

QUALITY REQUIREMENTS

Following are the terms and conditions for the suppliers of M.S. Casings to BHEL IP, Jagdishpur. Each and every supplier participating in Rate Contract shall go through this T&C document thoroughly and Participate in RC as per their Facilities and Process Maturity in line with this document. Supplier has to submit documentary proof/present physically of all requirements as and when required by BHEL.

RAW Material

M.S. Sheet:-

- As per BHEL Drawing
- Receipt and Issue to be maintained in prescribed format of BHEL (As attached)
- Test certificate of material will be required along with every dispatch of M.S. Casing.

Welding Electrode: - As per latest revision of document no. E&D 330 section 04.

- Photo copy of invoices for procurement of welding rod / flux core wire will be required against every procurement.

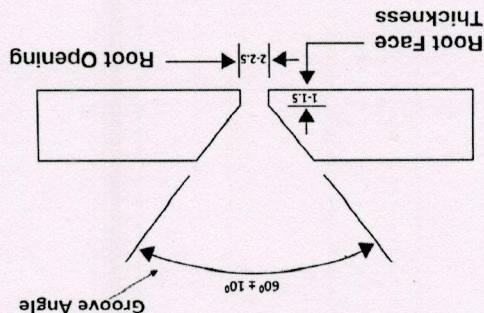
Paint: - As per latest revision of document no. E&D 330 section 05.

- Any other painting requirement will be indicated in drawing / painting scheme. It will be provided by BHEL separately.
- Photo copy of invoices for procurement of paint will be required against every procurement.

Fabrication/In Process

Fabrication of M.S. Casing:

- Strictly as per BHEL Document E&D 306 (Latest revision) and BHEL Drawing.
- Proper fit-up is to be maintained.



Welder Qualification:

- Once in every Year for each welder to be done strictly as per AWS D-1.1 by a third party NABL Accredited Lab. On lack of valid welder qualification certificate Casing manufacturing may be hold by BHEL till submission of same.

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Welding/Hard facing: - Strictly as per BHEL Document E&D 330 section 04 (Latest revision) and BHEL Drawing.

- Proper Penetration Required
- No Grinding on Weld bead allowed
- Grinding of all gas cut portion to be ensured (including lifting lug)

Machining:

- Surface roughness of 6.3 micron or as specified in drawing to be achieved at complete machining portion.
- Grinding/welding is strictly prohibited on machined portion.

Painting: - Strictly as per BHEL Document E&D 330 (Latest revision) and BHEL Drawing.

- Power Tool cleaning (SSPC-SP3) or Abrasive Blast cleaning for removal of dust, rust, slag, spatters, oil, grease etc. before painting is must
- No thinner to be added in paint.
- Rusting of received material at BHEL IP will be treated as use of poor paint/process and the same will be out rightly rejected or Repainting will be done on the risk and Cost of supplier on the discretion of BHEL.
- Any other painting requirement will be indicated in drawing / painting scheme. It will be provided by BHEL separately.

Mandatory Instruments for Inspection

1. Duly spirit leveled surface plate (Min thickness 50 mm).
2. One meter Right Angle (Tri square).
3. 01 meter height gauge.
4. 02 nos. Vernier Caliper one (Range 0-1000 mm) other (0-300 mm)
5. 02 nos. Measuring Tape one (0-3000mm) other (0-5000mm).
6. Ultrasonic wall thickness gauge (i.e. D' meter)
7. Digital Coating thickness gauge for checking thickness of paint
8. Feeler gauge
9. spirit level
10. 01 meter scale.
11. Plumb Bob.
12. Any kind of other instrument as per requirement of BHEL shall be arranged by the supplier within 10 days of requirement.

- All above Instrument's Calibration should be traceable to NABL
- BHEL has reserved the right to stop inspection in case of unavailability of above instruments

Optional Instruments

1. Digital Surface roughness gauge for checking the roughness of machined parts.
2. Hardness tester for checking the hardness of hard facing.
- All above Instrument's Calibration should be traceable to NABL
- Clearance will be subjected to final inspection at BHEL.
- Party has to rectify / replace the casing if the casing is not manufactured as per drawing & it is observed at BHEL's customer site.

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BHEL Inspection/Audit

Suppliers must have to raise their inspection call along with their internal inspection report. Inspection of MS Casings /items at root stage / Final stage will be carried out by BHEL representative /Third party at party's works. However final inspections will be carried out at IP, Jagdishpur.

The inspection of MS casing/items at root stage / final stage against any PO may be waived off for full / part quantity on BHEL discretions.

BHEL Authorized representative/ Inspectors will have right of inspection/Audit/Photography of BHEL product at any supplier's Premises without prior notice.

Documentary evidence of compliance of all clauses to be maintained/presented to BHEL whenever asked for.

In case of violation of any clause of this document BHEL Reserves the right to out rightly reject/ Hold for Rectification/Rectify at risk and cost of Supplier. BHEL also reserves the right to cancel the Purchase order or perform Risk Purchase.

In case of Rejection of casing at BHEL / BHEL's ultimate customer premises, supplier has to replace/rectify them within 07 days of notice otherwise same will be replaced/rectified by BHEL (if possible) at the risk and cost of supplier and replacement / rectification charges will be deducted from supplier's pending / future bills. Rejection of above material will also be reflected in vendor performance rating.

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Ref No.					
M/s. Bharat Heavy Electrical Limited					
Insulator Plant, Industrial Area Jagdishpur Amethi					
Kind Attention-					
Invoice No.					
Invoice Date					
Sub - Material used against order No. Dt.					
Dear Sir,					
With reference to above order, we are submitting our material test certificate for following material used in manufacturing of M.S casing.					
SI. No.	Plate Thickness	T.C. No.	Opening Balance	Material Consumption	Closing Balance
Authorised Signatory					

Date