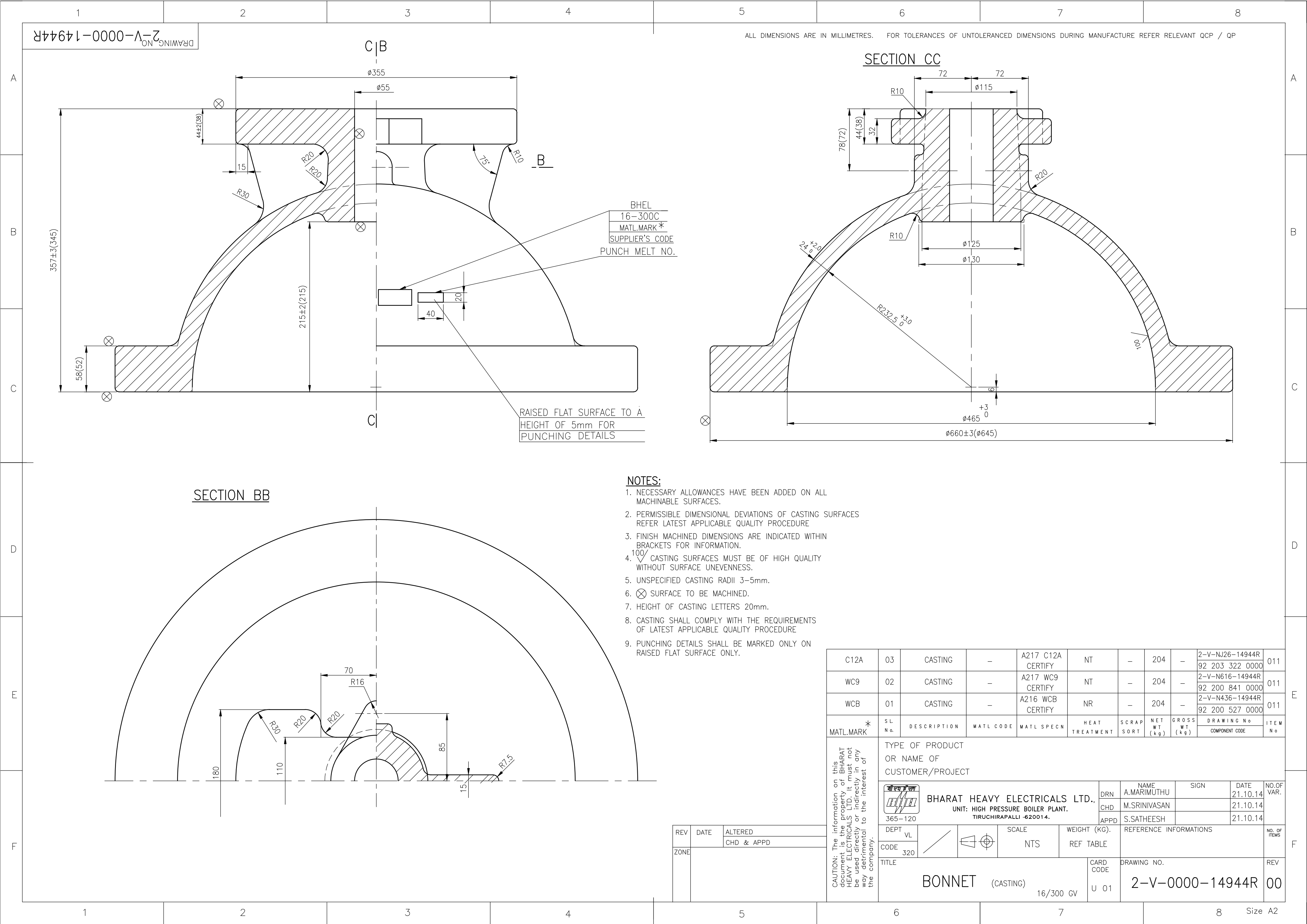
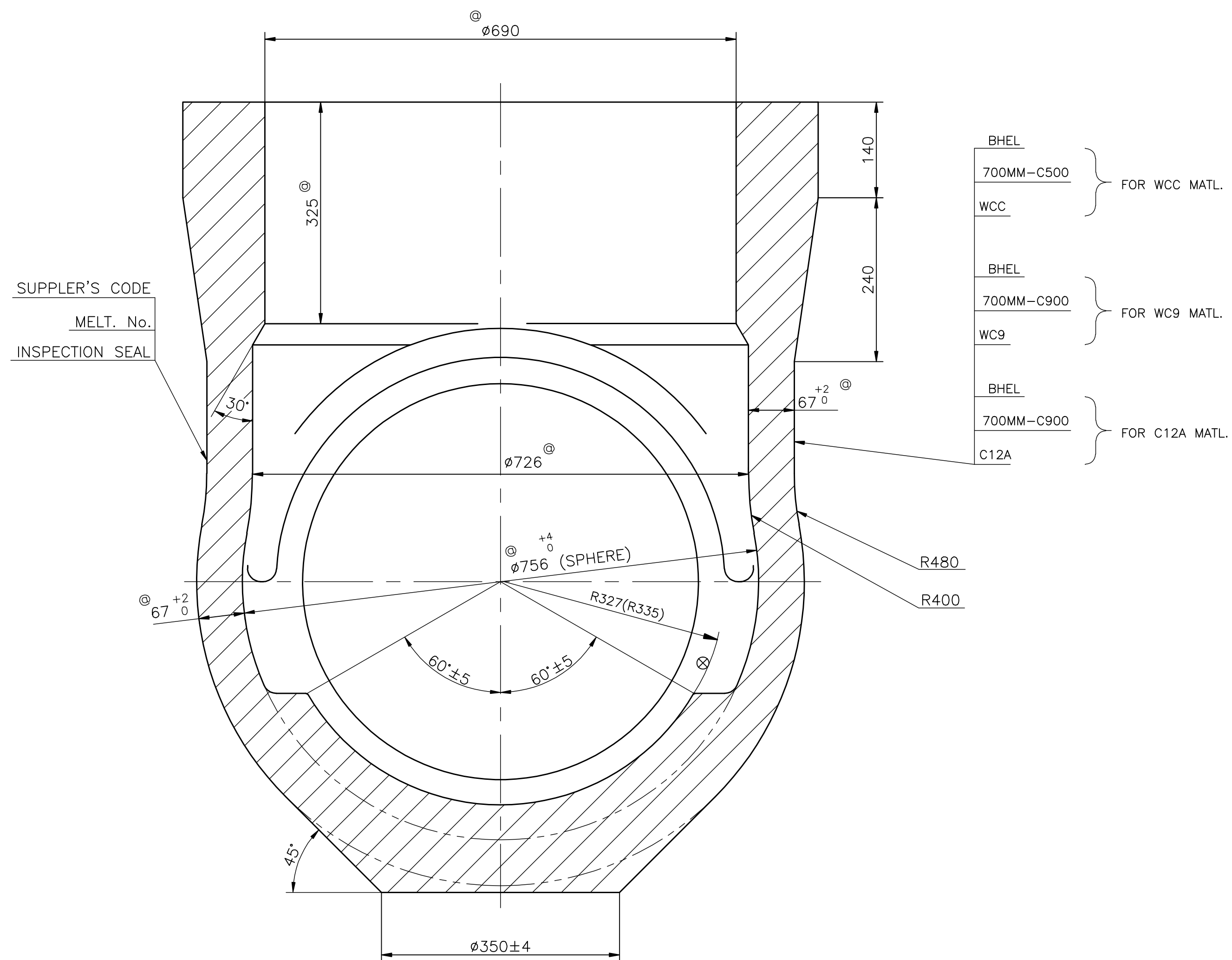
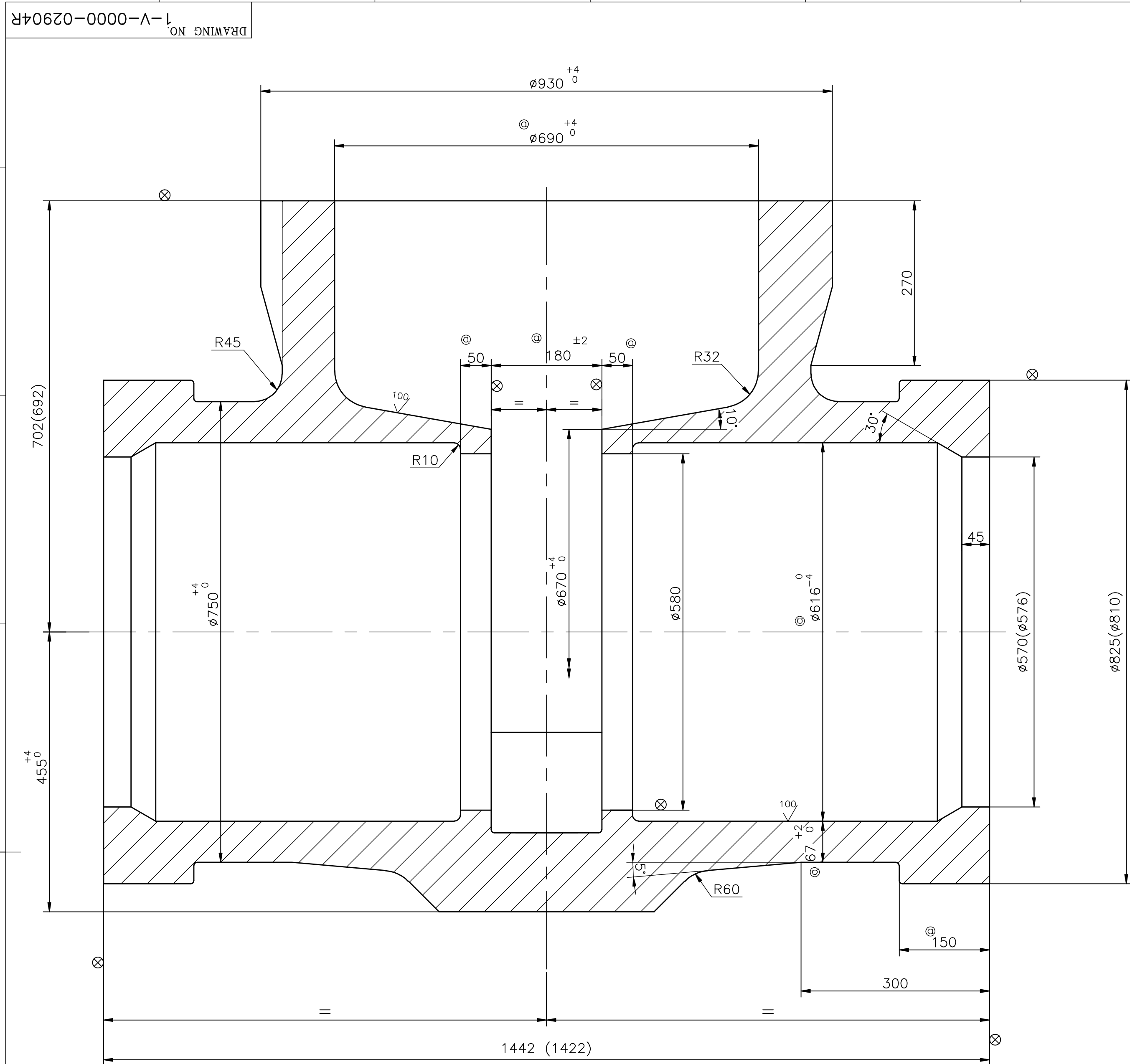






NOTE

01. NECESSARY MACHINING ALLOWANCES HAVE BEEN ADDED ON ALL MACHINABLE SURFACES.
02. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR INFORMATION ONLY.
03. LETTERS- BH&L,SIZE,MATL.& SUPPLIERS CODE ARE TO BE CAST IN THE INDICATED ZONE.
04. CASTING SHALL COMPLY WITH THE REQUIREMENTS OF APPLICABLE QUALITY PROCEDURE
05. UNSPECIFIED CASTING RADII = R3 TO R5
06. HEIGHT OF CASTING LETTERS = 40 mm
07. ⊗ INDICATES SURFACE TO BE MACHINED.
08. ¹⁰⁰√ INDICATED CASTING SURFACES SHALL BE OF HIGH QUALITY WITHOUT SURFACE UNEVENNESS.
09. MELT NUMBER AND INSPECTION SEAL ARE TO BE PUNCHED.

REV 08	DATE 18.08.09	ALTERED M.SRINIVASAN CHD & APPD M.RAJAKUMAR	REV 07	DATE 10.03.09	ALTERED M.SRINIVASAN CHD & APPD P.BOOMINATHAN	REV 06	DATE 18.08.07	ALTERED M.SRINIVASAN CHD & APPD P.BOOMINATHAN	REV 05	DATE 17.4.99	ALTERED R.MOHAN CHD & APPD C.V.L.N	REV 04	DATE 10.3.97	ALTERED T.R.RAMAMURTHY CHD & APPD A.VISWANATHAN	REV 03	DATE 23.7.94	ALTERED M.SRINIVASAN CHD & APPD N.NAGARAJAN	REV 02	DATE 10.12.90	ALTERED M.SRINIVASAN CHD & APPD N.NAGARAJAN	REV 01	DATE 14.09.90	ALTERED N.P.ESWARAN CHD & APPD N.NAGARAJAN	
GROOVE AT SEAT ZONE REMOVED			DCP-800979	DCP-800931	⑥ MARKED DIMENSIONS ARE REVISED / INCLUDED.			SL. No. 03 INCLUDED.			DIMENSION Ø570 (Ø576) WAS Ø580 (Ø590)			NOTES UPDATED REFER DCN:CS:0670			DCN:FS:0237	DIMENSIONS Ø580 (Ø590), 45 & 30° INCLUDED ON WELD END,			DCN:FS:0261	CASTING LETTERS 700MM-C500 & 700MM-C900 WERE 28"-C500 & 28"-C900 RESPECTIVELY.		
DCP:800979																		ø600 WAS ø614 Ø AT INLET AND OUTLET PORT ZONE THIS IS BASED ON THE REQUEST FROM FOUNDARY						

Q3	CASTING	-	ASTM A217 C12A ATTEST	NORMALISED & TEMPERED	-	2700	-	1.V.3244.02904R/2 92 021 680 0000	00
Q2	CASTING	-	ASTM A217 WC9 ATTEST	NORMALISED & TEMPERED	-	2700	-	1.V.3205.02904R/7 92 027 065 0000	00
Q1	CASTING	-	ASTM A216 WCC ATTEST	NORMALISED	-	2700	-	1.V.3204.02904R/7 92 027 064 0000	00
S.No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP	NET WT (kg)	GROSS WT (kg)	DRAWING NO COMPONENT CODE	ITEM No

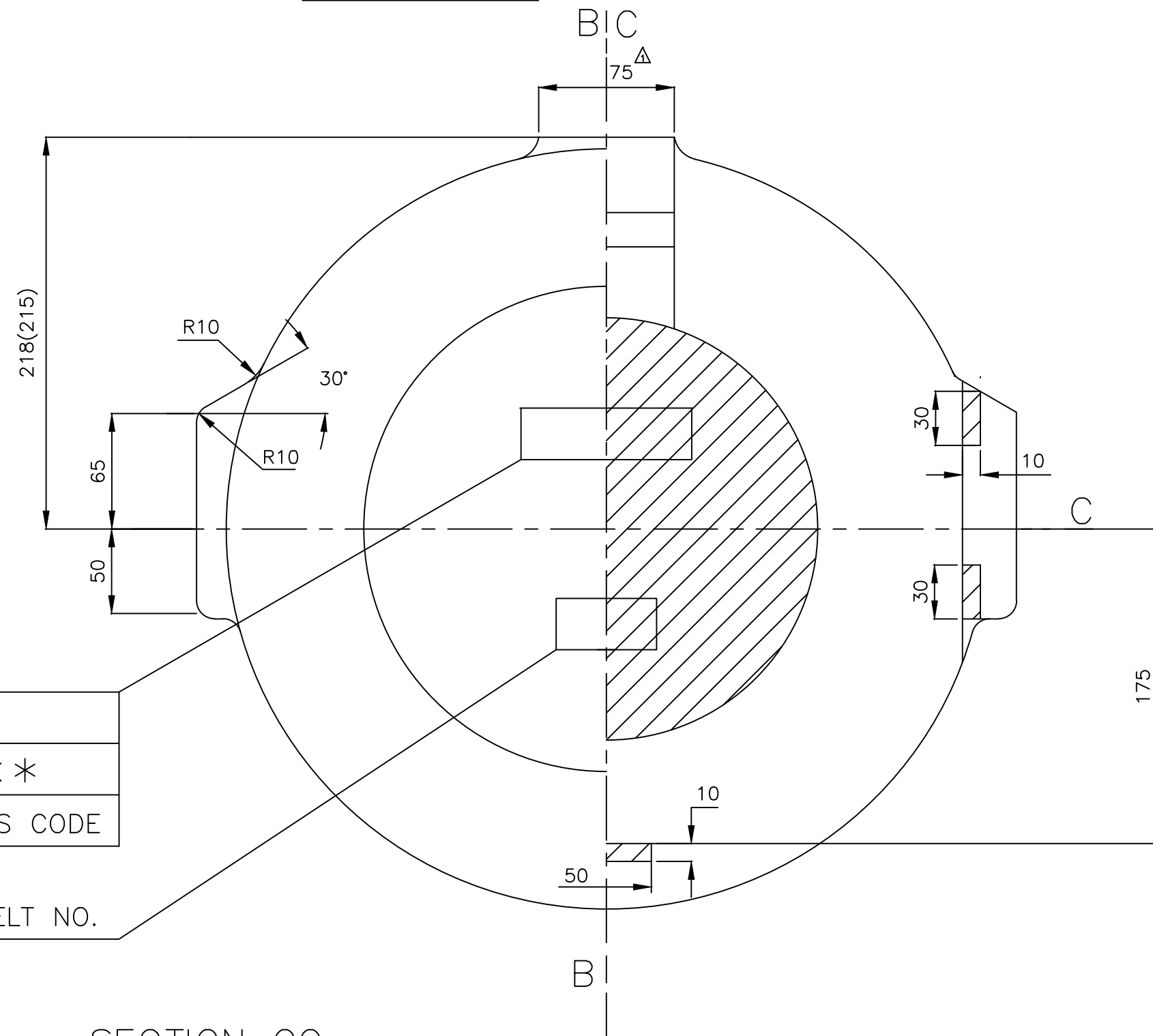
CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT							
		BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT, TIRUCHIRAPPALLI-620014.		DRN	M.SRINIVASAN	SIGN	DATE 31.08.90
365-119				CHD	N.P.ESWARAN		31.08.90
				APPD	N.NAGARAJAN		31.08.90
DEPT VL		SCALE	WEIGHT (KG).		REFERENCE INFORMATIONS		
CODE 320		NTS	2700				
TITLE				CARD CODE	DRAWING NO.		REV
BODY (700 MM)				U 01	1-V-0000-02904R		08

DRAWING NO. 2-V-0000-06124R

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

SECTION AA



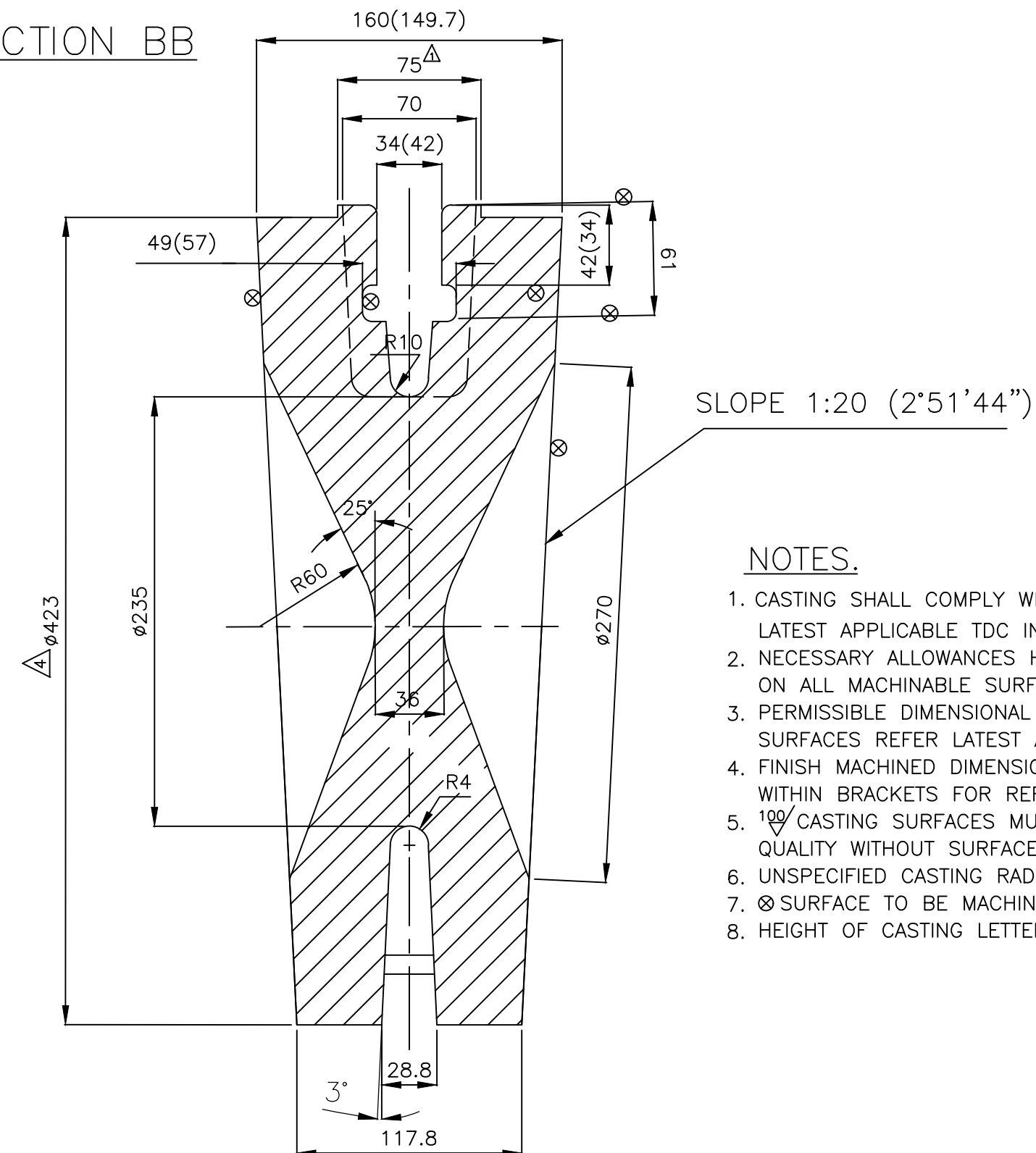
BHEL

16-300

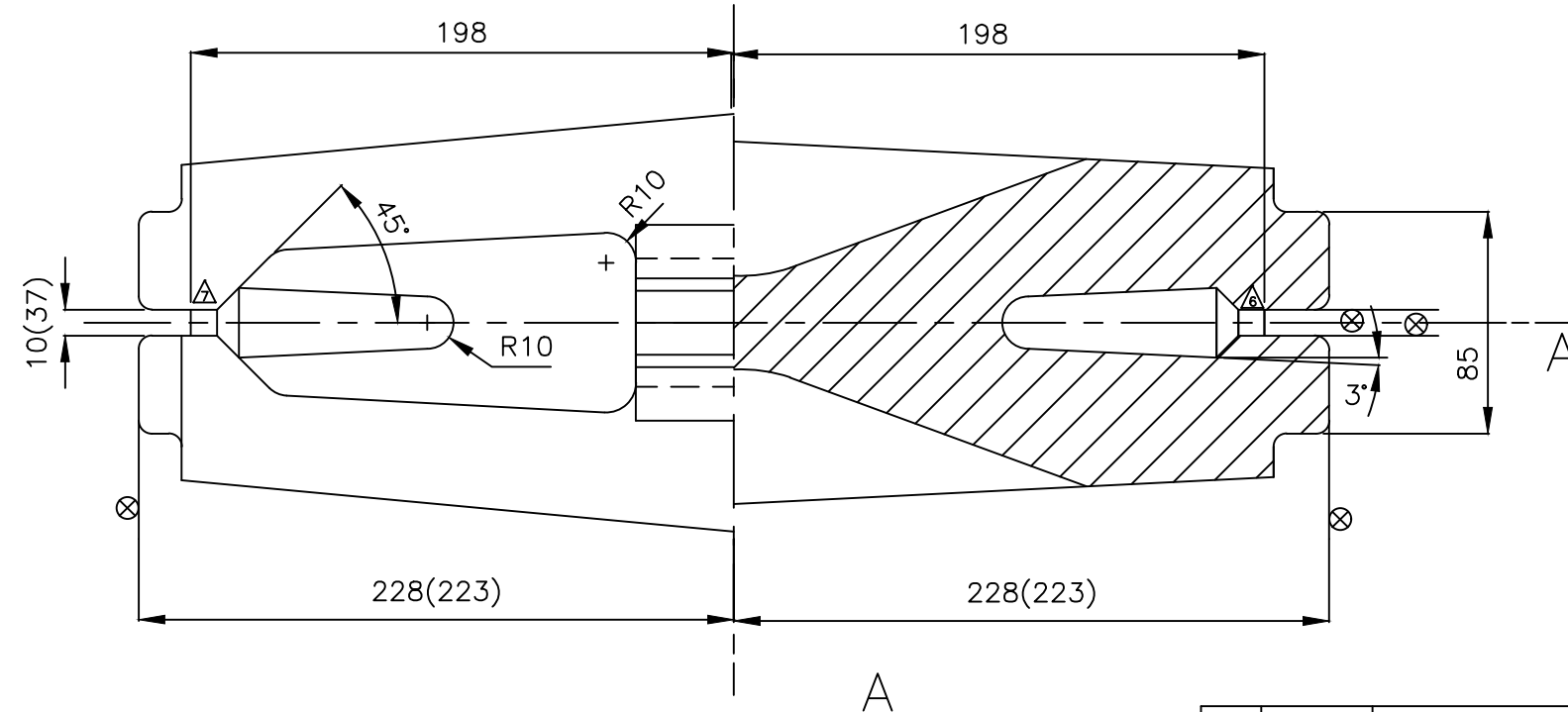
MATL.MARK *

SUPPLIER'S CODE

PUNCH MELT NO.

