



BHARAT HEAVY ELECTRICALS LIMITED

TRANSMISSION BUSINESS ENGINEERING MANAGEMENT

DOCUMENT No.	TB-400-508-017A	Rev. No.	00	Prepared	Checked	Approved
TYPE OF DOC.	TECHNICAL SPECIFICATION			SIGN	<i>[Signature]</i>	<i>[Signature]</i>
TITLE 220V & 48 V BATTERY SYSTEM				NAME	SS	SKS
				DATE	27/06/19	27/06/19
				GROUP	TBEM	W.O. No
OWNER	TAMILNADU GENERATION AND DISTRIBUTION CORPORATION (TANGEDCO)					
PROJECT	2 x 660 MW Udangudi STPP (Stage-I)					
SYSTEM	Electrical					

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Rev No.	Date	Altered	Checked	Approved	Revision Details	
Distribution				To	TBEM	TBMM
				Copies	1	1

1 Scope, Quantities, Specific Technical Requirements & Tests

1.1 Scope

This technical specification covers the requirements of design, engineering, manufacture, testing & inspection, packing, loading at works and transport to site of **220V & 48 V BATTERY SYSTEM** along with its accessories etc. as mentioned in this section and in various other sections of this specification. The scope also includes supervision of Erection, testing & commissioning of complete battery system & accessories.

The scope of work shall include supply, installation, testing and commissioning of the following:

- 2 numbers lead acid Plante battery bank for 220 V DC of switchyard
- 2 numbers Lead acid Plante battery bank for 48 V DC of switchyard
- Battery Health monitoring system (for above battery)
- Commissioning spares and consumables
- Mandatory spares
- Tools & tackles (to be brought by supplier at the time of commissioning on returnable basis)

The equipment is required for the following project:

Name of customer :TAMILNADU GENERATION AND DISTRIBUTION CORPORATION (TANGEDCO)
Name of the project : 2 x 660 MW Udangudi STPP (Stage-I)

Refer section-3 of this document for project details and general specification.

1.2 Quantities

S. No.	Item description	Quantity	Remarks
SUPPLY (complete with accessories as per section 2)			
1.	220V DC LEAD ACID PLANTE HIGH DISCHARGE BATTERY BANK COMPLETE IN ALL RESPECT MEETING THE LOAD CYCLE REQUIREMENT AS PER TS	2 Set	Sizing to be done & submitted with offer by bidder as per load cycle & design criteria given in this specification. No. of cells to be mentioned in offer.
2.	220V DC BATTERY HEALTH MONITORING SYSTEM COMPLETE IN ALL RESPECT AS PER TS	2 Set	System should be including all connecting cables, application software and accessories to make it fully functional system as per specification.
3.	48V DC LEAD ACID PLANTE HIGH DISCHARGE BATTERY BANK COMPLETE IN ALL RESPECT MEETING THE LOAD CYCLE REQUIREMENT AS PER TS	2 Set	Sizing to be done & submitted with offer by bidder as per load cycle & design criteria given in this specification. No. of cells to

			be mentioned in offer.
4.	48V DC BATTERY HEALTH MONITORING SYSTEM COMPLETE IN ALL RESPECT AS PER TS	2 Set	System should be including all connecting cables, application software and accessories to make it fully functional system as per specification.
SERVICES			
1.	220V DC BATTERY BANK SUPERVISION OF ERECTION, TESTING AND COMMISSIONING AT SITE	2 Set	
2.	220V DC BATTERY HEALTH MONITORING SYSTEM SUPERVISION OF ERECTION, TESTING AND COMMISSIONING AT SITE	2 Set	
3.	48V DC BATTERY BANK SUPERVISION OF ERECTION, TESTING AND COMMISSIONING AT SITE	2 Set	
4.	48V DC BATTERY HEALTH MONITORING SYSTEM SUPERVISION OF ERECTION, TESTING AND COMMISSIONING AT SITE	2 Set	

Sizing calculation alongwith K-factor table to be given with offer.

Battery spares:

220V BATTERY SYSTEM:

S. No.	Item description	Quantity	Remarks
a)	Inter cell connectors with insulated cover	10 Nos.	
b)	Inter row connectors with insulated cover	10 Nos.	
c)	Battery stand insulator	10 Nos.	
d)	Cell insulator	10 Nos.	
e)	Nuts, bolts and washers	1 Set	
f)	Vent plugs	10 Nos.	
g)	Battery cell without electrolyte (Dry cell)	10 Nos.	
h)	BHMS sensor (for each type and rating)	1 LOT	10 % of total population
i)	Battery sensing card (for sensing group of battery cells) (OPTIONAL)	1 No.	No. of battery cells catered by one card to be mentioned by bidder

48V BATTERY SYSTEM:

