shall also be EN 10204 3.2 certification by TPIA as per the contract terms and conditions. (TPIA for imported items shall be as per the contract only)
36	2 Of 16	4.1	R5 C2	Addition	N.A.	Source (i.e. Component manufacturer) shall be EIL approved vendors only.
37	3 Of 16	4.2.1	R6 C3, R6 C4, R6 C5 & R6 C6	Addition	N.A.	EN 10204 3.2 Certification by TPIA and or EIL at source to be verified.

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
38	3 Of 16	4.2.1	R6 C3, R6 C4 & R6 C5	Addition	N.A.	Mfr's QAP approved by BHEL, TPIA & EIL
39	3 Of 16	4.2.1	R6 C4 & R6 C5	Addition	N.A.	EIL Approved drawings.
40	3 Of 16	4.2.1	R6 C10	Addition	N.A.	"H" under EIL Column (C10)
41	3 Of 16	4.2.2	R7 C3, R7 C4, R7 C5 & R7 C6	Addition	N.A.	EN 10204 3.2 Certification by TPIA and or EIL at source to be verified.
42	3 Of 16	4.2.2	R7 C3, R7 C4 & R7 C5	Addition	N.A.	Mfr's QAP approved by BHEL, TPIA & EIL
43	3 Of 16	4.2.2	R7 C4 & R7 C5	Modification	As per TDC and	To be deleted as TDC is a internal document of BHEL and is not a contractual document that can be referffed by TPIA / EIL.
44	3 Of 16	4.2.2	R7 C3	Addition	N.A.	EIL PR
45	3 Of 16	4.2.2	R7 C5	Addition	N.A.	EIL Approved drawings
46	3 Of 16	4.2.2	R7 C10	Addition	N.A.	"H" under EIL Column (C10)
47	3 Of 16	4.2.3	R8 C2	Modification	Non-Pressure parts	Modify as "Non-Pressure Parts [Not getting welded to pressure parts or Non-wet Parts]"
48	3 Of 16	4.2.3	R8 C3	Addition	N.A.	EIL PR
49	3 Of 16	4.2.3	R8 C4 & R8 C5	Addition	N.A.	EIL Approved drawings
50	3 Of 16	4.2.3	R8 C3, R8 C4 & R8 C5	Addition	N.A.	EIL PR
51	3 Of 16	4.2.3	R8 C10	Addition	N.A.	"R" under EIL Column (C10)
52	3 Of 16	4.2.4	R9 C3	Addition	N.A.	EIL PR
53	3 Of 16	4.2.4	R9 C10	Addition	N.A.	"R" under EIL Column (C10)
54	3 Of 16	4.2.4	R9 C11	Addition	N.A.	Welding consumables shall be of reputed & proven make.
55	3 Of 16	4.2.5	R10 C3	Addition	N.A.	EIL PR
56	3 Of 16	4.2.5	R10 C10	Addition	N.A.	"R" under EIL Column (C10)
57	3 Of 16	4.2.5	R10 C3, R10 C4, R10 C5 & R10 C6	Addition	N.A.	EN 10204 3.2 Certification by TPIA and or EIL at source to be verified.
58	3 Of 16	4.2.5	R10 C3, R10 C4 & R10 C5	Addition	N.A.	Mfr's QAP approved by BHEL, TPIA & EIL
59	3 Of 16	4.2.5	R10 C4 & R10 C5	Modification	As per TDC and	To be deleted as TDC is a internal document of BHEL and is not a contractual document that can be referffed by TPIA / EIL.
60	3 Of 16	4.2.5	R10 C4 & R10 C5	Addition	N.A.	EIL Approved drawings
61	3 Of 16	4.2.6	R11 C4 & R11 C5	Modification	As per TDC and	To be deleted as TDC is a internal document of BHEL and is not a contractual document that can be referffed by TPIA / EIL.
62	3 Of 16	4.2.6	R11 C4	Addition	N.A.	Visual, Dimensions & Orientation markings Checks
63	3 Of 16	4.2.6	R11 C4 & R11 C5	Addition	N.A.	EIL Final Approved drawing
64	3 Of 16	4.2.6	R11 C9	Modification	R	Replace it with "H"
65	3 Of 16	4.2.6	R11 C10	Addition	N.A.	"R" under EIL Column (C10)
66	3 Of 16	4.2.6	R11 C11	Addition	N.A.	TPIA (M/s CEIL) may issue the IRN for foundation template as per the approved billing schedule and It shall be HOLD Point for TPIA. TPIA (M/s CEIL) issued IRN may be submitted for endorsement of EIL (Inspection) and It shall be HOLD Point for EIL.

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
67	4 Of 16	5.1	R12 C10	Addition	N.A.	No role fo EIL under Column C10
68	4 Of 16	5.2	R13 C2	Clarify	N.A.	Are both Dished ends(CS, LAS + SS Clad) Hot Formed (OR) Cold Formed ? Both CS Dished end & LAS + SS Clad D'end are of Crown & Petal Type Construction (OR) with Chordal Seams ? If with Chordal Seams, How many ? Accodngly modify all rows frrom 5.1 To 5.11
69	4 Of 16	5.2	R13 C10	Addition	N.A.	"R" under EIL Column (C10)
70	4 Of 16	5.3	R14 C10	Addition	N.A.	"R" under EIL Column (C10)
71	4 Of 16	5.4	R15 C10	Addition	N.A.	"R" under EIL Column (C10)
72	4 Of 16	5.5	R16 C10	Addition	N.A.	No Role under EIL Column (C10)
73	4 Of 16	5.6	R17 C10	Addition	N.A.	"R" under EIL Column (C10)
74	4 Of 16	5.7	R18 C9 & R18 C10	Modification	R	Witness of (100%) samples extraction from Joints by TPIA and review of lab test report for un-diluted chemical analysis by TPIA & EIL.
75	4 Of 16	5.7	R18 C10	Addition	N.A.	"RW" under EIL Column C10
	4 Of 16	After 5.7	New Row	Addition	N.A.	Ferrite check of clad overlay (2 spots per Seam) & Shall be itness point for TPIA and review point for EIL
76	5 Of 16	5.8	R19 C10	Addition	N.A.	No Role under EIL Column (C10)
77	5 Of 16	5.9	R20 C10	Addition	N.A.	"W" under EIL Column (C10)
78	5 Of 16	5.10	R21 C2	Addition	N.A.	Minimum of 10% of clad surface of Dished ends/ toricone made from clad plate shall be ultrasonically examined after final heat treatment for lack of bond.
79	5 Of 16	5.10	R21 C10	Addition	N.A.	"W" under EIL Column (C10)
80	5 Of 16	5.11	R22 C10	Addition	N.A.	"W" under EIL Column (C10)
81	5 Of 16	New Rows	New Rows	Addition	N.A.	PTC details to be added : Number of PTCs for seams in D'end and all tests on PTC as per EIL Specs.6-12-0002 Rev.8 and 6-12-0003 Rev.5 shall be reflected in QAP
82	5 Of 16	6.1	R23 C10	Addition	N.A.	No Role under EIL Column (C10)
83	5 Of 16	6.2	R24C2	Modification	Shell Rolling	To be replaced with " Shell Rolling [Main Shell & Rolled Nozzle Necks]
84	5 Of 16	6.2	R24 C10	Addition	N.A.	No Role under EIL Column (C10)
85	5 Of 16	6.2	R24 C11	Addition	N.A.	"R" under EIL Column (C10)
86	5 Of 16	6.3	R25 C10	Addition	N.A.	"R" under EIL Column (C10)
87	5 Of 16	6.3	R25 C5	Modification	WPS	Replace WPS with "EIL approved WPS" at all locations of QAP
88	6 Of 16	6.4	R26 C10	Addition	N.A.	"R" under EIL Column (C10)
89	6 Of 16	6.5	R27 C10	Addition	N.A.	"R" under EIL Column (C10)
90	6 Of 16	6.6	R28 C10	Addition	N.A.	No Role under EIL Column (C10)

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
91	6 Of 16	6.7	R29 C10	Addition	N.A.	"R" under EIL Column (C10)
92	6 Of 16	6.8	R30 C9 & R30 C10	Addition	N.A.	Witness of (100%) samples extraction from Joints by TPIA and review of lab test report for un-diluted chemical analysis by TPIA & EIL.
93	6 Of 16	6.9	R31 C10	Addition	N.A.	"R" under EIL Column (C10)
94	6 Of 16	6.10	R32 C10	Addition	N.A.	"R" under EIL Column (C10)
95	6 Of 16	6.11	R33	Addition	N.A.	To be Suitably added : Number of PTCs for seams in Shell and all tests on PTC as per EIL Specs.6-12-0002 Rev.8 and 6-12-0003 Rev.5 shall be reflected in QAP
96	7 Of 16	7.1	R34 C10	Addition	N.A.	"R" under EIL Column (C10)
97	7 Of 16	7.1	R34 C5	Modification	WPS	Replace it with "EIL approved WPS"
98	7 Of 16	7.2	R35 C10	Addition	N.A.	"R" under EIL Column (C10)
99	7 Of 16	7.3	R36 C10	Addition	N.A.	"R" under EIL Column (C10)
100	7 Of 16	7.4	R37 C10	Addition	N.A.	No Role under EIL Column (C10)
101	7 Of 16	7.5	R38 C10	Addition	N.A.	"R" under EIL Column (C10)
102	7 Of 16	7.6	R39 C9 & R39 C10	Addition	N.A.	Witness of (100%) samples extraction from Joints by TPIA and review of lab test report for un-diluted chemical analysis by TPIA & EIL.
103	7 Of 16	7.7	R40 C10	Addition	N.A.	"R" under EIL Column (C10)
104	8 Of 16	8.1	R41 C10	Addition	N.A.	"R" under EIL Column (C10)
105	8 Of 16	8.1	R41 C5	Modification	WPS	Replace it with "EIL approved WPS"
106	8 Of 16	8.2	R42 C10	Addition	N.A.	"R" under EIL Column (C10)
107	8 Of 16	8.3	R43 C10	Addition	N.A.	"R" under EIL Column (C10)
108	8 Of 16	8.4	R44 C10	Addition	N.A.	No Role under EIL Column (C10)
109	8 Of 16	8.5	R45 C10	Addition	N.A.	"R" under EIL Column (C10)
110	8 Of 16	8.6	R46 C9 & R46 C10	Addition	N.A.	Witness of (100%) samples extraction from Joints by TPIA and review of lab test report for un-diluted chemical analysis by TPIA & EIL.
111	8 Of 16	8.7	R47 C10	Addition	N.A.	"R" under EIL Column (C10)
112	9 Of 16	9.1	R48 C5	Addition	N.A.	EIL Approved weld-overlay procedure
113	9 Of 16	9.1	R48 C10	Addition	N.A.	No Role under EIL Column (C10)
114	9 Of 16	9.2	R49 C11	Addition	N.A.	Nozzle schedules indicated for weld overlay nozzles are minimum required. It shall be fabricators responsibility to select nozzle schedules so that no shrinkage or wrapping occurs during weld overlay

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
115	9 Of 16	9.2	R49 C11	Addition	N.A.	Flanges of nozzles and man-ways in clad portions of vessels shall be weld over-layered with the recommended alloy material and faced. The flange facing shall be made with weld metal overlay which is at least as thick as the vessels lining but not greater than twice the lining thickness. Weld metal overlay shall be made with minimum two passes(layers). The finish machined weld overlay shall exhibit undiluted weld metal composition at a depth of 2/3rd of the cladding thickness from the finished surface
116	9 Of 16	9.3	R50 C9 & R50 C10	Addition	N.A.	Witness of (RW - Min. 50%) samples extraction from Joints by TPIA and review of lab test report for un-diluted chemical analysis by TPIA & EIL.
117	9 Of 16	9.4	R51 C10	Addition	N.A.	"R" under EIL Column (C10)
118	9 Of 16	9.5	R52 C10	Addition	N.A.	"R" under EIL Column (C10)
119	10 Of 16	10.1	R53C10	Addition	N.A.	No Role under EIL Column (C10)
120	10 Of 16	10.2	R54C10	Addition	N.A.	"R" under EIL Column (C10)
121	10 Of 16	10.3	R55 C10	Addition	N.A.	No Role under EIL Column (C10)
122	10 Of 16	10.4	R56 C10	Addition	N.A.	"R" under EIL Column (C10)
123	10 Of 16	10.5	R57 C9 & R57 C10	Addition	N.A.	Witness of (100%) samples extraction from Joints by TPIA and review of lab test report for un-diluted chemical analysis by TPIA & EIL.
124	10 Of 16	10.5	R57 C10	Addition	N.A.	"R" under EIL Column (C10)
125	10 Of 16	10.6	R58 C10	Addition	N.A.	"R" under EIL Column (C10)
126	11 Of 16	11.1	R59 C10	Addition	N.A.	No Role under EIL Column (C10)
127	11 Of 16	11.2	R60 C10	Addition	N.A.	No Role under EIL Column (C10)
128	11 Of 16	11.3	R61 C10	Addition	N.A.	No Role under EIL Column (C10)
129	11 Of 16	11.3	R61 C11	Addition	N.A.	Nozzles and man-ways and their reinforcing pads shall be attached to the vessel with full penetration welds.
130	11 Of 16	New Rows	New Rows	Addition	N.A.	To be added at appropriate Locations : All Nozzle-To-Shell welds (Root and Final Run) shall be examined by MP / DP examination
131	11 Of 16	11.3a	R62 C10	Addition	N.A.	No Role under EIL Column (C10)
132	11 Of 16	11.4	R63 C10	Addition	N.A.	No Role under EIL Column (C10)
133	11 Of 16	11.5	R64 C10	Addition	N.A.	No Role under EIL Column (C10)
134	11 Of 16	11.6	R65 C10	Addition	N.A.	"R" under EIL Column (C10)
135	11 Of 16	11.7	R66 C9 & R66 C10	Addition	N.A.	Witness of (100%) samples extraction from Joints by TPIA and review of lab test report for un-diluted chemical analysis by TPIA & EIL.
136	11 Of 16	11.7	R66 C10	Addition	N.A.	"R" under EIL Column (C10)
137	11 Of 16	11.8	R67 C10	Addition	N.A.	"R" under EIL Column (C10)

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
138	11 Of 16	11.9	R68 C10	Addition	N.A.	"R" under EIL Column (C10)
139	12 Of 16	12.1	R69 C10	Addition	N.A.	"R" under EIL Column (C10)
140	12 Of 16	12.2	R70 C10	Addition	N.A.	"R" under EIL Column (C10)
141	12 Of 16	12.3	R71 C10	Addition	N.A.	"R" under EIL Column (C10)
142	12 Of 16	12.4	R72 C10	Addition	N.A.	"R" under EIL Column (C10)
143	12 Of 16	12.5	R73 C10	Addition	N.A.	"R" under EIL Column (C10)
144	12 Of 16	13.0	R74 C10	Addition	N.A.	"R" under EIL Column (C10)
145	12 Of 16	14.0	R75 C10	Addition	N.A.	"RW" under EIL Column C10
146	12 Of 16	14.0	R75 C4	Modification	Detection of leakage	Replace it with " Detection of leakage from both outside and inside shell"
147	12 Of 16	15.0	R76 C4	Addition	N.A.	Alignment, Straightness, The centerline of the skirt and the centerline of the shell shall be coincident.
148	12 Of 16	15.0	R76 C10	Addition	N.A.	"H" under EIL Column (C10)
149	12 Of 16	15.0	R76 C11	Addition	N.A.	Tolerances on Vessel dimensions shall be strictly as per EIL Std Doc. 7-12-0001 Rev.6
150	13 Of 16	15.1	R77 C4	Addition	N.A.	Add " Visual Check, Internals fouling check with L & C-Seams of main shell, Elevation of Internals"
151	13 Of 16	15.1	R77 C10	Addition	N.A.	"H" under EIL Column (C10)
152	13 Of 16	15.1	R77 C11	Addition	N.A.	Tolerance on column diameter up to & above 8000 mm shall be greater of $\pm 20\text{mm}$ or $\pm 0.2\%$ of diameter. However if stringer tolerance are recommended by internals supplier, the same shall be complied with.
153	13 Of 16	16.0	R78 C11	Addition	N.A.	Material History / Hat Chart signing by TPIA & EIL. RT & NDT (Upto the stage) Consolidated report signing by TPIA & EIL. All other stage inspection reports signature by TPIA & EIL shall be completed for giving clearance to PWHT.
154	13 Of 16	16.0	R78 C10	Addition	N.A.	"H" under EIL Column (C10)
155	13 Of 16	17.0	R79 C4	Addition	N.A.	All tests on PTC as per EIL Specs.6-12-0002 Rev.8 and 6-12-0003 Rev.5 shall be reflected in QAP
156	13 Of 16	17.0	R79 C10	Addition	N.A.	"W" under EIL Column (C10)
157	13 Of 16	18.0	R80 C10	Addition	N.A.	"RW" under EIL Column (C10)
158	13 Of 16	18.0	R80 C2	Addition	N.A.	WFMT shall be carried out on all weld seams of CS (NACE +HIC) Section & Top dish head including L & C Seam of CS (NACE+HIC) and LAS+CLAD Section after PWHT
159	13 Of 16	18.0	R80 C2	Addition	N.A.	100% Magnetic Particle Examination of all weld surfaces [Inside & Outside] shall be performed after Final PWHT

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
160	13 Of 16	18.0	R80 C2	Modification	100% UT on pressure retaining welds	100% UT shall be carried out on weld built-up after completion & After final PWHT
161	13 Of 16	19.0	R81 C10	Addition	N.A.	"RW" under EIL Column (C10)
162	13 Of 16	20.0	R82 C11	Addition	N.A.	Hardness measuring spots shall be strictly in-line with EIL Specs.6-12-0002 Rev.8 & 6-12-0003 Rev.5 and shall be reported accordingly.
163	13 Of 16	20.0	R82 C10	Addition	N.A.	"RW" under EIL Column C10
164	13 Of 16	21.0	R83 C4	Addition	N.A.	Alignment, Straightness, The centerline of the skirt and the centerline of the shell shall be coincident.
165	13 Of 16	21.0	R83 C10	Addition	N.A.	"W" under EIL Column C10
166	14 Of 16	22.0	R84 C2	Addition	N.A.	Including Allot Steel & SS Welds @ ID Side & OD Side
167	14 Of 16	22.0	R84 C10	Addition	N.A.	"RW" under EIL Column (C10)
168	14 Of 16	New Rows	R85 [New Rows to be added at relevant locations of QAP for welding, NDE and test]	Addition	N.A.	Torispherical / 2:1 Ellipsoidal dished ends shall be designed and supplied to nozzle connections (Nozzle mark "2" i.e. O.H. Vapor") provided with spool piece as per MDS for the purpose of hydrotest. After hydrotesting, the dished ends shall be cut and removed and weld edges of spool piece for Nozzle mark "2" i.e. O.H. Vapor" shall be prepared & supplied as per MDS
169	14 OF 16	23.0	R85	Addition	N.A.	External and internal surfaces of all welds shall be checked by Magnetic Particle examination after hydro-test for LAS portion of vessels having thickness above 50 mm.
170	14 OF 16	23.0	R85	Addition	N.A.	Gaskets used for hydrotesting of equipment shall be of the same specification as service gaskets and the fabricator shall supply new gaskets for manholes and nozzles with blind/companion flanges apart from spares. Gaskets used for hydrotest shall not be used for actual hook up.
171	14 OF 16	23.0	R85	Addition	N.A.	Only potable water shall be used for hydrostatic test with maximum chloride content shall be 25 ppm.
172	14 OF 16	23.0	R85	Addition	N.A.	During hydrotest, the yield strength of the material at the temporary saddle supports shall be taken care of to avoid local stresses in shell from exceeding 90 %.

