



BHARAT HEAVY ELECTRICALS LIMITED
INDUSTRIAL VALVES PLANT
433, INDUSTRIAL COMPLEX
GOINDWAL SAHIB
DISTT. TARN TARAN- PUNJAB – 143422

No.BHEL:IVP:
SC:SP:AD
2019-20/02
Dated
03.02.2020

NOTICE INVITING APPLICATIONS FOR REGISTRATION OF SUB CONTRACTORS

BHARAT HEAVY ELECTRICALS LIMITED [BHEL] is manufacturing Industrial Valves and other Boiler accessories at its Industrial Valves Plant, Goindwal Sahib unit. For financial year 2020 we have to manufacture 2000 MT. Post machining of the component; certain special processes such as chrome plating, are required to be completed to achieve the desired specification.

Expression of interest and applications for registration are invited from sub-contractors (BHEL encourages procurement from Micro and Small Enterprises (MSEs), MSEs are requested to apply for registration) for doing the chrome plating, nickel plating, cadmium plating, phosphating, nitriding/tuffriding, heat treatment etc.

Special processes

Indicative list of components on which plating or other processes are required to be done is attached herewith as Annexure-I. Sample drawings of some components are also attached. (S.No of list – 35 and 56)

BHEL is looking for prospective Sub Contractors for above job work.

BHEL shall evaluate the vendors as per its established vendor selection, evaluation and registration procedure. Supplier Registration can be done online <https://supplier.bhel.in/>

BHEL invites such vendors to visit its above located plant on any working day from Monday to Saturday between 0900 Hrs to 1730 Hrs and contact undersigned for any clarification regarding:

Items details and requirement		Vendor registration form/procedure
Vineet Kumar Dy. Manager (Sub Contracting)	Mukesh Kumar Dy. Manager (Sub Contracting)	Sahil Malhotra Dy. Manager (Sub-Contracting)
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BHARAT HEAVY ELECTRICALS LIMITED INDUSTRIAL VALVES
PLANT, 433, INDUSTRIAL COMPLEX, GOINDWAL SAHIB,
DISTT. TARN TARAN, PUNJAB – 143 422

S.No	Gr. No	Job/Component Description	Description of Valve/ Product (Used in)	Special process
1	G2232	LOCK PIN-40021200	Wall Blower	Cadmium plating to a depth of 50 microns
2	G2193	SPINDLE SLEEVE-30015200	Wall Blower	Cadmium plating (0.005 mm to 0.0125 mm)
3	G2206	COVER PLATE-40012400	Wall Blower	Cadmium plating (0.005 mm)
4	G2223	SPRING RETAINER-40019300	Wall Blower	Cadmium Plating (0.05mm)
5	G2234	SWITCH MOUNT BRT-40024500	Wall Blower	Cadmium Plating (0.007mm to 0.012mm)
6	G2247	CAM-40079700	Wall Blower	Cadmium Plating (0.012mm to 0.018mm)
7	G2208	SHAFT COLLAR-40026100	Wall Blower	To Galvanize to a thickness of 0.005 mm
8	G2186	WORM SHAFT-30015100	Wall Blower	to be phosphated
9	G2344	BASE PLATE-40159600	NOZZLE SETG.FIXT-30072500	to be phosphated
10	G2238	FLAT WASHER-40013000	Wall Blower	to be phosphated
11	G2204	GLAND PLATE-40011900	Wall Blower	to be phosphated
12	G2306	Stem	2.5-C1500-GLV/GNV-HO/MO-WCC	Chrome plating
13	G2307b	Stem	3-C1500-GLV/GNV-BW-HO/MO-WCB	Chrome plating
14	G2307	Stem	4-C1500-GLV/GNV-BW-HO/MO-WCB	Chrome plating
15	G2346	Stem Machining	5-C1500-GLV-BW-MO-WC9	Chrome plating
16	G1402	STEM (with Hard Chrome Plating)	10-C150-GV-WC6	Chrome Plating
17	G1405	STEM (with Hard Chrome Plating)	10-C300-GV-WC9	Chrome Plating
18	G1410	STEM (with Hard Chrome Plating)	12-C300-GV-WC9/WC6	Chrome Plating
19	G1414	STEM (with Hard Chrome Plating)	14-C300-GV-WC9	Chrome Plating
20	G1418	STEM (with Hard Chrome Plating)	16-C300-GV-WC9	Chrome Plating
21	G1428	STEM (with Hard Chrome Plating)	2-C300-RV/SV-WC6	Chrome Plating
22	G1442	STEM (with Hard Chrome Plating)	3-C300-RV/SV-WC6	Chrome Plating
23	G1447	STEM (with Hard Chrome Plating)	4-C150-GV-WC9	Chrome Plating
24	G1450	STEM (with Hard Chrome Plating)	4-C300-GV-WC6/WC9	Chrome Plating
25	G1453	STEM (with Hard Chrome Plating)	4-C300-RV/SV-WC6/WC9	Chrome Plating
26	G1469	STEM (with Hard Chrome Plating)	8-C150-GV-WC6/WC9	Chrome Plating
27	G1473	STEM (with Hard Chrome Plating)	8-C300-GV-WC9	Chrome Plating
28	G1458	STEM (with Hard Chrome Plating)	6-C150-GV-WC9	Chrome Plating
29	G1462	STEM (with Hard Chrome Plating)	6-C300-GV-WC6	Chrome Plating
30	G1465	STEM (with Hard Chrome Plating)	6-C300-RV/SV-WC9/WC6	Chrome Plating
31	G2530	Split Ring Assy-3200/3396	450/500-C500-CRHIV-BW-WCB/WCC/WC9	Hard Chrome plating to a thickness of 30 to 40 microns
32	G2531	Split Ring Assy-3208/3390	550-C900-HRHIV-BW-WC9/C12A	Chrome plating to a thickness of 30 to 40 microns
33	G2425a	SPLIT RING ASSY	700-C600-CRHIV-BW-WCC	Hard Chrome plating to a thickness of 30 to 40 microns
34	G2425	SPLIT RING ASSY-3245/3316	750-C600-CRHIV-BW-WCC	Hard Chrome plating to a thickness of 15 to 30 microns
35	G2195	SWIVEL TUBE D60.3X4.8-30069900 (Chrome plating length - 1088mm Total length - 1218mm)	Wall Blower	Hard Chrome plating to a thickness of 50 microns
36	G2195a	EXT. SWIVEL TUBE D60.3X4.8-30208600 (Chrome plating length - 1488 mm Total length - 1618 mm)	Wall Blower	Hard Chrome plating to a thickness of 50 microns