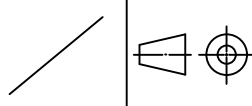
SECTION BB

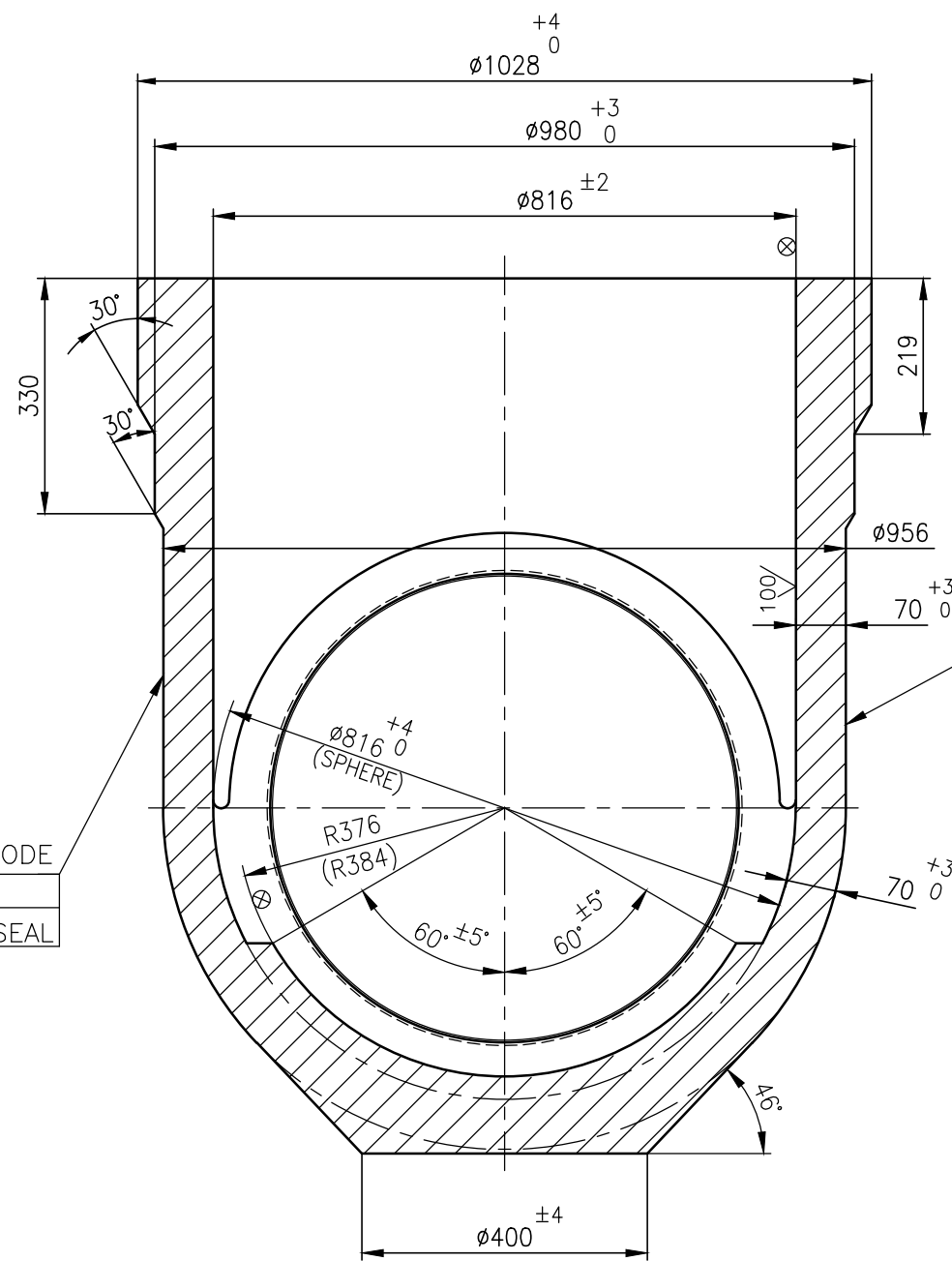
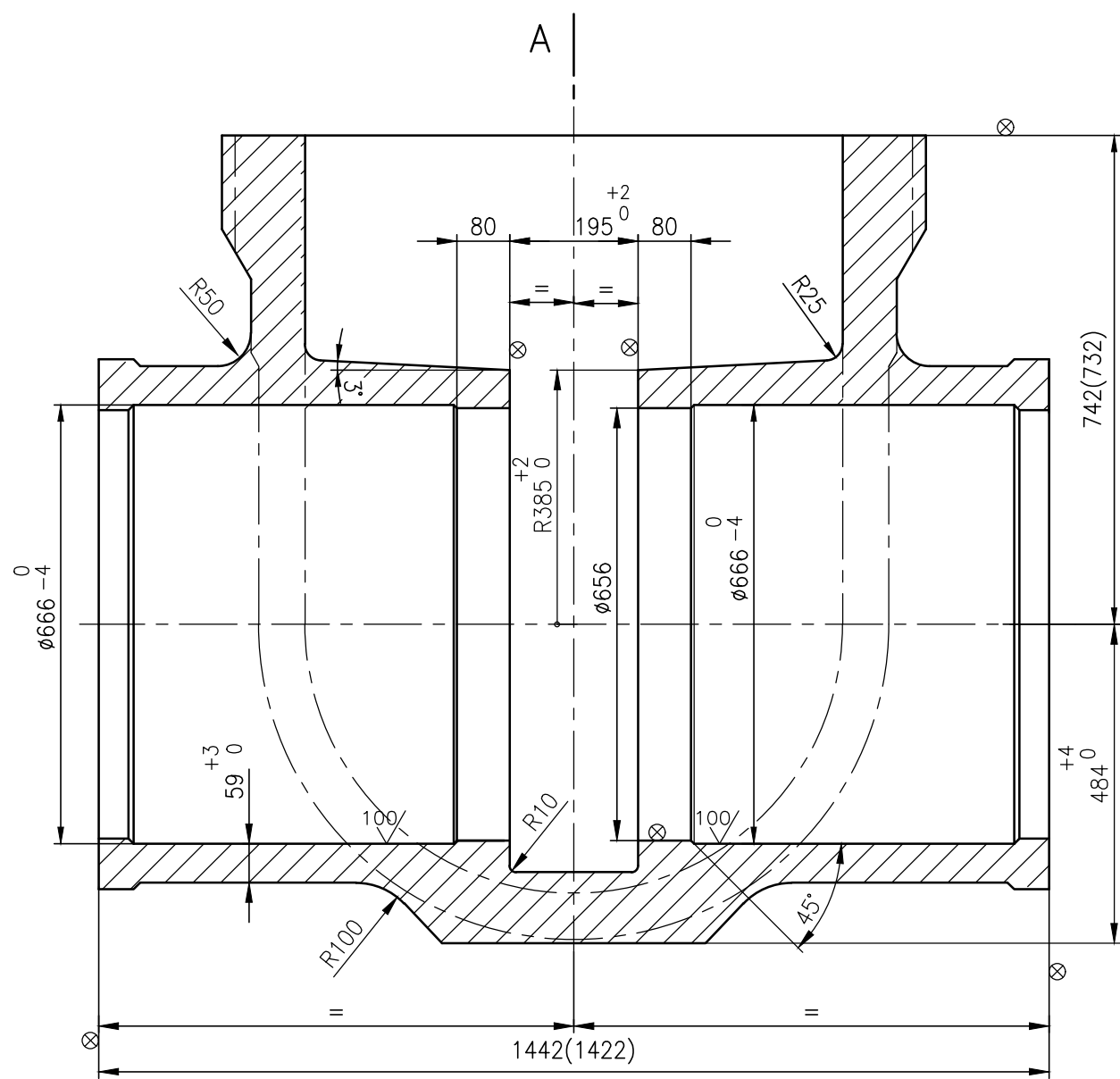
SECTION CC



NOTES.

1. CASTING SHALL COMPLY WITH THE REQUIREMENT LATEST APPLICABLE TDC IN ALL RESPECTS.
2. NECESSARY ALLOWANCES HAVE BEEN ADDED ON ALL MACHINABLE SURFACES.
3. PERMISSIBLE DIMENSIONAL DEVIATIONS OF CASTING SURFACES REFER LATEST APPLICABLE TDC.
4. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR REFERENCE ONLY.
5. ¹⁰⁰/~~90~~ CASTING SURFACES MUST BE OF HIGH QUALITY WITHOUT SURFACE UNEVENNESS.
6. UNSPECIFIED CASTING RADII 3-5.
7. ~~Ø~~ SURFACE TO BE MACHINED.
8. HEIGHT OF CASTING LETTERS 20MM.

C12A	03	CASTING	—	SA217 C12A CERTIFY	N&T	—	120	—	2.V.NJ26.06124R/2 922033230000	007
WC9	02	CASTING	—	SA217 WC9 CERTIFY	N&T	—	120	—	2.V.N616.06124R/04 922008420000	007
WCB	01	CASTING	—	SA216 WCB CERTIFY	NR	—	120	—	2.V.N436.06124R/05 922005330000	007
MATL. MARK TOBE CAST	S L No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMPONENT CODE	ITEM No
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. TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										
 BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI -620014.					DRN	NAME R.V.BAIRAVAN	SIGN	DATE 23.01.96	NO.OF VAR.	
365-120					CHD	R.L.NARAYANAN		31.01.96		
					APPD	M.RAJAKUMAR		09.02.96		
DEPT VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS				NO. OF ITEMS	
CODE 320			NTS	120.0						
TITLE					CARD CODE	DRAWING NO.				REV
WEDGE 16"/300C GV					U 01	2-V-0000-06124R				07



SECTION-CC

BHEL	}	FOR WCC MATL. SL.No. 01
750MM-C500		
WCC		

BHEL	}	FOR WC9 MATL. SL.No. 02
750MM-C900		
WC9		

BHEL	}	FOR C12A MATL SL.No. 03
750MM-C900		
C12A		

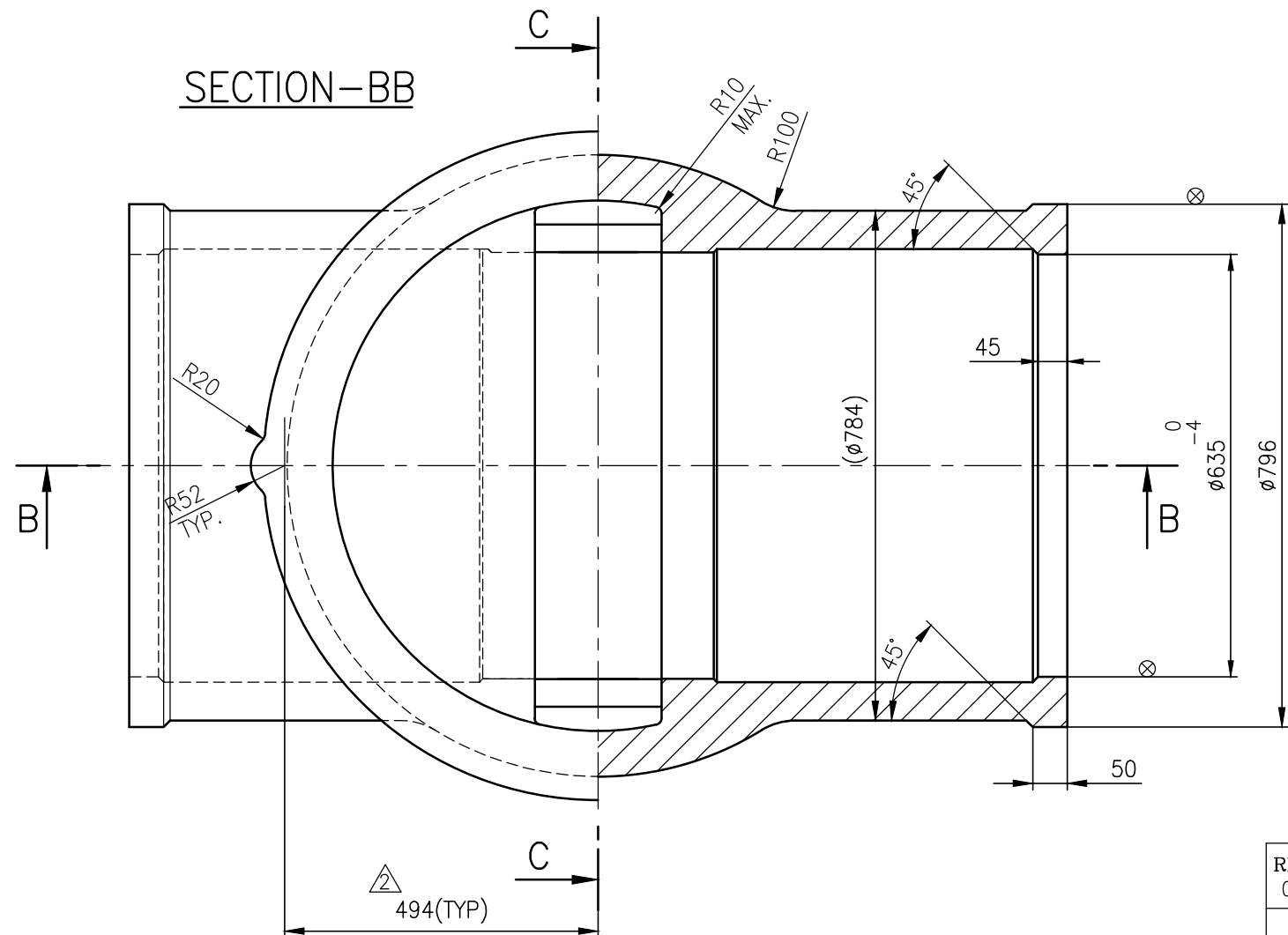
BHEL	}	FOR C12A MA SL.No. 04
750MM-C900SPL		
C12A		

BHEL	}	FOR WCC MATL. SL.No. 05
750MM-C600		
WCC		

NOTE

01. NECESSARY MACHINING ALLOWANCES HAVE BEEN ADDED ON ALL MACHINABLE SURFACES.
02. PERMISSIBLE DEVIATIONS OF NON TOLERANCED CASTING DIMENSIONS REFER APPLICABLE LATEST QUALITY PROCEDURE.
03. FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR INFORMATION ONLY.
04. LETTERS— BH&L,SIZE,MATL.& SUPPLIERS CODE ARE TO BE CAST IN THE INDICATED ZONE.
05. CASTING SHALL COMPLY WITH THE REQUIREMENTS OF APPLICABLE LATEST QUALITY PROCEDURE.
06. UNSPECIFIED CASTING RADII = R3 TO R5
07. HEIGHT OF CASTING LETTERS = 25 mm
08. $\otimes$ INDICATES SURFACE TO BE MACHINED.
09. $\sqrt[100]{}$ INDICATED CASTING SURFACES SHALL BE OF HIGH QUALITY WITHOUT SURFACE UNEVENNESS.
10. IT SHALL BE ENSURED THAT THE TEMPLATE AS PER DRG. No. 4-V-3245-26701 ENTERS FREELY FROM THE TOP OF THE BODY AND RESTS ON THE PAD OF R376 WITHOUT ANY INTERFERENCE.

* * 11. QUALITY PROCEDURE AS APPLICABLE TO SPECIAL
CLASS VALVE



SECTION-AA

REV 05	DATE 31.07.15	ALTERED S.SELVAM CHD & APPD MS & SSK	REV 04	DATE 15.03.14	ALTERED S.SARANYA CHD & APPD SSK & KRS	REV 03	DATE 30.09.13	ALTERED M.S CHD & APPD SSK & KRS	REV 02	DATE 09.09.11	ALTERED M.SRINIVASAN CHD & APPD M.RAJAKUMAR	REV 01	DATE 02.11.09	ALTERED M.SRINIVASAN CHD & APPD M.RAJAKUMAR
	TEST COLLAR INCLUDED DIMENSION Ø635 WAS Ø650 DCP:801971			SL.No. 05 INCLUDED			SL.No. 04 INCLUDED		 DIMENSION Ø650, 45 & 494 WERE Ø570, 300 & 482 RESPLY. DCP: 801226		 DIMENSION Ø828 & 295 REMOVED DRAWING Nos. 2.V.3315.14082R AND 2.V.3316.14082R INCLUDED.			

05	CASTING	—	SA 216 WCC—ATTEST	NORMALISED	—	2775	—	2V339314082R/2 922032460000	—
04	CASTING	—	SA 217 C12A—ATTEST	NORMALISED &TEMPERED	—	2775	—	2V331314082R/2 922031680000	—
03	CASTING	—	SA 217 C12A—ATTEST	NORMALISED &TEMPERED	—	2775	—	2V331614082R/3 922018740000	—
02	CASTING	—	SA 217 WC9—ATTEST	NORMALISED &TEMPERED	—	2775	—	2V324514082R/4 922016400000	—
01	CASTING	—	SA 216 WCC—ATTEST	NORMALISED	—	2775	—	2V331514082R/3 922018730000	—
SL No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMPONENT CODE	ITEM No

* *

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD.
UNIT: HIGH PRESSURE BOILER PLANT.
TIRUCHIRAPALLI -620014.

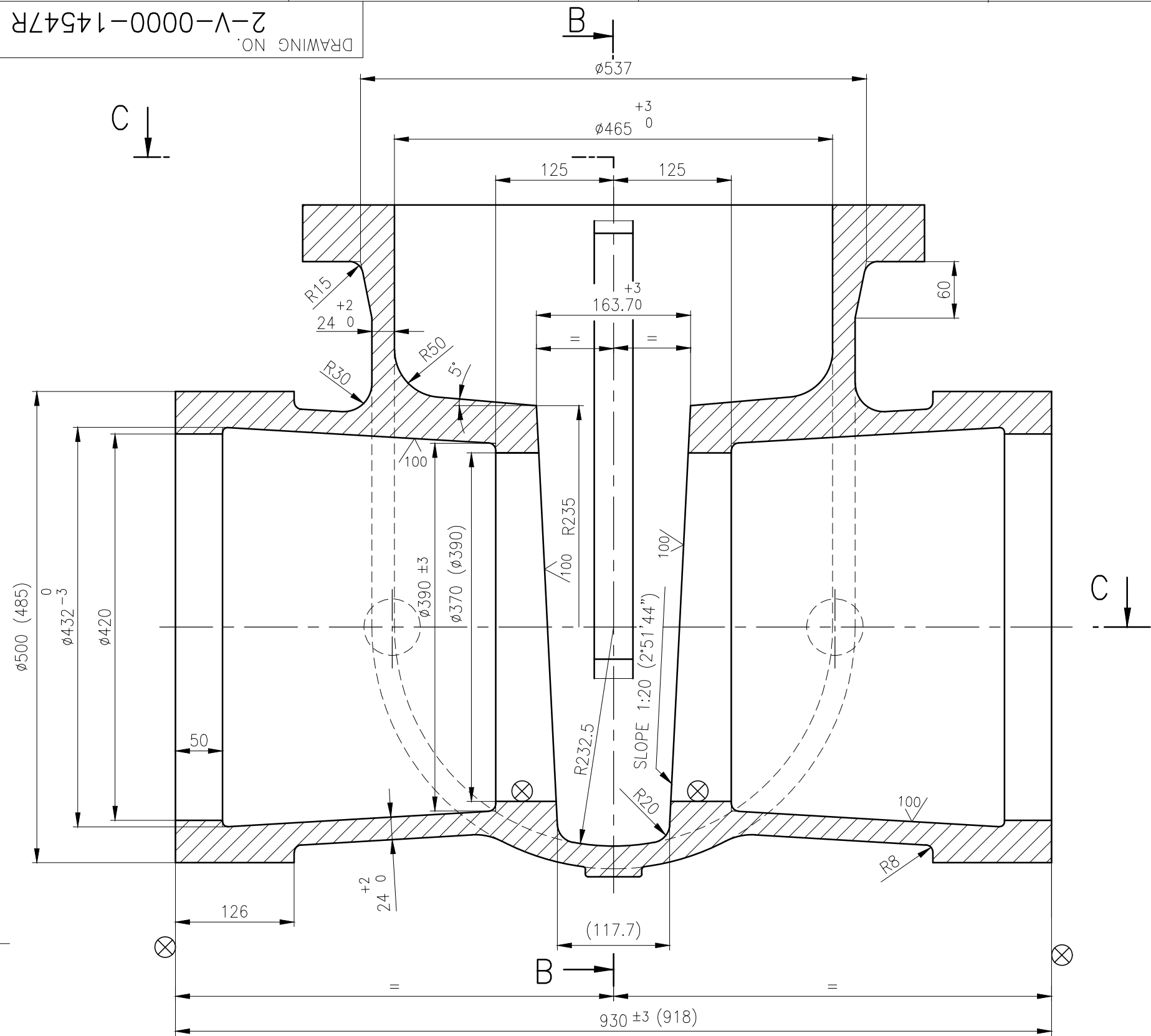
DRN	NAME M.SRINIVASAN	SIGN	DATE 07.03.07	NO.OF VAR.
CHD	P.BOOMINATHAN		07.03.07	
APPD	M.RAJAKUMAR		07.03.07	

DEPT VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATIONS	NO. OF ITEMS
CODE 320			NTS	REF. TABLE	CAD: F214082R	
TITLE				CARD CODE	DRAWING NO.	REV
BODY (750mm)				U 01	2-V-0000-14082R	07

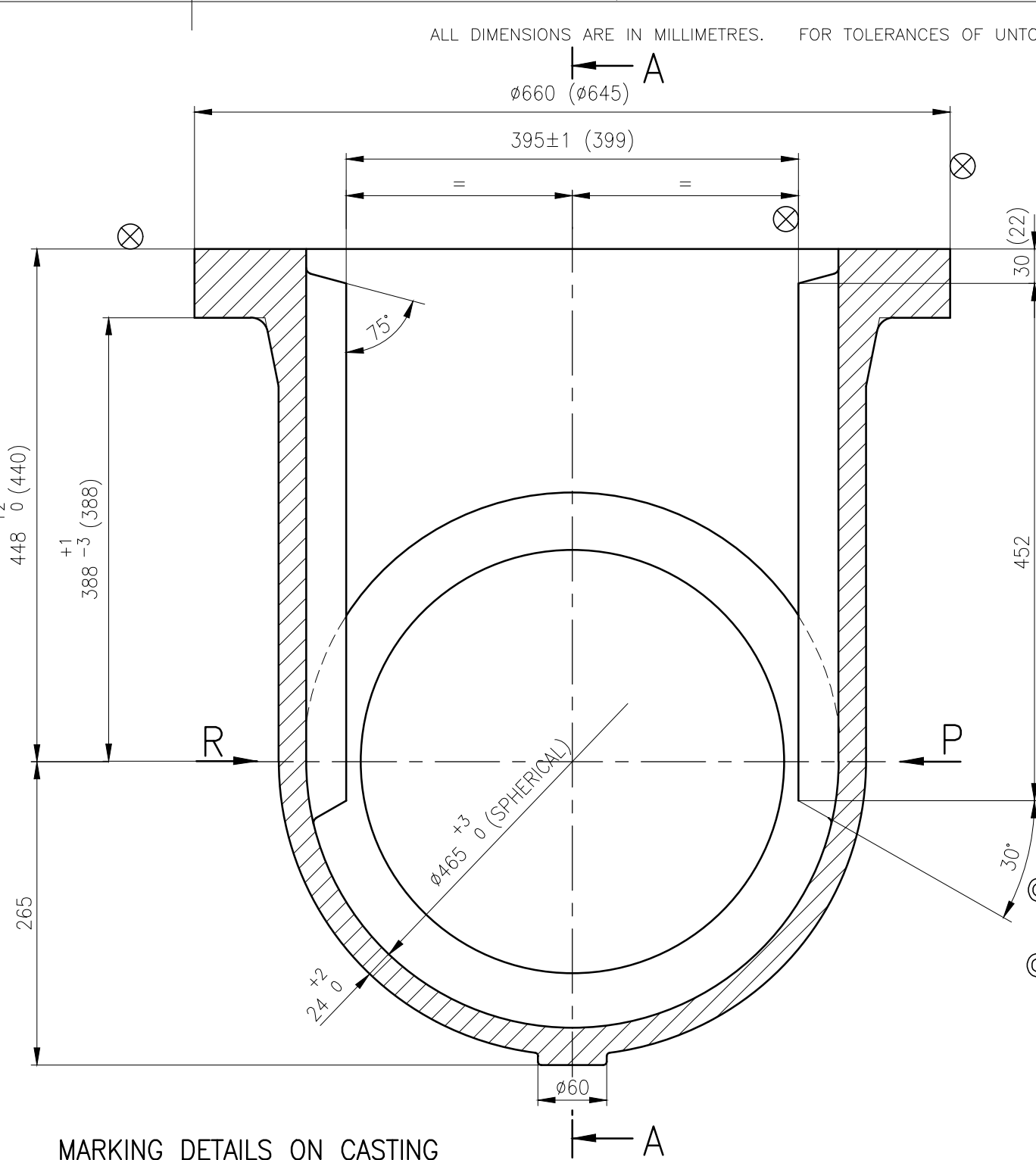
CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

2-V-0000-14547R
DRAWING NO.

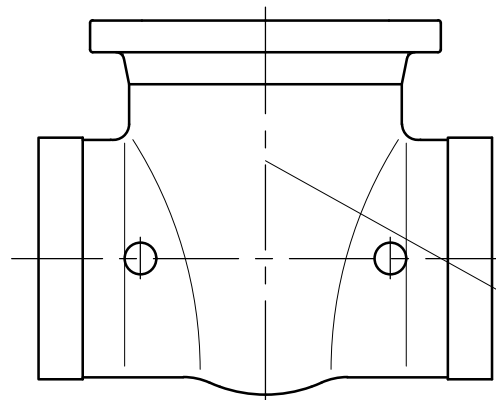
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP



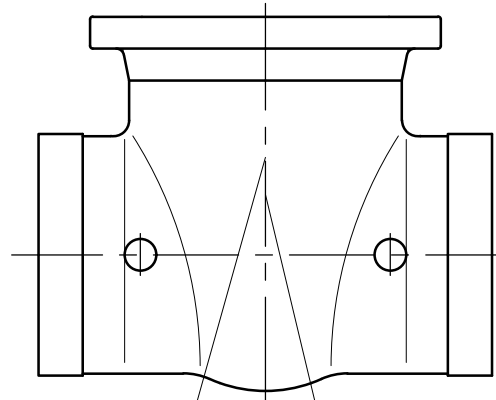
SECTION-AA



SECTION-BB



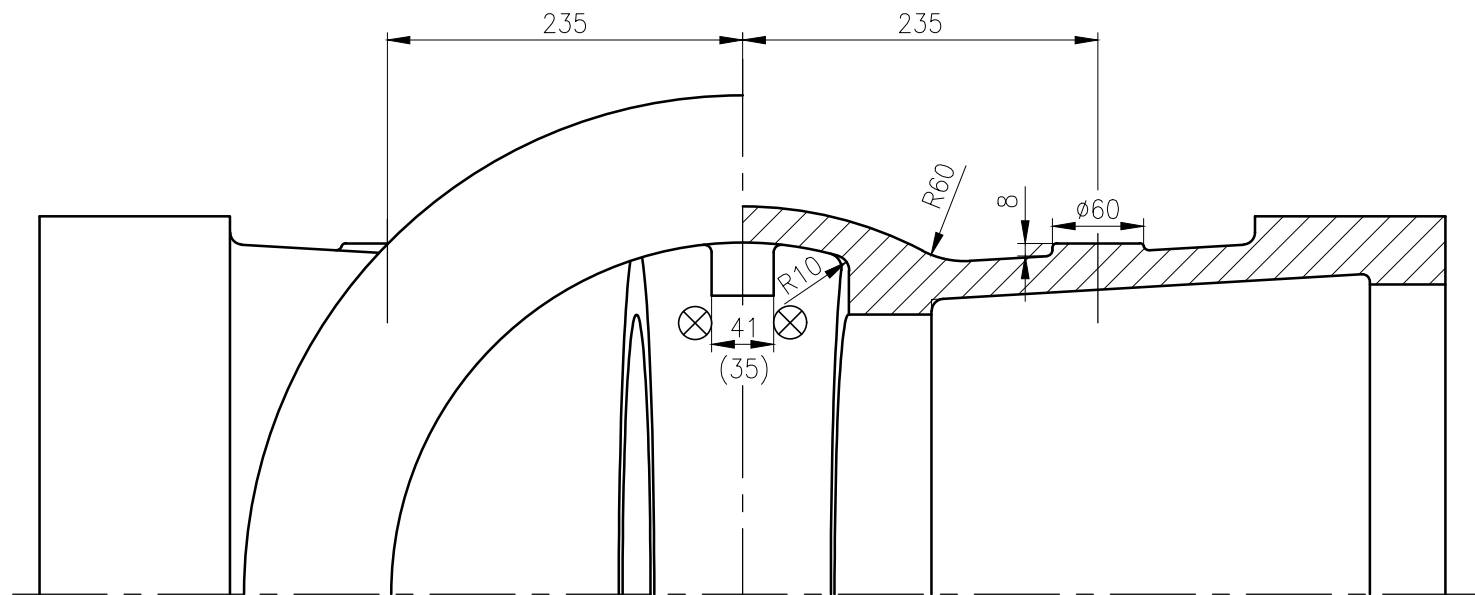
VIEW P



VIEW R

NOTES

- NECESSARY MACHINING ALLOWANCES HAVE BEEN ADDED ON ALL MACHINABLE SURFACES.
- THIS MARK INDICATES THE SURFACES TO BE MACHINED.
- UNSPECIFIED CASTING RADII-R5 MAX.
- FOR PERMISSIBLE DIMENSIONAL DEVIATIONS OF NON TOLERANCED CASTING DIMENSIONS REFER LATEST APPLICABLE QUALITY PROCEDURE
- CASTING SHALL GENERALLY COMPLY WITH THE REQUIREMENTS OF LATEST APPLICABLE QUALITY PROCEDURE IN ALL RESPECTS.
- INDICATES THE CASTING SURFACES WHICH MUST BE OF HIGH QUALITY WITHOUT SURFACE UNEVENNESS
- FINISH MACHINED DIMENSIONS ARE INDICATED WITHIN BRACKETS FOR INFORMATION ONLY.,
- PUNCHING DETAILS SHALL BE MARKED ONLY ON RAISED FLAT SURFACE SHOWN IN VIEW P&R
- HEIGHT OF CASTING LETTERS -30mm.
- THIS SPECIAL CLASS CASTING IS TO BE SUBJECTED RT/UT ON ALL CRITICAL LOCATIONS.
- ALL EXTERIOR AND ACCESSIBLE INTERIOR SURFACES OF BODY SHALL BE MPI/LPI TESTED.