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
173	14 OF 16	23.0	R85	Addition	N.A.	All necessary precautions shall be taken to guard against the risk of brittle fracture during hydrostatic test in the shop and at site. The temperature of testing medium shall be as per Code. Prior to hydrostatic test, all weld spatter, weld stubs, scale, dirt etc. shall be removed from vessel. After hydrostatic testing, vessel shall be thoroughly dried by blowing dry air. Vessel shall be dried thoroughly using hot air, immediately after draining, to prevent the possibility of evaporation and concentration of chlorides and fluorides
174	14 OF 16	23.0	R85	Addition	N.A.	Weld deposit overlay shall be spot liquid penetrant examined (a minimum of 10% of the surface, including no less than 1 square foot in each 10 square feet or fraction thereof) after final heat treatment and shop hydrostatic testing. Liquid dye penetrant examination shall be in accordance with methods described in ASTM E 165.
175	14 OF 16	23.0	R85	Addition	N.A.	If Hydrostatic test is chosen to be performed in horizontal position, Then test pressure shall be calculated by taking into account of pressure gradient. This calculated value shall be approved by EIL Engg.
176	14 OF 16	23.0	R85 C10	Addition	N.A.	"H" under EIL Column (C10)
177	14 OF 16	24.0	R86 C5	Addition	N.A.	EIL Approved procedure
178	14 OF 16	24.0	R86 C10	Addition	N.A.	"R" under EIL Column (C10)
179	14 OF 16	After 24.0	New Row	Addition	N.A.	After Hydrostatic test, drying and pickling & Passivation, The stainless steel surfaces shall be checked for free of iron pick up. This shall be checked by Ferroxyl test in accordance with ASTM A-380. This shall be witness point for TPIA and Review point for EIL.
180	14 OF 16	25.0	R87 C5	Addition	N.A.	EIL Approved procedure & EIL PR
181	14 OF 16	25.0	R87 C6	Addition	N.A.	Paint batch test certificate (TC) shall be reviewed by TPIA & EIL. Paint make / brand shall be as per PR.
182	14 OF 16	25.0	R87 C10	Addition	N.A.	"R" under EIL Column (C10)
183	14 OF 16	26.0	R88 C4	Clarify	N.A.	What is the difference between 25.0 & 26.0, Clarify ?
184	14 OF 16	26.0	R88 C2	Clarify	N.A.	What about application of finish paint as per Job Spec. ? Clarify
185	14 OF 16	27.0	R89 C10	Addition	N.A.	"R" under EIL Column (C10)
186	14 OF 16	27.0	R89 C11	Addition	N.A.	Bevelled ends for field welding shall be protected by metal covers to prevent damage and entrance of foreign materials.
187	14 OF 16	28.0	R90 C10	Addition	N.A.	"R" under EIL Column (C10)
188	14 OF 16	29.0	R91 C10	Addition	N.A.	"Endorsement on TPIA IRN by EIL"
189	15 OF 16	30.1	R92 C10	Addition	N.A.	"R" under EIL Column (C10)

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
190	15 Of 16	30.2	R93 C10	Addition	N.A.	"R" under EIL Column (C10)
191	15 Of 16	30.3	R94 C10	Addition	N.A.	"R" under EIL Column (C10)
192	15 Of 16	30.4	R95 C10	Addition	N.A.	"H" under EIL Column (C10)
193	15 Of 16	30.5	R96 C10	Addition	N.A.	"H" under EIL Column (C10)
194	15 Of 16	30.6	R97 C10	Addition	N.A.	"R" under EIL Column (C10)
195	15 Of 16	30.6	R97 C6	Addition	N.A.	Paint batch test certificate (TC) shall be reviewed by TPIA & EIL. Paint make / brand shall be as per PR.
196	15 Of 16	30.7	R98 C10	Addition	N.A.	"Endorsement on TPIA IRN by EIL"
197	15 Of 16	30.8	R99 C10	Addition	N.A.	"H" under EIL Column (C10)
198	15 Of 16	30.8	R99 C11	Addition	N.A.	Refer relevant notes below. Certification of As-Built Drawings & Final Documents Folders (In Hard & Soft Copies) by TPIA.
199	15 Of 16	30.8	R99 C11	Addition	N.A.	Submission of Final Documents in required number of hard copies and required number of CDs as detailed in VDR and also uploading / submission of final documents through in EIL Vportal is to be ensured by BHEL and Issuance of Certificate of Completeness of Final Documents as per VDR in prescribed format by TPIA.
200	New Rows	New Rows	New Rows	Addition	N.A.	Stages of quality checks for Structural assemblies like Platforms, Ladder Assemblies etc is not covered.
201	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	IMPORTANT NOTE : QAP is just a guiding document for inspection purpose and Review /approval of QAP shall not relieve the responsibility of BHEL to comply to all requirements of Contract, EIL PR & EIL approved drawings.
202	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All materials shall be new only.
203	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The tolerance on thickness of all plates (Base Plate separately & Clad Plate Separately) shall be positive only.
204	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All CS & LAS Plates shall be free from injurious defects and shall have workmanlike finish. Reconditioning/repair of plates by welding shall not be permitted. Surface conditions of CS & LAS Plates shall meet requirements of EN10163 Class-A Subclass 3.
205	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Outside surface of base metal of Clad Plate shall meet requirements of EN 10163 class- A sub clause-3.
206	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The SS surface of Clad Plates shall have No.1 finish for hot rolled and 2B finish for cold rolled.
207	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Product Chemical analysis for each plate shall be carried out for all CS & LAS Plates with requirements as per EIL Specs. for Plates

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
208	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Heat treatment of Plates shall be as below, CS Plates : Normalized // LAS Plates : Normalized & Tempered // SS Plates : Solution (Fully) annealed // Clad Plates : as per the applicable clad plate material specification (SA-264)
209	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	UT of all Plates shall be as below, CS, LAS & SS Plates : a) Plates having thickness 16 mm to 50 mm (both inclusive) shall be examined ultrasonically as per SA-435. b) For thicknesses above 50mm ultrasonic examination shall be carried out as per SA-578 and shall have acceptance standard of level-B.
210	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All additional requirements of CS (NACE + HIC) Plates as per EIL Spec.6-79-0013 Rev.2 shall be strictly be complied without any deviations.
211	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Charpy V-notch impact test shall be carried out for each LAS (P11) Plate at minus 18°C with average value of three specimens as 33 joules with minimum value of each specimen as 22 joules.
212	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Impact tests (Charpy V-Notch) shall be carried out for each LAS (P22) Plate at minus 29 °C with 55J average value for three specimens and with no single specimen below 48J. The orientation of test specimen shall be transverse to the direction of final rolling.
213	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Impact energy versus temperature (transition) curves shall be developed for each heat of LAS (P22) Plate with additional requirements as per EIL Spec.6-12-0018 Rev.4.
214	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Step cool tests shall be performed on completely heat treated material with minimum PWHT condition and maximum PWHT condition including all ISR from each heat of LAS (P22) Plate with additional requirements as per EIL Spec.6-12-0018 Rev.4.
215	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The hardness of each LAS (P11) plate shall be limited to such an extent that the final hardness in base metal, HAZ and welds of the vessel shall not exceed 225 BHN.
216	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Hardness of LAS (P22) plates shall not exceed 225 BHN.
217	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Additional requirements for higher thickness plates and simulation test coupon requirements of CS & LAS as per EIL Specs.6-12-0011 Rev.8, 6-12-0017 Rev.5 & 6-12-0018 Rev.4 shall be reflected in QAP and shall be ensured.

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
218	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All clad steel plates shall be ultrasonically examined in accordance with SA-578 with acceptance standard level-C and shall meet the supplementary requirements S1. Integrity of clad plate shall be ensured Quality level : Class-1 as per SA 263 or SA 264 or SA 265. The ultrasonic examination shall be conducted after the specified final heat treatment of the clad steel plates.
219	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	During the mill tension test of all clad steel plates after heat treatment, the cladding shall be removed and the tensile properties shall meet the requirements of the base material. Test specimen shall be taken transverse to rolling direction.
220	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	For all clad steel plates, shear test shall be conducted. Strength of bond shall be at least 20,000 psi in shear.
221	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The LAS (P22) Plate steel shall be made by electric furnace or basic oxygen process and shall be vacuum degassed.
222	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The tensile strength at room temperature shall not exceed 690 N/mm ² and the yield strength should not exceed 620 N/mm ² for LAS (P22) Plates.
223	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The LAS (P22) Plate material shall have an austenitic grain size 5 (Five) or finer as determined by the method of ASTM E-112.
224	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All SS Plates shall have No.1 finish on both sides with reference to SA-480.
225	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All SS Plates shall be supplied in hot-rolled, fully annealed and pickled condition.
226	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All SS Plate & SS Clad Plate representative of each heat shall be subjected to IGC test as per ASTM A-262 Practice-E for all the 300 series materials. The bend test specimen shall be examined at a magnification of 200 X and bent specimen shall be free of any cracks or grain dropping.
227	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All bought out items/ components can be sub-ordered or sub-contracted to EIL approved vendors/ sub-contractors only.
228	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All fabrication and manufacturing of column and it's components shall be performed at EIL approved locations / works only.
229	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	CS shell section & top dished end including nozzle shall meet NACE+HIC requirements as per NACE MR 0103 & EIL Spec. 6-79-0013. Hardness of base metal. Weld & HAZ after PWHT shall be 200 BHN max.
230	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All CS/LAS plates shall be impact tested as per code/spec

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
231	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	2.25 Cr.+1 Mo shall comply with requirement for step cooling, J-factor less than or equal to 100 & X factor less than or equal to 15
232	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	2 ¼ Cr-1 Mo and 1 ¼ Cr-1/2 Mo shall be normalized and tempered
233	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Calibration records of all measuring instruments to be reviewed and signed by TPIA & EIL.
234	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Tolerance on column diameter up to & above 8000mm shall be greater of $\pm 20\text{mm}$ or $\pm 0.2\%$ of diameter. However if stringer tolerance are recommended by internals supplier, the same shall be complied with.
235	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Nozzle schedules indicated for weld overlay nozzles are minimum required. It shall be fabricators responsibility to select nozzle schedules so that no shrinkage or warpage occurs during weld overlay
236	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Flange gasket face shall have 125 AARH finish
237	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	BHEL to store Radiographic examination reports with films for 5 years.
238	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Material History / Heat Chart for both Pressure and Non-Pressure Parts including welding consumables (With details like Appd Drg Part Numbers, Part Description, Size & Qty as per EIL appd drg., Part Description, Size & Qty offered and inspected, MTC Number, Heat Number, Material Identification Report reference Number, Deviation approval reference, IF any as applicable) to be reviewed by TPIA & EIL.
239	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Consolidated list (Weld Plan) of Weld Joint-wise applicable WPS, PQR & WPQ, Welders records to be reviewed by TPIA & EIL along with shooting sketch of entire column.
240	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Consolidated list of Weld Joint-wise all NDE records (RT, UT, DP, MPI) (NDE Plan) (Giving reference of Joint No, NDT Record No etc, TPIA / EIL sign date) to be reviewed by TPIA & EIL.
241	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Final dispatch clearance of Column at BHEL and Internals at Sulzer India by TPIA & EIL shall be based on Final (Code-1) approved drawings only.
242	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All telltale holes in pads, etc. shall be packed with grease prior to shipment. In the event of alloy material, the grease shall be low-lead and suitable to prevent contamination of material.
243	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Internal and exposed machined surfaces shall be coated with an easily removable protective coating equal to Rust-Ban 385. Other coatings may be used subject to the prior approval of the Purchaser.

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
244	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The North and East orientations shall be center-punched on the outside of each vertical vessel approximately 6 inches above the bottom tangent line and 6 inches below the top tangent line. The punch marks shall be circled with white paint.
245	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Center of gravity for shipment shall be paint marked on the two opposite sides of vessels.
246	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Column shall have the following notation painted on it prior to shipment: "NO WELDING PERMITTED ON THIS VESSEL" The letters shall be approximately 3 inches high painted with a contrasting color. a) On vertical vessels, this sign shall be located on two opposite sides near the bottom tangent line and repeated at approximately each 20 feet of height, but rotated 90 degrees.
247	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Specific marking with white paint on Column for slinging shall be provided.
248	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Certification of As-Built Drawings & Final Documents Folders (In Hard & Soft Copies) by TPIA.
249	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Submission of Final Documents in required number of hard copies and required number of CDs as detailed in VDR and also uploading / submission of final documents through in EIL Vportal is to be ensured by BHEL and Issuance of Certificate of Completeness of Final Documents as per VDR in prescribed format by TPIA.
250	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Inspection of Mandatory Spares of Column and Internals by TPIA shall be HOLD point and review for EIL
251	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All SS surfaces shall be pickled and passivated as per ASTM A380
252	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All self reinforced integrally forged nozzles shall have lip configuration (100% radiographable) with smooth radius at corners
253	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Temporary attachment welds on pressure shells shall be removed. The surface under such welds and under backing rings which have been removed shall be properly conditioned to eliminate surface stress risers. Such surfaces shall be examined by either the magnetic particle or liquid penetrant method.

As Commented



EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
254	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Arc strikes on the pressure shell shall be avoided. When they occur, the surface shall be properly conditioned to eliminate surface stress risers and shall be examined by either the magnetic particle or liquid penetrant method of examination.
255	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The profile of the fillet weld attaching the non-pressure, load bearing part to the vessel shall meet the requirements of AWS D.1.1
256	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Machined surfaces shall not be painted.
257	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	In addition to ASME Code requirements, the image quality indicator and radiographic examination shall be in accordance with ASTM E142 except that the penetrameter design shall conform to the ASME Code. Radiographic film shall be of the fine grain type possessing high contrast and definition, ASTM E94, Types I and II and shall be used with lead screens only. Film densities for radiographs made shall be in accordance with the requirements of Article 2 of Section V of ASME Code.
258	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Interference / Fouling of nozzles with circumferential seams is not acceptable. All main weld seams shall be clear of nozzles, reinforcement pads, internals, tray support rings, cleats and stiffening rings by 50 mm minimum (weld edge to weld edge). In case the same is unavoidable, It shall be brought to the notice of EIL with resolution.
259	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Inspection of Structured/Grid Packings, Chimney trays and Associated Internals shall be carried-out as per EIL Specifications No. 6-14-0015, 6-81-0016 & 6-81-0017.

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
260	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	For marine transportation, the following shall be taken care / provided by vendor: After completion of all testing and inspection, the inside of complete equipment shall be thoroughly drained and dried out. Equipment shall be completely dried by passing hot air for sufficient time until no further increase in relative humidity of outgoing air is observed. After drying, the equipment shall be purged and filled with dry N2 at 0.25 kg/cm2. The equipment shall be provided with pressure gauge to monitor N2 pressure and ½" non-return valve. For column / vessel sections to be transported via sea routes, temporary adequate closure (design & arrangement by vendor) shall be provided at open end (which shall be cut & removed at site before assembly) so that dry N2 at 0.25 kg/cm2 pressure is maintained inside. All threaded holes other than tell tale holes for testing shall be suitably protected with steel bar plugs. All nozzles not provided with blind flange shall be provided with steel covers, temporary gaskets and bolts. All external surfaces shall be properly protected / covered against sea environments.
261	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All reinforcing pads shall be provided with two 1/8" (3 mm) NPT tapped holes located 1800 apart for air soap solution test with a pressure of 1.25 Kg/cm2 (g).
262	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All bolts/studs shall have ISO threading unless otherwise specified. Studs shall extend beyond nuts at least by 2 threads & studs shall be threaded to full length. Bolts/studs (to be tightened by hydraulic bolt tensioner) shall be longer than normal length by minimum 1 nut diameter.
263	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All internal bolts shall be provided with double nuts.
264	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Threads on external bolting shall be lubricated with graphite grease for working temperature up to 200°C and with Molybdenum Disulphide for higher temperature.
265	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	In addition to stamping of the specifications & manufacturer's symbol as specified in ASME material specifications, size shall be clearly punch marked on one of the ends of the stud. Similarly the nuts shall have the size punch marked on one of the faces. Further for all Alloy / SS metallurgy bolts & nuts shall also be identified by distinct color marking at the stud end/bolt side face.

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
266	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Nozzles and man-ways and their reinforcing pads shall be attached to the vessel with full penetration welds.
267	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Vessels shall be post weld heat treated as a complete unit including skirt/support,
268	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All flange faces shall be suitably protected against oxidation during post weld heat treatment.
269	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Vessels shall be post weld heat treated as a complete unit including skirt/support,
270	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Weld seams of formed end & Toricones shall be 100% radiographed after PWHT. The specified radiography of welds may be performed before or after postweld heat treatment (PWHT). If performed before PWHT, an additional radiography or alternatively, ultrasonic examination shall be performed after PWHT.
271	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All Nozzle-To-Shell welds (Root and Final Run) shall be examined by MP / DP examination
272	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All electrodes and fluxes shall be properly baked / dried as per manufacturer's recommendation before use.
273	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	3.2.1. All bare electrodes and fluxes shall be selected as per ASME IIC. All weld metal shall have equal or better mechanical properties than the parent metal.
274	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Only dry flux shall be used.
275	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Magnetic particle/Dye-penetrant examination shall be carried out on the outside and inside surfaces including edges of tori-spherical or elliptical heads in knuckle zone for detection of cracks.
276	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All welding edges shall be checked by MPI for LAS and Magnetic particle/Dye-penetrant examination for CS for detection of cracks, laminations or segregations.
277	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	No welding shall be carried out when the ambient temperature is less than 15 C. Any welding once started should be completed in one operation as far as possible.
278	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The ultrasonic examination shall be carried out within 2t of material thickness (t) of all weld edges of LAS prior to welding as per ASTM A 578 with acceptance level-B.

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
279	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Flanges of nozzles and man-ways in clad portions of vessels shall be weld over-layered with the recommended alloy material and faced. The flange facing shall be made with weld metal overlay which is at least as thick as the vessels lining but not greater than twice the lining thickness. Weld metal overlay shall be made with minimum two passes(layers). The finish machined weld overlay shall exhibit undiluted weld metal composition at a depth of 2/3rd of the cladding thickness from the finished surface
280	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Clad steel plates used for the fabrication of vessels shall conform to SA264 of ASME Section-IIA and EIL Standard Specification for Clad Plates (No.6-12-0015 Rev.5)
281	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Cladding alloy weld deposit / restoration at weld seam location shall be made of at least two layers.
282	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The recommended SMAW welding consumables for welding different clad plates shall be as listed below. However for achieving the undiluted composition at the desired depth of 2/3rd of the cladding thickness from finished surface, intermediate grinding or half bead technique shall be used. Alternatively low dilution processes such as pulsed Gas Metal Arc Welding (P- GMAW) or Electro-slag Welding process with appropriate welding consumables shall be used for achieving the correct dilution and composition requirement.
283	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	For welding of clad piping components such as pipe to pipe / pipe fitting from single side where approach from clad side is not accessible, shall be done with a welding consumable matching the clad material followed by a intermediate layer of pure iron (ARMCO/KARDO Iron) welding filler material and then by a welding consumable matching the base material.
284	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Weld joints in the base plates shall be radiographed as specified in MDS for detection of cracks/flaws, before clad side welding is carried out. Just before clad restoration welding, the prepared surface shall be inspected by 100% dye penetrant testing.
285	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The weld overlay procedure shall be qualified as per ASME Code Section-IX. Weld deposition cladding procedure shall be qualified separately in presence of authorized inspector to yield a weld deposit that exhibits undiluted weld metal composition at a depth of 2/3rd of the cladding thickness from top of the finished overlay surface.