S.No	Gr. No	Job/Component Description	Description of Valve/ Product (Used in)	Special process
37	G2195b	EXT. SWIVEL TUBE D60.3X4.8-30212301 (Chrome plating length - 2088 mm Total length - 2218 mm)	Wall Blower	Hard Chrome plating to a thickness of 50 microns
38	G2195a	EXT. SWIVEL TUBE D60.3X4.8-30212301 (Chrome plating length - 1388 mm Total length - 1518 mm)	Wall Blower	Hard Chrome plating to a thickness of 50 microns
39	G2195a	EXT. SWIVEL TUBE D60.3X4.8-30212303 (Chrome plating length - 1575 mm Total length - 1705 mm)	Wall Blower	Hard Chrome plating to a thickness of 50 microns
40	G2224	GUIDE ROD-40019500	Wall Blower	Chrome plating to a thickness of 8 to 12 microns
41	G2235	THRUST WASHER-40025000	Wall Blower	Case Hardening to RC 40-45 to a depth of 0.5 mm
42	G2179	WORM-30011901	Wall Blower	to be case hardened to a depth of 0.8 mm to 1mm to a hardness RC 60-66
43	G2181	WORM L.H-30011902	Wall Blower	to be case hardened to a depth of 0.8 mm to 1mm to a hardness RC 60-66
44	G2325a	Sunk Key	2.5/3-C1500-GLV/GNV-BW- WCC/WCB/WC9	Hardness required is min 240 BHN
45	G2325b	Sunk Key	4-C1500-GLV-BW-HO-WCB	Hardness required is min 240 BHN
46	G1486	SUNK KEY-W057	Extension spindle valves	Hardness required is 220 to 270 BHN
47	G2178	VALVE STEM CAP-40019800	Wall Blower	Heat Treat to 38-41 HRC
48	G2183	RAMP CAM-30013700	Wall Blower	Heat Treat to 50-55 RC
49	G2185	CAM SHAFT COLLAR-30014700	Wall Blower	To be Hardened to HRC 28
50	G2189	WORM GEAR SHAFT-30015500	Wall Blower	Heat Treat to RC 40-44
51	G2493	Orifice Plate		to be hardened and tempered to RC32 to 38
52		KEY-40114200	SPECIAL KEY-40114100 (842099634400)	hardened and tempered to RC 40 to 42
53	G2308	Yoke Machining	2.5-C1500-GLV-HO/MO- WCC/WCB/WC9	Nickel Plating to a thickness of 25 to 35 microns
54	G2345	Yoke Machining	3-C1500-GLV-BW-HO-WC9	Nickel Plating to a thickness of 25 to 35 microns
55	G2309	Yoke Machining	4-C1500-GLV-HO/MO- WCC/WCB/WC9	Nickel Plating to a thickness of 25 to 35 microns
56	G2311a	Disc Final	2.5-C1500-GLV-BW-HO-WC9	Tufftriding/ Liquid nitriding
58	G2311b	Disc Final	3-C1500-GLV-BW-HO-WC9	Tufftriding/ Liquid nitriding
60	G2311j	Disc Final	3-C3500-GLV-BW-MO-WC9	Tufftriding/ Liquid nitriding
61	G2311c	Disc Final	4-C1500-GLV-BW-HO-WCB	Tufftriding/ Liquid nitriding
64	G2311k	Disc Final	6-C3500-GLV-BW-MO-WC9	Tufftriding/ Liquid nitriding
65	G2311i	Disc Final	6-C2500-GLV-BW-MO-WCC	Liquid Nitriding
57	G2316a	Disc Nut	2.5-C1500-GLV-BW-HO-WC9	Tufftriding/ Liquid nitriding to be carried out to a Hardness of 600 to 800 Vickers