S. No.	Item description	Quantity	Remarks
a)	Inter cell connectors with insulated cover	10 Nos.	
b)	Inter row connectors with insulated cover	10 Nos.	
c)	Battery stand insulator	10 Nos.	
d)	Cell insulator	10 Nos.	
e)	Nuts, bolts and washers	1 Set	
f)	Vent plugs	10 Nos.	
g)	Battery cell without electrolyte (Dry cell)	10 Nos.	
h)	BHMS sensor (for each type and rating)	1 LOT	10 % of total population
i)	Battery sensing card (for sensing group of battery cells) (OPTIONAL)	1 No.	No. of battery cells catered by one card to be mentioned by bidder

Quantity variation = $\pm 30\%$

1.3 Specific Technical Requirements

1. System voltage: 220 V

Max. Voltage = (Sys. Vol. +10%)

Min. Voltage = (Sys. Vol. -15%)

LOAD & CORRESPONDING DURATIONS		
LOAD A1(Amps.)	57.24	119 min
LOAD A2(Amps.)	232.39	1 min

2. System voltage: 48 V

Max. Voltage = (Sys. Vol. +10%)

Min. Voltage = (Sys. Vol. -15%)

LOAD & CORRESPONDING DURATIONS		
LOAD A1(Amps.)	44	600 min

Design criteria

Ambient temperature = 50 Deg. C

Battery Room Min temp = 17 Deg. C

Design Margin = 10%

End Cell Voltage = **1.85V**

Ageing margin = as per IEEE Std 485

Voltage Drop for cable = 3% (max)

1.4 Tests

1.4.1. All type test shall be conducted on the batteries as per applicable standard. Copies of certified reports of all type tests carried out on similar type and rating shall be furnished.

1.4.2. In case type test reports are found to be technically unacceptable to BHEL/TANGEDCO, the type test shall be conducted without cost and delivery implication to BHEL.

1.4.3. All routine and acceptance tests shall be conducted on the batteries as per applicable standard or customer approved Manufacturing quality plan. The charges for carrying out all other routine/acceptance tests shall be deemed to be included in the Bid price.

1.4.4. Sampling scheme and criteria for acceptance shall be as per IS.

1.4.5. Test shall be conducted at Site on completion of installation and commissioning and immediately prior to putting the battery in service.

1.4.6. Type tests shall comprise the following:

- Verification of constructional requirements.
- Dimensional check
- Test for capacity
- Retention of charge test
- Ampere - hour and watt-hour efficiency tests.
- Life & Endurance test.
- Short circuit current and internal resistance measurement test.
- Test for loss of capacity on storage
- Test for resistance to overcharge
- Test for voltages & specific gravity during discharge.
- Test for high rate discharge at normal temperature & at low temperature.
- Internal resistance measurement test.
- Accelerated aging test followed by Seismic test.

1.4.7. Acceptance tests shall comprise the following:

- Visual inspection.
- Dimensional check
- Test for capacity
- Test for voltages & specific gravity during discharge.
- Insulation resistance.
- Internal resistance of cells.

1.4.8. Site tests shall comprise the following minimum tests or to be conducted as per approved Field quality plan:

- Check name plate details according to the specification
- Check for physical damage
- Check tightness of all bolts, clamps, joints and connecting terminals
- Check for electrolyte level
- Check for correct polarity
- Check charging and discharging cycle

2 Equipment Specification

2.1 General

This section covers the general technical requirements of **220V & 48V Battery system**. In case of any discrepancies between the requirements mentioned in this section and those specified in section-3 of this specification, this section shall prevail and shall be treated as binding requirement.

- 2.1.1.** Each battery shall be sized to cater to 100% load plus 10% design margin. The ageing factor and electrolyte temperature correction factors shall also be considered for the site ambient temperature.
- 2.1.2.** Type of battery shall be as follows.
- Switchyard battery for 220 V system : Lead acid Plante type (High Discharge type)
 - Switchyard battery for 48 V system : Lead acid Plante type (High Discharge type)
- 2.1.3.** The duty cycle imposed on the 220 V battery shall be for duration of two hours. The loads shall include the following.
- Loads for two hours (Seal oil pumps, Scanner air fans, indicating lights, continuously energized coils, Annunciation, Relays, emergency lighting etc.)
 - Momentary loads for a duration of up to 1 minute (switchgear operation (Trip coil / Closing coil), Solenoid valves, starting current of emergency DC motor, emergency steam sop
 - Valves, inrush current of supervisory safety, system for fuel, turbine and generator controls) Loads for two hour (Emergency oil pump, Jacking oil pump, etc.)
- 2.1.4.** The duty cycle imposed on the 48 V battery for communication system shall be for duration of ten hours.
- 2.1.5.** Batteries shall normally be permanently connected to the load in parallel with a charger and shall supply the load during emergency conditions when AC supplies fail. Batteries shall be suitable for a long life under continuous float operations and occasional discharges.
- 2.1.6.** The following items shall be provided for the Battery.
- Insulators (if applicable)
 - Long/short connectors with insulated cover
 - Inter row connectors with insulated cover (if applicable)
 - Interbank connectors with insulated cover (if applicable)
 - Vent plug
 - Level indicator and float guide
 - Battery take-off
 - Fasteners
 - Cell number plates
- 2.1.7.** End take off connections from positive, negative and tap cell terminals of the battery shall be suitable for single core cables having XLPE insulated stranded aluminium conductors.