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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
286	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	When flush finish is required for the clad restoration side, back grinding of the base material to a depth of 2 mm can be permitted provided this reduction of thickness is compensated by the external reinforcement of the base metal weld.
287	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	A minimum of two samples of the weld metal overlay shall be taken from each overlaid shell section and each head to confirm required chemical analysis. Each manual weld overlay, such as those on nozzles and flanges, shall also be sampled. Chemical analysis at a depth of 2/3rd of the cladding thickness from top of the finished overlay thickness shall conform to the chemistry requirements
288	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	100% of surface of Knuckle area and Straight face and minimum of 10% of clad surface of Dished ends/ toricone made from clad plate shall be ultrasonically examined after final heat treatment for lack of bond.
289	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	A minimum of 10% of clad surface, not less than one square foot in each 10 square foot or fraction thereof shall be examined for lack of bond after forming of shells from Cladded plate including rolled nozzles of Cladded plate.
290	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	100% Ultrasonic examination shall be carried out of areas where attachments are to be welded directly to the cladding. The above areas shall include 50mm width of adjacent areas on both sides of attachment.
291	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Un-bonded areas of cladding that cannot be encompassed by a 1 inch diameter circle shall be repaired by weld deposit overlay in accordance with 5.1.2 of this specification. When repairs in excess of 3 % of total examined area are required, the vessel shall be 100 % ultrasonically examined. Repaired areas and weld deposit overlay at weld seams shall be 100% liquid penetrant examined. Ultrasonic examination shall be in accordance with ASME A578 with acceptance standard Level-C and meeting the supplementary requirement S7. Liquid dye penetrant examination shall be in accordance with methods described in ASTM E 165.
292	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	All weld deposit overlays, whether by manual or automatic procedures, shall be 100% liquid penetrant examined after each layer of deposit including final layer. Liquid dye penetrant examination shall be in accordance with methods described in ASTM E 165.


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EIL COMMENTS ON BHEL QAP No.: CQP 2516 Rev 0 DT.05-FEB-2021 FOR MAIN FACTIONATOR COLUMN (MFC) (TAG.111-C-2101) FOR M/s HRRL, BARMER						
Sl. No.	QAP Page No.	QAP Sl. No.	QAP Location (Cell) Identification	Addition / Modification	Existing Description, In case of Modification	EIL Comments
293	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Weld deposit overlay on machined surfaces shall be 100% liquid penetrant examined after final heat treatment. Liquid dye penetrant examination shall be in accordance with methods described in ASTM E 165.
294	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Weld deposit overlay shall be spot liquid penetrant examined (a minimum of 10% of the surface, including no less than 1 square foot in each 10 square feet or fraction thereof) after final heat treatment and shop hydrostatic testing. Liquid dye penetrant examination shall be in accordance with methods described in ASTM E 165.
295	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Cracks, Fissures and circular defects greater than 1/16 inch (1.6mm) diameter in weld deposit overlay shall be completely removed and repaired. Repaired areas shall be subjected to 100% liquid penetrant examination.
296	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	After the completion of fabrication and testing, all stainless steel clad surfaces shall be pickled and passivated in accordance with ASTM A-380.
297	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	SMAW welding consumables for welding different clad plates shall be, Barrier / First Layer : AWS A 5.4, ASME SPA5.4 / E309L and Top Layer : AWS A 5.4, ASME SPA5.4 / E308L.
298	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The stainless steel surfaces shall be free of iron pick up. This shall be checked by Ferroxy test in accordance with ASTM A-380.
299	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The repair of clad stainless steel should be avoided. If unavoidable, the number of repairs at the same spot should not exceed two. The repair procedure should be specifically qualified with IGC testing.
300	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Repair of cladding surface by welding shall not exceed 3% of surface area of individual plate
301	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	The integral & continuous cladding shall be produced by roll bonding or explosion bonding process with bond integrity Class 1.
302	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Alloy cladding representative of each heat shall be subjected to inter-granular corrosion test as per ASTM A-262, Practice E for all 300 series material. IGC test shall be carried out after cladding process.
303	Page.16 Of 16	N.A.	Under Notes :	Addition	N.A.	Removable Internals trial assembly inside the Column at BHEL works is not mentioned

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 HPVP	PROCEDURE FOR RADIOGRAPHIC EXAMINATION	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 1 of 18
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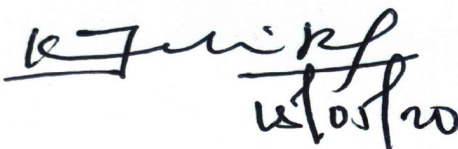

ISSUE NO. : 2

PROCEDURE FOR RADIOGRAPHIC EXAMINATION

Issue No	Rev No	Date of Revision	Brief Records of Revision
1	0	02-02-2015	First Edition
1	1	11-04-2017	Cl. no. 3,7,10,12,13,15 revised as per ASME Sec V Edition 2015
2	1	25-04-2018	Cl. no. 3,14,15,18 revised as per ASME Sec V Edition 2017
2	2	15-05-2020	Cl. no. 3.1,3.2,9.2,11,12.1,12.4,16.5 revised; Cl. no.1,5,6,9,14,15,16.2 Modified.

EIL Comments: All NDT procedure viz RT/UT/MPI /LPI made are a generic and not to the specific order. Additional requirement if any mentioned in PR shall be followed.
These procedure reviewed and noted .



Prepared by  (K. JANAKI RAMULU) NDE LEVEL-II	Reviewed & Approved by  VENKATA RAVI CHANDRA M. ASNT NDT LEVEL III-RT,UT,MT,PT CERTIFICATE No. 204694 (M.V. RAVI CHANDRA) NDE LEVEL-III
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All NDT procedures shall meet the requirements of applicable codes and specifications, PR Scope and extent , acceptance criteria shall be as per applicable drawing and specifications



 HPVP	PROCEDURE FOR RADIOGRAPHIC EXAMINATION	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 2 of 18
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TABLE OF CONTENTS

Cl. No.	Title	Sheet
1.	SCOPE	3
2.	POLICY	3
3.	APPLICABLE STANDARDS	3
4.	SYSTEM	3
5.	SURFACE PREPARATION	4
6.	REINFORCEMENT	4
7.	SELECTION OF RADIOGRAPH	5
8.	INTENSIFYING SCREENS	6
9.	IMAGE QUALITY INDICATORS (IQI)	6
10.	RADIATION ENERGY SELECTION	7
11.	BACKSCATTER RADIATION	7
12.	SYSTEM OF IDENTIFICATION	8
13.	RADIOGRAPH MAKING TECHNIQUES	8
14.	IQI SELECTION	9
15.	GEOMETRIC UNSHARPNESS, EXPOSURE TIME CALCULATION	9
16.	EVALUATION	11
17.	DISPOSITION OF WELDS	12
18.	PRESERVATION OF RADIOGRAPHS & EVALUATION REPORTS	12
	RADIOGRAPHY ACCEPTANCE LEVELS -FULL RADIOGRAPHY	13
	RADIOGRAPHY ACCEPTANCE LEVELS -SPOT RADIOGRAPHY	14
	ROUNDED INDICATION CHARTS	15 TO 18
Exhibit 1	RADIOGRAPHIC EXAMINATION TECHNIQUE SHEET CUM REPORT FORMAT	

 <p>HPVP</p>	<p align="center">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	<p>PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 3 of 18</p>
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1. SCOPE

This procedure specifies the requirement for radiographic examination of butt welded joints in steel(Carbon Steel, Alloy Steel, Stainless Steel etc.) and non-ferrous materials using x-rays or gamma rays as a source of radiation for detecting and evaluating flaws within the weld and HAZ (heat affected zone). It applies to the welded joints in pressure vessels, heat exchangers, columns and pipes etc. Radiographic technique used to demonstrate that required IQI sensitivity and density requirements are achieved.

2. POLICY

- 2.1.** The radiographic examination be carried out either as or one of the procedures enumerated in the following pages which are verified and found to be in accordance with latest ASME SEC V or as per any other applicable referencing code sections and specifications.
- 2.2.** Only personnel qualified in accordance with BHEL HPVP NDE Written Practice shall carry out any radiographic examination.


3. APPLICABLE STANDARDS

- 3.1.** ASME SEC V Edition 2019.
- 3.2.** Construction code sections ASME Sec I, ASME Sec VIII Div 1, ASME Sec VIII Div 2 Edition 2019, ASME B31.1 Edition 2016, NBIC NB 23 Edition 2019, SNT-TC-1A Edition 2016 & ASME SEC V Edition 2019 Art.1.

4. SYSTEM

All radiographic examination procedures be amended and approved as required by NDE level III taking into consideration of

- 4.1.** Experience gained in various examination procedures.
- 4.2.** Recommendations of audit teams.
- 4.3.** Referencing code sections.

 HPVP	PROCEDURE FOR RADIOGRAPHIC EXAMINATION	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 4 of 18
--	---	---

Each page of the document be independently controlled and revision status be indicated on the title page.

5. SURFACE PREPARATION:

The weld ripples or weld surface irregularities on both inside(where accessible) and outside shall be removed by any suitable process to such a degree that the images of surface irregularities cannot mask or be confused with the image of any discontinuity on the resulting radiograph.

The finished surface of all butt-welded joints may be flush with the base material or may have reasonably uniform crones, with reinforcement not to exceed that specified in the referencing code section.


Welds be visually examined to ensure free from surface irregularities which can mask or cause difficulty in detecting discontinuities. If required surface be ground and surface imperfections removed.

6. REINFORCEMENT

The thickness of reinforcement on each side of all butt welded longitudinal and circumferential joints not exceed the limits as given below:

As per ASME Sec-VIII Div 1:

Material thickness (Nominal) (mm)	Permitted Maximum Reinforcement	
	Cat B& C Butt welds (mm)	Other welds (mm)
< 2.4	2.4	0.8
2.4 to 4.8	3.0	1.5
>4.8 to 13	4.0	2.5
>13 to 25	5.0	2.5
>25 to 51	6.0	3.0
>51 to 76	6.0	4.0
>76 to 102	6.0	5.5
>102 to 127	6.0	6.0
>127	8.0	8.0

 HPVP	PROCEDURE FOR RADIOGRAPHIC EXAMINATION	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 5 of 18
---	---	---

As per ASME Sec-VIII Div 2:


Material thickness (Nominal) (mm)	Permitted Maximum Reinforcement	
	Circumferential welds in Pipes & Tubes (mm)	Other welds (mm)
< 2.5	2.5	0.8
≥ 2.5 to < 5.0	2.5	1.5
≥ 5.0 to < 13.0	3.0	2.5
≥ 13.0 to < 25.0	4.0	2.5
≥ 25.0 to < 50.0	4.0	3.0
≥ 50.0 to < 76.0	4.0	4.0
≥ 76.0 to < 100.0	5.5	5.5
≥ 100.0 to < 125.0	6.0	6.0
≥ 125.0	8.0	8.0

As per ASME Sec-I:

Material thickness (Nominal) (mm)	Permitted Maximum Reinforcement	
	Circumferential welds in Pipes & Tubes (mm)	Other welds (mm)
< 3.0	2.5	2.5
3.0 to 5.0	3.0	2.5
>5.0 to 13.0	4.0	2.5
>13.0 to 25.0	5.0	2.5
>25.0 to 50.0	6.0	3.0
>50.0 to 75.0	The greater of 6 mm or 1/8 times the width of the Weld (in mm).	4.0
>75.0 to 100.0		5.5
>100.0 to 125.0		6.0
>125.0		8.0

7. SELECTION OF RADIOGRAPH

Either Agfa D4/D7 or Fuji IX 50/100 brand radiographs be used

 HPVP	<p align="center">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 6 of 18
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8. INTENSIFYING SCREENS

For Iridium 192,X-ray(150 KV – 200 KV) 0.15 mm thick, Co-60 0.25 mm thick front and back Lead intensifying screens shall be used.

9. IMAGE QUALITY INDICATIONS (IQI)

9.1. SELECTION :

9.1.1. MATERIAL:

IQI shall be selected from either the same alloy material group or grade as identified in SE-747 for ASTM wire type or SE-1025 for hole type IQI or grade with less radiation absorption than the material being radiographed.

9.1.2. SIZE:


Nominal single wall Thickness of the base metal (thickness of the thinner incase dissimilar thickness base metals are joined) including the estimated allowed weld reinforcement both in ID and OD be considered for IQI selection. The values used for the estimated weld reinforcement thicknesses shall be representative of the weld conditions and shall not exceed the maximums permitted by the referencing code section. Physical measurement of the actual weld reinforcements not required. Backing rings or strips shall not be considered as part of the thickness in IQI selection. Refer Clause. 14 below for the selection of IQI designation.

9.2. PLACEMENT:

IQI(s) be placed on source side of the object unless hand placing of IQI is not feasible. In such case, the IQI be placed on radiograph side of weld with a letter 'F' placed adjacent to the IQI.

Wire type IQI's be placed on the weld so that the lengths of the wires are transverse to the longitudinal axis of the weld and Hole type IQI's be placed adjacent and parallel to the weld axis, one at each end of the radiography spot..

When weld reinforcement or backing strip is not removed, a shim of material radiographically similar to weld metal be kept under the hole type IQI.

 <p>HPVP</p>	<p align="center">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	<p>PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 7 of 18</p>
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9.3. NUMBER OF IQI's:

For unidirectional exposures, at least one IQI image appears on each radiograph where one or more radiograph holders are used for an exposure. If the density of the radiograph varies by more than –15% or +30% from the density through the body of hole type IQI, or adjacent to the required wire, an additional IQI be used for each exceptional area or areas and the radiograph is retaken.

For cylindrical components where the source is placed on the axis of the component for a single exposure at least three IQI's be placed approximately 120° apart.

10. RADIATION ENERGY SELECTION (SOURCE SELECTION):

The selection be such that required IQI sensitivity and density are achieved.


The recommended source for radiography of objects is as below.

Applicable ranges shall be as per provisions in Article 22 SE 94

- Iridium 192 – with thickness from 6 to 65 mm.
- Co-60 – for thickness above 35 mm.
- X-ray equipments (100 KV – 200 KV) may be used for thickness 12 mm and below to achieve higher sensitivity, if required.

11. BACK-SCATTER RADIATION

A lead symbol 'B' shall be placed within the area of radiograph with minimum dimensions of 11 mm height and 1.5 mm thick be attached on the back side of each radiograph holder to determine if back-scatter radiation is exposing the radiograph.

 HPVP	PROCEDURE FOR RADIOGRAPHIC EXAMINATION	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 8 of 18
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12. SYSTEM OF IDENTIFICATION:

Each radiograph must be identified uniquely so that there is a permanent correlation between the part radiographed and the radiograph.

A system of permanent identification of the radiograph be provided with the following minimum details.

- 12.1. HPVP Manufacturer Symbol/Name and NDE Subcontractor's Symbol/Name.
- 12.2. Work Order Number.
- 12.3. SAP generated RT number if requisition raised through SAP.
- 12.4. Welder No. and Part Number for Non SAP Requisitions.
- 12.5. Equipment number, if any.
- 12.6. Weld seam number, if any.
- 12.7. Segment number (location marker).
- 12.8. Date of radiography.
- 12.9. Letter 'R1, R2' to indicate first repair, second repair etc. when required.
- 12.10. Letter 'RT' to indicate retaken radiograph when required.


13. RADIOGRAPH MAKING TECHNIQUES:

Normally a single wall single image (SWSI) radiography technique be used.

For test objects with external diameter less than 89 mm (DWDI) double wall double image Elliptical technique or (DWSI) double wall single image technique or Super imposition technique be used.

(Note: When DWDI technique is used, one exposure be taken unless otherwise specified. The source position be such that two weld images are clearly separated. The maximum separation between two weld images / distance between two weld images be one weld width. IQI be placed on the source side.

In case of DWSI or Super imposition techniques sufficient number of radiography shots ensuring full coverage of the weld seam be used. The IQI be placed close to the radiograph with a lead letter "F")

 HPVP	PROCEDURE FOR RADIOGRAPHIC EXAMINATION	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 9 of 18
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14. IQI SELECTION: As per Table T-276 of ASME Sec V Edition 2019


Weld thickness (base metal thickness + Estimated allowed reinforcement) (mm)	Source side			Radiograph side		
	Hole Type Designation	Essential hole	Wire- type Essential wire	Hole Type Designation	Essential hole	Wire type Essential wire
Upto 6.4	12	2T	5	10	2T	4
Over 6.4 to 9.5	15	2T	6	12	2T	5
Over 9.5 to 12.7	17	2T	7	15	2T	6
Over 12.7 to 19.0	20	2T	8	17	2T	7
Over 19.0 to 25.4	25	2T	9	20	2T	8
Over 25.4 to 38.1	30	2T	10	25	2T	9
Over 38.1 to 50.8	35	2T	11	30	2T	10
Over 50.8 to 63.5	40	2T	12	35	2T	11
Over 63.5 to 101.6	50	2T	13	40	2T	12
Over 101.6 to 152.4	60	2T	14	50	2T	13

15. GEOMETRIC UNSHARPNESS:

Recommended maximum values of Ug are tabulated below


Material Thickness (mm)	Ug Maximum (mm)
Under 50	0.51
50-75	0.76
75-100	1.01
>100	1.78

$$\text{Exposure Time (Ci minutes)} = \frac{\text{Film factor} * (\text{SFD in Meters})^2 * 2^{(\text{thickness of job/HVT of material})}}{(\text{RHM of Source})} \times 60$$

 <p>HPVP</p>	<p align="center">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	<p>PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 10 of 18</p>
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General requirements:

- Persons working in radiation areas be provided with Personnel monitoring device (TLDs) and Radiation area monitoring devices (Survey meters).
- Personnel Qualification: The minimum qualification of radiography operator be BARC qualified and certified radiographer.
- The minimum Qualification of Radiography Evaluation personnel be ASNT / ISNT Level II.
- Extent of Examination: As per Applicable Drawing / QA plan / NDE plan.
- Marking and identification of the radiograph: Work order no., Joint No., Spot No(s). be permanently marked on the job by stamping. Where stamping is not permitted by code / specification (< 6mm for ferrous plates) sketches be prepared to identify weld joints and radiography spots.
- Location of weld in the radiograph: Set of Markers (arrows or V's) be placed on both sides of the weld at least 5 mm from the edge of the weld. At least two such sets be placed at each end of the radiography spot.
- Alignment of radiation beam: be directed to the centre of the area being radiographed and shall be perpendicular to the object surface at that point.
- Over lap of radiographs: When multiple radiographs are used to cover entire length of weld seams adjacent radiographs overlap at least 25 mm.
- Radiation Exposure times: Exposure charts indicating thickness vs exposure time (Gamma ray-Ir-192) or thickness vs milli Ampere minutes(mA-mts) (X-ray) prepared exclusively for a particular brand / type industrial x-ray radiograph shall be used.

 <p>HPVP</p>	<p align="center">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	<p>PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 11 of 18</p>
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16. EVALUATION:

16.1. FACILITIES FOR RADIOGRAPH VIEWING:

Radiographs shall be viewed in a room with subdued light after dark adaptation of eyes (minimum 5 minutes) using an illuminator of sufficient illumination. The illuminator shall have facility to adjust the illumination level required for the particular radiograph.

16.2. QUALITY OF RADIOGRAPHS:

All radiographs be free from mechanical, chemical or other blemishes to the extent that they cannot mask or be confused with the image of any discontinuity in the area of interest including:

- i. Fogging
- ii. Processing marks such as streaks, chemical stains, water marks, air bubble marks
- iii. Handling marks such as scratches, finger marks, nail marks, static marks, marks due to dirt on lead intensifying screens.
- iv. False indications due to defective screens.


16.3. RADIOGRAPHIC DENSITY:

Density estimation / measurement: The Density be estimated either with a calibrated densitometer or with a step wedge comparison radiograph.

Density of a radiograph at adjacent to essential hole/ wire and area of interest shall be from 1.8 minimum for single film viewing with X-Ray and 2.0(minimum) for Gamma Rays. For composite viewing of multiple film exposures, each film of the composite set shall have a minimum density of 1.3. The maximum density shall be 4.0 for single or composite viewing.

The density anywhere through the area of interest be within – 15% and +30% of that density obtained through the body of the hole type IQI adjacent to the essential hole or adjacent to the essential wire of wire-type IQI.

A tolerance of 0.05 in density is allowed for variation between densitometer readings.

 <p>HPVP</p>	<p align="center">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	<p>PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 12 of 18</p>
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When shims are used with hole type IQI(s) the +30% restriction may be exceeded, and the minimum density requirements mentioned above do not apply provided required IQI sensitivity is met.

16.4. EXCESSIVE BACKSCATTER

If a white image of a letter 'B' appears against a darker background, protection from back scatter radiation is needed and the radiograph be retaken by keeping a lead sheet of 1/16" thick at the back of the radiograph cassette.