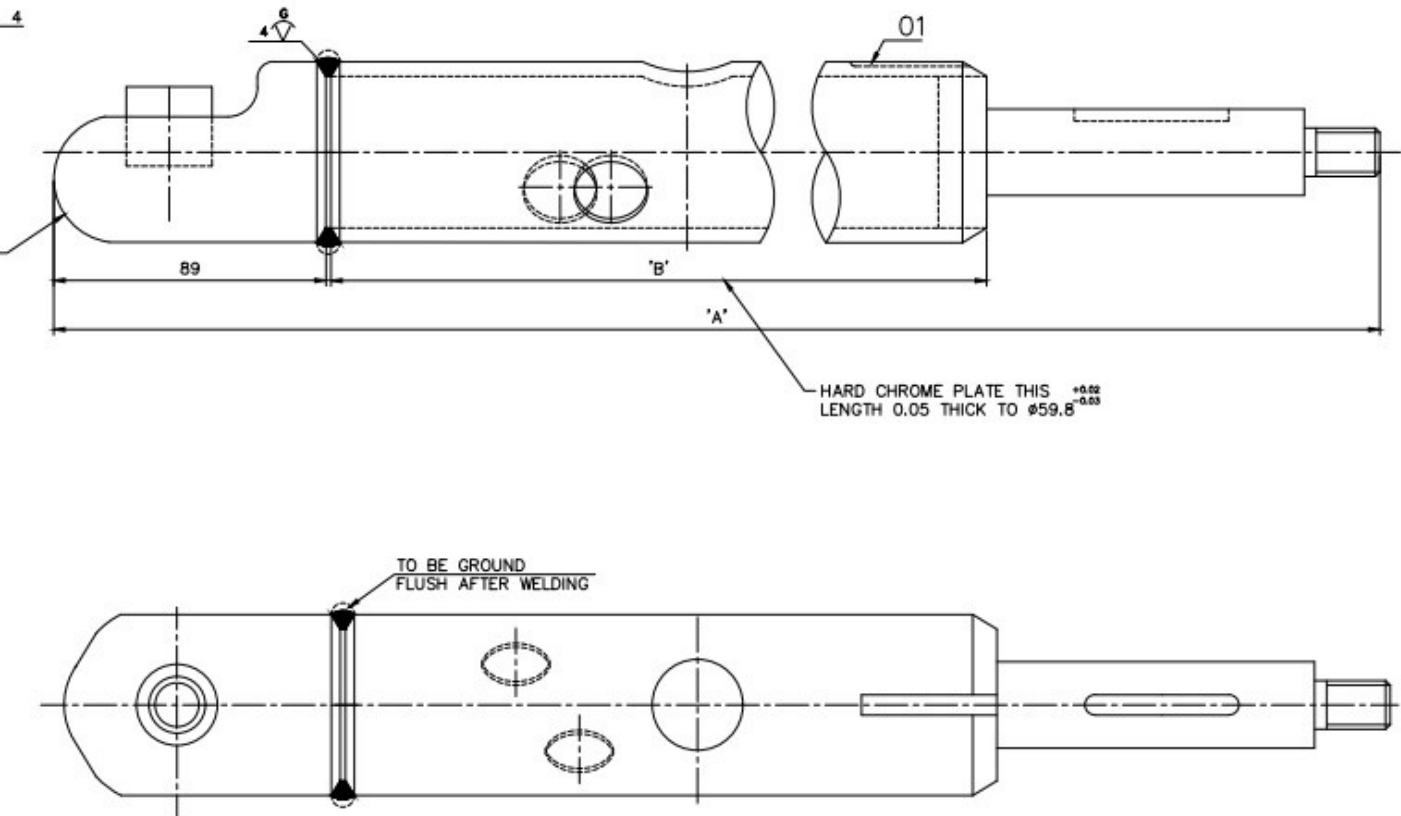
S.No	Gr. No	Job/Component Description	Description of Valve/ Product (Used in)	Special process
59	G2316b	Disc Nut	3-C1500-GLV-BW-HO-WC9	Tufftriding/ Liquid nitriding to be carried out to a Hardness of 600 to 800 Vickers
62	G2316c	Disc Nut	4-C1500-GLV-BW-HO-WCB	Tufftriding/ Liquid nitriding to be carried out to a Hardness of 600 to 800 Vickers
63	G2316d	Disc Nut	5-C1500-GLV-BW-GO-WC9	Tufftriding/ Liquid nitriding to be carried out to a Hardness of 600 to 800 Vickers
66	G1206	RING OF INDEX-K333	2-C300-RV-FL-HW-WCB	Chrome plate to a depth of 0.05 mm
67	G1207	RING OF INDEX-K334	3-C300-RV-FL-HW-WCB	Chrome plate to a depth of 0.05 mm
68	G1208	RING OF INDEX-K335	6-C300-RV-FL-HW-WCB	Chrome plate to a depth of 0.05 mm
69	G1209	RING OF INDEX	8-C300-RV-BW-HW-WCB	Chrome plate to a depth of 0.05 mm
70	G1211	SCALE OF INDEX-K333	2-C300-RV-FL-HW-WCB	Chrome plate to a depth of 0.05 mm
71	G1212	SCALE OF INDEX	3-C300-RV-FL-HW-WCB	Chrome plate to a depth of 0.05 mm
72	G1213	SCALE OF INDEX-2886	4-C300-RV-FL-HW-WCB	Chrome plate to a depth of 0.05 mm
73	G1214	SCALE OF INDEX	6-C300-SV-BW-HW-WCB	Chrome plate to a depth of 0.05 mm
74	G1215	SCALE OF INDEX-2925	8-C300-RV-BW-HW-WCB	Chrome plate to a depth of 0.05 mm

