



BHARATH HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014
WELDING TECHNOLOGY CENTRE

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WELDING CONSUMABLE PURCHASE INSTRUCTION FOR
LOW ALLOY STEEL SAW WIRE ASME.SEC.II.C SFA-5.23-EB-3

1.0 GENERAL:

- 1.1 The wire shall comply with requirements specified in the latest edition and addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.23, EB-3. All tests, acceptance criteria shall be in accordance with this. Additional requirements specified in this document and purchase order shall also be complied.
- 1.2 The wires shall be supplied in sizes and quantities as specified in the purchase order.
- 1.3 The wires are intended for use as filler for radiographic quality butt joints in high pressure boiler tubes and pipes.
- 1.4 Every batch of wires shall be inspected & test certificates countersigned by inspecting authority approved by IBR for the country of origin (latest).

2.0 Chemical Composition:

The chemical composition of the wires shall conform to ASME SECII.C SFA-5.23, EB-3.

3.0 SIZE:

The wire shall be supplied in diameter 2.0, 2.4, 3.2, 4.0 & 4.8 mm as specified in the purchase order. The tolerance on diameter shall be as per SFA-5.02. The net weight of the coil shall be 25/30Kg.

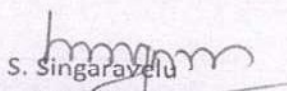
4.0 FORM :

The wires shall be appropriately wound in coils with suitable liners and shall meet the clause 4.3.3 of SFA-5.02 with dimensions 450mm maximum OD, 300mm ID and 100mm width. Alternatively Wires shall be appropriately wound in basket rim B450 as per SFA-5.02.

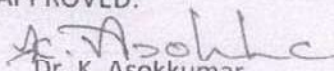
5.0 FINISH & UNIFORMITY:

The Wires shall meet the requirements of clause 16.2.2 and 16.2.4 of SFA-5.23.

PREPARED:


S. Singarayalu
DGM / WTC

REVIEWED & APPROVED:


Dr. K. Asokkumar
AGM/WTC



6.0 WINDING REQUIREMENTS:

The Wires shall meet the requirements of clause 16.4 of SFA-5.23.

7.0 IDENTIFICATION :

The Wires shall meet the requirements of clause 4.5.2, 4.5.4 & 4.5.5 of SFA-5.02.

8.0 MARKING:

The Wires shall meet the requirements of clause 4.6 of SFA-5.02.

9.0 PACKAGING:

9.1 The wire coils should be completely devoid of moisture or any other foreign material and shall be adequately sealed in suitable cartons to ensure against any deterioration in the wire quality during transportation by sea or long duration storage.

9.2 The liners shall meet the requirements of 4.3.3 of SFA-5.02 or the basket rim shall meet the requirements of 4.3.4 of SFA-5.02.

9.3 The cartons shall be packed in water proof boxes with crates so as to ensure no damage during shipment and normal storage conditions. Weight of each crate shall not exceed 1000kg.

9.4 The cartons shall have product information as per clause 4.6 of SFA-5.02

10.0 TESTING & CERTIFICATION:

10.1 Each consignment of wires supplied shall be from one batch only.

10.2 Batch /lot classification shall be Class S1 as per SFA-5.01 of filler metal procurement guidelines of ASME Sec.II.C (latest edition and addenda).

10.3 The level of testing shall be Schedule J as per SFA-5.01 of filler metal procurement guidelines of ASME Sec.II.C (latest edition and addenda).

10.4 Three copies of Original Test certificates in English countersigned by inspecting authority (latest) approved by IBR for country of origin giving details of the tests done in compliance with this Purchase Instruction and ASME Sec.II.C, SFA-5.23, EB-3 shall be sent.

10.5 The testing authority shall certify that supplies made against the batch conform to the requirements of the latest edition & addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.23 EB-3.

Pre- Qualification Criteria

Sl. No.	Pre –Qualification Criteria (EB-3) ✓	Bidder remark
1	Bidder shall be a manufacturer of the Quoted Submerged Arc Welding Wire or an authorized dealer of the same. If the offer is quoted by agent, letter of authorization or agreement duly signed by the manufacturer is required to consider the offer.	
2	Bidder shall have successful experience for supplying EB-3 SAW Consumable to any govt. Organizations/ PSUs/ Public Ltd./ Company/Reputed Industries etc. Purchase orders copies or any related document to be submitted along with offer to consider the offer. Note: Successful experience means – supplied and accepted.	
3	Kindly provide the self-declaration for “successfully supplied and accepted by customer” from Principle Supplier regarding document Sl. No. 2. In self-declaration document, kindly provide the following details: <ul style="list-style-type: none"> • PO number. • PO date. • PO items description. • Brand Name. • Supplied Quantity. • Customer Name. • Manufacturer Name. 	
4	Quoted Product Brand name.	
5	Quoted Product catalogue.	
6	Mill (Manufacturing plant) address	

Sign and seal of authorized person

ADITYA KUMAR
31-05-2022
ADITYA KUMAR
Senior Engineer
Welding Technology Centre
BHEL, TRICHY - 620 014

Sl. No.	Pre-Qualification Criteria (EB-3)	Bidder remark
7	Mill (Manufacturing plant) capacity for SAW Welding Consumables shall be provided along with offer.	
8	Manufacturer shall submit a valid ISO 9001 certificate or Quality management system certificate or Written down procedure.	
9	Manufacturer shall submit manufacturing process flow chart (Raw material to finished product) along with offer for Quoted Item.	
10	Shall confirm to Technical Specifications as per the WCPI-007/04.	
11	Vendor should give confirmation to BHEL's Technical Specification(WCPI-007/04). Any deviation from the Specification are to be mentioned in the "Bidder remark Space". If There is no deviation vendor should indicate "No Deviation".	
12	offered EB-3 Wire Diameter offered EB-3 Spool Weight.	
13	The testing authority shall certify that supplies made against the batch conform to the requirements of the latest edition & addenda (applicable on the date of issue purchase order) of ASME Sec.II.C.SFA-5.23 EB-3.	
14	<u>Meaning of Sl. No. 1.4 "Every batch of wires shall be inspected & test certificates countersigned by inspecting authority approved by IBR for the count of origin(latest)".</u> Original Test Certificates in English countersigned by Inspecting Authority (Latest approved by IBR for the country of origin giving details of the tests done in compliance with this Purchase Instruction and ASME Sec.II.C, SFA-5.23 for EB-3 shall be sent. (OR) "A copy of valid IBR Approval Certificate (for the brand being supplied) shall be sent along with supply. It is mandatory that, Manufacturer should possess a valid IBR certificate (for the brand being supplied) during the manufacturing period. Original Test Certificates in English countersigned by manufacturer, giving details of the tests done in compliance with this Purchase Instruction and ASME Sec.II.C, SFA-5.23 for EB-3 shall be sent.	

Sign and seal of authorized person

Aditya Kumar
31st Feb 2022

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