- 2.1.8.** Necessary supports for termination of these cables on the batteries shall be provided by the Contractor.
- 2.1.9.** All the inter cell, inter row and interbank connectors supplied along with the battery shall be capable of continuously carrying the maximum discharge current of the respective batteries and through fault short circuit current which the battery can produce and withstand for the period declared.
- 2.1.10.** Insulated mild steel racks suitably treated/coated with alkali /acid resistant compound mounted on the insulators shall be provided for the batteries.
- 2.1.11.** Battery racks and other supporting/interconnecting accessories shall be as per layout arrangement to be approved by Owner during contract engineering stage. The cells shall be supported on insulator fixed on to the rack with adequate clearance.
- 2.1.12.** Each battery bank shall be supplied with microprocessor base battery health monitoring system (BHMS). It shall be capable of calculating the net charge of Battery bank, deterioration of batteries in battery bank during the charge/discharge cycles and actual efficiency of the batteries. It shall continuously monitor each cell in the battery bank to identify deterioration in the cell prior to failure and Identify the net charge in the battery bank by monitoring charging and discharging currents. It shall identify the faulty cell by monitoring cell's parameters and create audio and visual alarms whenever battery fault occurs. Remote monitoring of battery health at DCS/SAS/EMS system through modem communication shall be provided. Interfacing Cable & application software for remote monitoring is included in BHMS scope.
- 2.1.13.** Following accessories shall be provided for the Batteries as applicable.
- Electronic Syringe type Hydrometer with temperature measurement and with built in memory.
 - Cell testing voltmeter with built in memory.
 - Acid resistant funnel
 - Acid resistant jug.
 - Rubber apron and gloves
 - Insulated Spanners
 - Wall mounted teak wood rack/ Acid resistance rubber insulated Steel rack for above items
 - Lifting device for cell

2.2 Technical Requirements

- 2.2.1.** The cell capacity shall be specified at 10 hour discharge rate. The nominal voltage per cell shall be 2.0 V and the end voltage of cell shall be not less than 1.85 V. AH efficiency of battery shall be not less than 90%. Battery sizing shall be carried out as per IEEE: 485.
- 2.2.2.** Batteries shall be Lead-Acid Plante, Type F – HDP as per IS 1652.
- 2.2.3.** Battery Containers shall be made of fire retardant polypropylene / fire retardant transparent styrene acrylo nitrile (SAN) polymer. Containers shall be robust, heat resistance, leak proof, non-absorbent, acid/alkaline resistant, non-bulging type and

free from flaws such as wrinkles, cracks, blisters, pin holes etc. The electrolyte shall be prepared from battery grade sulphuric acid and distilled water.

- 2.2.4.** Batteries shall have thick plates designed for maximum durability during all service conditions including high rate of discharge and rapid fluctuations of load. Cells shall be fitted with electrolyte level indicator floats enclosed in transparent tub covers. Vent plug shall be provided which shall be anti-splash type.
- 2.2.5.** The cells shall be supported on porcelain insulator fixed on to the rack with adequate clearance between adjacent cells.

2.3 Standards

The equipment to be furnished under this specification shall be in accordance with the applicable section of the latest version of the relevant Indian Standards, IEC publications and any other standards, if any, except where modified and /or supplemented by this specification.

- a) IEEE: 485 Recommended practice for sizing for large lead storage batteries for generating stations and substations.
- b) IEEE: 484 IEEE Recommended Practice for Installation Design and Installation of Vented Lead-Acid Batteries for Stationary Applications
- c) IS : 14782 Code of practice for maintenance and testing of large lead- acid batteries for generating systems and substations
- d) IS: 1652 Specification for stationary cells and batteries, lead acid type with Plante positive plates).
- e) IS: 266 Specification for sulphuric acid.
- f) IS: 1146 Specification for rubber & plastic containers for lead acid storage batteries
- g) IS: 3116 Sealing compound for lead acid batteries.
- h) IS: 8320 General requirements and methods of tests for lead acid storage batteries.
- i) IS: 6071 Specification for synthetic separators for lead acid batteries.

2.4 Information to be furnished after order

The following drawings and documents shall be submitted for approval during detail engineering stage.