16.5. IQI SENSITIVITY:

Essential Hole or Essential wire as referred above in "Clause 14" IQI selection be visible. For wire type IQI's the essential wire shall be visible within the area of interest representing the thickness used for determining the essential wire, inclusive of the allowable density variations described in Clause 16.3.

17. DISPOSITION OF WELDS:


Radiography review form shown in Exhibit 1 be used for recording, reporting evaluation and disposition details.

The indications shown on the radiographs which are unacceptable after interpretation and evaluation be repaired by grinding, welding or gouging. Repair welding be performed using qualified procedure and in a manner acceptable to the inspector. The weld repaired areas be re radiographed in accordance with written procedure.

18. PRESERVATION OF RADIOGRAPHS & EVALUATION REPORTS

The complete set of radiographs and radiography evaluation reports be preserved as per the following.

ASME Sec I & B 31.1 5 Years
ASME Sec VIII Div 1	Radiographs-- Till Data Reports are signed by AI
	RT Reports – 3 Years
ASME Sec VIII Div 2 3 Years
NBIC Part 3 5 Years

 HPVP	<p style="text-align: center;">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 13 of 18
---	--	--

RADIOGRAPHY ACCEPTANCE LEVELS


Ref : ASME SEC I , ASME SEC VIII Div 1, ASME SEC VIII Div 2 Edition 2019.

Full Radiography

Imperfection	Maximum permitted size / length
Any indication characterized as a crack or zone of incomplete fusion or penetration	Unacceptable
Elongated indications (also see notes 1. & 2. Below)	(a) 6 mm for t up to 19 mm (b) $\frac{1}{3}t$ for t from 19 mm to 57 mm (c) 19 mm for t over 57 mm Where t is the thickness of the weld excluding any allowable reinforcement
Rounded indications	As specified by the acceptance standards given in pages 13 to 16.

Note:

1. For a butt weld joining two members having different thicknesses at the weld, t is the thinner of these two thicknesses. If a full penetration weld includes a fillet weld, the thickness of the throat of the fillet be included in t.
2. Any group of aligned indications that have an aggregate length greater than t in a length of 12t, except when the distance between the successive imperfections exceeds 6L where L is the length of the longest imperfection in the group.


 <p>HPVP</p>	PROCEDURE FOR RADIOGRAPHIC EXAMINATION	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 14 of 18
--	---	--

Spot Radiography

Imperfection	Maximum permitted size / length
any indication characterized as a crack or zone of incomplete fusion or penetration	Unacceptable
slag inclusions or cavities	2/3t where t is the thickness of the weld excluding any allowable reinforcement.
Rounded indications	Not a factor in the acceptability of welds not required to be fully radiographed.

Note:

- If a full penetration weld includes a fillet weld, the thickness of the throat of the fillet be included in t.
- If several indications within the above limitations exist in line, the welds be judged acceptable if the sum of the longest dimensions of all such indications is not more than t in a length of 6t (or proportionately for radiographs shorter than 6t) and if the longest indications considered are separated by at least 3L of acceptable weld metal where L is the length of the longest indication. The maximum length of acceptable indications be 3/4 in.(19 mm). Any such indications shorter than 1/4 in. (6 mm) be acceptable for any plate thickness.

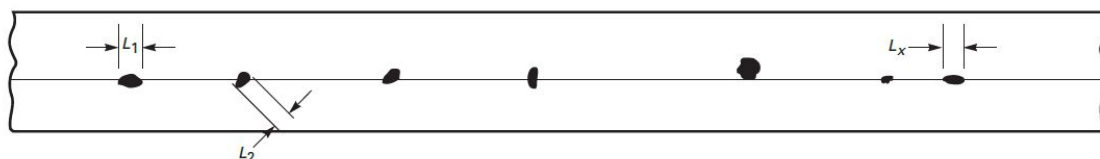
 HPVP	<p style="text-align: center;">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 15 of 18
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Acceptance Criteria for Rounded Indications


(Ref: Mandatory Appendix 4 ASME SEC I, SEC VIII DIV I Edition 2019)

SI Units			
Thickness, t , mm	Maximum Size of Acceptable Rounded Indication, mm		Maximum Size of Nonrelevant Indication, mm
	Random	Isolated	
Less than 3	$\frac{1}{4} t$	$\frac{1}{3} t$	$\frac{1}{10} t$
3	0.79	1.07	0.38
5	1.19	1.60	0.38
6	1.60	2.11	0.38
8	1.98	2.64	0.79
10	2.31	3.18	0.79
11	2.77	3.71	0.79
13	3.18	4.27	0.79
14	3.61	4.78	0.79
16	3.96	5.33	0.79
17	3.96	5.84	0.79
19.0 to 50, incl.	3.96	6.35	0.79
Over 50	3.96	9.53	1.60

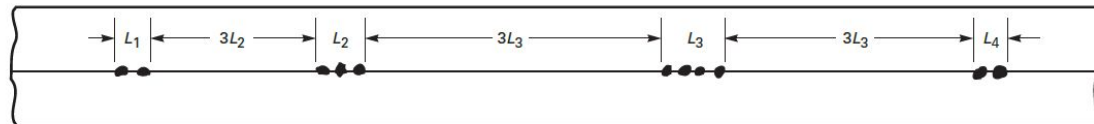
Figure 4-1
Aligned Rounded Indications



GENERAL NOTE: Sum of L_1 to L_x shall be less than t in a length of $12t$.

 <p>HPVP</p>	<p align="center">PROCEDURE FOR RADIOGRAPHIC EXAMINATION</p>	<p>PROC No : BHE-NDT-RT-07023 REVISION : 2 SHEET : 16 of 18</p>
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**Figure 4-2
Groups of Aligned Rounded Indications**

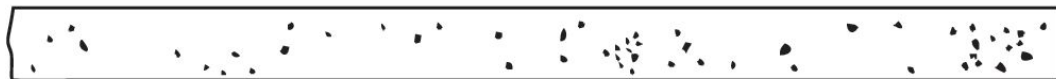


Maximum Group Length
 $L = 1/4$ in. (6 mm) for t less than $3/4$ in. (19 mm)
 $L = 1/3 t$ for t $3/4$ in. (19 mm) to $2 1/4$ in. (57 mm)
 $L = 3/4$ in. (19 mm) for t greater than $2 1/4$ in. (57 mm)

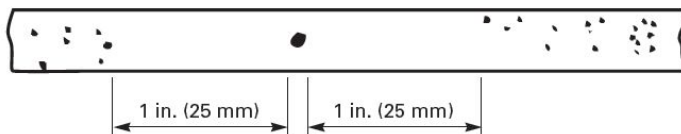
Minimum Group Spacing
 $3L$ where L is the length of the longest adjacent group being evaluated

GENERAL NOTE: Sum of the group lengths shall be less than t in a length of $12t$.

**Figure 4-3
Charts for t Equal to $1/8$ in. to $1/4$ in. (3 mm to 6 mm), Inclusive**



(a) Random Rounded Indications [See Note (1)]



(b) Isolated Indication [See Note (2)]



(c) Cluster

NOTES:

- (1) Typical concentration and size permitted in any 6 in. (150 mm) length of weld.
(2) Maximum size per [Table 4-1](#).



HPVP

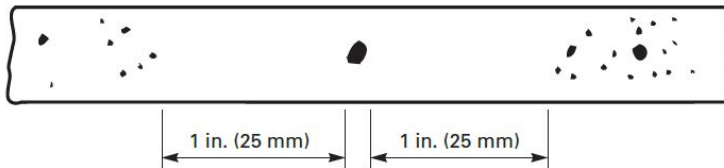
PROCEDURE FOR RADIOGRAPHIC EXAMINATION

PROC No : BHE-NDT-RT-07023
REVISION : 2
SHEET : 17 of 18

Figure 4-4
Charts for t Over $\frac{1}{4}$ in. to $\frac{3}{8}$ in. (6 mm to 10 mm), Inclusive



(a) Random Rounded Indications [See Note (1)]



(b) Isolated Indication [See Note (2)]



(c) Cluster

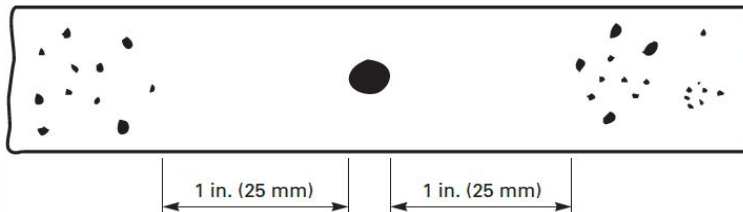
NOTES:

- (1) Typical concentration and size permitted in any 6 in. (150 mm) length of weld.
(2) Maximum size per [Table 4-1](#).

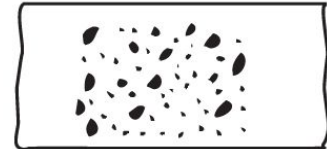
Figure 4-5
Charts for t Over $\frac{3}{8}$ in. to $\frac{3}{4}$ in. (10 mm to 19 mm), Inclusive



(a) Random Rounded Indications [See Note (1)]



(b) Isolated Indication [See Note (2)]



(c) Cluster

NOTES:

- (1) Typical concentration and size permitted in any 6 in. (150 mm) length of weld.
(2) Maximum size per [Table 4-1](#).

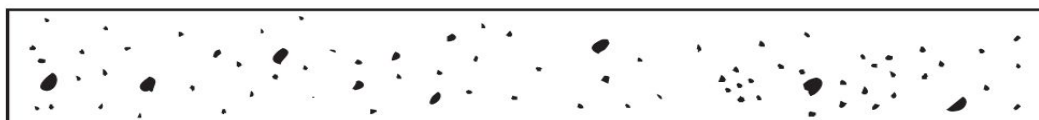


HPVP

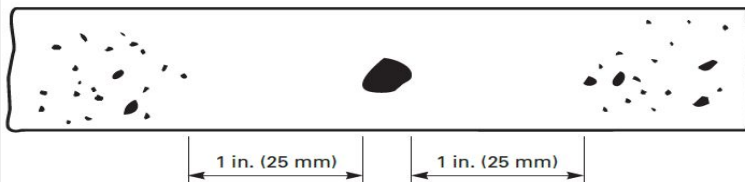
PROCEDURE FOR RADIOGRAPHIC EXAMINATION

PROC No : BHE-NDT-RT-07023
REVISION : 2
SHEET : 18 of 18

Figure 4-6
Charts for t Over $\frac{3}{4}$ in. to 2 in. (19 mm to 50 mm), Inclusive



(a) Random Rounded Indications [See Note (1)]



(b) Isolated Indication [See Note (2)]



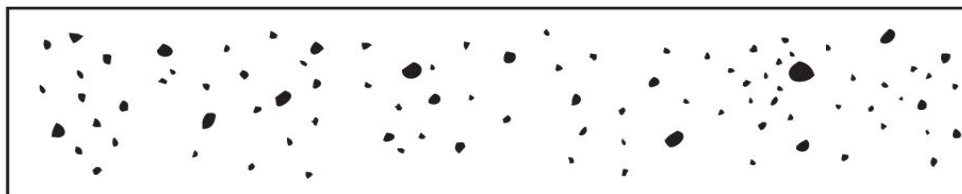
(c) Cluster

NOTES:

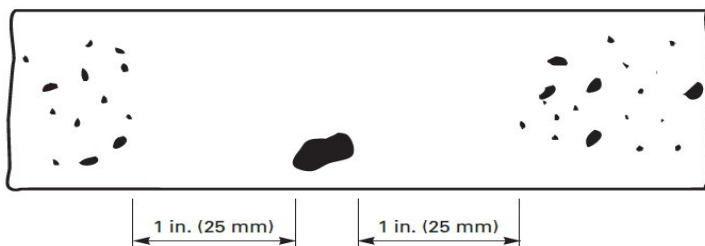
(1) Typical concentration and size permitted in any 6 in. (150 mm) length of weld.

(2) Maximum size per Table 4-1.

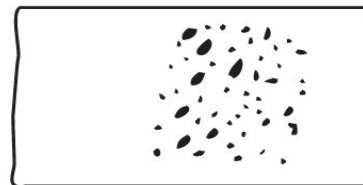
Figure 4-7
Charts for t Over 2 in. to 4 in. (50 mm to 100 mm), Inclusive



(a) Random Rounded Indications [See Note (1)]



(b) Isolated Indication [See Note (2)]



(c) Cluster

NOTES:

(1) Typical concentration and size permitted in any 6 in. (150 mm) length of weld.

(2) Maximum size per Table 4-1.

(For other Codes such as ASME B31.1, NBIC NB23 refer respective current Edition)

	<p align="center">PROCEDURE FOR ULTRASONIC EXAMINATION</p>	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 1 OF 10
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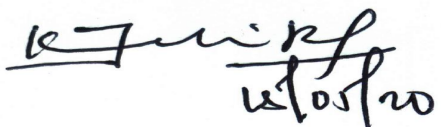
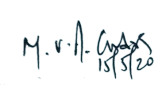
ISSUE NO.2

PROCEDURE FOR ULTRASONIC EXAMINATION

Issue No	Rev No	Date of Revision	Brief Records of Revision
1	0	02-02-2015	First Edition
1	1	11-04-2017	Cl no. 2,3,12,13 revised as per ASME Sec V Edition 2015
2	1	25-04-2018	Cl no. 2,3,12,13 revised as per ASME Sec V Edition 2017
2	2	15-05-2020	Cl no. 1,5,7,12 Modified and Cl no. 2.2,2.3,3,12 Revised as per ASME Sec V Edition 2019

Refer comments in 1st page of RT



<p align="center">Prepared by</p> <p align="center">  (K. JANAKI RAMULU) NDE LEVEL- II </p>	<p align="center">Reviewed & Approved by</p> <p align="center">  VENKATA RAVI CHANDRA M. ASNT NDT LEVEL III-RT,UT,MT,PT CERTIFICATE No. 204694 (M.V. RAVI CHANDRA) NDE LEVEL- III </p>
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 HPVP	<p align="center">PROCEDURE FOR ULTRASONIC EXAMINATION</p>	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 2 OF 10
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TABLE OF CONTENTS

Cl. No.	TITLE	Sheet
1	SCOPE	3
2	SYSTEM	3
	2.1 EXAMINATION PROCEDURE AND APPLICABLE STANDARDS	3
	2.2 REFERENCING CODE SECTION FOR ACCEPTANCE CRITERIA	3
	2.3 EXAMINATION PERSONNEL AND APPLICABLE STANDARDS	3
3	WRITTEN PROCEDURE REQUIREMENTS	3
4	SURFACE CONDITION	4
	4.1 BASEMATERIAL, WELD, CALIBRATION BLOCK	4
	4.2 TEMPERATURE DIFFERENCE	4
5	EQUIPMENT	4
	5.1 INSTRUMENT	4
	5.2 SEARCH UNITS	5
	5.3 COUPLANT	5
6	TECHNIQUE (S)	5
7	CALIBRATION	5
	7.1 EQUIPMENT CALIBRATION	5
	7.2 TECHNIQUES FOR STRAIGHT BEAM AND ANGLE BEAM CALIBRATION	5
	7.3 WELD METAL OVERLAY CLADDING CALIBRATION BLOCKS	6
	7.3 CALIBRATION FOR WELD METAL OVERLAY CLADDING	6
8	SCANNING	7
	8.1 GENERAL : EXAM SURFACE, COVERAGE, SCAN OVERLAP, SPEED AND SENSITIVITY	7
	8.2 BASE MATERIAL	7
	8.3 WELD	8
9	SIZING	8
	9.1 METHOD OF SIZING INDICATIONS	8
	9.2 CALIBRATION CORRECTION	8
10	EVALUATION	8
11	RECORDING AND REPORTING	9
	11.1 METHOD OF RECORDING	9
12	ACCEPTANCE STANDARDS	9
13	PRESERVATION OF DATA REPORTS	10
EXHIBIT 1	ULTRASONIC EXAMINATION TECHNIQUE SHEET CUM REPORT FORMAT	

 HPVP	PROCEDURE FOR ULTRASONIC EXAMINATION	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 3 OF 10
--	---	--

1. SCOPE:

This procedure covers Ultrasonic Examination for Ferritic welds (Carbon or Alloy steels) and Claddings by Manual, A-Scan, pulse-echo direct contact method of testing for detection of inclusions(slag) and planar discontinuities (cracks, non-fusion, etc.) and thickness measurement as

- a) Full penetration butt welds (double V, single V type), Full penetration corner welded nozzle joints for boiler and pressure vessels of equal to or greater than 10mm thickness.
- b) Butt joints in pipes with thickness equal to or greater than 10mm thickness.
- c) Claddings.
- d) Direct thickness read out by manual Ultrasonic Pulse echo contact method.

2. SYSTEM:

2.1 EXAMINATION PROCEDURE AND APPLICABLE STANDARDS:

All Ultrasonic Examination procedures shall be prepared in accordance with ASME SEC V Edition 2019 by at least NDE Level II and reviewed and approved by NDE Level III.

2.2 REFERENCING CODE SECTION FOR ACCEPTANCE CRITERIA:

ASME SEC I, ASME SEC VIII Div 1, ASME SEC VIII Div 2 Edition 2019, ASME B31.1 Edition 2018 & NBIC NB 23 Edition 2019, SNT-TC-1A Edition 2016 & ASME SEC V Edition 2019 Art.1.

2.3 EXAMINATION PERSONNEL AND APPLICABLE STANDARDS:

All NDE Level – I, NDE Level – II and NDE Level III personnel are qualified in accordance with NDE written practice (Based on SNT-TC-1A 2016& ASME Sec V Edition 2019 Art.1) and appearing in Latest List of Qualified NDE Personnel shall carry out any Ultrasonic Examination.

At the appropriate stage, the Ultrasonic Examination shall be carried out as per the requisitions from production shops endorsed by concerned Quality Controls.

3. WRITTEN PROCEDURE REQUIREMENTS:

This procedure based on T-421 of ASME SEC V Edition 2019 shall contain the requirements listed in the Table below of this procedure.

 HPVP	<p align="center">PROCEDURE FOR ULTRASONIC EXAMINATION</p>	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 4 OF 10
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**Table T-421
Requirements of an Ultrasonic Examination Procedure**

Requirement	Essential Variable	Nonessential Variable
Weld configurations to be examined, including thickness dimensions and base material product form (pipe, plate, etc.)	X	...
The surfaces from which the examination shall be performed	X	...
Technique(s) (straight beam, angle beam, contact, and/or immersion)	X	...
Angle(s) and mode(s) of wave propagation in the material	X	...
Search unit type(s), frequency(ies), and element size(s)/shape(s)	X	...
Special search units, wedges, shoes, or saddles, when used	X	...
Ultrasonic instrument(s)	X	...
Calibration [calibration block(s) and technique(s)]	X	...
Directions and extent of scanning	X	...
Scanning (manual vs. automatic)	X	...
Method for discriminating geometric from flaw indications	X	...
Method for sizing indications	X	...
Computer enhanced data acquisition, when used	X	...
Scan overlap (decrease only)	X	...
Personnel performance requirements, when required	X	...
Personnel qualification requirements	...	X
Surface condition (examination surface, calibration block)	...	X
Couplant: brand name or type	...	X
Post-examination cleaning technique	...	X
Automatic alarm and/or recording equipment, when applicable	...	X
Records, including minimum calibration data to be recorded (e.g., instrument settings)	...	X

It shall establish a single value, or range of values for each requirement. When required performance shall be demonstrated to the inspector. Any change in specified value or range of values of the essential variables mentioned above shall require requalification of the written procedure.

4. SURFACE CONDITION :

4.1 BASE MATERIAL, WELD, CALIBRATION BLOCK:

The base material and weld surface shall be prepared by grinding and sanding. The scanning surfaces of the basic calibration block shall be done by sanding.

4.2 TEMPERATURE DIFFERENCE:(examination surface vs calibration block)

The temperature difference between examination surfaces and the calibration block shall be within +/- 14 deg C (25 deg F) .