SECTION-CC

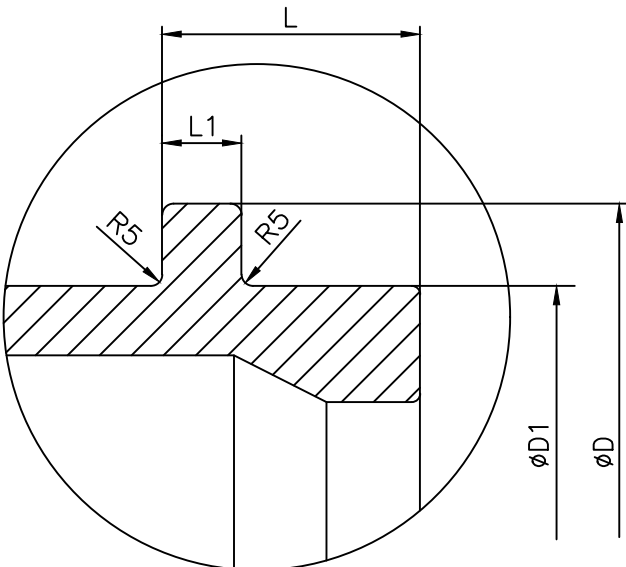
@	300 SPL	WC9	05	CASTING	—	SA 217 WC9 ATTEST	NORMALISED & TEMPERED	—	465	—	2-V-NK56-14547R 92 203 832 0000	001
	300	C12A	04	CASTING	—	SA217 C12A ATTEST	NORMALISED & TEMPERED	—	465	—	2-V-NJ26-14547R 92 203 321 0000	001
@	300 SPL	WCB	03	CASTING	—	SA 216 WCB ATTEST	NORMALISED	—	465	—	2-V-NG64-14547R 92 202 083 0000	001
	300	WC9	02	CASTING	—	SA 217 WC9 ATTEST	NORMALISED & TEMPERED	—	465	—	2-V-NG65-14547R 92 202 084 0000	001
	300	WCB	01	CASTING	—	SA 216 WCB ATTEST	NORMALISED	—	465	—	2-V-NG24-14547R 92 201 987 0000	001
	RATING **	MATL.MARK *	SL N o.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No COMPONENT CODE	ITEM No

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.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		DRN		NAME		SIGN		DATE		NO.OF VAR.	
BHARAT HEAVY ELECTRICALS LTD.,		CHD		M.SRINIVASAN				04.03.10			
365-120		APPD		M.RAJAKUAMR				04.03.10			
DEPT VL		SCALE		WEIGHT (KG).		REFERENCE INFORMATIONS				NO. OF ITEMS	
CODE 320		NTS		REF. TABLE		CAD :C214547R					
TITLE		BODY		CARD CODE		DRAWING NO.				REV	
(18" - 300CL - BW)		U 01		2-V-0000-14547R		04					

REV 04	DATE 31.12.18	ALTERED R.P.SINGH	REV 03	DATE 25.09.14	ALTERED A.MARIMUTHU	REV 02	DATE 03.08.11	ALTERED M.SRINIVASAN	REV 01	DATE 28.07.11	ALTERED M.SRINIVASAN
CHD & APPD SSK & KRS		CHD & APPD MS & SSK		CHD & APPD M.RAJAKUAMR		CHD & APPD M.RAJAKUAMR		CHD & APPD M.RAJAKUAMR		CHD & APPD M.RAJAKUAMR	
SL.NO. 05 INCLUDED		SL. NO. 04 INCLUDED.		SL. NO. 03 INCLUDED.		SL. NO. 02 INCLUDED.					

8909Z-0000-A-3
DRAWING NO.

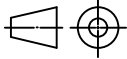
SL. No.	DRAWING NUMBER	DIMENSIONS				CASTING DRAWING NUMBER	SIZE/RATING/TYPE	SL. No.	DRAWING NUMBER	øD	DIMENSIONS				CASTING DRAWING NUMBER	SIZE/RATING/TYPE																	
		øD	øD1	L	L1						øD	øD1	L	L1																			
01.	3-V-Z022-25058	504	458	83	38	2-V-Z022-17267R	16"-C300-FV	19.	3-V-3393-25058	863	796	112	68	2-V-3393-14082R 2-V-3313-14082R	30"-C600/C900-RHID																		
02.	3-V-Z021-25058	605	546	108	33	2-V-Z021-17266R	20"-C150-FV	20.	3-V-NF97-25058	788	725	88	65	2-V-NF97-05228R	26"-C300-GV																		
03.	3-V-N370-25058	605	545	95	33	1-V-N370-05124R	20"-C150-GV	21.	3-V-NH51-25058	496	474	57	38	1-V-NH51-05254R	16"-C300-RV																		
04.	3-V-N595-25058	660	555	74	38	1-V-N595-05144R	20"-C300-GV	22.	3-V-NH57-25058	496	475	57	44	1-V-NH56-05255R	16"-C600-RV																		
05.	3-V-N788-25058	660	555	74	38	1-V-N788-05144R	20"-C300SPL-GV	23.	3-V-NH50-25058	456	425	63	44	2-V-NH50-14808R	14"-C600-RV																		
06.	3-V-N805-25058	710	652	97	28	1-V-N805-05158R	24"-C150-GV	24.	3-V-N929-25058	932	864	82	46	1-V-N929-05185R	32"-C150-GV																		
07.	3-V-NG24-25058	602	500	74	38	2-V-NG24-14547R	18"-C300-GV																										
08.	3-V-NE96-25058	710	610	74	38	2-V-NE96-14220R 2-V-NE97-14220R	22"-C300-GV																										
09.	3-V-Z023-25058	450	391	82	38	2-V-Z023-17268R	14"-C300-FV																										
10.	3-V-NG27-25058	602	480	85	38	2-V-NG27-14618R	18"-C300-FV																										
11.	3-V-P366-25058	368	335	56	33	1-V-P366-05211R	10"-C300-RV																										
12.	3-V-N594-25058	504	453	76	38	1-V-N594-05143R	16"-C300-GV																										
13.	3-V-P560-25058	405	365	56	33	1-V-P560-05251R	12"-C300-RV																										
14.	3-V-P538-25058	415	385	74	44	2-V-P538-14465R	12"-C600-RV																										
15.	3-V-N593-25058	450	400	75	38	1-V-N593-05142R	14"-C300-GV																										
16.	3-V-N589-25058	430	385	74	28	1-V-N589-05139R	14"-C150-GV																										
17.	3-V-N590-25058/1	497	440 _A	75	28	1-V-N590-05140R	16"-C150-GV	<table><tr><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td></tr><tr><td>NO</td><td></td><td></td><td></td><td>HEAT</td><td>SCRAP</td><td>NET</td><td>GROSS</td><td></td></tr></table>								-	-	-	-	-	-	-	-	-	NO				HEAT	SCRAP	NET	GROSS	
-	-	-	-	-	-	-	-									-																	
NO				HEAT	SCRAP	NET	GROSS																										
18.	3-V-N575-25058	537	490	75	28	1-V-N575-05136R	18"-C150-GV																										

NOTE

01. ALL OTHER DIMENSIONS ARE TO BE MAINTAINED AS PER THE RELEVANT CASTING DRAWING (LATEST REV.).

REV	DATE	ALTERED	RAVI PRATAP SINGH	REV	DATE	ALTERED	T.SANGEETHA
06	20.10.18	CHD & APPD	SSK & KRS	04	06.06.17	CHD & APPD	SSK & KRS
IN SL No. 17 DIMENSION 440 WAS 450.				SL. No. 24 INCLUDED.			
05	08.12.17	CHD & APPD	SSK & KRS	DIMENSION 33 WAS 28 IN IN SL No. 2 & 3.			

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-	-	-	-	-	-	-	-	-	-
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
 365-121					DRN	NAME	SIGN	DATE	NO.OF VAR.
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.					CHD	S.SATHEES		22.07.11	
					APPD	M.RAJAKUMAR		22.07.11	
DEPT VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS
CODE 320			NTS	REFER TABLE	CAD :F324178				
TITLE						CARD CODE	DRAWING NO.		REV
BODY TEST COLLAR (CASTING)						U 01	3-V-0000-25058		06

1. **Inviting Tenders**

The bidder shall submit his response through bid submission to the tender on e-Procurement platform at <https://bheleps.buyjunction.in>

- The bidder would be required to register on the e-procurement market place <https://bheleps.buyjunction.in> and submit their bids online. Sealed cover bids / e-Mails / FAX / Manual offer will NOT be accepted.
- The bidder has to keep track of any changes by viewing the addendum / Corrigendum's issued by the Purchaser on time-to- time basis in the E-Procurement platform. The Company calling for tenders shall not be responsible for any claims/problems arising out of this.
- The user should complete all the processes and steps required for bid submission. The successful bid submission can be ascertained once acknowledgement is given by the system through bid submission number after completing all the processes and steps. BHEL and mjunction Services Ltd. will not be responsible for incomplete bid submission by users. Users may also note that the incomplete bids will not be saved by the system and are not available for the Purchaser for processing.

Before uploading scanned documents, the bidders should sign on all the statements, documents, certificates uploaded by him, owning responsibility for their correctness / authenticity. If nothing is mentioned it is assumed that all terms and conditions are acceptable. If supplier is mentioning his rates in units not asked by BHEL, BHEL has the right to reject/accept quotation. Quotations shall reach us by 1400 Hrs (IST) on due date. **Techno-Commercial bid shall be opened at 1530 hrs (IST) on same day.**

For finalizing prices, BHEL may go in for opening of sealed price bids (Part-II) or conduct reverse auction. Price bids/Reverse Auction of only those bidders shall be opened/conducted who qualifies in techno-commercial (Part-I) evaluation. Qualification in Part-I shall be adjudged by criteria mentioned in checklist. Date shall be informed.

Please submit all the documents/confirmations as per checklist. This will facilitate quick evaluation and early finalization of tender.

In case overseas suppliers route their offer through their accredited selling agents, a letter of authority should be furnished mentioning the name and address of their selling agents who are authorised to bid, negotiate and conclude a Contract on their behalf. This letter should be sent before the tender submission otherwise bid will be considered as unsolicited bid.

Pre-Qualification Terms:

- 1) **Vendor has to present any customer Purchase Order of C12A Castings with minimum cumulative value of Rs. 500000.00 (Five Lakh Only) as proof. Purchase Order/s date should be 01.01.2016 or afterwards. For MSEs, the required cumulative value of PO value shall be Rs. 200000.00 (Two Lakh only). This Pre-Qualification terms shall not be applicable to Start-Up Firms. These relaxations and exemptions are in line with D.O. No. 5(4)/2016-BE-I dated 15.02.2017. For claiming Start-Up exemption, vendors have to give documentary evidence or undertaking. For Claiming MSE benefits, vendor have to give documentary evidence like NSIC, UAN, etc.**
- 2) **Vendor has to give undertaking that he is manufacturer of C12A Castings.**

1.1 INSTRUCTION TO BIDDER (In case of E-Procurement)

Interested bidders/Suppliers shall submit their offer through e-Procurement mode at <https://bhel.abcpurchase.com>. **Offers in any other mode will not be accepted.**

For Enterprise Procurement System (EPS) Bidders/Suppliers are requested to follow these steps:

a. Requirements

1. Computer with good Internet Connection.
2. Operating System should be Windows Vista / Windows 7 and above.
3. Web Browsers: Internet Explorer 9.0 (32-bit Browser only) & above

b. Mandatory Requirements:

Suppliers interested for registration for BHEL Open Tenders should have a valid DSC (Digital Signature Certificate) before Proceeding forward for Registration. Herein a Valid DSC refers to a Class-II/III Digital Signature Certificate (DSC) for Signing & Encryption (Required both digital signature certificate: Signing & Encryption) of bids issued by any of the valid Certifying Authorities (approved by Controller of Certifying Authorities) in India. Valid Digital Signature Certificate (DSC) must be installed in a computer system from where you want to access the website.

For Unregistered Suppliers in EPS:

Procedure for Online Registration in EPS for Open Tender Suppliers for BHEL. Please follow the below steps for registration: -

1. Click Register Button (Top of the Screen).
2. Please input your organization PAN No (in case of Indian supplier) or select your "country" in case you are an overseas Supplier.
3. Select Units to participate in.
4. Fill up Company details.
4. Key in your desired login id If you have registered by keying in PAN No. then your desired login id will be prefixed by "OTI", In case of **overseas suppliers it will be also prefixed with "OTI"**.
5. Fill in the Captcha code & agree to the terms & conditions and privacy policy of this website and click SUBMIT.

Once the above steps are completed, contact to M/s eProcurement Technologies Limited for ID Activation. M/s e Procurement Technologies limited, Ahmedabad will activate your ID within 2 business hours. After registering, follow the steps provided in "For Registered Supplier" to view RFQ.

NB: - 1 BHEL Administrator or user will have no role for approving Registration and Open Tenders and DSC for any supplier who has registered himself from the front END which is in case of OT.

For Registered Supplier in EPS:

1. Supplier visits EPS home page
2. Supplier Login in with their user id and password
3. Search the RFQ ID and views it.

4. Attaches themselves to the RFQ by clicking the “I/We wish to participate”.
5. Supplier fills the bid template and makes necessary attachments
6. Supplier submits their bid by clicking Sign, Encryption & Save button.

In any problem is faced by supplier while login/registration in EPS (<https://bhel.abcpurchase.com>) and any other assistance, please contact the support team of M/s e Procurement Technologies limited, Ahmedabad as per details mentioned in table below:

Name	Contact Nos.	e-mail ID	Role	Location
Mukunthan	+91 6353215001	Trichy.bhel@eptl.in	Support Executive	Trichy
Swapnil Hamilton	+91 7940270549	swapnil.h@eptl.in	Support Executive	HO – Ahmedabad
Hardik Oza	+91 7940270560	Hardik.oza@eptl.in	Support Executive	HO – Ahmedabad
Ankur Bhatt	+91 7940270590	ankur.bhatt@eptl.in	Support Executive	HO – Ahmedabad
Prashant Rajyaguru	+91 7940270545	prashant@eptl.in	Asst. Manager – Implementation & Support	HO – Ahmedabad
Dharam Rathod	+91 7940270596	dharam@eptl.in	Manager – Implementation & Support	HO – Ahmedabad
Pradip Parmar	+91 7940270532	pradip@eptl.in	Sr Mgr – Implementation & Support	HO – Ahmedabad
Devang Patel	+91 7940270576	devang@eptl.in	Sr Manager – Implementation & Support	HO – Ahmedabad

2 OTHER IMPORTANT INFORMATION RELATED TO E-PROCUREMENT TENDERS

- a) The bidder has to keep track of any changes by viewing the addendum / Corrigendum's issued by the Purchaser on time-to- time basis in the E-Procurement platform. The Company calling for tenders shall not be responsible for any claims/problems arising out of this.
- b) The user should complete all the processes and steps required for bid submission. The successful bid submission can be ascertained once acknowledgement is given by the system through bid submission number after completing all the processes and steps. BHEL and M/s e Procurement Technologies limited will not be responsible for incomplete bid submission by users. Users may also note that the incomplete bids will not be saved by the system and are not available for the Purchaser for processing.
- c) Before uploading scanned documents if any, the bidders shall sign on all the statements, documents, certificates uploaded by him, owning responsibility for their correctness / authenticity.
- d) On the due date of tender opening, only technical bids will be opened. The opened technical bids will be evaluated by us and clarifications required, if any, will be called for

from the bidders on technical and commercial points. If no reply is received from the vendor for the clarification raised by BHEL with in the final cut-off date, those vendors offer will be processed with the documents available / submitted against this tender. Offers not meeting the required specification and technical condition will be summarily rejected. The price bids of technically suitable bidders will be opened on a later date with prior intimation to techno-commercially suitable bidders.

- e) Ranking L-1, L-2 etc. shall be done for individual item for the techno-commercially acceptable offers on landed cost to BHEL, IVP Goindwal basis and BHEL reserves the right to place order for individual items with different vendors. In the event of more than one vendor becoming L1 for the item, the enquiry quantity will be shared equally among all the L1 vendors.
- f) BHEL reserves the right to negotiate with L1 vendor or re-float the tender for items where, L1 price is not the lowest acceptable price; BHEL reserves the right to increase or decrease the tender quantity.
- g) **If supplier is mentioning delivery destination within state/ outside state depending upon his location of factory, Free On Road etc these are assumed as on FOR Goindwal. If supplier is wishing to give delivery on Ex works basis, then he has to clearly mention about it.**

2.1 AGENCY COMMISSION:

In respect of offers from overseas suppliers, agency commission, if any, payable to their agents in India, shall invariably be shown separately in the proforma invoice and this will be paid by us in India, in Indian Rupees, on satisfactory completion of the Contract.

If overseas Principal has any tie up with any third party in respect of Agency Commission it should be declared while submitting the offers.

Copies of current Agency, / Agreemental Authorization Letter in respect of Agency Commission shall be furnished along with order, if not made available earlier.

3. PRICE BASIS

- a. The reimbursement of GST portion of invoice shall be released only upon: -
 - 1. vendor declaring such invoice in his GSTR-1and
 - 2. receipt of goods and Tax invoice by BHEL and
 - 3. Confirmation of payment of GST thereon by vendor on GSTN portal.
 - 4. 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.

Since ITC can be availed only when BHEL is in possession of GST Tax invoice and after receipt of goods. Thus, vendor to ensure timely dispatch of goods and Tax invoice. It may be noted that in case of any delay in receipt of Tax Invoice and/or receipt of goods, the ITC availment by BHEL will get delayed thus entailing additional cash outflow & may even get denied if ITC availment timelines are breached.

Further ITC can be availed only when vendor has declared such invoice in his outward supply Return GSTR-1 and after GST thereon has been paid by him at the time of filing of monthly Return.

- b. In case GST credit is delayed/denied to BHEL due to non/delayed receipt of goods and/or tax invoice or expiry of timeline prescribed in GST law for availing such ITC, or any other reasons not attributable to BHEL, GST amount shall be recoverable from vendor along with interest levied / leviable on BHEL.
 - c. 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 alongwith interest levied / leviable on BHEL.
 - d. Any GST liability arising on BHEL under Reverse Charge (RCM) before actual receipt of goods and/ or Invoice thereof would be subject to recovery of Interest leviable for the period between the date of such liability and actual date of eligibility of ITC based on receipt of goods, receipt of Invoices and other conditions specified in GST Law as applicable.
 - e. Order of enquiry item sl. No. shall be maintained in the quotation.
 - f. The rates quoted shall be firm and fixed. No price variation is proposed and allowed.
 - g. Rates quoted should be F.O.R Goindwal basis. If bidder has quoted Ex Works, loading shall be done as per BHEL discretion for tender evaluation.
 - 2a. Rates of raw casting components shall be quoted on **rate INR per kg basis & on FOR GOINDWAL SAHIB basis. Foreign supplier has to quote on FOB basis & in USD/INR.**
 - 2b. Rates shall be inclusive of pattern and development cost. The patterns cost shall be borne by the supplier.
 - 2c. **Comparison shall be made on landed rate per kg to BHEL Goindwal Sahib for deciding L1 offer.** Loading as per BHEL discretion will be done in case of deviation for delivery destination. For comparison purpose & Agent commission conversion rate from USD to INR will be taken for tender opening date. For conversion of fixed RT charges & repair charges into USD, the \$ rate at tender opening date will be taken throughout the contract. 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.
 - 2d. Unloading of material at Main Stores of BHEL shall be arranged by BHEL.
 - 2e. In case of disputes/errors/difficulty in interpretation of rates mentioned in figures, rates mentioned in words shall be taken as final.
 - 2f. Order of enquiry Sl. No. shall be maintained in quotation.
- Variation in taxes or any other statutory levis during contractual delivery period shall be to BHEL's account.

3.1 VALIDITY OF OFFERS:

The offers shall be kept open for acceptance **for 90 days** from the date of opening of the tender. In case of extension of tender opening date, the validity shall be suitably revised.

 BHEL GOINDWAL	Terms and Conditions for Tender Enquiry No. 1920-043E Dt 27.06.2019
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3.2 SCOPE OF SUPPLY:

Material shall be supplied as per the applicable latest Technical Delivery Conditions (TDC)/ Material Standard requirements/Drawings/RT Procedure and other requirement as given in the Purchase Order. The TDC applicable for Indian suppliers is TDC:0412/26 (latest revision) and for foreign supplier is TDC:0:433 Rev00 (or latest applicable).

Also vendor has to supply items in oldest PO first if any item is pending in more than two POs.

The details of items for weight given in tender is as below:

Material group for E Tendering purpose	Material Code	Description of material	Qty. (Nos)	Wt. (Kg) / No.	Total Weight in KG	In case, L1 is Non-MSE		In case, L1 is MSE
						Counter offer applicable quantity in Nos. to L2 vendor	Counter offer quantity in Nos. to MSE vendors if any (in case L1 is not MSE)	Counter offer quantity to others in Nos.
G92110320000	922031680000	BODY_750_900SPL-C12A HRHIV_3313	2	3165.00	6330.00	Not Applicable		Not Applicable
Total weight of Group (G92110300000)					6330.00			
G92110310000	922038610000	BODY-HRHIV-700-C900SPL-C12A-3399	4	3015.00	12060	1	1	1
Total weight of Group (G92110300000)					12060.00			
G92110300000	922033210000	BODY-18-C300-GV-BW-C12A-NJ26	7	590.00	4130.00	1	2	3
Total weight of Group (G92110300000)					4130.00			
G92110330000	922033230000	WEDGE_GV_16_300/400_C12A	7	114.10	798.70	1	2	3
	922033220000	BONNET-16-C300-GV-C12A-NJ26	7	175.00	1225	1	2	3
Total weight of Group (G92110330000)					2023.70			

Also kindly note that material group given above is generated for e-tendering purpose only. Actual PO will be released as per material code given in above table.

If in PO, some latest version of the drawings is mentioned than it is vendor's responsibility to demand the same from BHEL and supply according to latest version of drawing. If later, any item is rejected due to this reason than BHEL is not responsible.

Bodies have to be supplied alongwith test collar.

4. **WELL KNOWN FOUNDRY:**

It is the responsibility of successful vendor to ensure that all the castings are supplied with IBR TC [Valid IBR Well known Foundry status clearly mentioned on the TC] or under witness pouring clearly endorsed by IBR authority/authorized inspecting authority. The foundry will provide TCs in Form III G/III F (as applicable as per TDC) signed by competent authority. The cost for witness pouring from authorized inspecting authority has to be borne by supplier.

5. **DELIVERY SCHEDULE:**

Delivery period shall be 4 months for all the castings except BODY-HRHIV-700-C900SPL-C12A-3399.

Delivery period for BODY-HRHIV-700-C900SPL-C12A-3399 shall be first 2 Nos. in 4 months and next 2 Nos. in next 2 months.

All supplies should be completed within this time period

6. **ACCESS TO MANUFACTURING PREMISES:**

While Purchase Orders placed on the vendor are under execution, authorized representatives of BHEL shall be allowed free access to the manufacturing facilities for the purpose of inspection or monitoring the progress of purchase orders. This access will also be extended to representatives of BHEL's customers accompanying the authorized representative/s of BHEL, if our contractual requirements with our customers call for the same.

7. **PROCEDURE FOR CASTING WEIGHT ESTABLISHMENT**

Weight is not established for this item yet & mentioned weight is drawing weight. Weights of same patterns for different material grade castings shall be same. These established weights shall be applicable to all vendors. Weights shall be established again only on revision of dimensions of component. Weight shall be established as per clause no. 08 of TDC: 0:412: Rev 26 (or latest applicable). Rate of any item shall be derived by multiplying established weight with rate per kg for the period when PO is being released. When a vendor is taking any item as a new development, if his weight is less than already established weight, this weight will be considered as new established weight and binding on all vendors. If his weight is more than already established weight, it shall be binding on the vendor. For any new item, not established till date, the first verified weight by BHEL after complete dimensional verification and acceptance shall be declared as established weight (as per clause No. 08 of TDC). Payments shall be made on established weights only. Additional claim of any vendor due to his extra weight over and above the established weight shall not be entertained.

8. **DEVELOPMENT ORDERS FOR CASTINGS REQUIRING NEW PATTERNS:**

Sample clearance shall be by BHEL and bulk supply shall be undertaken only after sample clearance. Quality requirement of new developments shall be as per TDC:0412/26 (latest

revision) and for foreign supplier is TDC:0:433 Rev00 (or latest applicable) besides other technical documents.