- Battery sizing calculation
- Technical data sheet
- General arrangement, layout drawing and section
- Battery room layout
- Rating factor & Battery selection table
- Erection and commissioning procedures
- Operation and maintenance manual
- Test reports
- Manufacturing quality plan

2.5 Technical documents to be furnished with the offer

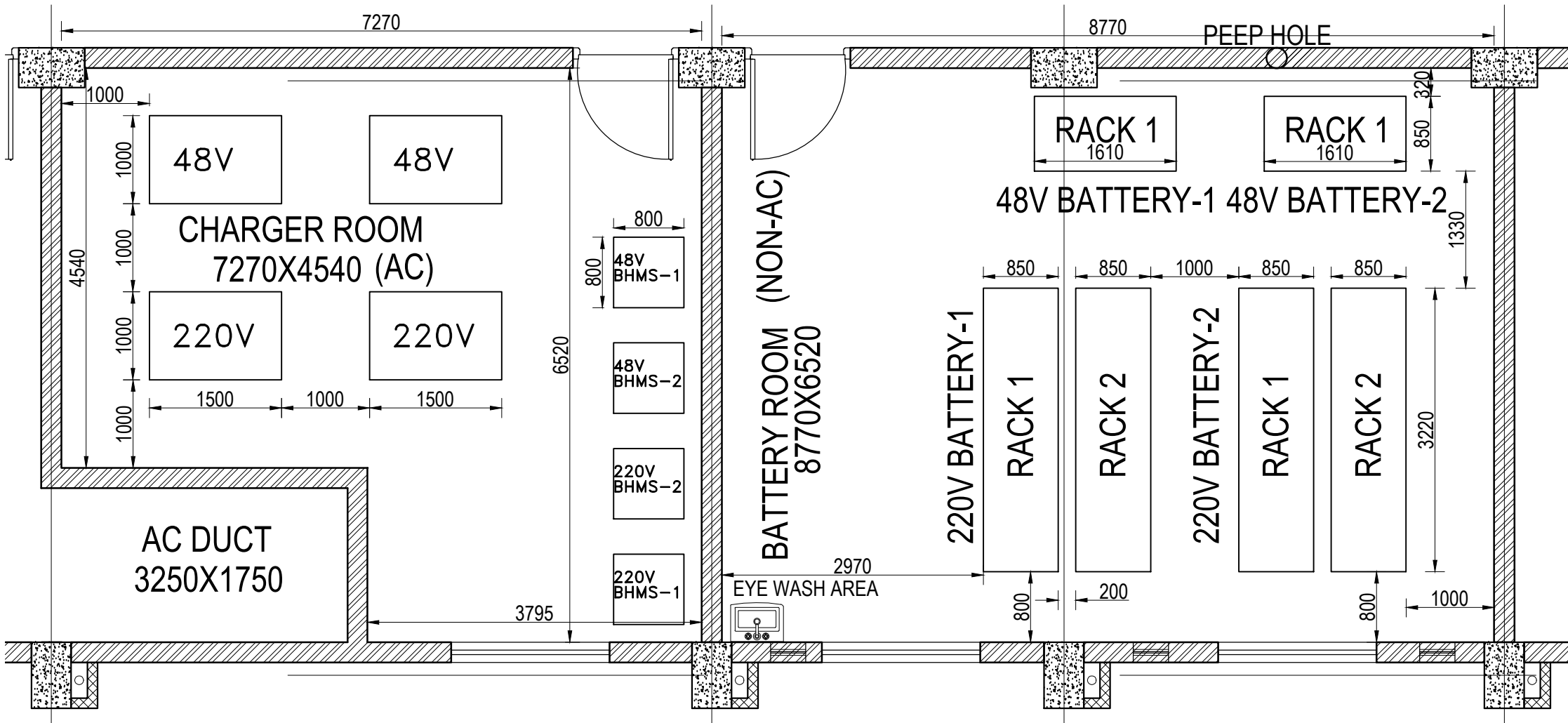
- Battery sizing calculation
- Technical data sheet
- General arrangement, layout drawing and section



- Battery room layout
- Rating factor & Battery selection table
- Test reports

3 General Technical Requirements

Please refer TB-400-316-000-REV 01: 'General Technical Requirements- Section 3'



SECTION 3**PROJECT DETAILS AND GENERAL SPECIFICATIONS****3.0 GENERAL**

This section stipulates the General Technical Requirements under the contract and will form an integral part of the Technical Specification.

The provisions under this section are intended to supplement general requirements for the materials, equipment and services covered under other sections and are not exclusive. However in case of conflict between the requirements specified in this section and requirements specified under other sections, the requirements specified under respective sections shall hold good.

