

ANNEXURE - B

QUALIFYING CRITERIA FOR THE MANUFACTURERS FIRST TIME SUPPLYING BLADE FLATS TO BHEL HYDERABAD

All the first time suppliers of the blade flats to BHEL Hyderabad shall confirm / fulfill the following conditions:

1.0 MANUFACTURING AND TESTING FACILITIES:

The details of the manufacturing and testing facilities of the Mills / manufacturer shall be submitted in the format enclosed as Annexure-C for assessment by BHEL.

2.0 FIRST PIECE QUALIFICATION / PROCESS QUALIFICATION:

The first time suppliers shall explicitly confirm their acceptance for the first piece qualification / process qualification as specified in HY10764 Rev.09 & HY10766 Rev.09 which will be applicable to each size of blade flat before supplies.

Note: If any of the suppliers are able to submit the evidences of their supplies of Steam turbine blade flats (of the same material grade and sizes as mentioned the present enquiry) to M/s Siemens, they can be considered for the waiver of first piece qualification / process qualification for the same grade and size of the flat for BHEL requirement. The evidences (like material test certificates along with order copy) shall not be more than 5 years old from the date of issue of this enquiry.

3.0 CREEP TESTING OF THE PILOT LOT:

All the manufacturers who are required to carry out Process Qualification / First piece qualification as per Clause 2.0 above shall explicitly confirm their acceptance for carrying out creep tests on the two samples each of the first lot of each size of the blade flats of material X22 Cr Mo V 121 (HY10766 Rev.09) as per the following test parameters.

No. of samples to be tested :	Two
Test temperature :	600 Degrees C.
Stress :	180 MPa
Minimum time before rupture :	200 hrs.

4.0 INSPECTION OF THE FIRST LOT OF EACH MATERIAL GRADE AND SIZE OF THE BLADE FLATS:

Inspection of the first lot of each material grade and size will be carried out in the presence of BHEL Hyderabad representative in addition to any other TPIA as per order conditions. A QAP shall be submitted along with the technical offer for review and acceptance by BHEL.

5.0 PAST EXPERIENCE:

The manufacturers who are having adequate experience of manufacturing and supplying blade flats for steam turbine applications will be considered for the present enquiry.

Evidences (such as copy of manufacturer's test certificates) meeting the requirement of BHEL specifications of the supplies in last five years from the date of issue of the present BHEL enquiry shall be submitted for review and acceptance by BHEL.

ANNEXURE -C

DETAILS OF THE MILLS SUPPLYING BLADE FLATS FOR THE FIRST TIME TO BHEL HYD

BHEL ENQ. NO. :

DATE:

1.0	ORGANISATIONAL INFORMATION		BHEL REMARKS
1.1	MILL NAME :		
1.2	HEAD OFFICE ADDRESS: TELEPHONE NO. WEB SITE		
1.3	FACTORY / WORKS ADDRESS: TELEPHONE NO. E-MAIL (of the chief contact person)		
1.4	BRANCH OFFICE / MARKETING OFFICE ADDRESS TELEPHONE E-MAIL(of the chief contact person)		
2.0	MANUFACTURING FACILITIES:		
2.1	MELTING FACILITIES :	CAPACITY / SIZE	
2.2	HOT / COLD ROLLING FACILITIES	CAPACITY / SIZE	
2.3	HEAT TREATMENT FACILITIES (INCLUDING QUENCHING FACILITIES)		
2.4	TESTING FACILITIES:		
	TESTING FACILITY	EQUIPMENTS/MACHINES	CAPACITY / SIZE
2.41	CHEMICAL		
2.42	MECHANICAL TEST		
2.43	MPI/DP		
2.44	ULTRASONIC TEST		
2.45	OTHER FACILITIES		
3.0	MILLS PAST EXPERIENCE / CREDENTIALS		
3.1	CUSTOMER REFERENCE LIST OF SAME ITEMS		
3.2	MILLS PRODUCTION RANGE (SIZE AND MATERIAL GRADES)		
3.3	COPY OF VALID ISO 9000 CERTIFICATE FOR THE MILL		
3.4	ANY OTHER INFORMATION LIKE REGISTRATION / SUPPLIES TO SISTER UNITS OF BHEL WITH EVIDENCES (OPTIONAL INFORMATION)		

Note:

- 1) The above data shall be furnished / certified by the manufacturer or mill only. Data certified by any other agencies will not be accepted
- 2) Any of the process / operation is sub-contracted, shall be mentioned by giving the details of the facilities and tie - up letter.
- 2) Mills catalogues shall also be provided
- 3) The above information will be used for scrutinizing the technical offers for the above mentioned enquiry

SIGNATURE AND COMPANY STAMP OF THE MILL