9. **TERMS OF PAYMENT:**

- a. Due payment against supplies received shall be due after 30 days of receipt and acceptance of material and shall be paid within next 15 days' period. In case of any deviation from standard payment term mentioned, BHEL at its discretion may load on the item price at "Base rate of SBI (as applicable on the date of bid opening; Techno-commercial bid opening) + 6% shall be considered for loading for the period of relaxation sought by bidders.
- b. Documents to be submitted (if applicable)
 - i. Tax invoice (Invoice shall be GST compliant and should contains all the required information such as GST No, HSN code etc.)
 - ii. Transporter copy along with material/consignment.
 - iii. Material Test Certificates (MTC) and
 - iv. Compliance Certificate.
 - v. Radiographic films and reports, if required.
 - vi. Third Party Inspection reports, if applicable.
 - vii. Packing Note
- c. GST registration number is to be submitted by qualified vendor as per GST law.
- d. It is mandatory to mention proper material codes in the invoices and separate invoices to be raised for different POs.
- e. ***BHEL releases payment through EFT mode ONLY. Necessary details may please be submitted by filling required format before release of payment.***
- f. ***Conditions relating to release of GST portion:***
 Payment of GST portion will be released to vendor only upon completion of statutory requirement and further subject to following:
 The reimbursement of GST portion of invoice shall be released only upon: -

5. vendor declaring such invoice in his GSTR-1and
 6. receipt of goods and Tax invoice by BHEL and
 7. Confirmation of payment of GST thereon by vendor on GSTN portal.
 8. 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.
 - In case GST credit is delayed/denied to BHEL due to non/delayed receipt of goods and/or tax invoice or expiry of timeline prescribed in GST law for availing such ITC, or any other reasons not attributable to BHEL, GST amount shall be recoverable from vendor along with interest levied / leviable on BHEL.
- 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 alongwith interest levied / leviable on BHEL.

For Foreign Supplier:

Payment shall be made in USD/INR only. 100% payment shall be made within 30-45 days of acceptance of received material at IVP Goindwal and receipt of following dispatch

documents.

Documents Required (Complete in all respects)

- a. Bill of Lading.
- b. Packing list & Invoice
- c. Country of origin Certificate
- d. Test Certificates / Compliance Certificate
- e. PBG for 10% value of contract. The validity of PBG should be for 18 months from acceptance of material at BHEL with additional 2 months for claim period. Vendor has to furnish a Performance Bank Guarantee from a consortium Bank at no extra cost in a proforma attached.

f. A Certificate that :

One copy of Tests / Compliances Certificate with non-negotiable documents, comprising of House Airway Bill, Invoice, Packing list, Country of origin Certificate, applicable drawings and catalogues, duly signed and stamped, have been sent separately to the port Consignee, purchaser

Attn: SDGM/ MM Department, BHEL, IVP Goindwal Sahib -143422 Distt. Tarn Taran, Punjab –India and to DGM / Finance, <<Same address>>

Above documents should include your Registration numbers such as GST no, PAN no, any other applicable statutory document etc.

BHEL releases payment through EFT mode ONLY. Necessary details may please be submitted by filling required format before release of payment.

It is mandatory to mention proper material codes in the invoices and separate invoices to be raised for different POs and Radiographed castings. It is necessary to send MTCs and RT films along with material, failing which material will not be accounted for and no receipt will be given. Also RT charges are to be mentioned in same invoice in which material is being supplied. Above documents should include your Registration numbers such as GST no, PAN no. etc.

10. **INSPECTION:**

- a. All required tests (Physical properties, Chemical properties, Heat Treatment, NDE, Visual, Surface finish etc.) as called in referred material standard/BHEL/TDC/drawing etc shall be carried out by vendor at no extra cost. **BHEL may decide to inspect itself/arrange third party at vendors' works itself as and when necessary with prior intimation to the vendor.** No additional charges shall be claimed for such inspections.
- b. Third party inspection charges will be borne by BHEL. Moreover all required infrastructure (testing, tools etc) have to be arranged by supplier.
- c. **Vendor will give inspection call sufficiently in advance considering the delivery period stipulated in the purchase order.**
- d. Material Test Certificates (MTC), Inspection reports and Compliance/Guarantee Certificate are to be provided along with the supplies.
- e. Latest applicable revisions of standards/procedures to be referred. International/National standards are to be arranged by vendor.

- f. Any inspection carried out before supply by vendor/incoming stage at BHEL notwithstanding, if any defect/non-conformity is noted during processing, the same shall be attended/replaced by vendor at no extra cost.
- g. Necessary tooling including thread gauges etc have to be arranged by vendor. Only in exceptional cases, based on BHEL discretions item/nature, BHEL may consider request to provide gauges if available with BHEL. But in no case this shall be linked with delivery of material
- h. Sample castings are to be identified by vendor in the delivery challan as “Sample” and the dimensional reports and RT reports are to be provided to BHEL along with supply. Also mention “Sample” on castings with white paint.
- i. RT castings have to be mentioned “RT” on castings with white paint.
- j. Material code as mentioned in PO is to be mentioned on all casting with paint.

11. **RADIOGRAPHY:**

Consistent radiography quality is to be ensured and to be maintained uniformly in bulk supply with adequate process and method controls. Since the castings required are of radiographic quality, BHEL reserves the right to conduct radiographic testing of sample pieces at its own arrangement and derive conclusion of soundness of casting supplied against the said lot/heat based on the results of such testing.

- Standard requirement of radiography of castings shall be as per TDC:0412/26 (latest revision) and for foreign supplier is TDC:0:433 Rev00 (or latest applicable).
- Any additional requirement shall be specifically called for in PO.
- BHEL intends to get delivery of castings along with radiographed sets as ordered. The claim of vendor for payment of supplies against any PO can be put on hold if the requisite no. of radiographed sets has not been delivered by then. BHEL shall reserve the right to select any sample from a lot offered and get it radiographed at vendor’s works.

As per requirement of BHEL, vendor will be required to submit radiographic test reports as specified in the purchase orders released under the purview of the contract. BHEL will review and evaluate radiography films and RT reports and reserves the discretion to do so at the premises of the vendor.

Radiography procedure shall be as per ASME B 16.34, as mentioned in BHEL’s TDC:0412/26 (latest revision) and for foreign supplier is TDC:0:433 Rev00 (or latest applicable). All the radiography films shall be dispatched to BHEL without delay either before the castings are being dispatched or along with the castings. Vendor shall undertake radiography on new development as per TDC 412 Rev.26 and TDC:0412/26 (latest revision) and for foreign supplier is TDC:0:433 Rev00 (or latest applicable).

RT charges for Indian supplier: Fixed RT charges @ Ir₁₉₂ : Rs 0.99 & Co₆₀ : Rs 1.50 per sq. cm shall be paid on actual verified film area.

RT charges for Foreign supplier: Fixed RT charges @ Ir₁₉₂ : Rs 0.99 & Co₆₀ : Rs 1.50 per sq. cm shall be paid on actual verified film area. The above RT cost is landed cost to BHEL (FOR Goindwal). Loading as per clause 2e of tender will be done if vendor is not quoting FOR Goindwal basis.

12. REPAIR OF CASTINGS:

All castings shall be supplied free of defects like shrinkage, hot tears and process variable defects like sand inclusion, slag inclusion, gas entrapment etc. If any casting is found containing defects more than allowable limit, the same shall be upgraded at foundry itself before dispatch to BHEL with necessary documentation, enabling BHEL to make use of such castings immediately for production.

Castings at different stages of manufacturing are found to be defective shall be repaired at the defective area and the repaired area shall be accepted after performing requisite NDT at vendors cost for further acceptance. BHEL shall decide about the areas to be repaired in all such cases.

Castings that are found defective after receipt at BHEL, if necessary repair of the castings will be carried out by BHEL and repair charges @ Rs. 21.00 per cc for Alloy Steel shall be deducted from any of the running bills of the vendor.

In case of rejection of casting after machining/ assembly/testing due to defects more than allowable limits or major variation in dimensions etc. then the entire cost incurred till that stage shall be deducted from any of the running bills of the vendor.

13. REPLACEMENT OF REJECTIONS

If the material is rejected due to defective workmanship during inspection or at the time of actual use, within the guarantee period (i.e. as per clause 16), the rejected material shall be replaced by the supplier. Corresponding quantity shall be treated as unsupplied against respective purchase order till replacement is received at BHEL. If the material is found defective and rejected during use for which payment has already been released the rejected quantity shall be supplied free of cost by the vendor within a month of intimation of the rejection by BHEL.

Lifting of rejected material is under Supplier's scope. BHEL will inform related invoice, qty etc to supplier. Supplier is expected to give the plan to lift and advance intimation when visiting to lift the material. Material should be lifted within one month from date of intimation. After one month BHEL will not be responsible for rejected material. BHEL may decide to send the rejected material on To Pay basis to supplier. Any leniency/unresponsiveness/delay on part of supplier may lead to appropriate action by BHEL. Any request to postpone in written may be considered but replacement should not be linked with lifting of material

Item/s pending in previous PO has to be billed in previous PO only. Otherwise BHEL will be free to adjust the supplies in previous PO. Any implication of taxes etc will be on supplier's account. For this it is desirable to reconcile the pending PO statement every month/frequently. BHEL will give pending PO statement every month. This can also be viewed at Portal (<http://vis.bheltry.co.in/mm/index.jsp>).

14. LOADING:

BHEL shall give counter offers to other than L1 vendor (as per below conditions) except highest bidder. Counter offer is not applicable for BODY_750_900SPL-C12A HRHIV_3313.

1. Tender quantity shall be divided in the proportion as mentioned above in the scope of supply in case the L1 vendor is not a MSE subject to following conditions:

- I. L2 acceptance of L1 rates.

- II. In tender, participating Micro and Small Enterprises quoting price within price band of L1+15 per cent shall also be offered quantity as mentioned in the scope of supply at L1 price in a situation where L1 price is from someone other than a Micro and Small Enterprise. In case there are two Micro and Small Enterprise, the quantity shall be shared in proportion of 1:1 based on final rank of MSE in price comparison sheet for the 18"300 GV Castings. No counter offer will be given to 3rd MSE. In case of More than 2 MSEs for 18"300 GV Castings, the counter offer will be limited only to first 2 MSEs based on their rank in price comparative sheet. If any of the MSEs refuse to accept counter offer, then quantity shall be offered to other MSE vendor. If no MSE accept the counter offer, then the quantity shall be offered to L2 bidder.

In case, there are two Micro and Small Enterprise for BODY-HRHIV-700-C900SPL-C12A-3399 castings, no counter offer will be given to 2nd MSE based on rank in price comparison. In case of non-acceptance of counter by first MSE, counter offer will be given to other MSEs based on rank in price comparative.

- III. No specific division of tender is possible for the SC/ST owned MSE bidder.

- IV. In case any MSE vendor does not accept the counter offer, the above mentioned quantities shall be offered to L2 subject to its acceptance to L1 price.

- V. If there is no MSE in the Price band of L1+15% then the mentioned quantities shall be offered to L2 vendor subject to his acceptance of L1 rates.

2. In case if the L1 vendor is MSE then quantity shall be provided as per above details mentioned in table under clause 3.2 "Scope of Supply" subject to acceptance of L1 rates.
3. Counter offer shall be given to L3 vendor in case of non-acceptance of L2 vendor and so on except the higher bidder.

In case of non- acceptance of counter offer by any vendor after above applicable provisions the whole quantity would be offered to L1 vendor. All above mentioned preferences shall be given to MSEs only on the submission of documentary evidence before Reverse auction/Price bid opening.

15. **GUARANTEE:**

Vendor shall give a guarantee of 18 months from the date of dispatch or 12 months from date of receipt, whichever is earlier (for undertaking repairs/replacement of any defect observed during machining/ assembly/ hydraulic testing or subsequent processing notwithstanding the previous acceptance. Entire cost of such castings will be deducted from any of the running bills/PBG). In case of non-acceptance of this term bid will be rejected.

16. **LIQUIDATED DAMAGES:**

'Time is the essence of the contract'. As such, delivery of goods specified in the Purchase Orders released under the scope this contract shall be made within the time limit prescribed

therein. Liquidated damages clause will be applicable for delayed supplies @ 0.5% per week or part thereof subject to a maximum of 10%.

If any vendor does not accept LD ½% of the supply for each week of delay subject to a maximum of 5%, their offer is likely to be rejected by BHEL and the price bid shall not be opened. Bidders accepting for 10% LD shall not be loaded on account of LD. However bidders who offer any other % LD [between 5% to 10%] shall be loaded @ % deviation from 10% and their accepted %.e.g. If a bidder accepts for a max of 7% LD only, their offer would be loaded @ 3% (10 – 7 = 3).

BHEL reserves the right to receive or not receive material after the due date of PO.

17. RISK PURCHASE:

BHEL shall be entitled to terminate the contract/pending POs at any stage and to purchase elsewhere at the risk and cost of the vendor, either the whole of the goods or any part thereof which the supplier has failed to deliver or dispatch within the time stipulated as aforesaid. Vendor shall be liable for the losses, which BHEL may sustain by way of such risk purchase.

18. SUB-CONTRACT:

The casting process shall not be sub-contracted, assigned or otherwise transferred without previously obtaining the BHEL's consent in writing.

19. FORCE MAJEURE:

If at any time during the continuance of the contract, the performance in which or in any part by either party of any obligations under the contract are prevented or delayed by reason of any war, hostilities, acts of public enemy, civil commotion, sabotage, fires, explosions, epidemics, quarantine restrictions, or acts of God (hereinafter referred to "an events" then provided the notice of happening of any such event is given by either party to the other within 21 days of the occurrence thereof, neither party shall by reason of such event be entitled to terminate the contract nor shall either party have any claim for damages against the other in respect of such non-performance and delay in performance and delivery under the contract shall be resumed as soon as practicable after such event has come to an end or ceased to exist. If the performance in whole or part of any obligation under the contract is prevented or delayed by reason of any such event, claims of extension of time shall be granted for periods considered reasonable by BHEL subject to prior notification by the vendor to BHEL of the particulars of the event and supply to BHEL, if required, of any supporting evidence. Any waiver of time in respect of partial installment shall not be deemed a waiver of time in respect of remaining deliveries.

20. DISPUTES:

In the event of any dispute and/or difference arising between the Vendor and BHEL as to interpretation and/or execution of the contract and/or the respective rights and liabilities of the parties, such disputes and/or differences shall be referred to the sole arbitrator nominated by BHEL. The provisions of the Indian Arbitration Act and the rules there under shall apply to such arbitration. The award passed by the arbitrator shall be final and conclusively binding on all the parties.

21. JURISDICTION:

The court of the place from where the purchase order is issued during the contractual period shall alone have jurisdiction to decide any dispute arising out of or in connection with the purchase order.

22. GENERAL:

- a) BHEL will not be bound by any power of attorney granted by the vendors or by changes in the composition of the firm made subsequent to the execution of the contract. They may, however, recognize such power of attorney and changes after obtaining proper legal advice, the cost of which will be chargeable to the vendor concerned.
- b) BHEL reserves the right to extend the due date of opening, which shall be informed. Validity of offer shall be deemed to be revised accordingly.
- c) BHEL reserves the right to accept or reject any part or whole of the tender of a bidder by assigning a valid reason thereof. BHEL reserves the right to cancel the tender without assigning any reason thereof and without any obligation before any commitment.
- d) If possible, please submit soft copy of price quotation [copied on a blank CD of standard make] put in the sealed offer.
- e) Acceptance of all terms and conditions, in the form of signed copy of T&C or confirmation separately written, shall be submitted along with quotation. If nothing is mentioned, it shall be concluded that terms and conditions are acceptable.
- f) BHEL may increase/decrease item/s based on BHEL requirement before price bid opening. Suitable price implication may be asked from suppliers.
- g) BHEL may drop item/items from tender at any stage of tender before placing PO. BHEL may also delete PO with consent with supplier within delivery date of PO.
- h) After releasing PO, it is assumed that supplier has accepted PO if we do not receive acknowledgement from supplier within 5 days of date of PO.
- i) Any term is special tender terms and conditions will supersede the GCC.
- j) BHEL reserves the right to negotiate with L1 bidder/s of Reverse auction/sealed bid.
- k) The Drawings and Technical documents given in this enquiry are the sole property of BHEL. It must not be used directly or indirectly in any way detrimental to the interest of the company.
- l) **Documents submitted with the offer shall be signed and stamped in each page by authorized representative of the bidder.**
- m) If vendor has mentioned **FOR Punjab** in his quotation, then it will be considered as FOR Goindwal Sahib (Pb.).

For Foreign Supplier only:

- a. All documents are to be in “ENGLISH LANGUAGE” only.
- b. Contract No. and Import License No. are to be inducted in all documents
- c. Invoice should show the description of the goods and the unit rate of each item as in the purchase contract.
- d. Packing list must indicate case identification, case dimension, and case contents, gross and net weight.

- e. Against each item in the invoice and packing list, the serial number of the corresponding item in the purchase contract or as per order acknowledgement should be indicated.
- f. Demurrage charges due to delayed presentation of the original shipping documents for the reason not attributable to the buyer should be borne by the seller
- g. All documents should be submitted in triplicate

23. WORDS AND FIGURES:

- a. If, in the price structure quoted for the required goods/ services/ works, there is discrepancy between the unit price and the total price (which is obtained by multiplying the unit price by the quantity}, the unit price shall prevail and the total price corrected accordingly, unless in the opinion of the purchaser there is an obvious misplacement of the decimal point in the unit price, in which case the total price as quoted shall govern and the unit price corrected accordingly.
- b. If there is an error in a total corresponding to the addition or subtraction of subtotals, the subtotals shall prevail and the total shall be corrected; and
- c. If there is a discrepancy between words and figures, 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 subject of (a) and (b) above.
- d. If there is such discrepancy in an offer, the same shall be conveyed to the bidder with target date upto which the bidder has to send his acceptance on the above lines and if the bidder does not agree to the decision of the purchaser, the bid is liable to be ignored.
- e. Bids should be free from correction, overwriting, using corrective fluid, etc. Any interlineation, cutting, erasure or overwriting shall be valid only if they are attested under full signature(s) of person(s) signing the bid else shall be liable for rejection.
- f. All overwriting/cutting, etc will be numbered by bid opening officials and announced during bid opening.

24. PREFERENCES FOR MSE's :

Preferences as mentioned in “Public Procurement Policy for Micro and Small Enterprises (MSEs) Order, 2012” shall be given to Micro and Small enterprises.

Main points which are mentioned in the above order are as follows:

- 25% Procurement of the tender value shall be made from MSE (Micro, Small Enterprises) firms.
- 6.25% from the above 25% procurement quantity shall be procured from MSE's owned by SC /ST's. Failure to participate by any MSE owned by SC/ST's this 6.25% quantity shall be procured from other MSEs.
- 3% from within the 25% quantity offered to the MSE's shall be reserved for women owned MSE's. Failure to participate by any MSE owned by SC/ST's this 3% quantity shall be procured from other MSEs.
- EMD shall be exempted for MSE's. All these benefits are subject to production of all statutory documents

- In tender, participating Micro and Small Enterprises quoting price within price band of L1+15 per cent shall also be allowed to supply a portion of requirement by bringing down their price to L1 price in a situation where L1 price is from someone other than a Micro and Small Enterprise and such Micro and Small Enterprise shall be allowed to supply up to 20 per cent of total tendered value. In case of more than one such Micro and Small Enterprise, the supply shall be shared proportionately (to tendered quantity).

“MSE suppliers can avail the intended benefits only if they submit along with the offer, attested copies of either EM II certificate having deemed validity (five years from the date of issue of acknowledgement in EM II) or valid NSIC certificate or EM II certificate along with attested copy of a CA certificate (Format enclosed at Annexure -1 where deemed validity of EM II certificate of five years has expired) applicable for the relevant financial year (latest audited). Date to be reckoned for determining the deemed validity will be the date of bid opening (Part 1 in case of two part bid). Non submission of such documents will lead to consideration of their bid at par with other bidders. No benefit shall be applicable for this enquiry if any deficiency in the above required documents is not submitted before price bid opening. If the tender is to be submitted through e-procurement portal, then the above required documents are to be uploaded on the portal. Documents should be notarized or attested by a Gazetted officer.”

Quantity division for MSE shall not be done for this tender, as evaluation is on total tender basis.

25. BANNED FIRMS:

The offers of the bidders who are on the banned list as also the offer of the bidders, who engage the services of the banned firms, shall be rejected. The list of banned firms is available on BHEL website www.bhel.com.

26. FRAUD PREVENTION POLICY:

The Bidder along with its associate/collaborators/sub-contractors/sub-vendors/consultants/service providers shall strictly adhere to BHEL Fraud Prevention Policy displayed on BHEL website <http://www.bhel.com> and shall immediately bring to the notice of BHEL management about any fraud or suspected fraud as soon as it comes to their notice.

27. CLARIFICATIONS:

The correspondence exchanged against the tender from both tenderer and BHEL through email & through e-procurement portal are considered as valid document legally though it is not signed. It is treated as valid confirmations made on behalf of the respective company and very much comes under the legal ambit of the business transaction and hence it is binding on both the parties to the business. Any transaction pertaining to the tender from both the parties of business done round the clock irrespective of the office or business hours of the companies, are valid legally and binding on both the parties. This applies to the extent only in such cases where deadline time for transaction is not specifically

declared by either or both the parties to the business. In case Letter of Intent (LOI) is issued through email, the PC generated time and date of mail shall be construed as the official time and date of release of LOI. In as much as this date is within the last date of validity given by the bidder the LOI is said to have been issued within the validity period and shall be bidding on both the parties to the business.

28. REVERSE AUCTION:

BHEL reserves the right to go for Reverse Auction (RA) (Guidelines as available on www.bhel.com) instead of opening the sealed envelope price bid, submitted by the bidder. This will be decided after techno-commercial evaluation. Bidders to give their acceptance with the offer for participation in RA. Non-acceptance to participate in RA may result in non-consideration of their bids, in case BHEL decides to go for RA.

Those bidders who have given their acceptance to participate in Reverse Auction will have to necessarily submit 'Process compliance form' (to the designated service provider) as well as 'Online sealed bid' in the Reverse Auction. Non-submission of 'Process compliance form' or 'Online sealed bid' by the agreed bidder(s) will be considered as tampering of the tender process and will invite action by BHEL as per extant guidelines for suspension of business dealings with suppliers/ contractors (as available on www.bhel.com).

The bidders have to necessarily submit online sealed bid less than or equal to their envelope sealed price bid already submitted to BHEL along with the offer. The envelope sealed price bid of successful L1 bidder in RA, if conducted, shall also be opened after RA and the order will be placed on lower of the two bids (RA closing price & envelope sealed price) thus obtained. The bidder having submitted this offer specifically agrees to this condition and undertakes to execute the contract on thus awarded rates.

If it is found that L1 bidder has quoted higher in online sealed bid in comparison to envelope sealed bid for any item(s), the bidder will be issued a warning letter to this effect. However, if the same bidder again defaults on this count in any subsequent tender in the unit, it will be considered as fraud and will invite action by BHEL as per extant guidelines for suspension of business dealings with suppliers/ contractors (as available on www.bhel.com).

29. SUSPENSION OF BUSINESS DEALINGS WITH DEFAULTERS

The offers of the bidders who are under suspension as also the offers of the bidders, who engage the services of the banned firms, shall be rejected. The list of banned firms is available on BHEL web site www.bhel.com.

1.0 Integrity commitment, performance of the contract and punitive action thereof:

1.1. Commitment by BHEL:

BHEL commits to take all measures necessary to prevent corruption in connection with the tender process and execution of the contract. BHEL will during the tender process treat all Bidder(s) in a transparent and fair manner, and with equity.

1.2. Commitment by Bidder/ Supplier/ Contractor:

1.2.1. The bidder/ supplier/ contractor commit to take all measures to prevent corruption and will not directly or indirectly influence any decision or benefit which he is not legally entitled to nor will act or omit in any manner which tantamount to an

offence punishable under any provision of the Indian Penal Code, 1860 or any other law in force in India.

1.2.2. The bidder/ supplier/ contractor 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 and shall adhere to relevant guidelines issued from time to time by Govt. of India/ BHEL.

1.2.3. The bidder/ supplier/ contractor will perform/ execute the contract as per the contract terms & conditions and will not default without any reasonable cause, which causes loss of business/ money/ reputation, to BHEL.

If any bidder/ supplier/ contractor during pre-tendering/ tendering/ post tendering/ award/ execution/ post-execution stage indulges in mal-practices, cheating, bribery, fraud or and other misconduct or formation of cartel so as to influence the bidding process or influence the price or acts or omits in any manner which tantamount to an offence punishable under any provision of the Indian Penal Code, 1860 or any other law in force in India, then, action may be taken against such bidder/ supplier/ contractor as per extant guidelines of the company available on [www. bhel.com](http://www.bhel.com) and/or under applicable legal provisions

30. DISCLAIMER CLAUSE: (Only for E procurement)

Neither the Organization (Bharat Heavy Electricals Ltd.) nor the service provider (M/s e Procurement Technologies limited) is responsible for any failure of submission of bids due to failure of internet or other connectivity problems or reasons thereof.

31. LOI (Letter of Intent)

BHEL may issue LOI prior to the PO for any reason whatsoever. The LOI in such cases is to be treated as PO for all practical purposes and all the Terms & Conditions of the tender shall be applicable from the date of issue of LOI.

32. PREFERENCE TO MAKE IN INDIA

For the procurement, Public Procurement (Preference to make in India), order 2017 dated 15.06.2017 & 28.05.2018 and subsequent Orders issued by respective Nodal Ministry shall be applicable even if issued after issue of this NIT before finalization of contract/PO/WO against this NIT

Check List for Tender

Necessary Document to be submitted in Part-I:

- Acceptance of all techno-commercial terms and conditions. If nothing is mentioned for any terms and condition, it shall be concluded that the same is accepted.
- MSME certificate if applicable

Document to be submitted in Part-II:

Prices per kg mentioned in figures as well as in words. **No other condition shall be mentioned.**

Note: Kindly ensure that each page of document given with quotation is signed by authorized representative of company.



70-006

Bharat Heavy Electricals Limited

High Pressure Boiler Plant, Tiruchirappalli-620 014, India.

Grams : BHARATELEC

Phone : --

Telex : 0455 - 211, 212, 295 & 298

FAX : 91 - (0431) - 52710

PRODUCT ENGINEERING/VALVES

VL:STDC:023

REV.00

PAGE 1 OF 6

TDC FOR UNTOLERANCED DIMENSIONS IN CASTING & FORGING DRAWINGS

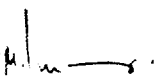
Scope :

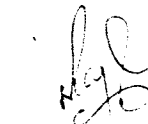
This technical delivery condition specifies the tolerance for the untoleranced dimension for the castings and forgings wherever tolerances are not specified in the applicable drawing applicable material TDC.