3.1 SITE INFORMATION

SL.NO.	DESCRIPTION	
3.1	PROJECT INFORMATION	
	a) Customer	Tamil Nadu Generation and Distribution Corporation (TANGEDCO)
	b) Project	400kV GIS at 2 x 660 MW Udangudi STPP (Stage-I)
	c) Project location	
	i) Country	India
	ii) State	Tamil Nadu
	iii) Administrative district	Thoothukudi
	iv) Next Big cities to site	Thoothukudi (approx.. 45 kms from site)
	v) Road access	East Coast Road- State high way (176)
	vi) Nearest Railway Station	Thiruchendur (approx.. 12 kms from site)
	vii) Nearest Airport	Vaigai (approx.. 60 kms from site)
	viii) Nearest Harbour	Tuticorin (approx.. 45 kms from site)
3.2	SITE CONDITIONS	
3.2.1	Ambient Air Temp.	

	a) Maximum dry bulb temp. (max.) °C	41 ⁰ C
	b) Minimum dry bulb temp. (min.) °C	17 ⁰ C
	Design ambient temperature	50 ⁰ C
3.2.2	Relative humidity	
	Mean Maximum humidity (Summer)	84 %
	Mean Minimum humidity (Summer)	62 %
	Maximum humidity (Monsoon)	97%
	Minimum humidity (Monsoon)	45%
3.2.3	Rain fall	
	Annual rainfall (Maximum)	718.2 mm
	Annual rainfall (Minimum)	384.1 mm
	Twenty four (24) Hour max	138.2 mm
3.2.4	High Flood Level	
	High Flood Level for site	RL 2.450 m
3.2.5	Wind	
	Mean Wind Speed (max)	39 m/sec (As per IS: 875)
	Wind direction	North, North east, North west, East
3.3	Seismic intensity	
	Seismic Intensity	As per IS:1893 Latest
	Zone	II

3.2 INSTRUCTION TO BIDDERS

The bidders shall submit the technical requirements, data and information as per the technical data sheets, provided in Section-4.

The bidders shall furnish catalogues, engineering data, technical information, design documents, drawings etc fully in conformity with the technical specification.

It is recognized that the Manufacturer may have standardized on the use of certain components, materials, processes or procedures different than those specified herein. Alternate proposals offering similar equipment based on the manufacturer's standard practice will also be considered provided such proposals meet the specified designs, standard and performance requirements and are acceptable to the Purchaser. Unless brought out clearly, the Bidder shall be deemed to conform to this specification scrupulously.

3.3 STANDARDS

The works covered by the specification shall be designed, engineered, manufactured, built, tested and commissioned in accordance with the Acts, Rules, Laws and Regulations of India.

The equipment to be furnished under this specification shall conform to latest issue (with all amendments) of specified standards.

In addition to meeting the specific requirement called for in Sections 1 and 2 of the Technical Specification, the equipment shall also conform to the general requirement of the applicable standards, which shall form an integral part of the specification.

The Bidder shall note that standards mentioned in the specification are not mutually exclusive or complete in themselves, but intended to complement each other.

When the specific requirements stipulated in the specifications exceed or differ from those required by the applicable standards, the stipulation of the specification shall take precedence.

Other internationally accepted standards, which ensure equivalent or better performance than that specified in the standards referred, shall also be accepted. The bidder shall submit copies of such standards.

In case governing standard for the equipment is different from IS or IEC, the salient points of difference shall be clearly brought out in the offer along with English language version of standard or relevant extract of the same. The equipment conforming to standards other than IS/IEC shall be subject to Purchaser's / owner's approval.

The bidder shall clearly indicate in his bid the specific standards in accordance with which the works will be carried out.

3.4 SERVICES TO BE PERFORMED BY THE EQUIPMENT BEING FURNISHED

All equipment shall also perform satisfactorily under various other electrical, electro mechanical and meteorological conditions of the site of installation. All equipment shall be able to withstand all external and internal mechanical, thermal and electro mechanical forces due to various factors like wind load, temperature variation, ice & snow, (wherever applicable) short circuit etc for the equipment.

3.5 ENGINEERING DATA

3.5.1 Drawings

The Supplier shall necessarily submit all the drawings/ documents unless anything is waived. The Supplier shall submit drawings/ design documents/ data/ test reports/manuals as may be required for the approval of the purchaser. All drawings submitted by the Manufacturer including those submitted at the time of bid shall be in sufficient detail to indicate the type, size, arrangement, material description, Bill of Materials, weight of each component, break-up for packing and shipment, the external connections, fixing arrangement required. The dimensions required for installation and interconnections with other equipment and materials, clearances and spaces required for installation and interconnections between various portions of equipment and any other information specifically requested in the specifications.

Each drawing submitted by the Manufacturer shall be clearly marked with the name of the Purchaser, the unit designation, the specifications title, the specification number and the name of the Project. If standard catalogue pages are submitted, the applicable items shall be indicated therein. All titles, noting, markings and writings on the drawing shall be in English. All the dimensions should be in metric units.

Further work by the Manufacturer shall be in strict accordance with these drawings and no deviation shall be permitted without the written approval of the Purchaser, if so required.