5. EQUIPMENT:

5.1 INSTRUMENT:

A Pulse-echo-type of ultrasonic instrument appearing in current list of NDE equipments under calibration and capable of operation at frequencies over the range of 2-4 MHz equipped with 2dB stepped gain control shall be used.

 HPVP	PROCEDURE FOR ULTRASONIC EXAMINATION	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 5 OF 10
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5.2 SEARCH UNITS:

Longitudinal wave Straight beam probe of size 10 mm to 24 mm Ø, 2 - 4 MHz ; Transverse wave angled beam probes 45°, 60°, 70° of nominal size (miniature size) 8 x 9 mm² ; make Modsonic / Olympus / GE with suitable 2mtr long probe cables shall be used.

5.3 COUPLANT:

SAE 30 Hylube machine oil or grease oil mixture shall be used. Calibration shall be carried out using the same couplant to be used in examination of welds.

6. TECHNIQUE (S):

Manual, A-Scan, pulse-echo direct contact using either single or dual element straight beam and angle beam search units.

7. CALIBRATION:

7.1 EQUIPMENT CALIBRATION:

The screen height linearity and amplitude control linearity shall be performed in accordance with Procedure No. 07013 (latest revision) at the beginning of each period of extended use or every 3 months.

7.2 TECHNIQUES FOR STRAIGHT BEAM AND ANGLE BEAM CALIBRATION:

7.2.1. SWEEP RANGE CALIBRATION:

The sweep range shall be adjusted to minimum 2T for straight beam, 3T for 45° angle beam and 4T for 60° using an IIW - V1 or V2 reference block.

7.2.2. SENSITIVITY CALIBRATION:

DAC curve plotted on the CRT screen Using Flat basic calibration block 1.5 inch ASME Block for Both Straight beam and Angle beam.

7.2.3. CALIBRATION VERIFICATION FREQUENCY:

Sweep range and DAC curve shall be calibrated at the beginning of each test and shall be verified at the end of each test,

- Whenever any component of test system is changed,
- Whenever operator is changed,
- At intervals of 4 hours during continuous testing.

7.2.4. CONFIRMATION ACCEPTANCE VALUES:

- If the deviation in distance range points exceeds 10% of the distance reading or 5% of full sweep whichever is greater, correct the distance range calibration, reexamine areas since last calibration and record.
- If the sensitivity decreases by 20% or 2dB of its amplitude correct the sensitivity and reexamine areas since last calibration and record. If the sensitivity increases by 20%

 HPVP	PROCEDURE FOR ULTRASONIC EXAMINATION	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 6 OF 10
--	---	--

or 2dB of its amplitude correct the sensitivity correct the data sheets since last valid calibration. If the sensitivity varies beyond 20% or 2dB of its amplitude recalibrate and reexamine areas since last valid calibration and record.

7.3 WELD METAL OVERLAY CLADDING CALIBRATION BLOCKS

7.3.1. CALIBRATION BLOCKS FOR TECHNIQUE ONE:

The basic calibration block configuration and reflectors shall be as shown in figure T-434.4.1 of ASME Sec V Article 4. Either a side –drilled hole or flat bottom hole may be used. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base material shall be at least twice the thickness of the weld metal overlay cladding.

7.3.2. ALTERNATE CALIBRATION BLOCKS FOR TECHNIQUE ONE:

Alternately, calibration blocks as shown in figure T-434.4.2.1. or figure T-434.4.2.2. of ASME Sec V Article 4 may be used. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base material shall be at least twice the thickness of the weld metal overlay cladding.

7.3.3. CALIBRATION BLOCK FOR TECHNIQUE TWO:

The basic calibration block configuration and reflectors shall be as shown in the figure T-434.4.3 of ASME Sec V Article 4. A flat bottom hole drilled to the weld /base metal interface shall be used. This hole may be drilled from the base material or weld metal overlay cladding side. The thickness of the weld metal overlay cladding shall be at least as thick as that to be examined. The thickness of the base metal shall be within 1 in. (25mm) of the calibration block thickness when the examination is performed from the base material surface. The thickness of the base material on the calibration block shall be at least twice the thickness of the weld metal overlay cladding when the examination is performed from the weld metal overlay cladding surface.

7.4 CALIBRATION FOR WELD METAL OVERLAY CLADDING

Dished end of clad plates shall be Ultrasonically examined after final heat treatment for lack of bond. 100% UT examination shall be carried out on areas where attachments are to be welded directly to the cladding. Above areas shall include 50mm of adjacent areas on both sides of attachment.

7.4.1. CALIBRATION FOR TECHNIQUE ONE:

Calibrations shall be performed utilizing the calibration block shown in figure T-432.4.1 of ASME Sec V Article 4. The search unit shall be positioned for the maximum response from the calibration reflector. When a side –drilled hole is used for calibration, the plane separating the elements search unit shall be positioned parallel to the axis of the hole. The gain control shall be set so that this response is $80\% \pm 5\%$ of full screen height. This shall be the primary reference level.

7.4.2. CALIBRATION FOR TECHNIQUE TWO:

 HPVP	PROCEDURE FOR ULTRASONIC EXAMINATION	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 7 OF 10
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Calibrations shall be performed utilizing the calibration block shown in figure T-434.4.3 of ASME Sec V Article 4. The search unit shall be positioned for the maximum response of the first resolvable indication from the bottom of the calibration reflector. The gain shall be set so that this response is $80\% \pm 5\%$ of full screen height. This shall be the primary reference level.

7.4.3. ALTERNATE CALIBRATION FOR TECHNIQUE ONE:

Calibration shall be performed utilizing the calibration blocks shown in figure T-434.4.2.1. or figure T-434.4.2.2 of ASME Sec V Article 4. The calibration shall be performed as follows;

- (a) The search unit shall be positioned for the maximum response from the reflector, which gives the highest amplitude.
- (b) When the block shown in the figure T-434.4.2.2 is used, the plane separating the elements of the dual elements search unit shall be positioned parallel to the axis of the hole.
- (c) The gain shall be set so that this response is $80\% \pm 5\%$ of full screen height. This shall be the primary reference level. Mark the peak of the indication on the screen.
- (d) Without changing the instrument settings, position the search unit for maximum response from each of the other reflectors and mark their peaks on the screen.
- (e) Connect the screen marks for each reflector to provide a DAC curve.

Note: When examination for lack of bond and weld metal overlay cladding flaw indications is required, Technique One shall be used. When examination for lack of bond only is required, Technique Two may be used.

8. SCANNING:

8.1 GENERAL:

8.1.1. EXAMINATION SURFACE:

Examination shall be carried out from identity-punched surface.

8.1.2. COVERAGE:

Shall be on both sides of the weld from 0 to $1\frac{1}{2}$ skip.

8.1.3. SCAN OVERLAP:

Each pass of the search unit shall overlap a minimum of 10% of the active transducer (piezoelectric element) dimension perpendicular to the direction of the scan.

8.1.4. SPEED AND SENSITIVITY:

The weld shall be scanned at a speed not exceeding 6" per second at a scanning sensitivity 6 dB above the DAC or primary Reference Level (PRL).

8.2 BASE MATERIAL:

Prior to angle beam examination of weld, adjacent parent material up to a width of 4T on both sides of the weld shall be scanned with a straight beam search unit to find discontinuities that could interfere with interpretation of indications obtained during subsequent angle beam scanning.

Any discontinuity found by straight beam search unit shall be investigated and not be a cause of rejection of element.

 HPVP	PROCEDURE FOR ULTRASONIC EXAMINATION	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 8 OF 10
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8.3 WELD:

Weld shall be scanned with two different angles beam search units for detection of Longitudinal and transverse discontinuities

8.3.1. DIRECTION AND EXTENT OF SCANNING:

8.3.1.1. REFLECTORS PARALLEL TO THE WELD SEAM:

The angle beam shall be directed at approximate right angles to the weld axis from both side of the weld (i.e., is from 2 directions) on the same surface when possible and probe manipulated so as to pass ultrasonic energy thro' the required volume of the weld and adjacent base material.

8.3.1.2. REFLECTORS TRANSVERSE TO THE WELD:

The angle beam shall be directed essentially parallel to the weld axis. The search unit shall be manipulated so that the ultrasonic energy passes thro' the required volume of weld and adjacent base material. Search unit shall be rotated 180 ° and the examination repeated.

9. SIZING:

9.1 METHOD OF SIZING INDICATIONS:

Length dimension of indications shall be measured by half maximum amplitude method.

9.2 CALIBRATION CORRECTION:

The surface finish difference between calibration block & scanning surface shall be compensated by using Transfer Correction.

Calibration correction due to Mode conversion and redirection for planar reflectors perpendicular to the examination surface at or near the opposite surface is carried out as per the following.

Position the search unit for maximum amplitude from the notch on the opposite surface of the basic calibration block and mark the position of peak of the indication on the screen

The opposite surface notch may give an indication 2 to 1 above DAC for a 45° angle beam search unit and ½ DAC for a 60° search unit. Therefore, the indications from the notch must be considered when evaluating reflectors at the opposite surface

10. EVALUATION :

It shall be carried out by at least NDE Level II personnel as per the following.

- All indications exceeding 20% of DAC shall be scanned for their nature and location and recorded. The gain shall be increased an additional amount so that no calibration reflector indication is less than 40% FSH during evaluation.

 HPVP	PROCEDURE FOR ULTRASONIC EXAMINATION	Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 9 OF 10
---	---	--

- The identity, maximum amplitude, location and extent of reflector causing a geometric indication(s) (segregates in the heat-affected zone, surface conditions such as weld root geometry) shall be recorded.
- Following shall be considered for Classifying an indication as geometric or not.
 - Plot and verify the reflector coordinates. Prepare a cross-sectional sketch showing the reflector position and surface discontinuities such as root and counter bore.
 - Review fabrication or weld preparation drawing. Other ultrasonic techniques or nondestructive examination methods may be helpful in determining a reflector's true position, size, and orientation.

11. RECORDING AND REPORTING:

11.1 METHOD OF RECORDING:

- Test data shall be recorded manually in the Proforma appended in exhibit-1 Annexed and reported and Direct thickness read out by manual Ultrasonic pulse echo contact method is recorded in exhibit-2.
- As a minimum all rejectable indications, type of indications (Crack, non-fusion, slag etc.), location and extent (length), depth below surface shall be recorded.
- Non-rejectable indications exceeding 50% of DAC shall be recorded

Report shall contain the following in addition to those mentioned in the table appended next page.

- Procedure identification and revision.
- Instrument reference level gain and, if used, damping and reject settings(s).
- Calibration data (including reference reflector(s) indication amplitude(s), and distance reading(s).
- Identification and location of weld or volume scanned.
- Map or record of rejectable indications detected or areas cleared.
- Areas of restricted access or inaccessible welds;
- Examination personnel identity and, when required by referencing code section qualification level.
- Date of examination.

12. ACCEPTANCE STANDARDS:

As per ASME SEC I, ASME SEC VIII Div 1, ASME SEC VIII Div 2 Edition 2019, ASME B31.1, NBIC NB 23 Latest Edition.

UT on clad plate (Dished ends) shall be performed as per ASME A 578.

ACCEPTANCE-REJECTION STANDARDS:

(Ref: ASME SEC I, ASME SEC VIII Div 1, ASME SEC VIII DIV 2 Edition 2019)

Imperfections recorded as per para 10 above shall be evaluated as below.

1. Indications characterized as cracks, lack of fusion or incomplete penetration are unacceptable regardless of length.

 <p>HPVP</p>	<p align="center">PROCEDURE FOR ULTRASONIC EXAMINATION</p>	<p>Proc. No : BHE-NDT-UT-07025 Revision : 2 Sheet : 10 OF 10</p>
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2. Other imperfections are unacceptable if the indications exceed the reference level amplitude and have lengths which exceed $1/3 T$ - (weld thickness(T) excluding any allowable reinforcement) or 6 mm whichever is greater.

Notes: Butt welds joining two different thicknesses at the weld, T is the thinner of these two thicknesses.

(For other Codes such as ASME B31.1, NBIC NB23 refer respective current Edition)

13. PRESERVATION OF DATA REPORTS:

All the reports of ultrasonic test shall be preserved till MDR signed.

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 1 OF 11
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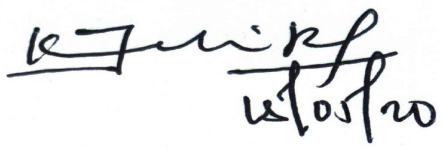
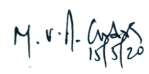
ISSUE NO.2

PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION

Issue No	Rev No	Date of Revision	Brief Records of Revision
1	0	02-02-2015	First Edition
1	1	11-04-2017	Cl no. 3,5,8.6,9,14 revised as per ASME Sec V Edition 2015
2	1	25-04-2018	Cl no. 3,5,8.2,19,14 revised as per ASME Sec V Edition 2017
2	2	15-05-2020	Cl. no. 1,6,7.1,7.2 Modified; 13,14,15,16,17,18 renumbered; Cl. no. 3,4,9.2,18 revised; Cl.no.8,10,11,12 added.

Refer comments in 1st page of RT



<p style="text-align: center;">Prepared by</p> <p style="text-align: center;">  (K. JANAKI RAMULU) NDE LEVEL-II </p>	<p style="text-align: center;">Reviewed & Approved by</p> <p style="text-align: center;">  VENKATA RAVI CHANDRA M. ASNT NDT LEVEL III-RT,UT,MT,PT CERTIFICATE No. 204694 (M.V. RAVI CHANDRA) NDE LEVEL- III </p>
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PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION

PROC No : BHE-NDT-MT-07024
REVISION : 2
SHEET : 2 OF 13

TABLE OF CONTENTS

Cl. No.	TITLE	SHEET NO.
1	SCOPE	3
2	POLICY	3
3	APPLICABLE STANDARDS	3
4	SYSTEM	3
5	WRITTEN PROCEDURE REQUIREMENTS	4
6	SURFACE CONDITIONING	4
	6.1 SURFACE PREPARATION	4
	6.2 TEMPERATURE OF PART SURFACE	5
7	EQUIPMENT	5
	7.1 TYPE OF EQUIPMENT	5
	7.2 CALIBRAITON OF EQUIPMENT	6
8	EXAMINATION MEDIUM	6
	8.1. DRY PARTICLES	6
	8.2. WET PARTICLES	7
9	EXAMINATION	8
	9.1 EXAMINATION COVERAGE	8
	9.2 MINIMUM LIGHT INTENSITY	8
	9.3 DIRECTION OF MAGENTIZATION	9
10	METHOD OF EXAMINATION	9
	10.1 DRY CONTINUOUS MAGNETIZATION METHOD	9
	10.2 WET CONTINUOUS MAGNETIZATION METHOD	9
11	TECHNIQUES	10
12	METHOD OF PARTICLE APPLICATION AND EXCESS PARTICLE REMOVAL	11
	12.1 DRY PARTICLES	11
	12.2 WET PARTICLES	11
13	INTERPRETATION AND EVALUATION	12
14	REPORTING	12
15	POST EXAMINATION CLEANING	12
16	DEMAGNETIZATION	12
17	RECORDS	12
18	ACCEPTANCE STANDARDS	13
EXHIBIT-1	LIGHT LEVEL VERIFICATION RECORD	
EXHIBIT-2	MAGNETIC PARTICLE EXAMINATION TECHNIQUE SHEET CUM REPORT	

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 3 OF 13
--	--	---

1. SCOPE :

This Procedure shall be applied for detecting of surface and near surface discontinuities in Butt welds, fillet welds, partial penetration welds, Back Gouging welds, Full penetration butt and corner welds, Nozzles of Boiler components, pressure vessels, heat exchangers, power piping and Non pressure parts welds, plates, forgings, etc. of Ferro Magnetic Materials to detect surface and subsurface discontinuities using visible Dry & wet particle Continuous Prod or Yoke technique and Fluorescent Wet Prod or Yoke Techniques.

2. POLICY:

- 2.1 The Magnetic Particle Examination shall be carried out either as per one of the procedures enumerated in the following pages which are verified and found to be in accordance with ASME SEC V or as per any other applicable referencing code sections and specifications.
- 2.2 Only personnel qualified to MT NDE Level II / MT NDE Level III in accordance with NDE written practice shall carry out any Magnetic Particle Examination.

3. APPLICABLE STANDARDS:

- 3.1 ASME SEC V Edition 2019
- 3.2 Construction code sections ASME Sec I, ASME Sec VIII Div 1, ASME Sec VIII Div 2 Edition 2019, ASME B31.1 Edition 2018, NBIC NB 23 Edition 2019, SNT-TC-1A Edition 2016 & ASME SEC V Edition 2019 Art.1.

4. SYSTEM:

All Magnetic particle examination procedures shall be amended and approved as required by NDE level III taking into consideration of

- 4.1 Experience gained in various examination procedures
- 4.2 Recommendation of Audit Teams
- 4.3 Referencing Code sections.

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 4 OF 13
--	--	---

5. WRITTEN PROCEDURE REQUIREMENTS:

This procedure based on Table T-721 of ASME SEC V Edition 2019 shall contain the requirements listed in the Table below.

It shall establish a single value, or range of values for each requirement. When required performance shall be demonstrated to the inspector. Any change in specified value or range of values of the essential variables mentioned in Table shall require requalification of the written procedure.

Table T-721 Requirements of a Magnetic Particle Examination Procedure		
Requirement	Essential Variable	Nonessential Variable
Magnetizing technique	X	...
Magnetizing current type or amperage outside range specified by this Article or as previously qualified	X	...
Surface preparation	X	...
Magnetic particles (fluorescent/ visible, color, particle size, wet/ dry)	X	...
Method of particle application	X	...
Method of excess particle removal	X	...
Minimum light intensity	X	...
Existing coatings, greater than the thickness demonstrated	X	...
Nonmagnetic surface contrast enhancement, when utilized	X	...
Performance demonstration, when required	X	...
Examination part surface temperature outside of the temperature range recommended by the manufacturer of the particles or as previously qualified	X	...
Shape or size of the examination object	...	X
Equipment of the same type	...	X
Temperature (within those specified by manufacturer or as previously qualified)	...	X
Demagnetizing technique	...	X
Post-examination cleaning technique	...	X
Personnel qualification requirements	...	X

6. SURFACE CONDITIONING :

6.1 SURFACE PREPARATION:

6.1.1. Prior to Magnetic Particle Examination, the surface to be examined and all adjacent areas within at least 1" shall be dry and free of all dirt, grease, lint, scale, welding flux & spatter, oil and other extraneous matter that could interfere with examination.

6.1.2. As welded, ground, Machined and Back Gouged conditions are preferable. However, Surface preparation by grinding or machining may be necessary where surface irregularities could mask indications due to discontinuities. This

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 5 OF 13
--	--	---

procedure does not address the testing of parts covered with coatings and / or non magnetic surface contrast enhancement.

6.1.3. The surfaces which are to be examined by Magnetic particle testing shall be free from any external Nonmagnetic coatings. If any nonmagnetic coatings are present, it shall be demonstrated that indications can be detected through the existing maximum coating thickness applied.

6.1.4. Nonmagnetic Surface Contrast Enhancement:

Nonmagnetic surface contrasts may be applied by the examiner to uncoated surfaces, only in amounts sufficient to enhance particle contrast. When nonmagnetic surface contrasts are used, it shall be demonstrated that indications can be detected through the enhancement. Thickness measurement of surface contract enhancement is not required.

6.2 TEMPERATURE OF PART SURFACE:

The surface temperature of the part examined with dry particles shall be within the range of 17 °C to 315 °C (within maximum temperature specified by the manufacturer of the particles) and wet particles shall be maximum 57 °C or temperature specified by the manufacturer of the particles.

7. EQUIPMENT:

7.1 TYPE OF EQUIPMENT:

7.1.1. Portable magnetic particle testing equipments appearing in the current list of NDE Equipments under calibration (230V, single phase, open circuit voltage <25V) provided with stepped / continuous current control, remote control switch for momentarily switching on / off, prods for application of current and capable of generating max 1000A HWDC shall be used for magnetization.