A. Castings :

Nominal dimension (in mm)	Tolerance on diameter & height (in mm)
UPTO 4	± 0.5
OVER 4 UPTO 16	± 1.0
OVER 16 UPTO 65	± 1.5
OVER 65 UPTO 125	± 2.0
OVER 125 UPTO 250	± 2.5
OVER 250 UPTO 500	± 3.0
OVER 500 UPTO 1000	± 4.0
OVER 1000 UPTO 1600	± 5.0

B. Forgings : As per Table (1), (2), (3) & (4)


PREPARED


CHECKED


APPROVED
(S. KUMAR)
SM/PE/VSB
28/2/94

TABLE 1. LENGTH, WIDTH, HEIGHT, MISMATCH, RESIDUAL FLASH AND TRIMMED FLAT OF DROP, PRESS AND UPSET FORGINGS (NORMAL TOLERANCES)

DROP, PRESS & UPSET FORGINGS - TOLERANCES FOR: LENGTH, WIDTH & HEIGHT ^M																						
MISMATCH	RESIDUAL FLASH (+) TRIMMED FLAT (-)	TRIM LINE		WEIGHT (kg) ABOVE TO (INCL)	DIFFICULTY OF MATERIAL		MISMATCH ; RESIDUAL FLASH & TRIMMED FLAT ^{(DIA & LENGTH FOR) UPSET FORGINGS}															
		ASYMMETRIC	STRAIGHT OR SYMMETRIC		M1	M2	NOTE: CENTRE TO SURFACE; STEP IN ONE DIE; + $\frac{1}{3}$, - $\frac{1}{3}$ OF TOTAL TOLERANCE															
							INTERNAL DIMENSION: REVERSE + AND - SIGNS.															
							MM															
							0 ABOVE	TO (INCL)														
							0	32	100	160	250	400	630	1000	1600	2500						
0.4	0.5			0-0.4			1	1.1 ^{+0.7} _{-0.4}	1.2 ^{+0.8} _{-0.4}	1.4 ^{+0.9} _{-0.5}	1.6 ^{+1.0} _{-0.6}	1.8 ^{+1.2} _{-0.7}	2 ^{+1.3} _{-0.7}									
0.5	0.6			0.4-10			2	1.2 ^{+0.8} _{-0.4}	1.4 ^{+0.9} _{-0.5}	1.6 ^{+1.0} _{-0.6}	1.8 ^{+1.2} _{-0.7}	2 ^{+1.3} _{-0.7}	2.2 ^{+1.5} _{-0.8}									
0.6	0.7			10-18			3	1.4 ^{+0.9} _{-0.5}	1.6 ^{+1.0} _{-0.6}	1.8 ^{+1.2} _{-0.7}	2 ^{+1.3} _{-0.7}	2.2 ^{+1.5} _{-0.8}	2.5 ^{+1.7} _{-0.9}	2.8 ^{+1.9} _{-1.0}								
0.7	0.8			18-32			4	1.6 ^{+1.0} _{-0.6}	1.8 ^{+1.2} _{-0.7}	2 ^{+1.3} _{-0.7}	2.2 ^{+1.5} _{-0.8}	2.5 ^{+1.7} _{-0.9}	2.8 ^{+1.9} _{-1.0}	3.2 ^{+2.1} _{-1.1}	3.6 ^{+2.3} _{-1.2}							
0.8	1			32-56			5	1.8 ^{+1.2} _{-0.7}	2 ^{+1.3} _{-0.7}	2.2 ^{+1.5} _{-0.8}	2.5 ^{+1.7} _{-0.9}	2.8 ^{+1.9} _{-1.0}	3.2 ^{+2.1} _{-1.1}	3.6 ^{+2.3} _{-1.2}	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}						
1	1.2			56-10			6	2 ^{+1.3} _{-0.7}	2.2 ^{+1.5} _{-0.8}	2.5 ^{+1.7} _{-0.9}	2.8 ^{+1.9} _{-1.0}	3.2 ^{+2.1} _{-1.1}	3.6 ^{+2.3} _{-1.2}	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}					
1.2	1.4			10-20			7	2.2 ^{+1.5} _{-0.8}	2.5 ^{+1.7} _{-0.9}	2.8 ^{+1.9} _{-1.0}	3.2 ^{+2.1} _{-1.1}	3.6 ^{+2.3} _{-1.2}	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}					
1.4	1.7			20-50			8	2.5 ^{+1.7} _{-0.9}	2.8 ^{+1.9} _{-1.0}	3.2 ^{+2.1} _{-1.1}	3.6 ^{+2.3} _{-1.2}	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}					
1.7	2			50-120			9	2.8 ^{+1.9} _{-1.0}	3.2 ^{+2.1} _{-1.1}	3.6 ^{+2.3} _{-1.2}	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}	8 ^{+3.7} _{-2.0}					
2	2.4			120-250			10	3.2 ^{+2.1} _{-1.1}	3.6 ^{+2.3} _{-1.2}	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}	8 ^{+3.7} _{-2.0}	9 ^{+3.9} _{-2.1}					
2.4	2.8						11	3.6 ^{+2.3} _{-1.2}	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}	8 ^{+3.7} _{-2.0}	9 ^{+3.9} _{-2.1}	10 ^{+4.1} _{-2.2}					
QUALITY (NORMAL)							12	4 ^{+2.5} _{-1.3}	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}	8 ^{+3.7} _{-2.0}	9 ^{+3.9} _{-2.1}	10 ^{+4.1} _{-2.2}	11 ^{+4.3} _{-2.3}					
							13	4.5 ^{+2.7} _{-1.5}	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}	8 ^{+3.7} _{-2.0}	9 ^{+3.9} _{-2.1}	10 ^{+4.1} _{-2.2}	11 ^{+4.3} _{-2.3}	12 ^{+4.5} _{-2.4}					
							14	5 ^{+2.9} _{-1.6}	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}	8 ^{+3.7} _{-2.0}	9 ^{+3.9} _{-2.1}	10 ^{+4.1} _{-2.2}	11 ^{+4.3} _{-2.3}	12 ^{+4.5} _{-2.4}	14 ^{+4.7} _{-2.5}					
							15	5.6 ^{+3.1} _{-1.7}	6.3 ^{+3.3} _{-1.8}	7 ^{+3.5} _{-1.9}	8 ^{+3.7} _{-2.0}	9 ^{+3.9} _{-2.1}	10 ^{+4.1} _{-2.2}	11 ^{+4.3} _{-2.3}	12 ^{+4.5} _{-2.4}	14 ^{+4.7} _{-2.5}						

TABLE 2 THICKNESS FOR DROP, PRESS AND UPSET FORGINGS AND EJECTOR MARKS FOR DROP AND PRESS FORGINGS (NORMAL TOLERANCES)

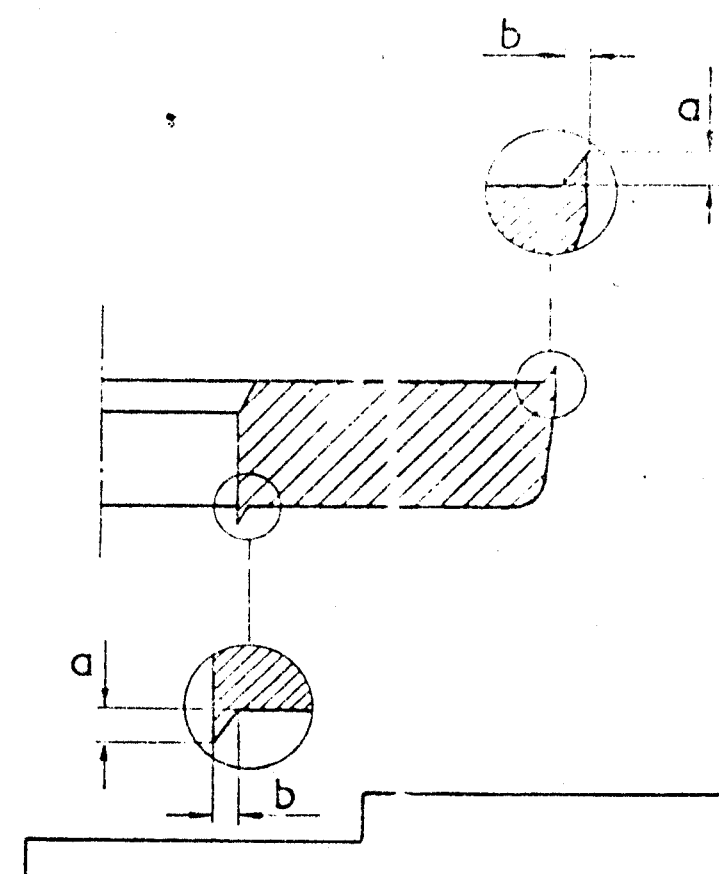
DROP, PRESS & UPSET FORGINGS - TOLERANCES FOR: THICKNESS; EJECTOR MARKS*																
EJECTOR MARKS	WEIGHT (kg) ABOVE - TO (INCL)	DIFFICULTY OF MATERIAL M1 M2	COMPLEXITY				* (DROP AND PRESS FORGINGS ONLY)									
			S1 A 0.63 ≤ 1	S2 A 0.32 ≤ 0.63	S3 A 0.16 ≤ 0.32	S4 S 0.15	0 ABOVE TO (INCL)	M M								
								16	40	63	100	160	250	> 250		
1	0-0.4						1	±0.3	1.1 ±0.4	1.2 ±0.4	1.4 ±0.4	1.6 ±0.4	1.8 ±0.4	2 ±0.4		
1.2	0.4-1.2						1.1	±0.4	1.2 ±0.4	1.4 ±0.4	1.6 ±0.4	1.8 ±0.4	2 ±0.4	2.2 ±0.4		
1.6	1.2-2.5						1.2	±0.4	1.4 ±0.4	1.6 ±0.4	1.8 ±0.4	2 ±0.4	2.2 ±0.4	2.5 ±0.4		
2	2.5-5						1.4	±0.4	1.6 ±0.4	1.8 ±0.4	2 ±0.4	2.2 ±0.4	2.5 ±0.4	2.8 ±0.4		
2.4	5-8						1.6	±0.4	1.8 ±0.4	2 ±0.4	2.2 ±0.4	2.5 ±0.4	2.8 ±0.4	3.2 ±0.4		
3.2	8-12						1.8	±0.4	2 ±0.4	2.2 ±0.4	2.5 ±0.4	2.8 ±0.4	3.2 ±0.4	3.6 ±0.4		
4	12-20						2	±0.4	2.2 ±0.4	2.5 ±0.4	2.8 ±0.4	3.2 ±0.4	3.6 ±0.4	4 ±0.4		
5	20-36						2.2	±0.4	2.5 ±0.4	2.8 ±0.4	3.2 ±0.4	3.6 ±0.4	4 ±0.4	4.5 ±0.4		
6.4	36-63						2.5	±0.4	2.8 ±0.4	3.2 ±0.4	3.6 ±0.4	4 ±0.4	4.5 ±0.4	5 ±0.4		
8	63-110						2.8	±0.4	3.2 ±0.4	3.6 ±0.4	4 ±0.4	4.5 ±0.4	5 ±0.4	5.6 ±0.4		
10	110-200						3.2	±0.4	3.6 ±0.4	4 ±0.4	4.5 ±0.4	5 ±0.4	5.6 ±0.4	6.3 ±0.4		
12.6	200-250						3.6	±0.4	4 ±0.4	4.5 ±0.4	5 ±0.4	5.6 ±0.4	6.3 ±0.4	7 ±0.4		
QUALITY (NORMAL)							4	±0.4	4.5 ±0.4	5 ±0.4	5.6 ±0.4	6.3 ±0.4	7 ±0.4	8 ±0.4		
							4.5	±0.4	5 ±0.4	5.6 ±0.4	6.3 ±0.4	7 ±0.4	8 ±0.4	9 ±0.4		
							5	±0.4	5.6 ±0.4	6.3 ±0.4	7 ±0.4	8 ±0.4	9 ±0.4	10 ±0.4		
							5.6	±0.4	6.3 ±0.4	7 ±0.4	8 ±0.4	9 ±0.4	10 ±0.4	11 ±0.4		
							6.3	±0.4	7 ±0.4	8 ±0.4	9 ±0.4	10 ±0.4	11 ±0.4	12 ±0.4		

TABLE 3 STRAIGHTNESS, FLATNESS AND CENTRE TO CENTRE DIMENSIONS FOR DROP, PRESS AND UPSET FORGINGS

DROP, PRESS AND UPSET FORGINGS																
NOTE. QUALITY E DOES NOT APPLY TO UPSET FORGINGS																
RANGE OF TOLERANCES FOR STRAIGHTNESS AND FLATNESS																
LENGTH		MM														
ABOVE TO (INCL)		0 100	100 125	125 160	160 200	200 250	250 315	315 400	400 500	500 630	630 800	800 1000	1000 1250	1250 1600	1600 2000	2000 2500
QUALITY	NORMAL	0.6	0.7	0.8	0.9	1	1.1	1.2	1.4	1.6	1.8	2	2.2	2.5	2.8	3.2
RANGE OF TOLERANCES FOR CENTRE TO CENTRE DIMENSIONS																
LENGTH		MM														
ABOVE TO (INCL)		0 100	100 160	160 200	200 250	250 315	315 400	400 500	500 630	630 800	800 1000	1000 1250				
QUALITY	NORMAL	±0.3	±0.4	±0.5	±0.6	±0.8	±1	±1.2	±1.6	±2	±2.5	±3.2				
		0.6	0.8	1	1.2	1.6	2	2.4	3.2	4	5	6.4				

TABLE 4 FILLET, EDGE RADIUS AND BURRS FOR DROP, PRESS AND UPSET FORGINGS

DRCP, PRESS AND UPSET FORGINGS		
FILLET AND EDGE RADII TOLERANCES		
r MM ABOVE -- TO (INCL)	+	-
0 -- 10	50%	25%
10 -- 32	40%	20%
32 -- 100	32%	15%
> 100	25%	10%
BURR TOLERANCES (AND PARTING LINE FINS FOR UPSET FORGINGS)		
WEIGHT (kg) ABOVE -- TO (INCL)	a	b
0 -- 1	1	0.5
1 -- 6	1.6	0.8
6 -- 40	2.5	1.2
40 -- 250	4	2



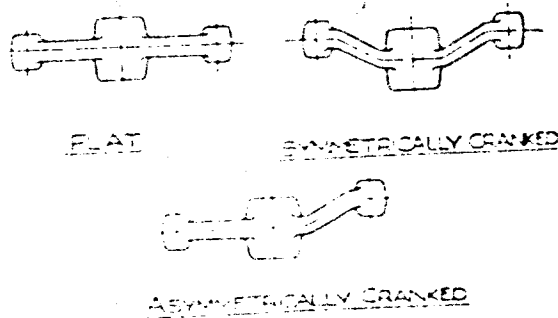


Fig. 1. Die boxes

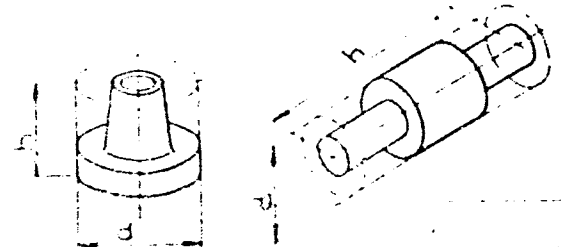


Fig. 2. Enveloping shapes of circular forgings

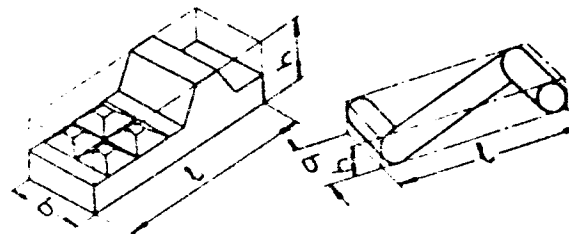


Fig. 3. Enveloping shapes of non-circular forgings

NOTE :

1. The type of steel used is determined as falling within one of the following categories :
 - a. M1 - steel with carbon content not more than 0.65% and total of specified alloying elements not more than 5%
 - b. M2 - steel with carbon content above 0.65% or total of specified alloying elements above 5%.
2. Complexity factor of a forging is the ratio of the weight of the forging to the weight of the overall shape necessary to accommodate the maximum dimensions of the forging.

The resulting complexity factor is determined as falling within one of the following categories :

- S4 - Upto and including 0.16
- S3 - Above 0.16 upto and including 0.32
- S2 - Above 0.32 upto and including 0.63
- S1 - Above 0.63 upto and including 1.00

Certificate by Chartered Accountant on letter head

This is to Certify that M/S
(hereinafter referred to as 'company') having its registered office at
is registered under MSMED Act 2006, (Entrepreneur
Memorandum No (Part-II) dtd:.....,
Category: (Micro/Small)). (Copy enclosed).

Further verified from the Books of Accounts that the investment of the company as per the latest audited financial year as per MSMED Act 2006 is as follows:

1. **For Manufacturing Enterprises:** Investment in plant and machinery (i.e. original cost excluding land and building and the items specified by the Ministry of Small Scale Industries vide its notification No.S.O.1722(E) dated October 5, 2006 :
Rs.....Lacs
2. **For Service Enterprises:** Investment in equipment (original cost excluding land and building and furniture, fittings and other items not directly related to the service rendered or as may be notified under the MSMED Act, 2006:
Rs.....Lacs

(Strike off whichever is not applicable)

The above investment of Rs.....Lacs is within permissible limit of Rs.....Lacs forMicro / Small (Strike off which is not applicable) Category under MSMED Act 2006.

Or

The company has been graduated from its original category (Micro/ Small) (Strike off which is not applicable) and the date of graduation of such enterprise from its original category is (dd/mm/yyyy) which is within the period of 3 years from the date of graduation of such enterprise from its original category as notified vide S.O. No. 3322(E) dated 01.11.2013 published in the gazette notification dated 04.11.2013 by Ministry of MSME.

Date:



(Signature)

Name -

Membership number -

Seal of Chartered Accountant

BHEL,Tiruchirapalli-620014.	Quality Assurance	TECHNICAL DELIVERY CONDITION
Product : STEEL CASTINGS (VALVES)- IMPORTED		
Document No: TDC:0:433	Rev No : 00	Effective Date: 15.07.2011 Page 1 of 4

1.0 MATERIAL:

Specification : ASME / ASTM {Latest on date of Purchase Order (PO)}:
 CARBON STEEL (CS) : SA / ASTM A216 WCB, WCC & 352 LCB , LCC
 ALLOY STEEL (AS) : SA / ASTM A217 WC6, WC9, C12A.
 STAINLESS STEEL (SS): SA / ASTM A351 CF3M,CF8,CF8C & CF8M.
 Additional Requirement : As listed below(Supplementary to Specification)
 Size, Qty, Grade/Class : As per Purchase order & Drawing / Pattern.

2.0 CHEMICAL COMPOSITION AND PROCESS:

Melting: As per the Specification, Fully Killed.
 Carbon= 0.25% maximum : for SA / ASTM A216 WCB only.
 Carbon= 0.15% maximum : for SA / ASTM A217 WC6 & WC9
 Product Analysis on test bar for each melt including residual elements shall be carried out and reported in Test Certificates.

In case of API-6D materials the following additional requirements shall be met:

CS: Carbon=0.23% max.(in ladle) and 0.25% max.(in Product analysis)
 Carbon Equivalent=0.43 max.(in ladle) and 0.45 max.(in Product analysis)
 Carbon Equivalent= $\%C + (\%Mn/6) + (\%Cr + \%Mo + \%V)/5 + (\%Ni + \%Cu)/15$
 SS: Carbon=0.03% max. except as below.
 Carbon=0.08% max.for stabilized steels with Nb >10xC.and
 for stabilized steels with Nb and Ta mass of (Nb+Ta)>8xC.

3.0 DIMENSIONS AND TOLERANCES:

Tolerances as per the Drawing.
 Non tolerance Dimensions for valve components as per the Drawing:VL:STDC:023 (Latest)

4.0 HEAT TREATMENT :(HT)

CS. Castings of High Pressure Valve.(Cl.1500 & above),QCNRV & CRHNRV: Shall be in Annealed Condition.
 AS. Castings: Normalized and Tempered.
 SA/ASTM A217 WC6 :Normalizing Temperature 920-950 °C and Tempering Temperature 680 °C (Minimum)
 SA/ASTM A217 WC9 :Normalizing Temperature 920-950 °C and Tempering Temperature 720 °C (Minimum)
 SA/ASTM A217 C12A: Normalizing Temperature 1050-1080 °C and Tempering temperature 750-780°C
 Others: Heat Treat as per the Specification.

5.0 MECHANICAL TESTS:

Test bars to be cast integral with the casting or separately. If cast separately, they shall be cast at the same time as the castings and from the same ladle. A metal strip with heat number stamped shall be fused with the test bar during casting, to maintain traceability. If one(1) casting is made from more than one heat, separate test bars for each heat/cast to be poured & all test bars shall satisfy the requirements. Following tests to be conducted per heat / Heat treatment batch, as per ASTM A370. .

S. NO	TEST	Material specification			
		SA/ASTM A216, 217		SA/ASTM A352	SA/ASTM A 351
1	Tension Test	As per the Specification			
2	Hardness Test	As per the Specification		225 BHN. max.	Not applicable
3	Bend Test Specimen 1"x ¾"		Angle of Bend	Dia of Pin	Not applicable S3 of SA703
		WCB	90°	2t	
		WCC	90°	2t	
		WC6	120°	3t	
		WC9	90°	3t	
		C12A	90°	2t	
4	Charpy- U Impact for all Quick Closing Non-Return Valve, Cold Re-Heat Non-Return Valve Bodies FOR IBR.	As per IBR. at Room temperature. Acceptance: Avg /Single=36J/32J min.		Not applicable	Not applicable
5	Charpy- V Impact for Low-Pressure Bye-pass Valve BODIES.	At 20 Deg.C temperature. Acceptance: Avg /Single=27J/21J min.		Not applicable	Not applicable

In addition to above IMPACT Test for API -6D and PED Valves shall be done as below

S. NO	TEST	Material specification		
		SA/ASTM A216, 217		SA/ASTM A 351
1	Charpy- V Impact for CE Marking-Pressure Equipment Directive (PED) items as Specified in the Purchase Order.	At 20 Deg.C temperature. Acceptance: Avg /Single=40J/27J min.		As per Specification Not applicable
2	Charpy- V Impact for API -6D items if design temperature below minus 29°C (-29 °C)	Test Temperature=As per specification Acceptance: Avg/Single=34J/25J		As per Specification Not applicable

6.0 FETTLING, DRESSING & CLEANING:

- Dressing of castings- Free from risers, in gates, notches, undercuts and deep marks etc.
- Fused wires, parting line fins, chills etc. shall be removed by grinding.
- Gas cutting if employed shall be done before Heat treatment.
- Preheat the material to 200 Deg. C. before gas cutting the Alloy steels.
- Castings shall be blast cleaned both inside and outside for the removal of fused sand, scales etc.
- Visual inspection of castings for surface quality as per MSS-SP-55 shall be carried out.

7.0 NON DESTRUCTIVE TESTING (NDT) AFTER HEAT TREATMENT:

The NDE requirements for the castings shall meet the following as shown in Table-1 below. Castings shall be free from surface and internal defects like porosity, shrinkage, sand inclusion, crack, cold shut and other harmful defects. All castings shall be of Radiographic Quality.

Radiographic Testing Procedure: As per ASME B16.34.

Magnetic Particle Inspection (MPI): As per ASTM E709

Liquid Penetrant Inspection (LPI): As per ASTM E165

Table: 1

Product	Components	Charecteristics	Type of NDE Check				
			RT	RT Area	RT Acc. Std	MT \$	MT Area
Conventional Valves (Gate, Globe & Check) and API 6D Gate Valves	Body,Bonnet	< 600Class	10%	ASME B16.34 (latest) as per SPL class Valve RT requirement	As per Table: 2	--	--
	Body,Bonnet	600Class & above	100%			--	
	Body,Bonnet & Wedge	1500Class & above	100%			100%	All accessible surfaces including belly
		All Special Class Valves	100%			100%	
<u>Quick Closing Non-Return Valve & Cold Re-Heat Non-Return Valve</u>	Body	150 & 300 Class	10%	Butt Weld Ends, Change of sections including seat and neck portion	As per Table: 2	100%	All accessible surfaces including belly
		600Class & above	100%		As per Table: 2	100%	All accessible surfaces .
	Body (Special)	150 & 300 Class					
	600Class & above						
	CRH Isolating Device	Body	< 600Class		100%	ASME B16.34 (latest) as per SPL class Valve RT requirement.	As per Table: 2
600Class & above			--				
1500Class & above			100%				
\$ LPI Can be substituted for MPI in all inaccessible area and for stainless steel castings.							

\$ LPI Can be substituted for MPI in all inaccessible area and for stainless steel castings.

Table: 2

TYPE OF DISCONTINUITY	ACCEPTANCE LEVEL CATEGORY	< 600 CLASS		≥ 600 CLASS	
		Thickness ≤2"	Thickness >2"	Thickness ≤2"	Thickness >2"
Gas Porosity	A	A2	A3	A1	A2
Sand/Slag inclusion	B	B3	B3	B2	B2
Shrink Type-1	C	CA2	CA3	CA1	CA2
Shrink Type-2	C	CB3	CB3	CB2	CB2
Shrink Type-3	C	CC3	CC3	CC2	CC2
Crack	D	NONE	NONE	NONE	NONE
Hot Tear	E	NONE	NONE	NONE	NONE
Unfused Inserts (Chills/Chaplets)	F	NONE	NONE	NONE	NONE

a. Butt welding ends shall be free of shrinkage, crack & hot tear.
b. For butt weld ends Gas hole/Porosity and sand inclusions to be within level A1 & B1 respectively

BHEL,Tiruchirapalli-620014.	Quality Assurance	TECHNICAL DELIVERY CONDITION
Product : STEEL CASTINGS (VALVES)- IMPORTED		
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7.1 Acceptance for MPI & LPI: ASME B16.34.

- (1)Cracks are not permitted.
- (2)For linear indications (with length > 3 times width) other than cracks,indications must be separated by a distance greater than the length of an acceptable indication. Maximum allowable length of the indication shall be:
 - (a) For thickness (t) up to 13mm= 8mm,
 - (b) For thickness from 13 to 25mm = 13mm
 - (c) For thickness above 25mm =18mm.
- (3)For rounded indications (circular or elliptical with length < 3 times width), 4 or more indications in a line separated by 1.5 mm or less edge to edge are unacceptable. Maximum allowable diameter of the indication shall be:
 - (a)For thickness up to 13mm =8mm, and
 - (b)For thickness above 13mm =13mm

8.0 Development Stage of Casting:

a. During developmental stage, RT on sample castings (3 Castings with nominal bore (NB) ≤100mm. & 1 casting with NB > 100mm) for each type of casting shall be carried out on entire area of the casting to the acceptance requirement of Table-1 & 2. In addition 100% MPI on all critical areas like change of sections, riser & in gate portions shall be carried out. If machining operation is involved the same shall be done and defect free condition shall be ensured. If any defect noticed in RT and machining, the type of defect shall be analysed and accordingly size of gate, runner, riser and pouring methodology to be modified to get defect free casting. Sampling shall be continued till achieving sound casting. After satisfactory development of sampling bulk production shall be started. However weld repaired areas identified in visual examination for doubtful indications to be probed by MPI.

b. During developmental stage RT on sample castings of yoke, yoke clamp & wedge/disc shall meet Level-3 of ASTM E446/E186/E280

9.0 REPAIR:

Castings with unacceptable cracks, hot tears, shrinkage, etc. to be rectified by grinding & if required by welding. Welding to be done by qualified welder and the procedure used for welding shall be qualified in accordance with ASTM A 488/ASME Section IX.

.For IBR items welder shall be qualified as per IBR and approved by IBR approved Inspecting Authority.

The welding consumables and parameters shall be as per the qualified procedures. The recommended welding consumables are given in Table below.

