

2026OSB042-SECTION I D - SCOPE OF WORK

SCOPE – Fabrication of Terminal Tubes with Fin Welding (Non – NTPC)

1. IBR approved firm to be loaded.
2. The welding shall be done by IBR qualified welders.
3. The welding procedure specification (WPS) shall be reviewed and approved by BHEL QC
4. Welding Consumables are to be procured from the BHEL approved vendors
5. Fabrication, Inspection and testing shall be carried out as per applicable quality documents (CQP/SQP/SIP/QCP).
6. **Form 3B** will be vendor's scope. **If the manufacturing is carried out within Tamil Nadu, the IBR inspection fees shall be borne by BHEL**, and the vendor is not required to pay these charges. **If the manufacturing is carried out outside Tamil Nadu, the vendor shall bear the IBR inspection fees** as per the applicable fee schedule prescribed by the respective State Government.
7. Production & common note given in manufacturing GMS has to be followed.
8. Collect the complete tubes and plates from BHEL stores with relevant documents.
9. Inspect the raw materials details & specification by spectrometer. All IBR inspection formalities should be followed. If any defects noticed in supplied raw material, inform the same to OS immediately.
10. Shot-blast the tubes.
11. Cut & edge prepare the tubes as per drawing.
12. Any butt joint planned & location of butt joint should be done based on engineering clearance. Prior approval must be obtained from engineering for the same.
13. Build the tubes to required length by Butt joint (TIG welding preferred).
14. Radiographic Test (RT) shall be performed on joints by BHEL or BHEL approved agency only.
15. RT film shall be evaluated by BHEL NDTL.
16. Cut & manufacture the attachments as per drawing.
17. For the purpose of FOT if raw material is required by Firm then it shall be issued by BHEL and shall be treated as scrap for the purpose of material accounting.
18. Bend the tubes as per drawing.
19. Carry out Attachment welding as per drawing.
20. At Butt joint locations, fin should be ground to suit the butt weld reinforcement. Weld over weld should be avoided.
21. Conduct visual inspection on welds. Conduct LPI on welds in the presence of BHEL NDT or BHEL approved agency.
22. All NDT testing such as MPI, LPI, sponge test and etc. wherever called for in the drawing /QWI/ PO are to be done by Firm.
23. Straightening to be ensured.
24. Obtain Stress relieving (SR) co-operation only from BHEL Trichy.
25. Conduct hydro test for tubes in the presence of BHEL QC.
26. Offer for Inspection to QC/BHEL & IBR for final inspection.
27. Provide Identification and End caps. After hydro test, the water must be drained completely. VCI pellets and Plastic End caps should be provided
28. Paint and Dispatch to shipping with relevant IBR and BHEL documents.
29. During dispatch from Vendors works to BHEL, bundle wise (DU wise & full quantity) dispatch must be ensured. (Split-up of DU quantity is not acceptable).