The review of these data by the Owner will cover only general conformance of the data to the specifications and documents, interfaces with the equipment provided under the specifications, external connections and of the dimensions which might affect substation layout. Owner may not indicate a thorough review of all dimensions, quantities and details of the equipment, material, any devices or items indicated or the accuracy of the information submitted. This review and /or approval by the Owner shall not be considered by the Manufacturer, as limiting any of his responsibilities and liabilities for mistakes and deviations from the requirements, specified under these specifications and documents.

All manufacturing and fabrication work in connection with the equipment prior to the approval of the drawings shall be at the Manufacturer's risk. The Manufacturer may make any changes in the design which are necessary to make the equipment conform to the provisions and intent of the Contract and such changes will again be subject to approval by the Purchaser. Approval of Manufacturer's drawing or work by the Purchaser shall not relieve the manufacturer of any of his responsibilities and liabilities under the Contract.

All engineering data submitted by the Manufacturer after final process including review and approval by the Owner shall form part of the Contract Document and the entire works performed under these specifications shall be performed in strict conformity, unless otherwise expressly requested by the Owner in Writing.

The title block of drawings shall contain the following information incorporated in all contract drawings

Title block for project:

1. Customer : Tamil Nadu Generation and Distribution Corporation (TANGEDCO)
2. Consultant : DESEIN PRIVATE LIMITED, DESEIN HOUSE, NEW DELHI
3. Project : 400kV GIS at 2 x 660 MW Udangudi STPP (Stage-I)
4. Contract No./LOA No. : Lr.No.CE/Proj.II/SE/C/UTPP/EE/E/LOI/D.179/2017, dt.07.12.2017
5. Main Contractor : Bharat Heavy Electricals Limited
6. BHEL Order No. & Date :

3.5.2 Documentation

Document Distribution Schedule - After Placement of Order:

S. No.	Stage	No. of copies	
i)	Submission of Data sheets Datasheet, drawings, documents, write-ups, calculation, test reports, Preliminary	13	As per agreed schedule
ii)	Resubmission of above, if required	13	As per agreed schedule
iii)	Final approved documents	13	As per agreed schedule
iv)	Instruction manuals for erection and O&M	6	As per agreed schedule
v)	As built drawings including O &M manual -Hard copy -Soft copy in CD/Pendrive	13 6	As per agreed schedule

NOTES:

- a) The manufacturer may note that all re-submissions must incorporate all comments given in the prior submission by the Purchaser. Adequate justification for not incorporating the same must be submitted, failing which the submitted documents may be returned.

3.5.3 Format of Documentation

- a) All engineering documents and drawings shall be of international "A" series sizes, that is, A0, A1, A2, A3 and A4.
- b) Two set of CD/ pendrive containing all the drawings in Auto CAD shall also be supplied in addition to hard copies. Soft copy of all documents shall be supplied in a CD/pendrive in PDF format.
- c) Grouped documents shall be provided by size A4, with the inclusion of bigger size drawings which, however, have to be folded as Size A4.

3.5.4 Instruction manuals and operating manuals

The Supplier shall provide Instruction & Maintenance Manuals for each part of the Plant and Equipment included in the Works and Operating Manuals for each Station.

The Instruction Manuals and Operating Manuals shall be arranged in an organized library adequately cross referenced to facilitate issuing clauses of the manuals as required by the work i.e. erection instructions shall be required before operating & maintenance instructions.

All Manuals provided by the Supplier shall be fully detailed and specifically prepared for the Works and equipment provided. General manuals not specifically required for the work shall not be acceptable.

The instruction manuals shall at least contain:

- a) A general description of all components
- b) Storage instructions
- c) Erection instructions
- d) Pre-commissioning Instruction:
- e) Material and part list.
- f) Design clearances and settings
- g) Complete sets of drawings as finally issued
- h) Operating Instructions:
- i) Routine and Preventive Maintenance instructions with material requirement for each site
- j) Preventive Maintenance Schedule.
- k) Replacement instruction for all equipment

The operation manuals shall at least contain:

- a) Operator oriented functional descriptions of the equipment.
- b) Operator oriented description of the protection and control systems
- c) Description of the equipment auxiliary systems
- d) Fault finding and diagnostic tools
- e) User software interface tools for modification/augmentation etc.

Notes:

The supplier may please note that all resubmissions must incorporate all comments given in the earlier submission by the Owner/Purchaser or adequate justification for not incorporating the same must be submitted failing which the submission of documents is likely to be returned.

If after the commissioning and initial operation of the substation, the instruction manuals require any modifications/ additions/changes, the same shall be incorporated and the updated final instruction manuals shall be submitted by the Supplier to the Owner/Purchaser.

The Supplier shall furnish to the Owner/Purchaser, catalogues of spare parts also.

3.6 QUALITY ASSURANCE PROGRAMME

This section contains general requirements for inspection of material, parts, equipment and workmanship during manufacture, assembling to demonstrate compliance with specification, codes and standards to ensure overall reliability of product operation and performance.