Casting Material	Electrode Specification	Minimum Preheat in ° C	Minimum Post heat Temperature in ° C	PWHT Temperature in ° C
A 216 WCB, A 216 WCC	E 7018 - A1	150	150 for 2 hours	595 to 625
A 217 WC6	E 8018 B2	220	220 for 2 hours	650 to 680
A 217 WC9, A 217 C5, CSN 422744	E 9018 B3	220	220 for 2 hours	675 to 705
A 217 C12A	E 9015 B9 E 9018 B9 Ref Note - 1	220-280	220-280 for 2 hrs	750 to 770
A 217 CA15	E 410	220	220 for 2 hours	760 to 790
A 351 CF3M, A 351 CF8M	E 316	Nil	Nil	Nil
A 351 CF8, A 351 CF8C	E 347	Nil	Nil	Nil

Note – 1:

A. The following welding filler materials only shall be used.

Cromocord 9 M (Oerlikon)

Fox C 9 MV (Bohler)

Cromo 9V (Thyssen)

B. C12A castings to be Post weld heat treated irrespective of depth or size of repair

BHEL,Tiruchirapalli-620014.	Quality Assurance	TECHNICAL DELIVERY CONDITION
Product : STEEL CASTINGS (VALVES)- IMPORTED		
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		Page 4 of 4

9.1 All repaired areas after PWHT shall be subjected to NDE and Hardness test. Hardness shall meet material Specification. (If Specified)

10.0 SURFACE TREATMENT:

SS castings to be pickled & passivated (after repair & HT if any) as per ASTM A380. Satisfactory passivity of the surface to be checked using SS passivity test kit (Free iron test). After passivation, rinsing & test, the rinsed demineralised water to be checked for chloride with 1% Silver nitride, which shall not exceed 0.5 PPM

11.0 DIMENSIONAL CHECK:

- Dimensional reports for Sample castings and for All fully Machined castings are to be furnished along with other Certificates.
- For all QCNRV & CRHNRV Body Castings, thickness of the body shall be checked on throughout the surface on a grid of 100mm x 100mm and recorded & reports to be submitted to BHEL.

12.0 MARKING AND PACKING:

Following details to be marked on each casting on a raised pad using low stress stamps and Castings shall be suitably packed to avoid damage during transit.

- Foundry code,
- Specification, grade & Melt number,
- Other details as per drawing.

13.0 INSPECTION AND CERTIFICATION:

13.1: For IBR items

- If the Foundry is recognized as "Well known Foundry" under IBR, Items shall be inspected by foundry and works certificate along with IBR Form III F shall be issued.
- If the Foundry is not recognized as "Well known Foundry" under IBR, Items shall be inspected by an Inspecting Authority approved by IBR and work certificate along with IBR Form III G shall be issued.

13.2: For CE-marking items the materials shall be inspected by M/s. LLOYD'S/ TUV/ BVQI or any other agency approved for PED of CEmarking, if the foundry is not certified to ISO 9000 by any of the above organisation.

13.3 For API items, the castings shall be inspected by the foundry and works certificate with details like PSL No., Temperature class rating, size shall be issued.

13.4 Test certificates shall contain the following details.

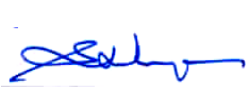
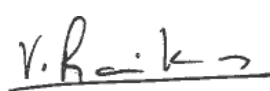
- Purchase Order No.(BHEL),TDC No. & Test certificate number
- Specification and Grade with applicable year of code, Heat Number, Quantity & Size
- Steel making process, Chemistry including incidental elements - Heat wise.
- Heat treatment details of the material and test bars.
- Mechanical test results, NDE test results with reference & acceptance standard.
- Repair details including HT, if any, Cleaning & Surface treatment details.
- Any other information like clearance of sample casting.
- Dimensional Inspection Report where applicable.

14.0 AUDIT CHECKS AT BHEL:

BHEL reserves the right to carry out audit checks for chemistry, HT condition, mechanical test and NDT on representative test bars or job. Items found defective during check or subsequent processing at BHEL are liable for rejection.

15.0 END USE:

For use in valves and other components like flanges, fittings etc. for high temperature & high pressure applications meeting IBR, ASME Section I, ASME B 16.34, PED and API.

			
D.SUDHAKARAN QA	M.RAJAKUMAR ENGG/VALVES	S.SELVARAJAN QUALITY ASSUARANCE	V.RAVIKUMAR QUALITY ASSUARANCE
PREPARED BY	REVIEWED BY		APPROVED BY

All communication should be addressed to the Secretary to the Government of India, Ministry of Industry, by title, NOT by name

Fax : 011-2306 2626

संख्या /No. 20/29/2009 -Boilers

भारत सरकार

वाणिज्य और उद्योग मंत्रालय
(औद्योगिक नीति एवं संवर्धन विभाग)

उद्योग भवन, नई दिल्ली - 110107

GOVERNMENT OF INDIA
MINISTRY OF COMMERCE AND INDUSTRY
(DEPTT. OF INDUSTRIAL POLICY & PROMOTION)

UDYOG BHAWAN, NEW DELHI-110107,
दिनांक/ Dated, the 8th April, 2011

To

1. All the members of the Central Boilers Board
2. All the inspecting Authorities

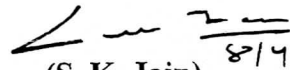
Subject: List of recognised Inspecting/Competent Authorities, Well Known Steel Makers, Foundries/Forgings units, Tube/Pipe Makers, Material Testing Laboratories and Remnant Life Assessment Organizations under Indian Boiler Regulations as on 31st March, 2011.

Sir,

I am to forward herewith a copy each of the list of recognised Inspecting/Competent Authorities, Well Known Steel Makers, Foundries/Forgings units, Tube/Pipe Makers, Material Testing Laboratories and Remnant Life Assessment Organizations under Indian Boiler Regulations, 1950 as on 31st March, 2011 for your reference and record.

Thanking you,

Yours faithfully,


(S. K. Jain) 8/4/2011

Development Officer &
Assistant Secretary, Central Boilers Board
Tel.No.23063321/3318

Encl: "As above"

Sri Pankumar
Pl take copies & circulate to
the appropriate agencies
JKans

original in
well known file

→ Sri Cini
Kriddy arrange for
scanning & placing in
VRK folder with
title "2011 well known"
list
V.R. Kishore

INSPECTING AUTHORITIES (As on 31/3/2011)

<u>NAME OF THE AUTHORITY</u>	<u>AREA OF OPERATION</u>
1. Director of Boilers, Andhra Pradesh	Andhra Pradesh
2. Chief Inspector of Boilers, Arunachal Pradesh	Arunachal Pradesh
3. Chief Inspector of Boilers Assam	Assam
4. Chief Inspector of Boilers Bihar.	Bihar
5. Chief Inspector of Boilers Chattisgarh	Chattisgarh
6. Chief Inspector of Boilers, Delhi.	N.C.T.D.
7. Chief Inspector of Boilers, Goa.	Goa
8. Director of Boilers, Gujarat.	Gujarat, Daman & Diu and Dadra & Nagar Haveli
9. Chief Inspector of Boilers, Haryana.	Haryana & Chandigarh
10. Chief Inspector of Boilers, Himachal Pradesh.	Himachal Pradesh
11. Chief Inspector of Boilers,, Jharkhand.	Jharkhand
12. Director of Boilers, Karnataka.	Karnataka
13. Director of Boilers, Kerala.	Kerala
14. Director of Boilers, Madhya Pradesh.	Madhya Pradesh
15. Director of Boilers, Maharashtra.	Maharashtra
16. Chief Inspector of Boilers, Meghalaya	Meghalaya
17. Chief Inspector of Boilers, Manipur	Manipur

18. Chief Inspector of Boilers, Mizoram	Mizoram
19. Chief Inspector of Boilers, Nagaland	Nagaland
20. Director of Boilers, Orissa	Orissa
21. Director of Boilers, Punjab	Punjab
22. Chief Inspector of Boilers, Labour Department, Government of Puducherry, Puducherry	Puducherry
23. Chief Inspector of Boilers, Rajasthan.	Rajasthan
24. Director of Boilers Tamil Nadu	Tamil Nadu
25. Chief Inspector of Boilers, Tripura	Tripura
26. Director of Boilers, Uttar Pradesh	Uttar Pradesh
27. Deputy Director of Factories & Boilers Uttarakhand	Uttarakhand
28. Chief Inspector of Boilers, West Bengal	West Bengal
29. M/s. TUV Nord Systems GmbH Co.KG. Langemarckstr 20 451141 Essen GERMANY.	All countries except India
30. M/s. Royal & Sunalliance Engineering, 17, York Street, Manchester, M2 3RS, ENGLAND	All countries except India
31. M/s. Japan Inspection Company Limited, No.10-7, 1-Chome, hatchobori, Chou-ku, Tokyo, 104-0032, Japan	All countries except India
32. M/s. S.G.S. Korea Company Limited, Industrial Division, 16 th FL, KT Pusan IT Center, 830-29, Beomil 2-Dong, Jung-Gu, Pusan, KOREA (601-706).	Korea & Japan

- | | | |
|-----|--|--|
| 33. | M/s Bureau Veritas,
67-71, Boulevard du Chateau,
92200 Neuilly-sur-Seine,
FRANCE | All countries except India. |
| 34. | M/s Lloyd's Register of Verification Ltd.,
71, Fenchurch Street,
London EC 3M, U.K. | All countries except India. |
| 35. | M/s. Velosi Certification Bureau Ltd.,
318a Kings Road, Clifton House,
Reading Berkshire, RG1 4JG,
United Kingdom | All countries except India |
| 36. | M/s TUV Rheinland Brandenburg Pfalz e.V.,
Am Grauenstein, D-51105 Klon,
Germany | Europe, Japan, China &
Korea |
| 37. | M/s Moody International Ltd.,
Cuckfield House, High Street,
Cuckfield, West Sussex,
RH 17 5EL, U.K. | All countries except India |
| 38. | Technischer Überwachungs-Verein Saarland e.V.,
Am Tüvie 1,
66280 Sulzbach,
Germany | Europe |
| 39. | M/s OOO "Tekhnologicheskoe Energostroye"
1. Kalinina St. Belgorod, 308001
Russia | Russia, China, Ukraine & USA |
| 40. | M/s. Det Norske Veritas,
Veritasveien 1, P.O. Box 300,
N-1322, Hovik,
NORWAY | Argentina, Australia, Austria, Belgium,
Brazil, Denmark, Finland, France,
Germany, Italy, Japan, Netherlands,
Norway, South Korea, Spain, Sweden,
Switzerland, U.K. and U.S.A. |
| 41. | M/s. Engineering Bureau Franke
International,
55, Amurskaya St.,
Ukraine 49108 | Ukraine, Russia, Belarus, China,
Uzbekistan, Poland, Belgium, Romania,
& Czech Republic |
| 42. | M/s. ARISE Boiler Inspection &
Insurance Company Risk Retention Group,
Grand Bay 1, 7000 South Edgerton Road,
Suite 100, Brecksville,
OH 44141 USA | Argentina, Austria, Canada, Brazil, France,
Germany, Italy, Malaysia, Netherlands,
Singapore, U.K. and USA |
| 43. | Tata Projects Limited,
"Mithuna Towers-I", 1-7-80 to 87,
Opp. Wesley Co-Ed. Jr. College,
Prenderghast Road,
Secunderabad- 500 003, (India) | All countries except India |

44. M/s TUV SUD Industrie Service GmbH, All countries except India
Wstendstr. 199,
80686 Munich,
Germany
45. M/s Germanischer Lloyd Industrial Services GmbH, All countries except India
Steinhoeft 9,
20459 Hamburg,
Germany
- 46 M/s. TUV Thuringen e.V., Europe
Business Division Steam and Pressure Technology,
Melchendorfer Str. 64,
99096 Erfurt,
Germany

COMPETENT AUTHORITIES (As on 31/3/2011)

NAME OF THE AUTHORITY

1. Director of Boilers,
Andhra Pradesh
2. Chief Inspector of Boilers,
Arunachal Pradesh
3. Chief Inspector of Boilers
Assam
4. Chief Inspector of Boilers
Bihar.
5. Chief Inspector of Boilers
Chattisgarh
6. Chief Inspector of Boilers,
Delhi.
7. Chief Inspector of Boilers,
Goa.
8. Director of Boilers,
Gujarat.
9. Chief Inspector of Boilers,
Haryana.
10. Chief Inspector of Boilers,
Himachal Pradesh.
11. Chief Inspector of Boilers,,
Jharkhand.
12. Director of Boilers,
Karnataka.
13. Director of Boilers,
Kerala.
14. Director of Boilers,
Madhya Pradesh.
15. Director of Boilers,
Maharashtra.
16. Chief Inspector of Boilers,
Meghalaya
17. Chief Inspector of Boilers,
Manipur

18. Chief Inspector of Boilers,
Mizoram
19. Chief Inspector of Boilers,
Nagaland
20. Director of Boilers,
Orissa
21. Director of Boilers,
Punjab
22. Chief Inspector of Boilers,
Labour Department,
Government of Puducherry,
Puducherry
23. Chief Inspector of Boilers,
Rajasthan.
24. Director of Boilers
Tamil Nadu
25. Chief Inspector of Boilers,
Tripura
26. Director of Boilers,
Uttar Pradesh
27. Deputy Director of Factories & Boilers
Uttarakhand
28. Chief Inspector of Boilers,
West Bengal
29. M/s. National Test House,
Plot No.F-10, M.I.D.C.,
Marol, Andheri (E),
MUMBAI - 400 093.
30. Welding Research Institute,
Bharat Heavy Electricals limited,
Tiruchirapalli - 620014.
31. M/s. Royal & Sunalliance Engineering,
17, York Street,
Manchester,
M2 3RS, ENGLAND.
32. M/s. TUV Nord Systems GnbH Co. KG,
Langemarcestrasse 20,
45841 Essen,
GERMANY

All countries except India

33. M/s. Hartford Steam Boiler Inspection and Insurance Company of Connecticut,
Code Services, One State Street,
P.P.Box 299, Hartford, CT 06141-0299
U.S.A.
34. M/s. Japan Inspection Company Limited,
No.10-7, 1-Chome, hatchobori, Chou-ku,
Tokyo, 104-0032, Japan
35. M/s. S.G.S. Korea Company Limited,
Industrial Division,
16th FL, KT Pusan IT Center,
830-29, Beomil 2-Dong, Jung-Gu,
Pusan, KOREA (601-706).
36. M/s Bureau Veritas,
67-71, Boulevard du Chateau,
92200 Neuilly-sur-Seine,
FRANCE
37. M/s. Lloyds Register of Verification Limited,
71, Fenchurch Street,
London EC3M 4BS,
UNITED KINGDOM All countries except India
38. M/s. Velosi Certification Bureau Ltd.,
318a Kings Road, Clifton House
Reading, Berkshire, RG1 4JG,
United Kingdom
39. M/s Moody International Ltd.,
Cuckfield House, High Street,
Cuckfield, West Sussex
RH 17 5 EL, U.K.
40. Technischer Uberwachungs-Verein Saarland e.V., Europe
Am Tuev 1,
66280 Sulzbach,
Germany
41. M/s. OOO "TekhnoLogicheskieEnergositime", Russia, China, Ukraine & USA
1, Kalinia St. Belgorod, 308001,
Russia.
42. M/s. Det Norske Veritas,
Veritasveien 1, P.O. Box 300,
N-1322, Hovik,
NORWAY.
43. M/s. National Test House,
11/1, Judges Court Road
Alipore, Calcutta - 700027

44. M/s. ARISE Boiler Inspection & Insurance Company
Risk Retention Group,
Grand Bay 1, 7000 South Edgerton Road,
Suite 100, Brecksville,
OH 44141 USA
45. M/s TUV Rheinland Brandenburg Pfalz e.V.,
Am Grauen Stein, D-51105 Klon,
Germany
46. M/s National Test House,
Kamla Nehru Nagar,
Ghaziabad- 201 002
Uttar Pradesh
47. M/s Germanischer Lloyd Industrial Services GmbH, All countries except India
Steinhoeft 9,
20459 Hamburg,
Germany
48. M/s. TUV Thuringen e.V., Europe
Business Division Steam and Pressure Technology,
Melchendorfer Str. 64,
99096 Erfurt,
Germany

(As on 31/03/2011)

WELL-KNOWN STEEL MAKERS

1. M/s. Vallourec & Mannesmann Tubes,
V & M France, Aciere de Saint
Saulve, BP 10,
Rue du Galibot, 59880 Saint – Saulve,
FRANCE.
2. M/s. FACOR Steels Limited,
46 A & B, MIDC Industrial Estate,
Hingna Road,
NAGPUR-440 028
3. M/s. Kalyani Carpenter Special Steel Limited,
Mundwa,
PUNE – 411 036.
4. M/s. ISMT Ltd.,
Jejuri – Morgaon Road,
Village Kolvihire,
P.O. Jejuri-412303,
Tal Purandar, Distt. Pune.
5. M/s. Tata Steel Limited,
Steel Division,
JAMSHEDPUR- 831 001
6. M/s. Star Wire India Ltd.,
21/4, Mathura Road,
BALLABGARH-121004
7. M/s. Jindal Steel & Power Ltd.,
Kharsia Road, P.B. No. 16,
Raigarh 496001.
CHHATISGARH
8. M/s Bharat Heavy Electricals Limited,
Central Foundry Forge Plant,
HARDWAR-249 403
9. M/s Steel Authority of India Ltd.,
Visvesvaraya Iron & Steel Ltd.,
BHADRAVATI-577 301
KARNATAKA
10. M/s Mu kand Limited,
Belapur Road,
Dighe, P.O. Kalwe
Thane-400 605,
Maharashtra
11. M/s Kal yani Steel Limited,
Hospet Division, Hospet Road,
Taluka & Distt. Koppal,
GINIGERA-583228
Karnataka

12. M/s Mukand Limited,
Hospet Division, Hospet Road,
Taluka & Distt. Koppal,
GINIGERA-583228
Karnataka.
13. M/s Steel Authority of India Ltd.,
Bhilai Steel Plant,
Bhilai-490 001
Chhattisgarh.
14. M/s Mahindra Ugin Steel Company Ltd,
Jagdishnagar,
Khopoli - 410216
Distt. Raigad
Maharashtra.
15. M/s Steel Authority of India Ltd.,
Bokaro Steel Plant,
Ispat Bhavan,
Bokaro Steel City - 827001,
Distt. Bokaro,
Jharkhand.
16. M/s. Ilseburger Grobblech GmbH,
Veckenstedter Weg 10,
D-38871 Ilseburg,
Germany.
17. M/s HKM Hüttenwerke Krupp Mannesmann GmbH,
Postfach 251124,
D47251 Duisburg,
Germany.
18. M/s. Tubos Reunidos Industrial S.L.U.,
Barrio Sagarribai 2,
01470 Ammurio (Alava),
SPAIN.
19. M/s Benteler Stahl/Rohr GmbH,
Stahlwerk Lingen,
Niederdarmer Strasse 5,
49811 Lingen,
Germany.
20. M/s Ambica Steels Limited,
51/2, Site IV,
Sahibabad Industrial Area,
Ghaziabad - U.P. - 200 1010.

21. M/s Ambica Steels Limited,
Plot No. 32, Site II,
Loni Road,
Mohan Nagar,
Ghaziabad- 201 010.
U.P
22. M/s Ja yaswals Neco Ltd,
Siltara Growth Centre, Siltara,
Raipur - 493 111,
Chattisgarh.
23. M/s Re mi Metals Gujarat Ltd.,
Plot No.1, GIDC,
Industrial Estate,
Valia Road,
Jhagadia - 393 110,
Dist.Bhaurch, Gujarat.
24. M/s Steel Authority of India Ltd.,
Rourkela Steel Plant,
Rourkela-769 011.
25. M/s Wu yang Iron and Steel co.Ltd.,
Wuyang City, Henan Pro,
P.R.China-462 500
26. M /s Adhunik Metaliks Limited,
Chadrihariharpur, Kuarmuda,
Distt. Sundergarh,
Orissa-770 039
27. M/s. Essar Steel Limited,
27 km, Surat Hazira Road,
Hazira- 394 270,
Surat, Gujarat
28. M/s Steel Authority of India Limited,
Alloy Steels Plant,
Durgapur- 713 208
West Bengal
29. M/s JSW Steel Li mited,
Salem Works,
P.O. Pottaneri-Kallipatti Village,
Mecheri- 636 453
Distt. Salem
Tamil Nadu
30. M/s AG der Dillinger Huttenwerke,
Werkstr.1, D-66736 Dillingen,
Germany

31. Ms Shyam Forgings Pvt. Limited,
6th Milestone, G.T. Road,
Chhaprola,
Gautam Budh Nagar-201 009
Uttar Pradesh

32. M/s Sunflag Iron & Steel Co. Limited,
P.O. Bhandara Road,
Distt. Bhandara-441 905
Maharashtra

WELL-KNOWN FOUNDRIES

1. M/s. Samco Metals and Alloys Pvt. Ltd.,
Kaniyambadi-632102,
Vellore Taluk, N.A. Distt.,
TAMIL NADU.
2. M/s. Gujarat Techno-Castings Pvt. Ltd.
Near C.D. High School,
Sajipur-Bogha,
AHMEDABAD.
3. M/s. Ratan Engineering Company Pvt. Ltd.,
F-454 RIICO Industrial Area,
Bhiwadi, Distt ALWAR
RAJASTHAN
4. M/s. Uni Deritend Limited,
Maneck Nagar, Tumsar-4410912
Distt. Bhandara,
MAHARASHTRA.
5. M/s. Malnad Alloy Castings Pvt. Ltd.,
36-A, Shimoga-Bhadravathi Industrial Area,
Machenahalli,
SHIMOGA - 577 222
6. M/s. Auto Shell Casts Pvt. Ltd.,
10, SIDCO Industrial Estate,
COIMBATORE - 641 021
7. M/s. Jsos Foundry Pvt. Ltd.,
Plot No.G/13, MIDC,
Kupwad Block,
Sangli-416 436
MAHARASHTRA.
8. M/s. Veeyes Alloys Pvt. Ltd.,
Door No.3CI-3C4, Athipalayam Pirivu,
Ganapathy,
COIMBATORE-641 006.
9. M/s. Upper India Special Castings Limited,
Dhandari Industrial Area, Focal Point,
LUDHIANA-141 010
10. M/s. A nagraha Valve Castings Limited,
391/2, Sendoda Goudan Pudur,
Arasur Village, Palladam (TK),
COIMBATORE-641 407.
11. M/s. Aruna Alloy Steels Pvt.Ltd.,
Unit - II,
3/1, Olaganeri Village, Uthangudi Post,
MADURAI-625 107.

12. M/s. Oswal Industries Limited,
Bileswarpura,
P.O. Chhatral, Tal Kalol,
Distt. Gandhinagar,
Gujarat - 382 729.
13. M/s. Uni Deritend Limited,
S.V. Road, Manpade,
THANE-400 607
14. M/s. A.V. Valves Limited,
160, Industrial Estate,
Nunhai,
AGRA-282 006.
15. M/s. Veeyes Foundry Pvt. Ltd.,
SF No.302/1 & 4, Kodathur Road,
Kunnathur Pudur (P.O.),
COIMBATORE-641 107.
16. M/s. Madura Steel Industries Pvt. Ltd.,
Chettinaickenpatty,
DINDIGUL-624 004.
17. M/s Creative Castings Limited,
102, G.I.D.C. Phase II,
Dolatpara,
JUNAGARH - 362 003
18. M/s Peekay Steel Castings (P)Ltd.,
(Foundry Division), Nallalam,
KOZHIKODE-673027,
Kerala.
19. M/s PTC Industries Ltd.,
B-480, RIICO Industrial Area,
BHIWADI -301019.
20. M/s The KCP Limited,
Engineering Unit,
Post Box No. 2278,
Tiruvottiyur,
CHENNAI - 600019.
21. M/s. Jayaswal Neco Ltd.,
T-41/42, MIDC Industrial Area,
Hingna Road, NAGPUR-440 016
22. M/s. Saurabh Metals Pvt. Ltd.,
1,22, New Industrial Area,
Mandideep - 462 046,
Bhopal.

23. M/s. Star Wire India Ltd.,
21/4, Mathura Road,
BALLABGARH-121004.
24. M/s. Sanmar Foundries Ltd.,
Foundry Division,
87/1, Vadugapatti Village,
Viralimalai-621316.
TAMILNADU
25. M/s. Sri Ranganaathar Industries Pvt. Ltd.,
12/45, Thadagam Road,
Edayapalayam P.O.,
COIMBATORE - 641025.
26. M/s. Aruna Alloy Steel Pvt.Ltd.,
Unit-I
Super B-6, Industrial Estate,
K. Pudur,
MADURAI - 625007.
27. M/s Hindustan Udyog Limited,
Biren Roy Road,
Ranipur, Maheshtala,
24, Paragana (South), West Bengal.
28. M/s Harihar Alloy Castings Ltd.,
SF No. 421 & 671, Trichi-Thuraiyur Road,
PULIVALAM - 621006.
29. M/s Coimbatore Super Alloy (P) ltd.,
Thelungupalayam Pirivu,
Ellapalayam P.O., Annur (Via),
Pogalur - 641697.
Coimbatore Distt.
30. M/s Ultimate Alloys (P) ltd.,
Kannampalayam Village,
Trichi Road, Sular,
COIMBATORE - 641402.
31. M/s Kartik Steel Ltd.,
52-53, Sipcot Industrial Complex,
Ranipet - 632403.
N.A. District
32. M/s S.V.E Castings Pvt.Ltd.,
Plot No. 1 & 2, KIADB Indl. Area,
Anantapur Road,
Bellary - 583101.
33. M/s Sueeraa Alloys Global (P) Ltd.,
315/2 Kandampalayam,
Sembiyanallur Village,
Avanashi - 641654.
Coimbatore.

34. M/s. Shiva Sai Cast Pvt. Ltd.
(Formerly: M/s Aaditya Cast)
Survey No. 57,
Gejjenahalli,
Shimoga - 577204.
35. M/s R.K. Machine Tools Ltd.,
854, R.K. Road,
Industrial Area -A,
Ludhiana - 141003.
36. M/s Mani's Foundries (Pvt.) Ltd.,
SF No. 211 & 274, Uralipatty,
Velvarkottai (PO)
Dindigul - 624803.
37. M/s Castech Foundries Pvt. Ltd.,
1708/1709, G.I.D.C., Phase - II,
Dolatpara, Junagarh - 362003 (Gujarat)
38. M/s S.S. Alloy Products Pvt. Ltd.,
83/5, Phase-I, "F" Road,
GIDC Vatva,
Ahmedabad - 382445.
39. M/s. Sri Padmabalaji Steels P. Ltd.,
459/460, Masandipalayam,
Karakoundampalayam Post,
Annur, Coimbatore - 641 697.
40. M/s NMVST Alloys Cast,
4/363, Kallipalayam Village,
Chikkarampalayam PO.,
Karamadai (PO) - 641 104,
Coimbatore Dist.,
Tamilnadu.
41. M/s. Veeyes Alloys Private Limited,
Unit-II, S.F. No.518/1A&1B,
Saravanampatti- Tudiyalur Road,
Vellakinar Post,
Coimbatore - 641 029.
42. M/s. Amex Alloys Private Limited,
SF No. 289/2, Sathy Road,
Kunnathur Pudur PO,
Coimbatore 641 107.
43. M/s. Balaji Super Alloys,
Bettathapuram Pirivu,
Karamadai (PO) - 641 104
Coimbatore Dist.