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

NOTES:-

- VARIANT No. 02, 03 & 04 MEANT FOR COPES VULCON SWIVEL TUBE ASSEMBLY REPLACEMENT.
- FOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.
- WELD NOZZLE HEAD ASSEMBLY WITH SWIVEL TUBE IN SUCH A WAY THAT THE 'V' GROOVE PROVIDED ON SWIVEL TUBE SHOULD BE INLINE WITH THE CENTRE LINE OF NOZZLEFOR QUALITY REQUIREMENTS REFER LATEST APPLICABLE QUALITY PROCEDURES.
- VARIANT No. 05 MEANT FOR STAINLESS STEEL (SS) SWIVEL TUBE MATERIAL.
- HARD CHROME PLATING IS NOT REQUIRED FOR VARIANT No. 5 (SS SWIVEL TUBE).



	02	NOZZLE HEAD ASSY.	4-20-201-00164	842020125600	0.920
				WELDMENT	1
	01	SWIVEL TUBE	3-20-201-02010	842020135503	9.200
				WELDMENT	1
05		SWIVEL TUBE ASSY.(SS)	2-20-201-00280	842020125503	10.120
				WELDMENT	1
	02	NOZZLE HEAD ASSY.	4-20-201-00164	842020125600	0.920
				WELDMENT	1
	01	SWIVEL TUBE	3-20-201-00903	-	8.436
				WELDMENT	1
04		SWIVEL TUBE ASSY.	2-20-201-00280	-	9.356
				WELDMENT	1
	02	NOZZLE HEAD ASSY.	4-20-201-00164	842020125600	0.920
				WELDMENT	1
	01	SWIVEL TUBE	3-20-201-00846	-	8.580
				WELDMENT	1
03		SWIVEL TUBE ASSY.	2-20-201-00280	842020126400	9.500
				WELDMENT	1
	02	NOZZLE HEAD ASSY.	4-20-201-00164	842020125600	0.920
				WELDMENT	1
	01	SWIVEL TUBE	3-20-201-00810	-	8.196
				WELDMENT	1
02		SWIVEL TUBE ASSY.	2-20-201-00280	842020102400	9.106
				WELDMENT	1
	02	NOZZLE HEAD ASSY	4-20-201-00164	842020125600	0.920
				WELDMENT	1
	01	SWIVEL TUBE	3-20-201-00699	842020135500	8.580
				WELDMENT	1
01		SWIVEL TUBE ASSY.	2-20-201-00280	842020125500	9.500
				WELDMENT	1
VARIANT No.	ITEM No.	DESCRIPTION	DRAWING No.	MATL. CODE	UNIT WT.(kg)
				MATL. SPEC.	QTY(Nos)