7.1.2. Direct/Alternating current electromagnetic yokes shall be used to detect discontinuities that are open to the surface of the part by longitudinal magnetization method and to examine the surfaces where arcing is not permitted or prod method is not practicable.

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 6 OF 13
--	--	---

7.2 CALIBRATION OF EQUIPMENT:

- 7.2.1. Each magnetizing equipment with an ammeter shall be calibrated at least once a year, or whenever the equipment has been subjected to major electric repair, periodic overhaul, or damage.
- 7.2.2. The magnetizing power of yokes shall be verified prior to use on every day the yoke is used. The magnetizing power of yokes shall be verified whenever the yoke has been damaged or repaired.
- 7.2.3. Each alternating current electromagnetic yoke shall have a lifting power of at least 4.5 kg at the maximum pole spacing that will be used with contact similar to what will be used during the examination.
- 7.2.4. Each direct current or permanent magnetic yoke shall have a lifting power of at least 18 kg at the maximum pole spacing that will be used with contact similar to what will be used during the examination.
- 7.2.5. Each weight shall be weighed with a scale from a reputable manufacturer and stencilled with the applicable nominal weight prior to first use. Weight need only be verified again if damaged in a manner that could have caused potential loss of material.

8. EXAMINATION MEDIUM:

8.1 DRY PARTICLES:

Finely divided ferromagnetic dry particles (non-fluorescent free flowing dry particles of colors either red or grey.) supplied by M/s Arora / M/s Pradeep with brand name Automag RD-7 Red or M/s Ferrochem with Brand names Ferrochem grey and Ferrochem Red shall be used.

8.2 WET PARTICLES:

8.2.1. WET PARTICLE CONCENTRATION:

Non fluorescent or fluorescent wet particles will be black or reddish brown in color that provide adequate contrast with the surface being examined.

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 7 OF 13
--	--	---

Wet particles shall be suspended in kerosene or water for application to the test surface by flowing or spraying. Suitable conditioning agents shall be added to the water to provide proper wetting and corrosion protection for the parts being examined.

The bath concentration shall be determined by measuring the settling volume through the use of pear-shaped centrifuge tube with a 1-mL stem (0.05-mL divisions) for fluorescent particle suspensions or a 1.5-mL stem (0.1-mL divisions) for non-fluorescent suspensions. The suspension shall be mixed thoroughly or shall be run through the re-circulating system for at least 30 minutes to ensure thorough mixing of all particles. Take a 100-mL portion of the suspension from the hose or nozzle, demagnetize and allow it to settle for 30 minutes' minimum with water based suspension or 60 minutes' minimum with petroleum distillate suspension before taking the reading.

For fluorescent particles, the required settling volume is from 0.1 mL to 0.4 mL in a 100-mL bath sample and from 1.2 mL to 2.4 mL per 100 mL of vehicle for non-fluorescent particles or as recommended by the manufacturer. Concentration checks shall be made at least every eight hours.

8.2.2. WET PARTICLE CONTAMINATION:

Both fluorescent and non-fluorescent suspensions shall be checked periodically for contaminants such as dirt, scale, oil, lint, loose fluorescent pigment, water (in the case of oil suspensions), and particle agglomerates which can adversely affect the performance of the magnetic particle examination process. The test for contamination shall be performed at least once per week.

8.2.2.1. Carrier Contamination:

For fluorescent baths, the liquid directly above the precipitate should be examined with fluorescent excitation light. The liquid will have a little fluorescence. Its color can be compared with a freshly made-up sample using the same materials or with an unused sample from the original bath that was retained for this purpose. If the "used" sample is noticeably more fluorescent than the comparison standard, the bath shall be replaced.

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 8 OF 13
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8.2.2.2. Particle Contamination.

The graduated portion of the tube shall be examined under fluorescent excitation light if the bath is fluorescent and under visible light (for both fluorescent and non-fluorescent particles) for striations or bands, differences in color or appearance. Bands or striations may indicate contamination. If the total volume of the contaminates, including bands or striations exceeds 30% of the volume magnetic particles, or if the liquid is noticeably fluorescent, the bath shall be replaced.

Note: In any case, color of particles used shall have adequate contrast with the surface being examined.

9. EXAMINATION:

9.1 EXAMINATION COVERAGE:

All examinations shall be conducted with sufficient field overlap to ensure 100% coverage at the required sensitivity.

9.2 MINIMUM LIGHT INTENSITY:

9.2.1. Visible Light Intensity

9.2.1.1. The examination area and the accumulation of magnetic particles shall be observed under adequate lighting. An intensity of 1076 lux is adequate. The minimum light intensity shall be 100 fc (1076 lux). The light intensity, natural or supplemental white light source, shall be measured with a white light meter prior to the evaluation of indications or a verified light source shall be used. Verification of light sources is required to be demonstrated only one time, documented, and maintained on file.

All following activity shall be done under the illumination of 100 watt 230V incandescent bulb at a minimum distance of 25 cms from test part for ensuring 1076 Lux light intensity at test part surface.

9.2.2. Black Light (UV-A Light)

9.2.2.1. Black light intensity at the examination surface shall be not less than 1000 micro watt/ cm² at a distance of 15 inch.

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 9 OF 13
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- 9.2.2.2. The black light intensity shall be measured at least once in every 8 hrs. and whenever the work station is changed. The UV-A and White Light Meter should be calibrated once in One year.
- 9.2.2.3. With fluorescent particles, the examination is performed in a darkened area. The Intensity of Ambient visible light in the darkened area shall not exceed 2 fc or 21.5 lux.
- 9.2.2.4. The examiner shall be in the darkened area for at least 5 minutes prior to performing the examination for eye adaptation. The examiner shall not wear glasses with permanent Tint or Photo Chromic (light sensitive) lenses which change colour in Sunlight.
- 9.2.2.5. The black light shall be warmed up for a minimum period of 5 minutes prior to use or measurement of the intensity.

Lux meter/Light meter shall be calibrated at least once a year or whenever a meter has been repaired. If meters have not been in use for one year or more, calibration shall be done before being used.

For selection of other light sources vs maximum distances permitted refer Exhibit 1.

9.3 DIRECTION OF MAGNETIZATION:

Two separate examinations shall be performed on each area. During second examination, the lines of magnetic flux shall be approximately perpendicular to those used in the first examination.

10. METHOD OF EXAMINATION:

Examination shall be made by continuous method.

10.1 Dry continuous magnetization method:

The magnetizing current remains on while the examination medium (Brick red Dry particle) is being applied and while the excess of the examination medium is being removed.

10.2 Wet continuous magnetization method:

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 10 OF 13
--	--	--

The magnetizing current shall be turned on after the particles have been applied. Flow of particles shall stop with the application of current. Wet particles applied from aerosol spray cans/pump sprayers may be applied before and/or during magnetizing current application.

11. TECHNIQUES:

11.1 PROD TECHNIQUE:

11.1.1. Magnetizing Procedure:

The prod electrodes are pressed firmly against the surface in the area to be examined. In order to avoid arcing, a remote control switch shall be built into the prod handles, to permit the current to be turned on after the prods have been properly positioned and to be turned off before they are removed. The prods tips shall be kept dressed and cleaned to make satisfactory electrical contact.

11.1.2. Magnetizing Current and Prod Spacing:

Single-phase (half-wave rectified) current HWDC shall be used. The current shall be 100 to 125amps per inch of prod spacing for sections 0.75 inch thick or greater. For sections less than 0.75 inch thick the current shall be 90 to 110 amps per inch of prod spacing. Prod spacing shall not exceed 8 inches and shall not be less than 3 inches.

11.2 YOKE TECHNIQUE:

11.2.1. This technique is primarily intended to cover the region between the poles. The pole spacing shall be between 100 mm to 150 mm. In order to ensure that the region of interest gets 100 % coverage, every region (or segment of the test area, divided according to the pole spacing), shall be tested twice such that the pole space displacements are mutually perpendicular in the former and later cases. For example, in the case of the weld, the pole space orientation can be 45 Deg. and 135 Deg. Respectively with respect to the weld center line orientation, in the first and second attempts.

11.2.2. Pie-Shaped Magnetic Particle Field Indicator shall be used to ensure field adequacy as well as direction of field. It shall be positioned on the surface to be examined with copper-plated side away from the inspected surface.

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 11 OF 13
--	--	--

Suitable field strength is indicated by formation of clearly defined lines of magnetic particles across the copper face of the indicator when the magnetic particles are applied simultaneously with the magnetizing force. When a clearly defined line of particles are not formed in the desired direction, the magnetizing technique shall be changed as needed.

- 11.3** For inspection of components of Gr 91 material including Gr C12A, prod technique shall not be used. This shall be inspected by Yoke technique using Dry or Wet method.

12. METHOD OF PARTICLE APPLICATION AND EXCESS PARTICLE REMOVAL:

12.1 DRY PARTICLES:

- 12.1.1. The dry particles shall be applied in such a manner that a light uniform dust-like coating settles on the surface of the area being examined. The application technique shall be such that the particles are suspended in air and reaches the examination surface in a uniform cloud with a minimum force, using hand powder applicators (squeeze bulb) or specially designed mechanical blower or by a spray nozzle.
- 12.1.2. Dry particles shall not be applied to a wet surface nor when there is excessive wind. The particles shall not be applied by pouring, throwing, or spreading with fingers.
- 12.1.3. Any excess powder shall be removed while the magnetization current is on and shall be with a gentle air stream by a blower or squeeze bulb without removing or disturbing particles attracted by a leakage field that may prove to be a relevant indication.

12.2 WET PARTICLES:

- 12.2.1. The application of wet particles involves the bathing of the area to be examined, by spraying or flowing during the application of magnetizing current.
- 12.2.2. Two or more shots shall be applied, but the last shot shall be applied while the bath still remains on the area to be examined and after the particle flow has been stopped. Care shall be taken to cut off the bath application before

	PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 12 OF 13
--	--	--

removing the magnetic field, to prevent high-velocity particle flow that may wash away or remove fine or weakly held indications.

13. INTERPRETATION AND EVALUATION :

- (a) All indications shall be evaluated in terms of the acceptance standards of the referencing Code Section.
- (b) Discontinuities on or near the surface are indicated by retention of the examination medium. However, localized surface irregularities due to machining marks or other surface conditions may produce false indications.
- (c) Broad areas of particle accumulation, which might mask indications from discontinuities, are prohibited, and such areas shall be cleaned and reexamined.

All indications shall be evaluated by a NDE Level II or NDE Level III in terms of the acceptance standard of ASME SEC VIII DIV 1, ASME SEC VIII DIV 2, ASME SEC I, ASME B31.1, NBIC NB 23 current Edition.

14. REPORTING :

Interpretation and evaluation shall be reported in the Proforma appended in Exhibit-2.

15. POST-EXAMINATION CLEANING :

The examination surface shall be wiped clean using cloth / cotton waste.

16. DEMAGNETIZATION :

No demagnetization is required unless specifically required by customer. When required one of the following methods (ref. SE-709-95 for detail techniques) shall be used.

- Withdrawing from AC coil.
- Decreasing alternating current.
- Demagnetizing with yokes.

17. RECORDS :

All the reports of Magnetic particle test shall be preserved till MDR signed.

	<p style="text-align: center;">PROCEDURE FOR MAGNETIC PARTICLE EXAMINATION</p>	PROC No : BHE-NDT-MT-07024 REVISION : 2 SHEET : 13 OF 13
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18. ACCEPTANCE STANDARDS:

(Ref: ASME SEC I, ASME SEC VIII Div 1 & Div 2 Edition 2019)

All surfaces to be examined shall be free of

- Relevant Linear indications
- Relevant rounded indications greater than 5 mm.
- Four or more relevant rounded indications in a line separated by 1.5 mm or less edge to edge.

Notes: Any indication believed to be non relevant shall be confirmed by re-examination using same method or other non destructive examination method and/or by surface conditioning.

1. **Relevant indications:** Indications having any dimension greater than 1.5 mm.
2. **Linear indications:** Relevant Indications having length greater than three times the width.
3. **Rounded indications:** Relevant indications having circular or elliptical shape with a length equal to or less than three times its width.

(For other Codes such as ASME B31.1, NBIC NB23 refer respective current Edition)

	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 1 of 9
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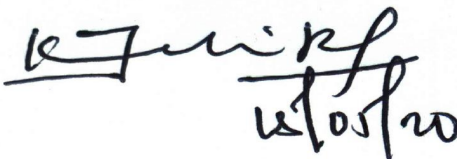
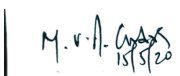
ISSUE NO.: 2

PROCEDURE FOR LIQUID PENETRANT EXAMINATION

Issue No	Rev No	Date of Revision	Brief Records of Revision
1	0	02-02-2015	First Edition
1	1	11-04-2017	Cl no. 3,5,13 revised as per ASME Sec V Edition 2015
2	1	25-04-2018	Cl no. 3,5,6.2,6.4,6.6,7.2.4,7.3,10,15 revised as per ASME Sec V Edition 2017
2	2	15-05-2020	Cl no. 3.1,3.2,6.2,14 revised and Cl no.1,6.1,6.4,8 modified as per ASME Sec V Edition 2019.

Refer comments in 1st page of RT



<p style="text-align: center;">Prepared by</p>  <p style="text-align: center;">(K. JANAKI RAMULU) NDE LEVEL-II</p>	<p style="text-align: center;">Reviewed & Approved by</p>  <p style="text-align: center;">(M.V. RAVI CHANDRA) NDE LEVEL-III</p>
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VENKATA RAVI CHANDRA M.
ASNT NDT LEVEL III-RT,UT,MT,PT
CERTIFICATE No. 204694



 HPVP	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 2 of 9
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TABLE OF CONTENTS

Cl. No.	TITLE	SHEET NO.
1	Scope	3
2	Policy	3
3	Applicable standards	3
4	System	3
5	Written Procedure Requirements	4
6	Method of Examination	4
	6.1 Identification of penetrant examination materials:	5
	6.2 Minimum light intensity	5
	6.3 Surface preparation	5
	6.4 Surface temperature	5
	6.5 Method of applying penetrant	5
	6.6 Penetration (Dwell) time	5
	6.7 Method of removing excess surface penetrant	6
	6.8 Drying After Excess Penetrant Removal	6
	6.9 Method of applying developer	6
	6.10 Developer dwell time (Interpretation Time)	6
	6.11 Minimum and maximum time periods between steps and drying aids	7
7	Personnel qualification requirements	7
8	Materials, shapes, or sizes to be examined and the extent of examination	7
9	Post examination cleaning technique	7
10	General Requirements	8
11	Evaluation	8
12	Documentation	8
13	Records	8
14	Acceptance Standards for Liquid Penetrant Examination	8-9

LIGHT LEVEL VERIFICATION RECORD	Exhibit 1
LIQUID PENETRANT EXAMINATION TECHNIQUE SHEET CUM REPORT FORMAT	Exhibit 2

	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 3 of 9
--	---	--

1. SCOPE:

This Procedure shall be used for the detection of open surface discontinuities in welds, plates, and forgings etc., used in Pressure Vessels., Heat Exchangers, Boilers and parts thereof by visible Liquid Penetrant Examination using solvent removable process for ferrous and non-ferrous materials.

2. POLICY:

- 2.1. The Liquid Penetrant Examination shall be carried out either as per one of the procedures enumerated in the following pages which are verified and found to be in accordance with ASME SEC V or as per any other applicable referencing code sections and specifications.
- 2.2. Only personnel qualified in accordance with BHEL HPVP NDE Written Practice shall carry out any Liquid Penetrant examination.


3. APPLICABLE STANDARDS:

- 3.1 ASME SEC V Edition 2019.
- 3.2 Construction code sections ASME Sec I, ASME Sec VIII Div 1, ASME Sec VIII Div 2 Edition 2019, ASME B31.1 Edition 2018, NBIC NB 23 Edition 2019, SNT-TC-1A Edition 2016 & ASME SEC V Edition 2019 Art.1.

4. SYSTEM:

All Liquid Penetrant Examination procedures shall be amended and approved as required by NDE Level III taking into consideration of

- 4.1. Experience gained in various examination procedures.
- 4.2. Recommendation of Audit Teams.
- 4.3. Referencing Code sections.

 HPVP	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 4 of 9
--	---	--

5. WRITTEN PROCEDURE REQUIREMENTS: (As per ASME Sec V Article 6 T-621)

Liquid Penetrant examination shall be performed in accordance with a written procedure, which shall as a minimum contain the essential and non-essential variable as mentioned in the table below. The written procedure shall establish a single value, or range of values, for requirement.


Table T-621.1 Requirements of a Liquid Penetrant Examination Procedure		
Requirement	Essential Variable	Nonessential Variable
Identification of and any change in type or family group of penetrant materials including developers, emulsifiers, etc.	X	...
Surface preparation (finishing and cleaning, including type of cleaning solvent)	X	...
Method of applying penetrant	X	...
Method of removing excess surface penetrant	X	...
Hydrophilic or lipophilic emulsifier concentration and dwell time in dip tanks and agitation time for hydrophilic emulsifiers	X	...
Hydrophilic emulsifier concentration in spray applications	X	...
Method of applying developer	X	...
Minimum and maximum time periods between steps and drying aids	X	...
Decrease in penetrant dwell time	X	...
Increase in developer dwell time (Interpretation Time)	X	...
Minimum light intensity	X	...
Surface temperature outside 40°F to 125°F (5°C to 52°C) or as previously qualified	X	...
Performance demonstration, when required	X	...
Personnel qualification requirements	...	X
Materials, shapes, or sizes to be examined and the extent of examination	...	X
Post-examination cleaning technique	...	X

Any change of requirement specified as an essential variable mentioned above shall require requalification of the written procedure.

6. METHOD OF EXAMINATION:

6.1. IDENTIFICATION OF PENETRANT EXAMINATION MATERIALS:

- 6.1.1. PRADEEP/PMC/MAGNAFLUX brands of PT chemicals be used. Other brands may also be used with the approval of NDE Level-III.
- 6.1.2. Refer certification of contaminant content for all liquid penetrant materials used.
- 6.1.3. Ensure manufacturers batch numbers, on the penetrant material containers and Certificate mentioned above are same.

 HPVP	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 5 of 9
--	---	--

6.2. MINIMUM LIGHT INTENSITY:

All following activity shall be done under the illumination of 100 watt 230V incandescent bulb at a maximum distance of 25 cms from test part for ensuring 1076 Lux light intensity at test part surface.

6.3. SURFACE PREPARATION (FINISHING AND CLEANING, INCLUDING TYPE OF CLEANING SOLVENT) (As per ASME Sec V Edition 2019 Article 6 T-642)

This procedure applies to below mentioned surface preparations.

- 6.3.1. As welded
- 6.3.2. As ground
- 6.3.3. As machined /As Forged/As Plates

6.3.4. SURFACE CLEANING:

- 6.3.4.1. Ensure Surface examined and all adjacent areas within 1” shall be free of scale, welding flux, weld spatter.
- 6.3.4.2. Use Organic solvent - Cleaner mentioned above to remove oil, and other extraneous matter.
- 6.3.4.3. Wait for a minimum of 3 minutes for evaporation of cleaning solvent used above.

6.4. SURFACE TEMPERATURE (As per ASME Sec V Edition 2019 Article 6 T-652)


Ensure that the temperature of the penetrant and the surface of the part to be subjected to penetrant testing is between 5 to 52 deg centigrade. For examination between 5- 10 deg Centigrade, the minimum Penetrant dwell time shall be two times than that established for testing between 10 to 52 deg Centigrade.

6.5. METHOD OF APPLYING PENETRANT

Use brush or spray for application of penetrant to the surface of the part.

6.6. PENETRATION (DWELL) TIME

- 6.6.1. Allow penetrant on the weld surface for minimum 5 minutes and maximum 10 for welds & Casts.

	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 6 of 9
--	---	--

6.6.2. Allow penetrant on the surface for minimum 10 minutes and maximum 15 minutes and for plates & forgings.

Note: Ensure that penetrant is not dried during dwell time.

6.7. METHOD OF REMOVING EXCESS SURFACE PENETRANT

6.7.1. After completion of penetration (dwell) time remove any penetrant remaining on the surface using clean, dry, and lint free cloth.