The Owner and/or authorized Representatives shall, at any time, be allowed free and ready access to the Contractor's premises and those of his suppliers as well as to the site installation and the Contractor has to make the items available for the purpose of inspection of the specified equipment components and obtaining information as to the progress of the work. Failure on the part of the Owner, at this or any other time, to discover or reject materials or work which do not meet specified requirements shall not be deemed an acceptance thereof nor a waiver of defects therein.

The approval of the Owner shall not prejudice the right to reject equipment if it does not give complete satisfaction in service.

To ensure that the equipment and services under the scope of this Contract, whether manufactured or performed within the Manufacturer's Works or at his Sub-manufacturer's premises or at the Purchaser's site or at any other place of Work, are in accordance with the specifications, the Manufacturer shall adopt a suitable quality assurance programme to control such activities at all points, as necessary.

Before manufacture commences and not later than 45 days after award of contract, the Contractor shall submit an outline of his proposed inspection program, which shall include all major stages during manufacturing. The inspection and test program shall include for the various items the designation No., name of equipment, part of equipment, the kind of test, test standard, company which carries out the test, place, date and witnesses by the Contractor, third party or Owner's Representative. The detailed manufacturer's quality assurance plan shall be subject to approval after award of contract.

The Owner will return a copy of the Contractor's proposed inspection program indicating those inspection stages for which notification is required. Notification shall be by Fax or email in a format to be agreed and shall be sent prior to the intended test. If the Owner intends to be represented at the test he will provide at least 24 hours' notice and if his representative does not attend on the notified date, an alternative date has to be informed by the Owner.

A quality assurance programme of the manufacturer shall generally cover the following:

- (a) Manufacturer's organisation structure for the management and implementation of the proposed quality assurance programme;
- (b) Documentation control system;
- (c) Qualification data of bidder's key personnel;
- (d) The procedure for purchases of materials, parts components and selection of sub-Manufacturer's services including vendor analysis, source inspection, incoming raw material inspection, verification of material purchases etc.
- (e) System for shop manufacturing and site erection controls including process controls and fabrication and assembly control;
- (f) Control of non-conforming items and system for corrective actions;
- (g) Inspection and test procedure both for manufacture and field activities;
- (h) Control of calibration and testing of measuring instruments and field activities;
- (i) System for indication and appraisal of inspection status;
- (j) System for quality audits;
- (k) System for authorising release of manufactured product to the Purchaser
- (l) System for maintenance of records;
- (m) System for handling storage and delivery; and
- (n) A quality plan detailing out the specific quality control measures and Procedures adopted for controlling the quality characteristics relevant to each item of equipment furnished and/or services rendered. The Purchaser or his duly authorised representative reserves the right to carry out quality audit and quality surveillance of the system and Procedure of the Manufacturer/his vendors quality management and control activities.

3.7 Quality Assurance Documents

The Manufacturer shall be required to submit all Quality Assurance Documents as stipulated in the quality plan at the time of purchaser's inspection of equipment/material.

3.8 TYPE TESTING, INSPECTION, TESTING & INSPECTION CERTIFICATE

All equipment being supplied shall conform to type tests and shall be subject to routine and acceptance tests in accordance with requirements stipulated under respective sections. Purchaser reserves the right to witness any or all the tests. The

Manufacturer shall intimate the Purchaser the detailed programme about the tests at least three (3) weeks in advance in case of domestic supplies & six (6) weeks in advance in case of foreign supplies. The Manufacturer shall also submit type test procedure for approval of the Purchaser.

In the event of any discrepancy in the test reports i.e. any test report not acceptable due to any design/manufacturing changes (including substitution of components) or due to non-compliance with the requirement stipulated in the technical specification or any/all additional type tests not carried out, Such test shall be conducted fresh without any additional cost implication to the Purchaser.

The price of conducting all tests and additional type tests is deemed to be included in Bid price. In case any bidder indicates that he shall not carry out a particular test, his offer shall be considered incomplete and shall be liable to be rejected.

Inspection may be made at any stage of manufacture, dispatch or at site at the option of the Purchaser and the equipment if found unsatisfactory due to bad workmanship or quality, material is liable to be rejected.

The Purchaser or Inspector shall, within fifteen (15) days from the date of inspection as defined herein, give notice in writing to the Manufacturer, of any objection to any drawings and all or any equipment and workmanship which in his opinion is not in accordance with the Contract. The Manufacturer shall give due consideration to such objections and shall either make the modifications that may be necessary to meet the said objections or shall confirm in writing to the Purchaser/ inspector giving reasons therein, that no modifications are necessary to comply with the Contract.

When the factory tests have been completed at the Manufacturer's works, the Purchaser/inspector shall issue a certificate to this effect within fifteen (15) days after completion of tests but if the tests are not witnessed by the Purchaser/inspector, the certificate shall be issued within fifteen (15) days of receipt of the Manufacturer's Test certificate by the Engineer/ Inspector. Failure of the Purchaser/inspector to issue such a certificate shall not prevent the Manufacturer from proceeding with the Works. The completion of these tests or the issue of the certificate shall not bind the Purchaser to accept the equipment should it, on further tests/ after erection, be found not to comply with the Contract. The equipment shall be dispatched to site only after approval of test reports and issuance of MICC by the Purchaser.