44. M/s. Anugraha Valve Castings Limited,
(Formerly : M/s Graha Industries Private Limited)
S.F. No.307, Sendoda Goudan Pudur,
Arasur Village, Palladam (TK),
COIMBATORE-641 407.
45. M/s Aruna Alloy Steels Pvt. Ltd.,
Narasingampatti, (Unit-III)
Therkutheru,
Madurai - 625112.
46. M/s Rine Engineering Pvt. Ltd.,
Plot No. 73 AB&C, HPSIDC, Industrial Area Baddi,
Distt. Solan - 173 205, (H.P.)
47. M/s Ratnamani Techno Casts Ltd.,
3310, Phase IV, GIDC Estate, Chhatral 382 729,
Ahmedabad Mehsana Highway, Dist. Gandhinagar,
Gujarat.
48. M/s Nectar Steel Cast Pvt. Ltd.,
E-62, MIDC Waluj,
Aurangabad - 431 136.
49. M/s Western Precicast Pvt. Ltd.,
Gate No. 170, Village Savali,
Taluka Miraj, Dist. Sangli. (Maharashtra)
50. M/s. Shyam Forgings Pvt. Ltd.,
6th Mile Stone, G.T. Road, Chhaprola,
Gautambudh Nagar - 201 009 (U.P.).
51. M/s Simplex Castings Limited,
(Special Castings Division),
Urla Industrial Estate,
Raipur - 492 023
(Chhattisgarh State).
52. M/s Electralloy Special Steel Castings Pvt. Ltd.,
Plot No. 25, SIPCOT Industrial Complex,
6th Cross Road,
Hosur-635 126 (Tamil Nadu)
53. M/s Koso Fluid Control (P) Limited,
Foundry Division,
1/80, Talungupalayam Road,
Pillayappampalayam Post,
Annur, Coimbatore-641 653
54. M/s Bharat Heavy Electricals Limited,
Central Foundry Forge Plant,
Ranipur, Haridwar-249 403 (Uttarakhand)
55. M/s Amsteel Castings Pvt. Limited,
35-A, Sipcot Industrial Industrial Complex,
Hosur-635 126 (Tamil Nadu)

56. M/s Neesa Infrastructure Limited,
278, Pancharatna Industrial Estate,
Vill: Changodar, Tal.: Sanand,
Distt. Ahmedabad- 382 213
Gujarat
57. M/s RLS Alloys Private Limited,
S.F. No. 118/1,2,3 Sethurapatti,
Fathimanagar,
Trichy- 620 012
Tamil Nadu
58. M/s Harihar alloys Castings (P) Limited,
Unit II, S.F. No. 229/2 & 4B,
Laxmanampatti Village,
Kulathur(Tk),
Pudukottai-622 054
Tamil Nadu
59. M/s Leader Valves Limited,
S-3,S-4, Industrial Town,
Jalandhar-144 004
Punjab
60. M/s A. K. Multimetals Private Limited,
A-1, Focal Point,
Mandi Gobindgarh-147 301
Punjab
61. M/s Uttar Pradesh Steels,
Village- Nara,
P.O. Mansurpur-251 203
Distt. Muzaffarnagar,
Uttar Pradesh
62. M/s Shree Kumaran Alloys,
S.F.No. 461, Telungupalayam Road,
Ellapalayam Post
Annur,
Coimbatore-641 697
63. M/s Yama Control Company,
Old No. 26, New No. 43A, P.N.Palayam Road,
Perumal Koil Thottam,
Ganapathy
Coimbatore-641 006

(As on 31/03/2011)

WELL-KNOWN FORGES

1. M/s. M.M. Forgings Limited, Plant I,
Singampunari-630502.
Singampunari District,
TAMILNADU.
2. M/s. Sadhu Forgings (P) Ltd.,
Plot No.140, Sector 24,
FARIDABAD.
3. M/s. Unity Forge Limited,
D-10, Maraimalai Nagar,
Kattangulathur-603 209.
TAMILNADU.
4. M/s. Vishnu Forge Industries Limited,
C-01/C-02 and A-24,
HMT Industrial Estate,
BANGALORE - 560031.
5. M/s. LGB Forge Limited,
(Formerly: M/s L.G. Balakrishnan & Bros.),
Plot No. 80 & 81, 5th Mile K.R.S. Road,
Metagalli Post,
MYSORE-570 016.
6. M/s Chaudhary & Sons(Forgings) Pvt. Limited,
Plot No. 4, Lal Kuan,
G. T. Road ,
Ghaziabad- 201 009
Uttar Pradesh
7. M/s. C.D. Engineering Company,
C-199, Bulandshahr Road,
Industrial Estate,
GHAZIABAD- 201 009
8. M/s. Steel & Industrial Forgings Limited,
Athani P.O. Mulankunnathukavu,
Thrissur Distt. Pin-680 771.
Kerala
9. M/s. MM Forgings Limited Plant 2,
Erasanayakanpatti,
Fathimanagar Post,
Viralimalai,
Pudukottai Distt.-621 316.
TAMILNADU
10. M/s Pradeep Metals Limited,
R-205, T.T.C. Industrial Area,
M.I.D.C. Rabale,
NAVI MUMBAI -400 701.

11. M/s Echjay Industries Private Limited,
Echjay Steel Division,
Lalpari Lake Road,
RAJKOT - 360 003.
12. M/s Ghaziabad Ispat Udyog Pvt. Ltd.,
C-89, Industrial Area,
Bulandshar Road, GHAZIABAD - 201 001.
13. M/s. Chaudhry Hammer Works (P) Ltd.,
Village Acheja, G.T. Road,
Greater NOIDA,
Distt. Gautam Budh Nagar,
UTTAR PRADESH
14. M/s Bharat Heavy Electricals Limited,
Heavy Electrical Equipment Plant,
Ranipur
HARDWAR-249 403
15. M/s ACME Forgings Pvt. Ltd.,
Rajkot-Gondal Highway,
P.O. T.B. Hospital,
RAJKOT-360002.
16. M/s Vikrant Forge Ltd.,
Maity Para,
Delhi Road, P.O. Dunkuni- 711 224,
Distt. Hoogly,
West Bengal.
17. M/s Vinir Engineering Pvt. Ltd.,
104, Bammasandra Industrial Area,
Bangalore - 560 099.
18. M/s. CD Industries,
Plot No.3, South of G.T. Road,
Industrial Area, Bulandshahr Road,
GHAZIABAD - 201 001.
19. M/s Hi-Tech Forgings (Bangalore) Pvt. Ltd.,
V-1(A), 3rd Cross,
Behind B-167/B-168, Peenya 1st Stage,
Peenya Industrial area,
Bangalore-560058.
20. M/s Sree Lakshmi Industrial Forge & Engineers Ltd.,
(Unit - II),
Plot No. 8, Attebelle Industrial Area,
Icchangoor Village,
Bangalore- 560 007
21. M/s. The Punjab Steel Works,
B-38, Mayapuri Industrial Area-Phase 1,
New Delhi-110064.

22. M/s. Kissan Steels (P) Ltd.,
B-12, Industrial Area No. 1,
Bulandshahar Road, Ghaziabad
U.P. - 201001.
23. M/s. Thillai Engineering Works,
161, SIDCO Industrial Estate,
Ambattur,
Chennai - 600 098.
24. M/s Anandmayee Forgings Pvt. Ltd.,
5A, Industrial Area,
Site-4, Sahibabad,
Distt. Ghaziabad - 201 010 (U.P.).
25. M/s. Omni Forge Private Limited,
No.2, Visveswaraiah Industrial Area,
BANGALORE - 560 048.
26. M/s Steel Smith,
C-168, Bulandsher Road Industrial Area,
Ghaziabad (UP)
27. M/s Kunj Forgings Pvt. Ltd.,
C-177, Buland Shahr Road, Industrial Area,
Ghaziabad - 201 001 (UP).
28. M/s AMW-AGM Forgings Pvt. Ltd.,
(Formerly: M/s MGM Forgings Pvt. Ltd)
Plant II, 82-84, 5th Mile, Metagalli Post,
Mysore - 570016.
29. M/s. Fivebros Forgings Pvt. Ltd.,
145-A, G.I.D.C. Industrial Estate,
Ankleshwar - 393 002
Gujarat.
30. M/s Bharat Heavy Electricals Limited,
Central Foundry Forge Plant,
Ranipur, Haridwar-249 403
Uttarakhand
31. M/s Alka Forgings,
C-20, Bulandshar Road Industrial Area,
Ghaziabad
Uttar Pradesh
32. M/s Hindon Forge (P) Lilited,
C-173, Bulandshahar Road Industrial Area,
Ghaziabad-201 001
Uttar Pradesh
33. M/s Metal Forgings Private Limited,
B 1, Mayapuri Industrial Area Phase I
New Delhi- 110064

34. M/s R.D. Forge,
(A Unit of R. D. Chemicals Pvt. Ltd.)
C-114, Bulandshar Road Industrial Area,
Ghaziabad- 201 009
Uttar Pradesh
35. M/s Lal Metal Forge Limited,
A-7/1/13, Electro Steel Casting Compound,
South Side of G. T. Road Industrial Area ,
Ghaziabad- 201 009
Uttar Pradesh
36. M/s Good Luck Engineering Co.,
Khasra No. 2839,
Gram Dhoom Manikpur,
G.T.Road, Dadri
Distt. Dautam Budh Nagar (U.P.)

WELL-KNOWN TUBE AND PIPE MAKER

1. M/s. Bharat Heavy Electricals Limited,
Unit Seamless Steel Tube Plant,
Tiruchirapalli-620014.
TAMILNADU
2. M/s Vallourec & Mannesmann Tubes,
V&M Deutschland GmbH, Wiesen Strasse 36,
45476 Muelheim an der Ruhr, Germany.
3. M/s Vallourec & Mannesmann Tubes,
V&M Deutschland GmbH, Ratherkreuzweg, 106,
D-40472 Duesseldorf, Germany.
4. M/s Vallourec & Mannesmann Tubes,
V&M Deutschland GmbH, Henkelstrasse, 209,
D-40599 Duesseldorf, Germany.
5. M/s Vallourec & Mannesmann Tubes,
Saint Saulve Tube Plant, Z I rue du Galibot, B P 2,
59880 Saint Saulve, France.
6. M/s Vallourec & Mannesmann Tubes,
Aulnoye Tube Plant, 64, rue de Leval B P 159,
59620 Aulnoye Aymeries, France.
7. M/s. Tata Steel Limited,
Tube Division,
P.O. Burma Mines
JAMSHEDPUR.-831 007
8. M/s. Maharashtra Seamless Ltd.,
Village Sukeli, NH 17,
B.K.G. Road, Taluka Roha,
Distt. Raigarh-402 126.
MAHARASHTRA.
9. M/s. ISMT Ltd.,
Plant B,
B-13, M.I.D.C., Baramati,
Distt. Pune – 413 133.
10. M/s Tube Products of India,
Post Bag No. 4,
Avadi,
CHENNAI – 600 054.
11. M/s. Tubos Reunidos Industrial S.L.U.,
Barrio Sagarribai 2,
01470 Ammurrio (Alava),
SPAIN.

12. M/s Jindal Pipes Ltd.,
22nd Mile, Delhi-Hapur Road,,
P.O. Jindal Nagar,
GHAZIABAD
13. M/s ISMT Ltd.,
C-1, MIDC Industrial Area,
Nagapur,
AHMEDNAGAR-414111.
14. M/s Ratnamani Metals & Tubes Ltd.,
SSTP Division, Survey No. 769,
Ahmedabad - Mehsana Highway,
Village Indrad - 382 729
GUJARAT.
15. M/s Ratnamani Metals & Tubes Ltd.,
Kutch Division, Survey No. 474,
Bhimsar Road,
Village Bhimsar - 370 201
Taluka Anjar, GUJARAT
16. M/s. Mahalaxmi Seamless Ltd.,
Pipe Nagar (Sukeli), Via Nagothane,
Tal. Roha, Distt. Raigarh,
Maharashtra-402126.
17. M/s. Tube Investment of India Ltd.,
Unit: Tube Products of India,
Shirwal P.O., Khandala Taluka,
Satara District,
Maharashtra - 412 801.
18. M/s Jindal Saw Ltd., (Seamless Tube Div),
Plot No. A-59/60, Malegaon MIDC,
Sinnar-422 113,
Dist. Nashik - Maharashtra.
19. M/s Dalmine S.p.A.-Dalmine Plant,
Piazza caduti 6 luglio 1944,
24044 Dalmine (Bnergamo)
Italy.
20. M/s Dalmine S.p.A.-Costa Volpino Plant,
Via Pio, 1,
24062 Costa Volpino (Bergamo)
Italy.
21. M/s Benteler Stahl/Rohr GmbH,
Residenzstrasse 1,
33043 Paderborn,
Germany.

22. M/s SC Mittal Steel,
Cordun Village, Roman-lasi Highway,
Km. 333, Neamt County, Romania.
23. M/s. CJSC Nikopolsky Seamless Tube Plant "NIKO TUBE",
56, Trubnikov Avel, Nikopol,
Dniepropetrovsk Region 53201,
Ukraine.
24. M/s CSJC Nikopol Tube Company (NTC),
56, Trubnikov Avel, Nikopol,
Dniepropetrovsk Region 53201,
Ukraine
25. M/s. Lalit Pipes & Pipes Ltd.,
Survey No.77,
Village Varaskol,
Khardi Railway Station (C.R.),
Tal. Shahpur, Dist Thane,
Maharashtra.
- 26 M/s Tube Products of India,
A-16-17, Industrial Area,
Phase - 6,
S.A.S. Nagar, Mohali,
Punjab - 160055.
27. M/s Remi Metals Gujarat Ltd.,
Plot No.1, GIDC,
Industrial Estate,
Jhagadia - 393 110,
Dist. Bharuch, Gujarat.
28. M/s Caparo Tubes India,
Steel Tube Road,
Dewas - 455 001,
Madhya Pradesh.
29. M/s Heavy Metal & Tubes limited,
101, Bileshwarpura,
Ta.: Kalol, Distt. Gandhinagar,
Gujarat
30. M/s Heavy Metal & Tubes limited,
138, Bileshwarpura,
Ta.: Kalol, Distt. Gandhinagar,
Gujarat
31. M/s Bhushan Steel Limited,
Vill. Nifan & Savroli,
Savroli-Kharpada Road,
Tal.: Khalapur, Distt. Raigad-410 202
Maharashtra

WELL KNOWN PIPE MAKERS

1. M/s Productos Tubulares S.A.U,
Carretera Galindora Ugarte s/n,
8510 - Valle de Trapaga,
(Vizcaya)
SPAIN.
2. M/s Surindra Engineering Co. Ltd.,
Surindra House, Safaid Pool,
M.V. Road, Andheri (East),
MUMBAI - 400072.
3. M/s Mukat Tanks & Vessels Pvt. Ltd.,
J-11/G-69, MIDC Industrial Area,
Tarapur, Distt.-Thane,
Maharashtra
4. M/s Ratnamani Metals & Tubes Ltd.,
SAW Pipe Division, Plot Nos. 3306 to 3309,
GIDC Estate, Phase IV
Ahmedabad - Mehsana Highway,
Village Chhatral, -382 729
Taluka Kalol, District Gandhinagar
GUJARAT.

(As on 31/3/2011)

WELL-KNOWN MATERIAL TESTING LABORATORIES

1. M/s. R.K. Inspection & Testing Services,
C-196/2, Mayapuri, Phase-II,
NEW DELHI-110064.
2. M/s National Test House,
11/1, Judges Court Road,
Alipore,
Kolkata-700 027
3. M/s National Test House,
Plot No. F-10, MIDC,
Marol, Andheri (E),
Mumbai-400 093
4. M/s IRC Engineering Services India Pvt. Ltd.,
A-53, Sector 63,
Noida
5. M/s Spectro Analytical Labs Limited,
E-41, Okhla Industrial Area,
Phase-II,
New Delhi-110 020
6. M/s National Test House,
Kamla Nehru Nagar,
Ghaziabad-201 002
Uttar Pradesh

WELL KNOWN REMNANT LIFE ASSESSMENT ORGANISATIONS

1. M/s Bharat Heavy Electricals Limited,
High Pressure Boilers Plant,
TIRUCHIRAPALLI - 620014.
2. M/s Tata Power Comp[any Limited,
Trombay Thermal Power Station,
Mahul Road, Chembur,
MUMBAI - 400074.
3. M/s. Thermax Babcock & Wilcox Ltd.,
D-1 Block, Plot No. 7/2,
R D Aga Road,
MIDC, Chinchwad,
PUNE 411019.
4. M/s. Central Power Research Institute,
Thermal Research Centre,
Chinchwara Road,
KORADI.-441 111
5. M/s. Central Mechanical Engineering Research Institute,
Mahatma Gandhi Avenue,
DURGAPUR-713 209
6. M/s. Utility Powertech Ltd.,
Reliance Energy Tower, 5th Floor,
A - 2, Sector 24,
NOIDA - 201301.
7. M/s. NTPC Alstom Power Services Pvt. Ltd.,
B-1, J-1, Mohan Cooperative Industrial Area,
Mathura Road,
New Delhi-110044.
8. M/s Energo Engineering Projects Pvt.Ltd.,
A 57/4, Okhla Industrial Area,
Phase-II,
New Delhi - 110 020.
9. M/s NDE Inspection,
50 - Fourth Cross, Raja Colony,
Collector Office Road,
Tiruchirapalli - 620 001.
10. M/s IRC Engineering Services India Pvt. Ltd.,
612, Chiranjiv Tower,
43, Nehru Place,
New Delhi - 110019.

11. M/s ALSTOM Projects India Limited,
Durgapur – 713206,
Distt.- Burdwan, (West Bengal)
12. M/s National Thermal Power Corporation Ltd.,
Research & Development Centre,
A-8A, Sector-24,
Noida, U.P.
13. M/s MECON Limited,
(In association with M/s National Metallurgical Laboratory,
Jamshedpur)
Doranda, Ranchi – 834002
14. M/s Electrical Research and Development Association,
ERDA Road, GIDC, Makarpura Industrial Estate,
Vadodara-390 010
Gujarat
15. M/s Evonik Energy Services (India) Limited,
A-29, Sector- 16,
Noida-201 301
Uttar Pradesh

.(TO BE STAMPED IN ACCORDANCE WITH STAMP ACT AND THE EXPIRY DATE OF BG MUST BE AFTER 60 DAYS FROM THE DATE OF COMPLETION OF WARRANTY PERIOD)

PERFORMANCE BANK GUARANTEE

In accordance of M/s. Bharat Heavy Electricals Limited (A Government of India undertaking, a company incorporated under the Companies Act 1956 having its Registered Office at "BHEL House", SIRI Fort, New Delhi 110 049) through its Industrial Valves Plant located at Goindwal Sahib, Distt. Tarn Taran- 142423 [Punjab] (hereinafter called 'the Company') having entered into a contract withhereinafter called ' the said contractor ' which term includes 'suppliers' for the purpose of this Bond and under the terms and conditions of the contract No..... Dt Between BHEL, Goindwal and as per the contract, the contractor / supplier is to furnish a performance Bank guarantee for Rs. for the due performance of the equipment to be supplied under the above referred contract and for the fulfillment of all the terms and conditions of the contract, We(indicate the name of the bank) (herein after referred to as the bank) at the request of (Contractor(s)) do here by undertake to pay the company an amount not exceeding Rs.....against any loss or damage caused to or suffered or would be caused to or suffered by the company by reason of any breach by the said contractor (s) of any of the terms and conditions contained in the said agreement.

2. We(indicate the name of the bank with full address), do hereby undertake to pay the amounts due and payable under this guarantee without any demur, merely on a demand from the Company stating that the amount claimed is due by way of loss or damage caused to or would be caused to or suffered by the Company by reason of breach by the said Contractor(s) of any of the terms and conditions contained in the said Agreement or by the reason of the contractor(s) 'failure to perform' the said agreement. Any such demand made on the Bank shall be conclusive as regards the amount due and payable by the Bank under this guarantee. However, our liability under this guarantee shall be restricted to an amount not exceeding Rs._____.

3. We undertake to pay unconditionally to the Company any money so demanded notwithstanding any dispute(s) raised by the Contractor in any suit, or proceedings pending before any Court or Tribunal or Arbitration or before any other authority relating thereto our liability under this present being absolute and unequivocal. The payment under this guarantee would not wait till the disputes have been decided by any Court or Tribunal or in the arbitration proceedings or by any other authority. The payment so made by us under this Bond shall be a valid discharge of liability for payment thereunder and the Contractor(s) shall have no claim against us for making such payment.

4. We.....(indicate the name of Bank), further agree that the guarantee herein contained shall remain in full force and effect during the period that would be taken for the performance of the said Agreement and that it shall continue to be enforceable till all the dues of the Company under or by virtue of the said Agreement have been fully paid and its claims satisfied or discharged or till _____Office / Department/ Division of the Company certifies that the terms and conditions of the said Agreement have been fully and properly carried out by the said Contractor(s) and accordingly discharges this guarantee.

5. (i) Unless a demand or claim under this guarantee is made on us in writing on or before the _____we shall be discharged from all the liability under this guarantee thereafter. But where such claim or demand has been preferred by the Company with the Bank before the expiry of the said date, the claim shall be enforceable notwithstanding the fact that the said enforcement is effected after the said date.

(ii) For the purpose of this clause, any letter making demand on the Bank by M/s. BHEL dispatched by Registered Post with Ack.Due or by Telegram or by any Electronic media addressed to the above mentioned address of the Bank shall be deemed to be the claim / demand in writing referred to above irrespective of the fact as to whether and when the said

letter reaches the Bank, as also any letter containing the said demand or claim is lodged with the bank personally.

6. We(indicate the name of Bank), further agree with the company that the Company shall have the fullest liberty without our consent and without affecting in any manner our obligations hereunder to vary any of the terms and conditions of the said agreement or to extend time of performance by the said Contractor (s) from time to time or to postpone for any time or from time to time any of the powers exercisable by the Company against the said Contractor(s) and to forbear or enforce any of the terms and conditions relating to the said Agreement and we shall not be relieved from our liability by any reason of any such variation or extension being granted to the said Contractor(s) or for any forbearance, act or omission on the part of the company or any indulgence by the company to the said Contractor(s) or by any such matter or thing whatsoever which under the law relating would, but for this provision, have effect of not so relieving us.
7. This guarantee will not be discharged due to the change in the constitution of the Bank or the Contractor(s).
8. It shall not be necessary for the company to proceed against the contractor before proceeding against the guarantor-bank and the guarantee herein contained shall be enforceable against them notwithstanding any security, which the company may have obtained or obtain from the Contractor shall, at the time when proceedings are taken against the guarantor hereunder be outstanding or unrealized.
9. Any claim or dispute arising under the terms of this document shall only be enforced or settled in the Courts at Tarn Taran, Punjab, India.
10. The guarantor hereby declare that it has power to execute this guarantee and the executant has full powers to do so on its behalf under the proper authorities granted to him/them by the guarantor.
11. We(indicate the name of Bank) lastly undertake not to revoke this guarantee during its currency except with the previous consent of the company in writing.

In witness whereof we....., (indicate the name of Bank) have hereunto set out Bank Seal the _____ day _____ month 200
BANK E-MAIL ID:
BANK PHONE NO.
BANK FAX NO:

LIST OF CONSORTIUM BANKS

Annexure: J

List of consortium bank for getting PBG released

Sl. No.	BANKS
1	STATE BANK OF INDIA
2	PUNJAB NATIONAL BANK
3	HDFC BANK
4	SYNDICATE BANK
5	CANARA BANK
6	INDIAN BANK
7	ST. BANK OF HYDERABAD
8	ICICI BANK
9	STANDARD CHARTERED BANK
10	UCO BANK
11	KOTAK MAHINDRA
12	ORIENTAL BANK OF COMMERCE
13	STATE BANK OF TRAVANCORE
14	CENTRAL BANK
15	IDBI BANK
16	FEDERAL BANK
17	HSBC LTD
18	DEUTSCHE BANK
19	CORPORATION BANK
20	CITI BANK
21	BANK OF BARODA
22	ABN AMRO BANK
23	UNITED BANK OF INDIA
24	VIJAYA BANK
25	UNION BANK OF INDIA
26	PUNJAB & SIND BANK
27	ANDHRA BANK
28	BANK OF INDIA
29	AXIS BANK



Product: Steel Castings for Boilers & Valves

Revisions record:

Rev. 21 – 1) Cl 8 – requirements of test bar added. 2) Cl 7 Table 1 – SV, SRV and QC NRV RT quantum for body casting modified. 3) Isolating valve, product name modified. 4) Cl 8 a) clarity on need for re qualification of castings added. 5) Cl 12 modified to include drawing details, 6) Cl 13.4 A – clarity to submit IBR certificate and MTC added.

Rev. 22- Dt: 26/06/2014 1) Cl 7.0 Table 1 –RT area of QCNRV body revised. 2) Cl.8.0 a) Modified. 3) Sketch of Zones of RT – RT zones of SV and SRV base castings modified based on Engineering review.

Rev. 23 Dt: 06/10/2015: Cl. 2, 4, 5, 6, 7, 8, 13, 15 modified to incorporate API 6D 24th Edition requirements.

Rev 24 Dt: 23/12/2015: Cl 1, 2, 3, 5, 6, 7, 8, 9, 10, 13, 14 & 15 modified.

Rev: 25 Dt: 11/02/2017: Cl 1 changed to indicate the use of latest revisions of referred codes, standards, specifications, drawings, procedures, etc; Requirements of API 6D removed from Cl 2, 4, 5, 7, 13 & 15 since the API 6D certificate license was not applied for; Definitions for relevant, linear and rounded indications provided in Cl 7; Cl 2 to 10, 12, 13 & 15 revised to bring better clarity; Type 3.2 certification updated as per BS EN 10204-2004 in Cl 13.2.

Rev: 26 : Dt – 21/02/2018 - SA/ASTM A 995 Gr 4A (CD3MN) added in Cl 1 & 5 based on Engineering/Valves input; Creep testing requirements removed and referred to SIP:RM:01.

1. MATERIAL SPECIFICATIONS:

All the codes, standards, specifications, drawings & procedures, etc., referred in this TDC shall be of latest revision as on the date of Enquiry/Purchase Order, whichever is earlier, unless specified otherwise.

Carbon Steel (CS)	:	SA / ASTM A216 WCB, WCC & 352 LCB, LCC
Alloy Steel (AS)	:	SA / ASTM A217 WC6, WC9, C12A.
Stainless Steel (SS)	:	SA / ASTM A351 CF3M, CF8, CF8C & CF8M; SA / ASTM 995 Gr. 4A(CD3MN)
Additional Requirement	:	As listed below (Supplementary to above material specifications)
Size, Quantity, Grade/Class	:	As per Purchase Order & Drawing / Pattern.

2. CHEMICAL COMPOSITION AND PROCESS:

a) Melting: As per the Specification, Fully Killed.

Carbon= 0.25% maximum: for SA / ASTM A216 WCB only.

Carbon= 0.15% maximum: for SA / ASTM A217 WC6 & WC9 (For the castings used in QCNRV, CRHNRV, TOA Valves & Conventional valves having contours for welding).

Product Analysis on test bar for each melt including residual elements shall be carried out.

b) All raw materials used in steel making including incoming scrap shall be checked by supplier to ensure freedom from radioactivity. (Applicable for SS material only)

c) Tolerance for chemistry shall be as per the above applicable material specifications/standards specified in Cl 1.