6.7.2. Remove the remaining traces of penetrant on the weld surface by wiping the surface with clean, lint- free material lightly moistened with the solvent remover. Complete this step within 10 minutes after start of excess penetrant removal.

6.7.3. Do not flush the weld surface with cleaning solvent for removal of excess penetrant.

6.8. DRYING AFTER EXCESS PENETRANT REMOVAL (AS PER ASME SEC V ARTICLE 6 T-674)

Wait for a maximum of 2 minutes for evaporation of cleaning solvent used above for Excess Penetrant Removal.

6.9. METHOD OF APPLYING DEVELOPER

Apply Developer using aerosol can spray after above step. (i.e. Drying After Excess Penetrant Removal). Maximum time for Developer application is 5 min.

6.10. DEVELOPER DWELL TIME (INTERPRETATION TIME)


6.10.1. Developing time for final interpretation begins immediately after developer coating is dry.

6.10.2. Wait for a minimum of 2 minutes after developer spray for developer coating to dry.

6.10.3. Observe closely during application of developer to aid in characterization of indications developed.

6.10.4. Final interpretation shall be made within 10 to 20 min after developer coating is dry.

6.11. MINIMUM AND MAXIMUM TIME PERIODS BETWEEN STEPS AND DRYING AIDS

 HPVP	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 7 of 9
--	---	--

6.11.1. Minimum time between surface cleaning and application of penetrant 3 minutes. Maximum No limit.

6.11.2. Minimum/Maximum time between application of penetrant and start of excess Penetrant removal 5/10 minutes for welds and 10/15 minutes for plates and forgings.

6.11.3. Maximum time between excess penetrant removal and application of Developer 10 minutes.

6.11.4. Final interpretation time minimum 10 and maximum 20 minutes after developer coating is dry.

7. PERSONNEL QUALIFICATION REQUIREMENTS


Personnel qualified and certified to NDE Level III in PT shall demonstrate this procedure to the satisfaction of AI. Application of this procedure on jobs shall be by personnel qualified and certified to NDE Level II / NDE Level III in PT as per the Written Practice.

8. MATERIALS, SHAPES, OR SIZES TO BE EXAMINED AND THE EXTENT OF EXAMINATION

This procedure is applicable to welds, plates, forgings of all shapes and sizes for ferrous and non ferrous materials. The extent of examination shall be as per referred specification or test plan.

9. POST EXAMINATION CLEANING TECHNIQUE:

Using cloth or cotton waste Post-examination cleaning shall be done as soon as practical after Evaluation and Documentation.

 HPVP	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 8 of 9
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10. GENERAL REQUIREMENTS:

- 10.1. If the surface to be examined is large enough to complete examination within the above established times the examination shall be performed in increments.
- 10.2. Ensure bleed-out from large indications does not alter the examination results during interpretation time.
- 10.3. Any change of requirement specified as an essential variable in para 5 shall require requalification of this written procedure.

11. EVALUATION:

All indications shall be evaluated in terms of the acceptance standards Referred below.

12. DOCUMENTATION (AS PER ASME SEC V EDITION 2019ARTICLE 6 T-690):

Recording of Indications shall be done in Liquid Penetrant Examination Requisition cum report format referred in Exhibit 2.

- 12.1. Non rejectable Indications: Non rejectable indications shall be recorded as specified by the referencing Code Section.
- 12.2. Rejectable Indications: Rejectable indications shall be recorded.
As a minimum, the type of indications (linear or rounded), location and extent (length or diameter or aligned) shall be recorded.

13. RECORDS:


All the reports of Liquid Penetrant Examination shall be preserved till MDR signed.

14. ACCEPTANCE STANDARDS FOR LIQUID PENETRANT EXAMINATION:

REF: ASME SEC I, ASME SEC VIII Div 1 & Div 2 Edition 2019.

All surfaces to be examined shall be free of

1. Relevant linear indications.
2. Relevant rounded indications greater than 3/16 inch (5mm).

 HPVP	PROCEDURE FOR LIQUID PENETRANT EXAMINATION	PROC No: BHE-NDT-PT-07026 REV. No.: 2 SHEET : 9 of 9
--	---	--

3. Four or more relevant rounded indications in a line separated 1/16 inch (1.5mm) or less (edge to edge).

Notes:

- Only indications with major dimensions greater than 1/16 inch (1.5 mm) shall be considered relevant.
- A linear indication is one having a length greater than three times the width.
- A rounded indication is one of circular or elliptical shape with the length equal to or less than three times the width.
- Any questionable or doubtful indications shall be reexamined to determine whether or not they are relevant.

(For other Codes such as ASME B31.1, NBIC NB23 refer respective current Edition)



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

EIL Ref No B224/2025

Date: 29.03.2021

Page 1 of 9

1.0 SCOPE:

This procedure is applicable for Surface Preparation and application of Primers and Paints on surface of Main Fractionator of this specific project manufactured as per ASME Section VIII Div. 1 Ed 2017.

2.0 REFERENCE DOCUMENTS

- 1) EIL Specification no. B224-000-79-41-PLS-01 Rev. 05
- 2) Approved drawing(s) latest revision.
- 3) Inspection and Test Procedure latest revision.

3.0 APPLICABILITY

Applicable to following item of this specific project.

Main Fractionator (Item No. **111-C-2101**)

4.0 SURFACE PREPARATION

a) General:

Adhesion of the paint film to the surface depends largely on the degree of cleanliness of the metal surface. Proper surface preparation contributes more to the success of the paint protective system. In order to achieve the maximum durability, surface preparation by Abrasive blast cleaning shall be done.

Mill scale, rust, rust scale and foreign matter shall be removed fully to ensure that a clean and dry surface is obtained and it shall be Sa 2-1/2 as per Swedish standard SIS-055900 (latest edition) or SSPC-SP⁻¹⁰ or ISO 8501-01.

Before surface preparation by blast cleaning, the surface shall be degreased by aromatic solvent to remove all grease, oil etc as per SSPC-SP-1.

Blast cleaning shall not be performed where dust can contaminate surfaces undergoing such cleaning or during humid weather conditions having humidity 85%.



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021

Page 2 of 9

Irrespective of the method of surface preparation, the first coat of primer must be applied by airless spray/ air assisted conventional spray, if recommended by the paint manufacturer, on dry surface.

This should be done immediately and in any case within 4 hours of cleaning of the surface. However, at times of unfavourable weather conditions, BHEL QC-Incharge shall have the liberty to control the time period, at his sole discretion and/or to insist on re-cleaning before primer application is taken up. In general, during unfavourable weather conditions, blasting and painting shall be avoided as far as practicable.

b) Procedure for surface preparation

➤ **Air blast cleaning with abrasives**

The surfaces shall be blast cleaned using one of the abrasives such as Al_2O_3 particles, chilled cast iron or steel grit, copper slag or nickel slag at a pressure of 7.0 kg/cm² and at an appropriate distance & angle depending on nozzle size maintaining constant velocity and pressure.

Chilled cast iron or steel shall be in the form of shot or grit of size in the range of G16 – G42 conforming to SSPC AB1 and S250 grade size of steel shots (maximum) to obtain a desired surface profile of 35-50 microns' trough to peak. For all other abrasives, size shall be in the range of G16 – G24. The combination of steel grits and shots shall be normally in the ratio of 3:1.

The quality of abrasives shall be free from contaminants and impurities and shall meet the requirements of SSPC AB1. The compressed air shall be free from moisture and oil. The blasting nozzles should be venturi style with tungsten carbide or boron carbide as the material for liners. Nozzle orifice may vary from 3/16" to 3/4".

On completion of blasting operation, the blasted surface shall be clean and free from any scale or rust and must show a grey-white metallic luster.

Primer or first coat of paint shall be applied within 4 hours of surface preparation. Blast cleaning shall not be done outdoors in bad weather without adequate protection. If there is dew on the metal surface, it shall be cleaned. The surface profile shall be uniform to provide good adhesion (i.e. 35 to 50 microns) to the paint. If possible, a vacuum collector shall be installed to collect and recycle the abrasives.



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021

Page 3 of 9

➤ Mechanical or power tool cleaning

Power tool cleaning shall be done by mechanical striking tools, chipping hammers, grinding wheels or rotating steel wire- brushes. Excessive burnish of the surface shall be avoided as it can reduce paint adhesion. On completion of cleaning, the detached rust, mill scale etc. shall be removed by clean rags and /or washed by water/steam and thoroughly dried with compressed air jet before application of paint.

Shop primed equipment and surfaces will only be 'spot cleaned' in damaged areas by means of power tool brush cleaning or hand tool cleaning and then spot primed before applying one coat of field primer, if applicable. In case of the shop primer that is applied is not compatible with field primer, then shop coated primer should be completely removed before application of selected paint system for a particular environment.



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021

Page 4 of 9

5.0 COATING PROCEDURE AND APPLICATION

a) General:

All coatings shall be applied by airless spray except for the following special cases, where application can be carried out by brush subject to suitability of the application of the paint product by brush.

- Spot repair
- Stripe coating on edges
- Small bore parts not suitable for spray application

Irregular surfaces such as sharp edges, welds, small brackets, and interstices may stripe coated to ensure specified DFT is achieved. Paint manufacturer recommendation should be followed before deciding for brush application.

Surface shall not be coated in rain, wind or in an environment where injurious airborne elements exist, when the steel surface temperature is less than 5 °F above dew point, when the relative humidity is greater than 85%, when the temperature is below 40°F and when the ambient/substrate temperature is below the paint manufacturers recommended temperature of application and curing. Dehumidifier equipment shall be used to control RH and Dew point. The paint application shall not be done when the wind speed exceeds 20 km per hour.

Blast cleaned surface shall be coated with complete application of primer as soon as practicable but in no case later than 4 hours the same day.

To the maximum extent practicable, each coat of paint shall be applied as a continuous film with uniform thickness and free of probes. Any spots or areas missed in application shall be re-coated and permitted to dry before the next coat is applied. Applied paint should have the desired wet film thickness.

Each coat shall be in proper state of cure or dryness before the application of succeeding coat. Material shall be considered dry for re-coating when an additional coat can be applied without the development of any detrimental film irregularities such as lifting or loss of adhesion of the under coat. Manufacturer's instructions shall be followed for inter coat interval.

When the successive coat of the same colour have been specified, alternate coat shall be tinted, when practical, sufficiently to produce enough contrast to indicate the complete coverage of the surface. The tinting material shall be compatible with the material underneath and shall not be detrimental to its service life and shall be recommended by the original paint manufacturer.

Brush application of paint shall be in accordance with the following:



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021

Page 5 of 9

- a. Brushes shall be of a style and quality that will enable proper application of paint.
- b. Round or oval brushes are most suitable for rivets, bolts, irregular surfaces, and rough/pitted steel. Wide flat brushes are suitable for large flat areas but they shall not have width over 5 inches.
- c. Paint shall be applied into all corners.
- d. Any runs or sags shall be brushed out.
- e. There shall be a minimum of brush marks left in the applied paint.
- f. Surfaces not accessible to brushes shall be painted by spray, daubers, or sheepskin.

b) Drying of coated surfaces

No coat shall be applied until the preceding coat has dried. The material shall be considered dry for re-coating when another coat can be applied without the development of any film irregularities such as lifting or loss of adhesion of undercoats. Drying time of the applied coat should not exceed maximum specified for it as a first coat. If this exceeds, the paint material has possibly deteriorated or mixing is faulty.

No paint shall be force dried under conditions which will cause chalking, wrinkling, blistering formation of pores, or detrimentally affect the conditions of the paint.

No drier shall be added to paint on the job unless specifically called for in the manufacturer specification for the paint.

Paint shall be protected from rain, condensation, contamination, snow and freezing until dried to the fullest extent practicable.

c) Spot repair of damaged primer

Where pre-erection/shop primer has been damaged at isolated localized spots during handling and transportation or after erection / welding, its repair shall be done as given below

Design Temp. in °C	Surface Preparation	Coating System	Total DFT in Microns (min.)
-90 to 400	SSPC-SP-3	1 coat of F-9	65-75
401-550	SSPC-SP-3	1 coat of F-12	20

EIL comment:
This is not as per PR requirement . Follow as per Mfg recommend.

Repair of damaged inorganic zinc silicate pre-erection/pre-fabrication/shop primer (F9) after erection / welding in the design temperature of -90°C to 400°C and damaged silicone aluminium (F-12) pre-erection/pre-fabrication/shop primer after erection/welding for design temperature range of 401 to 550°C.

Surface preparation: Quickly remove the primer from damaged area by mechanical scraping and emery paper conforming to SSPC-SP-3 to expose the white metal. Blast clean the surface, if possible. Feather the primed surface, over the intact adjacent surface surrounding the damaged area, by emery paper.

Paint type and application shall be as per approved drawing



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021

Page 6 of 9

~~Primer coating: One coat of F-9 shall be applied wherever damage was observed on pre-erection / pre fabrication or shop primer of inorganic zinc silicate coating (F-9). Similarly, one coat of F-12 shall be applied wherever damage observed on pre erection / pre-fabrication/shop primer of silicone aluminium (F-12).~~

~~If damaged areas are found to be extensive and spread over large areas, then entire pre-erection / pre-fabrication / shop primer shall be removed by blasting to achieve SSPC-SP-10 and entire blasted surface shall be primed again with F-9 or F-12, as applicable, for the intended design temperature as per above Table.~~

EIL Comment: Above painting is not as per requirement , recheck.

d) Documentation / records

Daily progress report with details of weather conditions, particular of applications, no. of coats and type of materials applied, anomalies, progress of work versus program.

Results of measurement of temperatures, relative humidity, surface profile, film thickness, holiday detection, adhesion tests with signature of appropriate authority.

Particulars of surface preparation and paint application during trials and during the work.

Details of non-compliance, rejects and repairs.

Type of testing equipment and calibration.

Code and batch numbers of paint materials used.



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021

Page 7 of 9

6.0 QUALITY CONTROL, INSPECTION AND TESTING

a) General:

All painting materials including primers and thinners to be procured as per specifications and shall be accompanied by manufacturers' test certificates. Paint formulations without certificates are not acceptable.

The painting work shall be subject to inspection at all times. In particular, following stage-wise inspection will be performed and the work for inspection and approval of every stage before proceeding with the next stage. Stages of inspection are as follows:

- a) Surface preparation
- b) Primer application
- c) Each coat of paint

b) Following tests are to be carried out during surface preparation:

- Test for presence of oil/grease and contamination

The steel substrate after degreasing as per SSPC-SP-1 shall be tested as per following procedure to validate absence of oil and grease contamination:

- i) Visual inspection - continue degreasing until all visible signs of contamination are removed.
 - ii) Conduct a solvent evaporation test by applying several drops or a small splash of residue-free tri-chloromethane on the suspect area especially pitting, crevice corrosion areas or depressed areas. An evaporation ring formation is indicative of oil and grease contamination. Continue degreasing and inspection till test is passed.
- Tests for surface finish of blasted surface shall be done by visual inspection using SSPC-VIS1. Clear cellophane tape test as per ISO 8502-3 shall be used to confirm absence of dust on blasted surface. Checks shall be done on each component at least once per 200 m² of blasted surface and a minimum of 3 checks per shift.
- Test for presence of soluble salt as per method ISO 8502-9. Maximum allowable salt content shall be considered 20 mg/m². Checks shall be done on each component at least once per 200 m² of blasted surface and minimum of 3 checks per shift. In case salt exceeds specified limit, the contaminated surface shall be cleaned by method as per Annexure-C of IS 12944-4 (water cleaning). After cleaning, surface shall be retested for salt after drying.



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021

Page 8 of 9

iii) Blast Profile Measurement:

The angular profile depth measurement shall be done by profile tape as per method NACE Standard RP 0287 or ASTM D 4417 method B (Profile depth gauge micrometre). Spot measurement shall be carried out every 15m² of blasted surface.

At each spot three measurements shall be taken over an area of 10 cm² and average of measurements to be recorded and reported. If profile is <65 microns blasting shall continue till greater than 65 microns depth profile is achieved.

➤ Tests for blasting media, blasting air

Blasting Media: (For every fresh batch of media and one random test during blasting)

Blasting Media shall be visually inspected for absence of contamination and debris using 10 X magnification.

Inspection for the absence of oil contamination shall be conducted using following procedure:

- Fill a small clean 200 ml bottle half full of abrasive.
- Fill the bottle with potable water, cap and shake the bottle.
- Inspect water for oil film/slick. If present, the blasting media is not to be used.
- Soluble salt contamination if suspected shall be verified by method ASTM D 4940. If present, media to be replaced.
- Clean blasting equipment, especially pot and hoses, and then replace blasting media and retest.

Test for Blasting Air : (Once Daily before start of blasting and once at random during blasting) The air for blasting shall be free from moisture and oil. The compressor air shall be checked for oil and water contamination per ASTM D 4285.

Primer Application

After surface preparation, the primer should be applied to cover the crevices, corners, sharp edges etc. The shades of successive coats should be slightly different in colour in order to ensure application of individual coats, the thickness of each coat and complete coverage should be checked as per provision of this specification.

EIL Comment: Required painting system is not mentioned in this procedure.

This procedure approved with null & Void



Surface Preparation & Painting Procedure

BHEL Doc No: HPVP-2439-SP & PP Rev. 0

Date: 29.03.2021



Page 9 of 9

c) Final inspection of finished coating shall consist of the following:

- 1) **Coating dry film thickness check:** DFT measurement shall be as per ISO 2808. Type II electromagnetic gauges should be used for ferrous substrates. DFT gauge calibration, number of measurement shall be as per SSPC-DA-2. Measured DFT shall be within + 10% of the dry film thickness, specified in the specifications.
- 2) **Adhesion testing:** Adhesion of the primer to the steel substrate and inter-coat adhesion of the subsequent coat(s) after curing for at least a week after application of the topcoat shall be examined by a knife test in accordance with ASTM D6677. For the knife test, if the rating is better than 8, the adhesion is considered acceptable. The adhesion is destructive and tested areas shall be repaired afterward using the spot repair procedure. Alternatively, the applicator may perform the adhesion test on a steel panel coated using the same surface preparation and coating application procedure as the work piece. Adhesion testing shall be carried out for each component at least once per 200 m² of coated surface
- 3) **Holiday detection check:** Holiday testing shall be conducted in case the total paint DFT is more than 500 microns in accordance with NACE SP0188. For atmospheric exposure, 10% of coated area which must include weld seams, corners and edges to be holiday tested. Voltage at which test is to be carried out will depend upon DFT of coating being tested and shall be as per NACE SP0188. Any holiday is unacceptable and should be marked and repaired immediately. In case the total paint DFT is less than 500 microns, Pin Hole test will be applicable.

7.0 ENCLOSURES:

- 1) Painter Qualification Certificate (Annexure I –A)
- 2) Record of Training & Qualification (Annexure I- B)
- 3) Painting Certificate: FORMAT NO: QOS/PNT/002

Prepared by	Reviewed & Approved by	Approved by TPIA	Approved by EIL
			Required painting system is not mentioned in this procedure . Hence this procedure is appd as ' Null & Void
P. Gopi Kishore Manager /QA	A.K. Mandal AGM (Q & BE)		



 374-109	BHARAT HEAVY ELECTRICALS LIMITED Visakhapatnam – 530012
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Annexure I-A

(FOR BHEL VENDORS PAINTER QUALIFICATION)

QUALITY/PLANT LABORATORY

PAINTER'S QUALIFICATION CERTIFICATE

1. Name :
2. Father's name :
3. Date of birth/ Age :
4. Basic Qualification :
5. Experience in the painting field :

Name of Expert trainer :
Designation :

Photo

Date of start of training	Training subject	Faculty	Duration (Hrs.)	Certificate issued Yes/no	Remarks
	1.Painting process and Equipment		2		Issued on Validity Up to:
	2.Painting Document/ Data sheet/Batch TC		1		
	3.Knowledge of paint Component and mixing		1		
	4.Painting performance Evaluation on sample		2		
	5.Safety and hygiene		1		

Marks obtained: (each section carry 10 marks)

- 1) Knowledge of painting process and equipment : _____
- 2) Understanding of documents / specification : _____
- 3) Handling components : _____
- 4) Performance evaluation based on jobs/samples : _____
- 5) Knowledge of safety and hygiene : _____

Qualifying marks are 25/50

Qualified for : Airless spray & air spray

Painting System : ~~Alkyd/Epoxy/zinc silicate and heat Resistant based paints~~

Signature of Section I/C
Initiating the Certificate

Signature of
Plant laboratory

Signature of
Certifying expert



BHARAT HEAVY ELECTRICALS LIMITED
Visakhapatnam – 530012

Annexure I-B

(FOR BHEL VENDORS PAINTER QUALIFICATION)

RECORD OF TRAINING & QUALIFICATION FOR PERSONNEL TO BE DEPLOYED FOR
PAINTING PROCESS

VENDOR NAME AND ADDRESS

1. Name :
2. Father's name :
3. Date of birth/ Age :
4. Basic Qualification :
5. Experience in the painting field :

Photo

Name of Expert trainer :
Designation :

Date of start of training	Training subject	Faculty	Duration (Hrs.)	Certificate issued Yes/no	Remarks
	1.Painting process and Equipment		2		Issued on
	2.Painting Document/ Data sheet/Batch TC		1		Validity Up to:
	3.Knowledge of paint Component and mixing		1		
	4.Painting performance Evaluation on sample		2		
	5.Safety and hygiene		1		

Marks obtained: (each section carry 10 marks)

- 1) Knowledge of painting process and equipment : _____
- 2) Understanding of documents / specification : _____
- 3) Handling components : _____
- 4) Performance evaluation based on jobs/samples : _____
- 5) Knowledge of safety and hygiene : _____

Qualifying marks are 25/50

Qualified for : Airless spray & air spray
Painting System : ~~Alkyd/Epoxy/zinc silicate and heat~~
Resistant based paints

Signature of
Initiating Official

Signature of
Certifying Expert

	BHARAT HEAVY ELECTRICALS LIMITED HEAVY PLATES & VESSELS PLANT- VISAKHAPATNAM PAINTING CERTIFICATE				
	FORMAT NO: QOS/PNT/002				

Report No.	:-				
W. O. No.	:-		PGMA/DU/EQ	:-	
Customer	:-		Project	:-	
Description	:-		Drawing No.	:-	
Paint Specified as per Drawing:			:-	Primer :	
				Final :	
Shade of Paint			:-		
Operator / Painter Name			:-		
Method of Surface Preparation			:-		
Date of Surface Preparation		Date:	:-	Time:	Grade:
PAINT DETAILS	PRIMER	2ND PRIMER	Int coat 1	Int coat 2	FINAL
Painting Specification (Inner & Outer Surface)					
Maker / Supplier					
PTS No/Batch No.					
Date of Manufacturing					
Date of Expiry					
Paint Process / Gun Pressure					
Date & Time of Application					
Drying Time					
No. of Coat					
Required DFT Per Coat					
Total DFT (Required)					
Total DFT (Found)					
Adhesion Test:					

Remarks:-

ENGINEER (QC)



Hydro Test, Flushing & Dry out Procedure

BHEL Doc No: HPVP-2439-HYD Rev. 0

Date: 29.03.2021

Page 1 of 5

HYDROSTATIC TEST: (AT SHOP)

Clause	Description	Details
1.0	Scope	This procedure is applicable for hydrostatic testing of Main Fractionator of this specific project manufactured as per ASME Section VIII Div. 1 Ed 2017.
2.0	Reference Documents	<ol style="list-style-type: none">1) B224-80-43-TR-6006-2025 (including General Instruction 25)2) Approved drawings including General Notes3) Doc No. 076405C-111-JSS-0400-0002 Rev.0 (including Sl.no. 5.1.1)4) ASME Sec VIII Div. 1, UG-99 Edition 2017 as applicable.
3.0	Applicability	Applicable to following item of this specific project. <ol style="list-style-type: none">1) 111-C-2101 – Man Fractionator
4.0	Hydro Test Requirement	As per the reference documents and the water quality shall be potable water with less than 50 ppm chloride content. Water test report may be made available during the test.
5.0	Stage of testing	After PWHT and the arrangement of hydro test shall be as specified in the drawing..
6.0	Method of testing	<ol style="list-style-type: none">A) Production / OS shall ensure that hydrostatic test is carried out properly in accordance with Code requirements. It is also to be ensured that the Hydrostatic test is carried out in a safe manner and during the test, the vessel is adequately and firmly supported. In case Hydrostatic test is conducted in vertical position, In-Charge (Engg) shall be consulted for supporting arrangement.B) QC shall witness the test and carry out necessary visual inspection.C) Witness of TPI/Customer shall be as per approved ITP of this project.D) Only calibrated pressure gauges graduated over a range of about double the intended maximum test pressure but in no case the range is less than 1.5 times nor more than 4 times of that pressure are used. Digital reading pressure gages having a wider range may be used provided the readings give the same or a greater degree of accuracy than obtained with dial pressure gages.E) Type / Number pressure gauges used to be as specified by engineering.F) Fill the water from topside opening of the vessel slowly.G) The pressure shall be applied preferably from bottom side.H) Venting arrangement shall be provided at the top most position, in which the vessel will be tested, to remove the trapped air while the vessel is filling. Vent shall be closed only after the water starts overflowing from it. Before applying pressure, the test equipment shall be examined to see that it is tight and that low pressure filling lines and the other appurtenances that should not be subjected to the test pressure have been disconnected.

25 PPM as per para 10 of EIL Specification 6-12-0007



Hydro Test, Flushing & Dry out Procedure

BHEL Doc No: HPVP-2439-HYD Rev. 0

Date: 29.03.2021

Page 2 of 5

		<ul style="list-style-type: none">I) Vessel shall be pressurized gradually until the test pressure specified in the drawing is reached.J) Care shall be taken by the operator to ensure that the pressure does not exceed the test pressure, in such way that might cause visible permanent distortion and also the vessel shall not be left unattended during the test.K) Following the application of the hydrostatic test pressure, the test pressure may be brought down to a value of not less than test pressure divided by 1.3 and visual examination shall be carried out for all joints and connections. Dy Manager (QC) shall witness the test and carry out necessary visual inspection before offering to TPI/Customer as per the approved ITP. The test pressure as per drawing shall be held for minimum 1 hour.L) Any leakage from temporary support is not allowed, need to be attended/ repaired prior to hydrostatic test. Any pressure drop due to such leakage cannot confirm total hydro-test of the vessel.M) Gasket used shall be same as job.N) The vessel is acceptable when there is no evidence of any leak.O) After completion of hydro test, topside vent shall be opened first and then the bottom side valve to drain the water.P) Vessel shall be dried by compressed air or by cloth to remove traces of water.
7.0	Documentation	<ul style="list-style-type: none">A) After the acceptance of hydro test by the TPI/Customer, QC shall prepare Pressure Test Report.B) TPI/Customer shall give his acceptance by signing Pressure Test Report.C) PO number, project name, ITP reference and this hydro test procedure number shall be specified in the hydro test report.D) Pressure gauge calibration shall be verified after each pressure test and it shall be documented on Pressure Test Report. (Actual readings are not required). QC shall verify calibration status of pressure gauges used.



Hydro Test, Flushing & Dry out Procedure

BHEL Doc No: HPVP-2439-HYD Rev. 0

Date: 29.03.2021

Page 3 of 5

FLUSHING & DRY OUT: (AT SHOP)

Clause	Description	Details
1.0	Stage	Flushing/draining after satisfactory hydrostatic test.
2.0	Procedure	<p>A) Flushing shall be done by clean potable water with max 50²⁵ ppm chloride content.</p> <p>B) Required pressure for water flushing shall meet the utility water pressure.</p> <p>C) Flushing & Draining</p> <ol style="list-style-type: none">1) One opening at the top most/highest point always be opened.2) Water connection at the bottom shall now be completely opened to start the draining of the equipment.3) Temporary flange/blind cover connection of additional/all nozzles may also be opened for higher rate of flow.4) After proper draining of equipment, all nozzle connections shall be open.5) The equipment shall be kept in tilted position from RHS/LHS side, with the nozzle connection on lower side, to facilitate the draining.6) The equipment shall then be tilted from the other side to facilitate draining. This process is repeated for 2 times.7) After ensuring that no water is flowing out from outlets, it shall then be offered for inspection. <p>D) Drying:</p> <ol style="list-style-type: none">1) After flushing of the equipment it shall be connected to a pressurized air supply on nozzle.2) Column shall be dried completely by compressed air for sufficient time. <p>E) Inspection</p> <ol style="list-style-type: none">1) QC shall inspect the internal surfaces by light/torch for any water drops in the equipment and offer to TPIA for inspection as per ITP.2) Ensure dry air at air outlet.
3.0	Documentation	E) Details of flushing and drying to be recorded in the hydro test report.



Hydro Test, Flushing & Dry out Procedure

BHEL Doc No: HPVP-2439-HYD Rev. 0

Date: 29.03.2021

Page 4 of 5

HYDROSTATIC TEST: (AT SITE)

Clause	Description	Details
1.0	Scope	This procedure is applicable for hydrostatic testing of site weld joint. The site joint is as specified in approved drawing (s).
4.0	Hydro Test Requirement <small>25 PPM as per para 10 of EIL Specification 6-12-0007</small>	As per the reference documents and the water quality shall be potable water with less than <u>50 ppm</u> chloride content. Water test report may be made available during the test.
5.0	Stage of testing	After Local Heat Treatment as specified in approved Heat Treatment procedure. The arrangement of hydro test shall be as specified in the drawing..
6.0	Method of testing	<p>A) Site shall ensure that box hydrostatic test for site joint is carried out properly in accordance with the requirements. It is also to be ensured that the Hydrostatic test is carried out in a safe manner and during the test, the vessel is adequately and firmly supported.</p> <p>B) QC shall witness the test and carry out necessary visual inspection.</p> <p>C) Witness of TPI/Customer shall be as per approved ITP of this project.</p> <p>D) Only calibrated pressure gauges graduated over a range of about double the intended maximum test pressure but in no case the range is less than 1.5 times nor more than 4 times of that pressure are used. Digital reading pressure gages having a wider range may be used provided the readings give the same or a greater degree of accuracy than obtained with dial pressure gages.</p> <p>E) Fill the water slowly through the opening provided.</p> <p>F) Venting arrangement may be provided to remove the trapped air while water is being filled.</p> <p>G) Box arrangement to be pressurized gradually until the test pressure specified in the drawing is reached.</p> <p>H) Care shall be taken by the operator to ensure that the pressure does not exceed the test pressure, in such way that might cause visible permanent distortion and also the vessel is not to be left unattended during the test.</p> <p>I) Following the application of the hydrostatic test pressure, the test pressure may be brought down to a value of not less than test pressure divided by 1.3 and visual examination shall be carried out for the site joint and other connections if any. QC shall witness the test and carry out necessary visual inspection before offering to TPI/Customer as per the approved ITP. The test pressure as per drawing shall be held for minimum 1 hour.</p> <p>J) Gasket if any used shall be same as job.</p> <p>K) The site joint is acceptable when there is no evidence of any leak.</p> <p>L) The equipment may be slightly rotated clock wise and anti-clock wise directions to facilitate the draining of box.</p> <p>M) Box / Vessel may be dried by compressed air or by cloth to remove traces of water.</p> <p>N) After ensuring that no water is flowing out from outlets, it shall then be offered for inspection.</p>



Hydro Test, Flushing & Dry out Procedure




BHEL Doc No: HPVP-2439-HYD Rev. 0

Date: 29.03.2021

Page 5 of 5


		<p>O) Inspection</p> <ol style="list-style-type: none"> 1) QC shall inspect the internal surfaces by light/torch for any water drops in the equipment and offer to TPIA for inspection as per ITP. 2) Ensure dry air at air outlet.
7.0	Documentation	<p>A) After the acceptance of hydro test by the TPI/Customer, QC shall prepare Pressure Test Report for site joint.</p> <p>B) TPI/Customer shall give his acceptance by signing Pressure Test Report.</p> <p>C) PO number, project name, ITP reference and this hydro test procedure number shall be specified in the hydro test report.</p> <p>D) Pressure gauge calibration shall be verified after each pressure test and it shall be documented on Pressure Test Report. (Actual readings are not required). QC shall verify calibration status of pressure gauges used.</p> <p>E) Details of flushing and drying to be recorded in the hydro test report.</p>

EIL comment: Water shall be Max 25PPM & Test Pr. shall be as per drawing .
Appd with above comment.

Prepared by	Reviewed & Approved by	Approved by TPIA	Approved by EIL
			
P. Gopi Kishore Manager /QA	A.K. Mandal AGM (Q & BE)		

निम्न मिश्र स्टील वैसल्स के पूरक विनिर्देश

SUPPLEMENTARY SPECIFICATION FOR LOW ALLOY STEEL VESSELS

5	28.08.2018	REVISED AND REISSUED AS STD. SPEC.	SK		KJH	RKT
4	30.06.2010	REVISED AND REISSUED AS STD. SPEC.	KA	RKT	AKM/DM	N.DUARI
3	29.06.09	REAFFIRMED & REISSUED AS STD. SPECN.	VB	RKG	AKM	N.DUARI
2	23.03.04	REVISED & REISSUED AS STD. SPECN.	SCDD	DNN	SSA	SKG
1	16.12.98	REVISED & REISSUED AS STD. SPECN.	USG	AKM	CRMN	AS
Rev. No	Date	Purpose	Prepared by	Checked by	Standards Committee Convenor	Standards Bureau Chairman
Approved by						

Abbreviations:

ASME	:	American Society of Mechanical Engineers
ASTM	:	American Society for Testing and Materials
BHN	:	Brinell Hardness Number
HAZ	:	Heat Affected Zone
HIC	:	Hydrogen Induced Cracking
LPG	:	Liquified Petroleum Gas
LWN	:	Long Weld Neck
NB	:	Nominal Bore
PWHT	:	Post Weld Heat Treatment

Static Equipment Standards Committee

Convenor : Mr. K.J Hari Narayanan

Members : Mr. Mr.Sanjay Mazumdar

Mr.K.Anjaneyulu

Mr. Arun Kumar

Mr. Inder Kumar

Mr. Anish Trehan

Mr. Tarun Kumar

Mr. Srikanth Karanam

Mr. M.Azim (Projects)

Mr. S. Ghosal (Process)

Mr. T.Kamalakaran (Inspection)



CONTENTS

1.0	SCOPE	4
2.0	DESIGN	4
3.0	MATERIALS	4
4.0	WELDING AND WELDING CONSUMABLES	4
5.0	FABRICATION	5
6.0	PRE AND POST WELD TREATMENT	6
7.0	PRODUCTION WELD TESTS	7

conform to one of the classifications listed in ASME SEC.II Part C unless specifically approved otherwise.

The welding consumables shall be selected such that for welds of similar metallurgy, the chemistry of weld shall match the chemical composition of the base material and the physical strength of weld shall be better or equal to the base material. Also the corrosion properties of the filler material shall be in line with the base metal.

- 4.7 Hardness reading on base metal, actual welds and HAZ shall be taken and these values shall not exceed the maximum hardness values obtained on the welding procedure. Hardness limits on various materials are as indicated below:

For P3 and P4 materials	-	225 BHN
For P5 materials	-	235 BHN

5.0 FABRICATION

- 5.1 Dish heads and knuckles shall preferably be hot formed to prevent possible cracks during cold-forming, with intermediate checking of hardness. However, if vendor has past experience of cold forming, same is acceptable.

- 5.2 Magnetic particle examination shall be carried out on the formed knuckle surface (both inside and outside) of dished ends and toricones for detection of cracks.

- 5.3 The preparation of the edges shall be made by oxyacetylene flame cutting or by machining. Cold shearing is permitted for cutting to size up to a thickness of 10mm. Oxy acetylene flame cutting done in any circumstances shall be followed by machining or grinding to eliminate any discoloration of material affected.

5.4 Non-Destructive Test

- 5.4.1 All welding edges shall be checked by Magnetic Particle examination for detection of cracks, laminations or segregations.

- 5.4.2 The ultrasonic examination shall be carried out within 2t of material thickness (t) of all weld edges prior to welding as per ASTM A 578 with acceptance level-B.

- 5.4.3 External and internal surfaces of all welds shall be checked by Magnetic Particle examination after hydro-test for vessels having thickness above 50mm.

- 5.4.4 Hardness shall be measured on both inside and outside after final PWHT of each vessel for the following:

- i) On every longitudinal weld and corresponding HAZ. (At centre of each shell section and fabricated nozzle).
- ii) On every circumferential weld and corresponding HAZ (Two locations)
- iii) On each T-joint and corresponding HAZ.
- iv) On vessel to support joint. (Two locations)
- v) On nozzle welds (Any five numbers)

6.0 PRE AND POST WELD TREATMENT

6.1 Fabricator shall propose the preheat required for each type of weld including tack welds in the welding procedure specifications. The preheat requirements shall be established at the time of approval of welding procedure.

6.2 Preheating performed by using resistance or induction heating method shall be preferred. However, preheating by gas burners, using oxy-acetylene or LPG with neutral flame may be acceptable when permitted by the inspecting authority.

6.3 Pre heating shall extend uniformly to at least three times the thickness of the joint but not less than 50mm on both sides of the weld. Temperature indicating crayons shall be used for assessment of correct preheat temperature.

6.4 Post Heating

6.4.1 In case of P4 and P5 materials, if post-weld heat treatment is not carried out immediately after welding, the weld joint and adjacent portion of the joint at least 50mm on either side of weld shall be uniformly heated to 300°C. This temperature shall be maintained for a duration of 1 hr./inch (minimum 20 minutes) and then wrapped in asbestos or insulation before allowing it to cool to room temperature. Post weld heat treatment as applicable shall be carried out later on.

6.4.2 Post weld heating shall also be necessary for highly restrained joints or where heavy welding is carried out in a localized area for example full throat nozzle welding etc.

6.5 Post Weld Heat Treatment

6.5.1 When PWHT is required as per code or specified in vessel design data, the procedure and scheme for PWHT shall be submitted to inspecting authority for review.

6.5.2 Heat treatment of formed parts shall be carried out as per following:

- a) All cold formed dished ends or knuckles shall be stress relieved.
- b) When hot forming of any part is carried out, the complete procedure including heat treatment shall be submitted to inspecting authority.
- c) When any of the treatments referred to above involves a final treatment which coincides with the final post weld heat treatment of completed vessel, that part of earlier treatment may be omitted.
- d) Vessels in Amine, sour, HIC, Hydrogen service and cyclic services shall be stress relieved.
- e) It shall be fabricator's responsibility to ensure that mechanical properties of material are not impaired during any cold / hot forming process and subsequent stress relieving heat treatment. Tests to demonstrate suitability of process shall be carried out by fabricator.

7.0 PRODUCTION WELD TESTS

Production weld tests shall be applicable for vessels over 25mm thickness. The following requirements shall apply:

- a) Two production test plate coupons representative of one longitudinal and another circumferential seam shall be provided for each procedure, position and thickness in each vessel shell..
- b) One production test plate representative of the weld seams shall be provided for each procedure, position and thickness for welded dished ends/cones.
- c) The production test plate shall be from material of the same heat and thickness as of shell/head. During and after welding the test plates shall be subjected to same heat treatment as and together with the course they represent, extra coupons shall be preserved to take care of eventually of retests. The production test plate shall incorporate additional PWHT cycle in case the equipment closing seam is to be post weld heat treated.
- d) The tests mentioned below shall be carried out as per methods of testing in governing codes:
 - i) One transverse tension test.
 - ii) Two side bend test with weld located in the center of bend.
 - iii) Hardness test on production test coupon weld and HAZ.
 - iv) Micro and macro examination of welds. Microstructure shall be free from untempered martensite.
 - v) Charpy V notch tests on weld and HAZ. Unless otherwise specified, the acceptance criteria (energy absorption values) shall be as per design code with test temperature of minus 18 degree Celsius.