3. DIMENSIONS AND TOLERANCES:

Dimensions & their tolerances shall be as per applicable drawings. For untoleranced dimensions: VL: STDC: 023.

4. HEAT TREATMENT (HT):

CS – Castings of High Pressure Valve. (Cl.1500 & above), QCNRV & CRHNRV: Shall be in Annealed Condition.

AS – Castings: Normalized and Tempered.

Normalizing Temperature: SA/ASTM A217 WC6, WC9: 920-950°C and for C12A: 1050-1080°C.

Tempering Temperature: SA/ASTM A217 WC6: 680°C min.; WC9: 720°C min.; C12A: 750-780°C.

All other materials: Heat treatment shall be as per the applicable material specification & grade.

5. MECHANICAL TESTS:

a) Test bars to be cast integral with the casting or separately. If cast separately, they shall be cast at the same time as the castings and from the same ladle. A metal strip with heat number stamped shall be fused with the test bar during casting, to maintain traceability.

If one (1) casting is made from more than one heat, separate test bars for each cast to be poured and all test bars shall satisfy the requirements. Tests mentioned in Table 1 shall be conducted per heat / Heat treatment batch, as per ASTM A370.

Perform tensile tests at room temperature in accordance with the procedures specified in ASTM A370. Perform a minimum of one tensile test. All yield strengths shall be determined using 0.2 % offset method of ASTM A370. The results of the tensile test(s) shall satisfy the applicable material specification requirements. Hardness testing shall be as per ASTM E10 or E18.



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If the results of the tensile test(s) do not satisfy the applicable requirements, two additional tests on two additional test specimens (removed from the same TC with no additional heat treatment) may be performed in an effort to qualify the material. The results of each of these tests shall satisfy the applicable requirements.

Table 1.

No	TEST	MATERIAL SPECIFICATIONS			
		SA/ASTM A216, 217	SA/ASTM A352	SA/ASTM A351	SA/ASTM A995
1	Tension Test	As per the Material Specification			
2	Hardness Test	As per the Specification	225 HBW max.	Not applicable	<i>Not Applicable</i>
3	Bend Test Specimen 1" x 3/4"		Not applicable	S3 of SA703	<i>Not applicable</i>
		Bend Angle			
		WC6			
		WC9			
		C12A			
4	Charpy- U Impact for all QCNRV, CRHNRV bodies for IBR.	As per IBR. At Room temperature. Acceptance: Avg /Single=36J/32J min.	Not applicable	Not applicable	<i>Not applicable</i>
5	Charpy- V Impact for CE Marking-Pressure Equipment Directive (PED) items as Specified in the Purchase Order.	At 20 Deg.C temperature. Acceptance:Avg/Single=40J/27J min.	As per Specification	Not applicable	<i>Not applicable</i>
6	Charpy- V Impact for LPBP bodies	At 20 Deg.C temperature. Acceptance: Avg/Single=27J/21J min.	Not applicable	Not applicable	<i>Not applicable</i>

b) Creep testing & reporting shall be carried out as per SIP:RM:01 (latest revision) whenever indicated in the Enquiry/Purchase Order/Engineering Drawing.

6. FETTLING, DRESSING & CLEANING:

- Dressing of castings-Free from risers, in gates, notches, undercuts, deep marks etc.
- Fused wires, parting line fins, chills etc. shall be removed by grinding.
- Gas cutting if employed shall be done before Heat treatment.
- Preheat the material to 200°C before gas cutting the Alloy steels.
- Castings shall be blast cleaned both inside and outside for the removal of fused sand, scales etc.
- Visual inspection: 100% as per MSS-SP:55. Acceptance: Type 1: none accepted; Type 2-12: A & B only accepted.

7. NON DESTRUCTIVE TESTING (NDT) AFTER HEAT TREATMENT

The NDE requirements for the castings shall meet the following as shown in Table-2 below. Castings shall be free from surface and internal defects like porosity, shrinkage, sand inclusion, crack, cold shut and other harmful defects. All castings shall be of Radiographic Quality.

1. Radiographic Testing Procedure (RT) : As per ASME B 16.34
2. Magnetic Particle Inspection (MPI) : As per ASTM E709
3. Liquid Penetrant Inspection (LPI) : As per ASTM E165

Table: 2

Product	Components	Characteristics	Type of NDE Check				
			RT	RT Area	RT Acc. Std	MT \$	MT Area
Conventional Valves (Gate, Globe & Check)	Body, Bonnet Pr.part yoke, Cover	< 600 Class	10%#	ASME B 16.34 / On critical area as indicated in the Drawing.	As per Table: 3	--	--
	Body, Bonnet, Cover	600 Class & above	100%			--	
	Body, Bonnet, Cover	1500 Class & above	100%			100%	All accessible surfaces
	Wedge	All Special Class Valves	--			100%	



Product: Steel Castings for Boilers & Valves

							including belly.
Safety Valve	Base	Flanged ends of All Castings	100%	Critical Zones as given in the Drawing/ area shown in the sketch below . The areas where RT cannot be carried out MPI shall be done.	Class 2 of ASTM E446 / E186. For Butt weld ends as per Table- 3	100%	All accessible surfaces
		Weld ends of All Castings	100%			--	--
Safety Relief Valve	Base	All	100%		Class-2 of ASTM E446 / E186.	--	--
	Bonnet		10%#			--	--
	SRV Nozzle	All	100%	All area		--	--
QC NRV, CRH NRV	Body	150 & 300 Class	100%	Butt Weld Ends	As per Table: 3	100%	All accessible surfaces including belly.
		600 Class & above	100%	Critical Zones as given in the Drawing/ area shown in the sketch below. The areas where RT cannot be carried out MPI shall be done.	As per Table: 3	100%	
	Body (Special)	All					
Soot Blower Valve	Body	All	10%#	Critical Zones as given in the Drawing/ area shown in the sketch below. The areas where RT cannot be carried out MPI shall be done.	As per Table: 3	--	--
Isolating Valve/ device	Body	< 600 Class	100%	Critical Zones as given in the Drawing/ area shown in the sketch below. The areas where RT cannot be carried out MPI shall be done.	As per Table: 3	--	All accessible surfaces including belly.
		600 Class & above				--	
		1500 Class & above				100%	
LP Bypass Valve	Body	All	100%	Critical Zones as given in the Drawing/ area shown in the sketch below. The areas where RT cannot be carried out MPI shall be done.	As per Table: 3	--	--

\$ LPI can be substituted for MPI in all inaccessible area and for stainless steel castings # Refer Cl 7.1

Table: 3

Type Of Discontinuity	Acceptance Level Category	< 600 CLASS		≥ 600 CLASS	
		Thickness ≤2"	Thickness >2"	Thickness ≤2"	Thickness >2"
Gas Porosity	A	A2	A3	A1	A2
Sand/Slag inclusion	B	B3	B3	B2	B2
Shrink Type-1	C	CA2	CA3	CA1	CA2
Shrink Type-2	C	CB3	CB3	CB2	CB2
Shrink Type-3	C	CC3	CC3	CC2	CC2
Crack	D	NONE	NONE	NONE	NONE
Hot Tear	E	NONE	NONE	NONE	NONE
Un-fused Inserts (Chills/Chaplets)	F	NONE	NONE	NONE	NONE
a. Butt welding ends shall be free of shrinkage, crack & hot tear. b. For butt weld ends Gas hole/Porosity and sand inclusions to be within level A1 & B1 respectively					

NDE for SS material: Castings shall be checked for radioactive contamination and reported. Survey meter shall be used to measure near the surface. Acceptance limits: Shall be less than 0.1 milli Rontgen (MR) per hour or 1 micro Sievert per hour.



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7.1 # 10% Sampling shall be done as follows: (Wherever specified): The vendor shall select 10% of the Casting from the lot consisting of same size and type, (along with melt number / Sl.nos of the castings covered in the lot) for Radiography. A lot to be specified as the total number of castings as above, supplied in 4 months period (Jan-Apr, May-Aug, Sep-Dec). The vendor shall radiograph these specified castings and incorporate the lot size and melt no and Sl.no in the RT reports along with the other Sl.nos of the other castings covered in the lot. If the identified casting is defective then 2 more castings shall be radiographed. If these 2 castings are defect free then the lot is acceptable. If any one of these castings is defective then all the remaining castings shall be radiographed and all defective areas shall be repaired. BHEL will carry out audit on the lots at the vendor works at any time.

7.2 Surface NDE (MPI & LPI): Testing as per ASME B16.34.

1. **Relevant indication: Surface-rupture NDE indication with major dimensions > 1.6 mm (1/16 in).**
 2. **Linear indication: Surface NDE indication whose length is $\geq$ three times its width.**
 3. **Rounded indication: Surface NDE indication whose length is < three times its width.**
- Acceptance for MPI & LPI:**
4. Cracks are not permitted.
 5. For linear indications other than cracks, indications must be separated by a distance greater than the length of an acceptable indication. Maximum allowable length of the indication shall be:
 - a) For thickness(t) up to 13mm = 8mm,
 - b) For thickness from 13 to 25mm = 13mm
 - c) For thickness above 25mm = 18mm.
 6. For rounded indications, 4 or more indications in a line separated by 1.5 mm or less edge to edge are unacceptable. Maximum allowable diameter of the indication shall be:
 - a) For thickness up to 13mm = 8mm
 - b) For thickness above 13mm = 13mm

8. DEVELOPMENT STAGE OF CASTING:

- a) During developmental stage, of new castings or change to an existing casting on account of change in dimension which warrants pattern correction, Foundry to ensure, first sample pieces meet dimensional, NDE & Quality requirements in this TDC, before starting bulk production. Sample castings, 3 castings with nominal bore (NB) $\leq$ 100mm. & 1 casting with NB > 100 mm for each type shall be inspected for dimension and RT requirements at BHEL/Vendor works by BHEL personnel. One Test bar for each melt/heat treatment batch shall be supplied along with casting for test at BHEL. RT shall be carried out on entire area of the casting to the acceptance requirement of Table-2 & 3. In addition 100% MPI on all critical areas like change of sections, riser & in gate portions shall be carried out. Casting to be inspected for dimensions after proof machining wherever necessary. If machining operation is involved the same shall be done and defect free condition shall be ensured. If any defect noticed in RT and machining, the type of defect shall be analyzed and accordingly size of gate, runner, riser and pouring methodology to be modified to get defect free casting. Sampling shall be continued till achieving sound casting. After satisfactory development of sampling bulk production shall be started. However weld repaired areas identified in visual examination for doubtful indications to be probed by MPI. Accepted sample castings may be considered for fixing the nominal weight of the castings.
- b) During developmental stage RT on sample castings of Yoke, Yoke Clamp & Wedge/Disc shall meet Level-3 of ASTM E446/E186/E280.
- c) Radiography not required after satisfactory development of casting & production based on established method for following parts: SRV Bonnet, Disc Holder, Upper and Lower adjusting rings, Packed cap, Cover Plate, Yoke and SRV guide flanges.

9. REPAIR:

Castings with unacceptable cracks, hot tears, shrinkage, etc. to be rectified by grinding & if required by welding. Welding to be done by qualified welder and qualified procedure as per ASME Section IX. For IBR items welders shall be qualified as per IBR.

Guidelines for repair of steel castings shall be as per SIP:VS:17 for activities like defects require/ not require weld repair, welding, Post Weld Heat Treatment, NDE and surface treatment. All repaired areas after PWHT shall be NDE tested and Hardness tested. Hardness shall meet material specification.

For PED (CE-Marking) castings, permanent joining (welding and weld repair) of components must be carried out by suitably qualified personnel according to suitable operating procedures. Also Non-Destructive tests of permanent joints must be carried out by suitable qualified personnel.

The procedures and personnel must be approved by a competent third party which at the manufacturer's discretion, may be - A notified body, - A third party organization recognized by a Member State of European Community.

	BHEL – Tiruchirappalli - 620014, India. Quality Assurance Department TECHNICAL DELIVERY CONDITIONS	DOC No: TDC:0:412 Rev: 26 Effective Date: 21/02/2018 Page: 5 of 7
Product: Steel Castings for Boilers & Valves		

10. SURFACE TREATMENT:

SS castings to be pickled & passivated (after repair & HT if any) as per ASTM A380. Satisfactory passivity of the surface to be checked using SS passivity test kit (Free iron test). After passivation, rinsing & test, the rinsed demineralised water to be checked for chloride with 1% Silver nitride, which shall not exceed 0.5 PPM.

11. DIMENSIONAL CHECK:

For all QCNRV & CRHNRV Body Castings: Thickness of the body shall be checked throughout the surface on a grid of 100mm x 100mm and recorded & submitted to BHEL.

12. MARKING AND PACKING:

Representation of Marking and identification shall be as per drawing. Also following details to be marked on each casting, on a raised pad using low stress stamps and Castings shall be suitably packed to avoid damage during transit.

1. Foundry code, 2. **Material** specification, grade & **Heat**/melt number, 3. Size and 4. Class rating.

13. INSPECTION AND CERTIFICATION:

13.1 For IBR items:

Products shall be inspected at works and the applicable IBR Form must be countersigned by the Inspecting Authority as indicated below in case the shop/**mill/foundry** is not recognised as a "Well known Foundry" under IBR:

- ☐ **Imported Items:** Inspecting Authority approved by IBR for the Country of origin.
- ☐ **Indigenously Supplied items:** Director of Boilers/Chief Inspector of Boilers/Inspecting Authority approved by IBR, for the respective state.

Certification in IBR Form III-F for IBR items from "IBR-Well Known Foundry" or "Inspecting Authority", as applicable, to be submitted. IBR Form III-F & **separate** Test certificate in English language with following details, shall accompany the product:

1. Purchase Order No. (BHEL), TDC No & its revision no, Test certificate no & date.
2. **Material** Specification, Grade & **Class** with applicable year of code, Heat Number, Quantity & Size
3. Steel making process, Chemistry including incidental elements - Heat wise, Product analysis, Carbon Equivalent (CE).
4. Heat treatment details of the material and test bars.
5. Mechanical test results-Tensile (UTS, YTS (**0.2% offset**), % elongation, % reduction in area), Impact & Hardness and NDE test results with reference & acceptance standard.
6. Repair details including HT, if any, Cleaning & Surface treatment details.
7. Any other information like clearance of sample casting.
8. Dimensional Inspection Report, where applicable.
9. **For SS:** Measured Radioactivity levels at 5cm from the surface of the castings shall be reported in the Test Certificate stating the measured value at the specified distance (not to be recorded in IBR Form).
10. **Creep test report as per the format suggested in Cl 5 of this TDC (applicable only for IBR application).**

13.2 For PED 2014/68/EU (CE-marking), test certificates of type 3.1 or 3.2, with details specified in Cl 13.1 for separate test certificate, shall be submitted as per BS EN 10204.

- ☐ Type 3.1 – Suppliers shall have ISO 9001-2008/2015 certification certified by Notified Body recognized by European community and test certificate certified by suppliers authorized inspection representative.
- ☐ Type 3.2 – Components inspected and test certificates certified by both the supplier's authorized inspection representative and Notified Body recognized by European community.

14. AUDIT CHECKS AT BHEL:

BHEL reserves the right to carry out audit checks for chemistry, HT condition, mechanical test and NDT on representative test bars or job. Items found defective during check or subsequent processing at BHEL will be rejected.

15. END USE:

For use in valves and other components like flanges, fittings etc. for high temperature & high pressure applications meeting IBR, ASME Section I, ASME B 16.34 and PED 2014/68/EU (CE-marking).



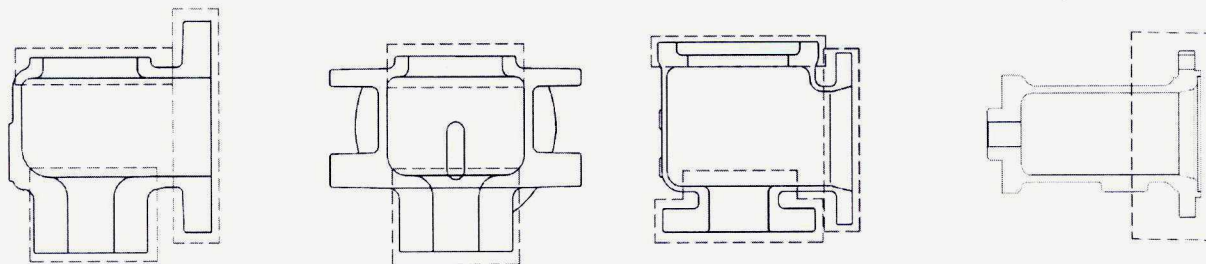
Product: Steel Castings for Boilers & Valves

Sketch of zones for RT

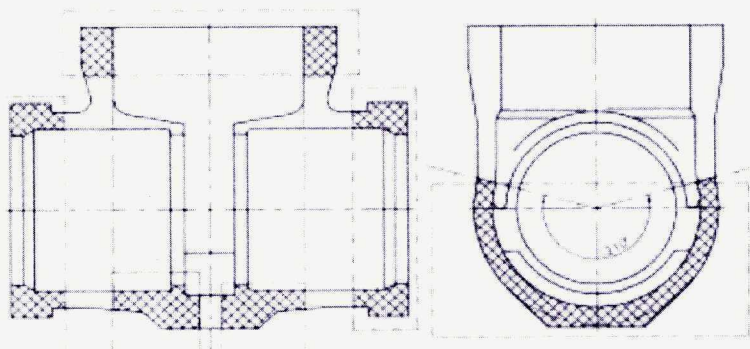
SV and SRV Base castings

Base

Bonnet

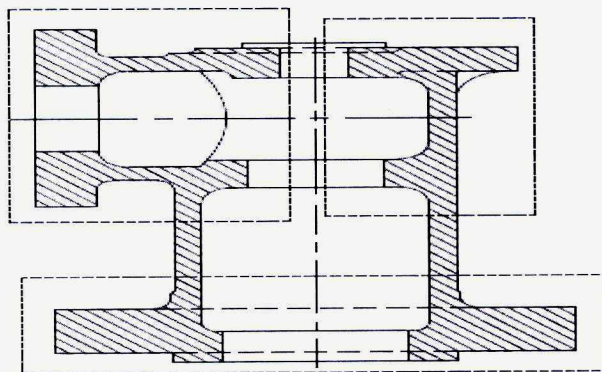


Reheater Isolating Device Body



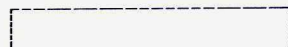
 Radiography Area

Soot Blower Valve Body



PART CODES : 920243870000, 920131810000, 920243870100, 920131810100

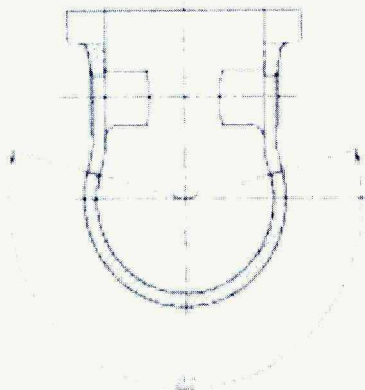
LRD IE, LRD IIE & WB IE - 2.5" 600#

 — RADIOGRAPHY AREA

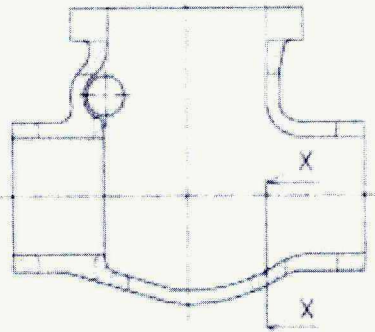
Quick Closing Non Return Valve Body



Product: Steel Castings for Boilers & Valves

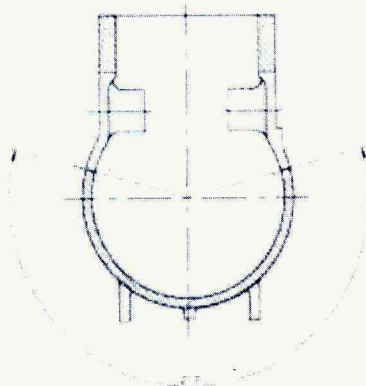


Section-XX

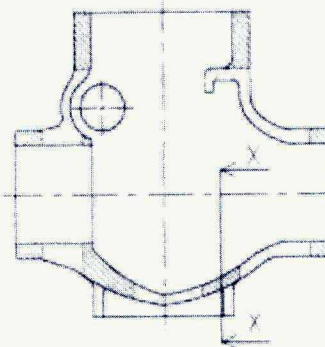


Radiography Area

Cold Reheat Non Return Valve Body

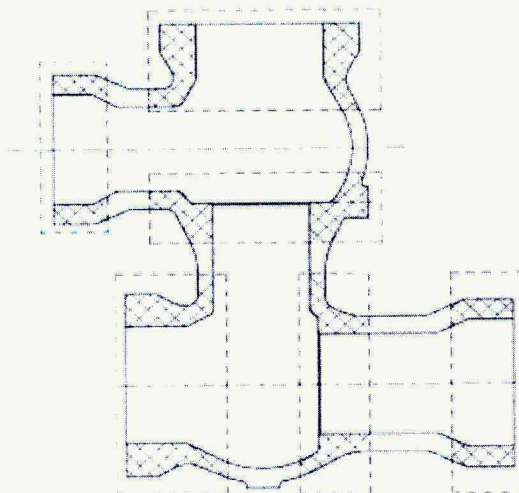


Section-XX



Radiography Area

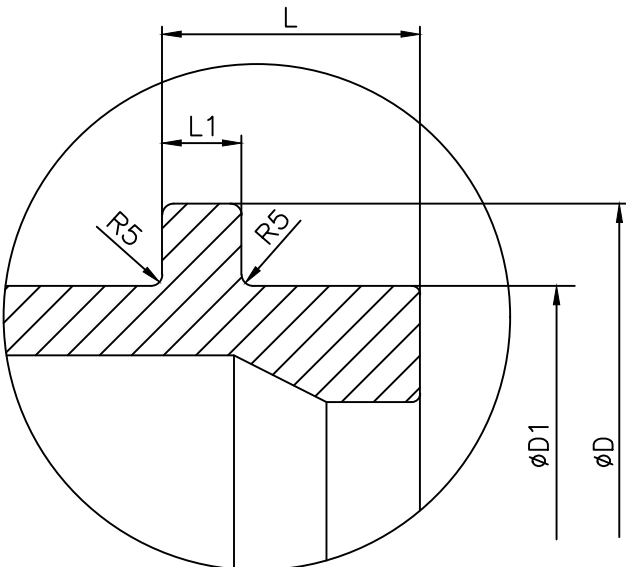
LP Bypass Stop cum Control Valve Body



Radiography Area

<i>R. Venkanna</i> 21/02/2018	<i>G. Panneer Selvam</i> 21/02/18	<i>K. Rajasekaran</i> 21/02/18	<i>R. Ananthakrishnan</i> 21/02/18	<i>Amit Roy</i> 21/02/18
Venkanna Rupani	G. Panneer Selvam	K. Rajasekaran	R. Ananthakrishnan	Amit Roy
Sr.Engineer /QA	DGM/QA	SM/Valves/Engg	AGM/Valves/Purchase	AGM/QA&BE
Prepared By	Reviewed By			Approved By

8909Z-0000-A-3
DRAWING NO.

SL. No.	DRAWING NUMBER	DIMENSIONS				CASTING DRAWING NUMBER	SIZE/RATING/TYPE	SL. No.	DRAWING NUMBER	øD	DIMENSIONS				CASTING DRAWING NUMBER	SIZE/RATING/TYPE
		øD	øD1	L	L1						øD	øD1	L	L1		
01.	3-V-Z022-25058	504	458	83	38	2-V-Z022-17267R	16"-C300-FV	19.	3-V-3393-25058	863	796	112	68	2-V-3393-14082R 2-V-3313-14082R	30"-C600/C900-RHID	
02.	3-V-Z021-25058	605	546	108	33	2-V-Z021-17266R	20"-C150-FV	20.	3-V-NF97-25058	788	725	88	65	2-V-NF97-05228R	26"-C300-GV	
03.	3-V-N370-25058	605	545	95	33	1-V-N370-05124R	20"-C150-GV	21.	3-V-NH51-25058	496	474	57	38	1-V-NH51-05254R	16"-C300-RV	
04.	3-V-N595-25058	660	555	74	38	1-V-N595-05144R	20"-C300-GV	22.	3-V-NH57-25058	496	475	57	44	1-V-NH56-05255R	16"-C600-RV	
05.	3-V-N788-25058	660	555	74	38	1-V-N788-05144R	20"-C300SPL-GV	23.	3-V-NH50-25058	456	425	63	44	2-V-NH50-14808R	14"-C600-RV	
06.	3-V-N805-25058	710	652	97	28	1-V-N805-05158R	24"-C150-GV	24.	3-V-N929-25058	932	864	82	46	1-V-N929-05185R	32"-C150-GV	
07.	3-V-NG24-25058	602	500	74	38	2-V-NG24-14547R	18"-C300-GV									
08.	3-V-NE96-25058	710	610	74	38	2-V-NE96-14220R 2-V-NE97-14220R	22"-C300-GV									
09.	3-V-Z023-25058	450	391	82	38	2-V-Z023-17268R	14"-C300-FV									
10.	3-V-NG27-25058	602	480	85	38	2-V-NG27-14618R	18"-C300-FV									
11.	3-V-P366-25058	368	335	56	33	1-V-P366-05211R	10"-C300-RV									
12.	3-V-N594-25058	504	453	76	38	1-V-N594-05143R	16"-C300-GV									
13.	3-V-P560-25058	405	365	56	33	1-V-P560-05251R	12"-C300-RV									
14.	3-V-P538-25058	415	385	74	44	2-V-P538-14465R	12"-C600-RV									
15.	3-V-N593-25058	450	400	75	38	1-V-N593-05142R	14"-C300-GV									
16.	3-V-N589-25058	430	385	74	28	1-V-N589-05139R	14"-C150-GV									
17.	3-V-N590-25058/1	497	440 _A	75	28	1-V-N590-05140R	16"-C150-GV									
18.	3-V-N575-25058	537	490	75	28	1-V-N575-05136R	18"-C150-GV									

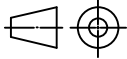
-	-	-	-	-	-	-	-	-
NO.				HEAT	SCRAP	NET	GROSS	

NOTE

01. ALL OTHER DIMENSIONS ARE TO BE MAINTAINED AS PER THE RELEVANT CASTING DRAWING (LATEST REV.).

REV	DATE	ALTERED RAVI PRATAP SINGH	REV	DATE	ALTERED T.SANGEETHA
06	20.10.18	CHD & APPD SSK & KRS	04	06.06.17	CHD & APPD SSK & KRS
IN SL No. 17 DIMENSION 440 WAS 450.			SL. No. 24 INCLUDED.		
05	08.12.17	CHD & APPD SSK & KRS	DIMENSION 33 WAS 28 IN IN SL No. 2 & 3.		

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.

-	-	-	-	-	-	-	-	-	-
NO OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
 365-121					DRN	NAME	SIGN	DATE	NO.OF VAR.
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.					CHD	S.SATHEES		22.07.11	
					APPD	M.RAJAKUMAR		22.07.11	
DEPT VL			SCALE	WEIGHT (KG).	REFERENCE INFORMATION				NO. OF ITEMS
CODE 320			NTS	REFER TABLE	CAD :F324178				
TITLE						CARD CODE	DRAWING NO.		REV
BODY TEST COLLAR (CASTING)						U 01	3-V-0000-25058		06