In all cases where the Contract provides for tests whether at the premises or at the works of the Manufacturer or of any Sub-Contractor, the Manufacturer except where otherwise specified shall provide free of charge such items as labour, materials, electricity, fuel, water, stores, apparatus and instruments as may be reasonably demanded by the Purchaser /Inspector or his authorised representative to carry out effectively such tests of the equipment in accordance with the Contract and shall give

facilities to the Purchaser Inspector or to his authorised representative to accomplish testing.

The inspection by Purchaser and issue of Inspection Certificate thereon shall in no way limit the liabilities and responsibilities of the Manufacturer in respect of the agreed quality assurance programme forming a part of the Contract.

The Purchaser reserves the right for getting any field tests not specified in respective sections of the technical specification conducted on the completely assembled equipment at site. The testing equipment for these tests shall be provided by the Purchaser.

3.9 MATERIALS AND WORKMANSHIP

Equipment materials and components shall be new, of high grade and good quality and be to the latest engineering practice. The material and workmanship throughout shall be in accordance with the purpose for which they are intended. Each component shall be designed to be consistent with its duty.

All the information concerning materials or components to be used in manufacturing, machinery, equipment, materials and components supplied, installed or used shall be submitted for approval. Without such approval the supplier shall run risk of subsequent rejection. The cost as well as time delay associated with such rejection shall be borne by the supplier.

3.10 COLOUR SCHEME

The Supplier shall propose a colour scheme for the equipment for the approval of the Employer. The decision of the Employer shall be final. However, the finishing colour shall be RAL 7035 for all Control panels/ MCC/ Switchgear panels. The scheme shall include:

- Finishing colour of Indoor equipment
- Finishing colour of Outdoor equipment
- Finishing colour of various auxiliary system equipment including piping
- Finishing colour of various building items.
- Finishing colour of all cubicles.

All steel structures, plates etc shall be painted with non-corrosive paint on a suitable primer. The galvanised structures in the switchyard shall not be painted. However galvanised structures in other areas may require painting for aesthetic reasons.

3.11 PACKING AND STORAGE

Packing specification shall be submitted for BHEL/customer approval after award of contract.

All the equipment shall be suitably protected, coated, covered or boxed and crated to prevent damage or deterioration during transit, handling and storage at site till the time of erection. On request of the purchaser, the manufacturer shall also submit packing details/associated drawing for any equipment/ material at a later date, in case the need arises. While packing all the materials, the limitation from the point of view of availability of Railway wagon sizes in India should be taken into account. The manufacturer shall be responsible for any loss or damage during transportation, handling and storage due to improper packing. Any demurrage, wharf age and other such charges claimed by the transporters, railways etc shall be to the account of the manufacturer. Purchaser takes no responsibility of the availability of the wagons.

All coated surfaces shall be protected against abrasions, impact, discoloration and any other damages. All exposed threaded portions shall be suitably protected with either a metallic or a non-metallic protecting device.

Supplier shall ensure that equipment shall be properly packed, blocked, padded, coated and protected so that it is not damaged due to possible mishandling. Storage requirements shall be clearly defined by the supplier. Packing shall be such that if required, long time storage (at least 1 year) at site should not deteriorate the performance of the equipment.

3.12 NAME PLATE

Name plates which are to be firmly fixed on all the equipment, buildings and structures shall be provided. For equipment of small size, these are to be fixed on the piping or structure adjacent to the equipment. The contents of nameplate are to include the designation and principal parameters of the equipment.

The nameplate within the field shall be made of a high temperature - resistant metallic sheets, with designation permanently engraved on them. Indoor installed equipments (e.g., panels, cabinets, switchgear, etc.) shall also be labelled by appropriate name plate.

The form, size, base colour and colour of contents of the name plates and prompting plates will be agreed between the Contractor and the Owner. It shall be possible for these to be readily seen by the operator. The designation of warning tags shall be different from that of other tags.

The Equipment identification shall be finalized by vendor in consultation with BHEL/TANGEDCO and should be included in name plates.

3.13 CLAMPS & CONNECTORS

- i) All power clamps and connectors shall conform to IS: 5561, and/or IEC standard and shall be made of materials listed below:

a)	For connecting ACSR conductors	Aluminium alloy casting, conforming to designation A6 of IS: 617 and shall be tested for all tests as per IS:617
b)	For connecting equipment terminals made of copper with ACSR conductors	Bimetallic connectors made from aluminium alloy casting, conforming to designation A6 of IS 617 with 2 mm thick Bimetallic liner and shall be tested as per IS: 617.
c)	For connecting G.I. Shield wire	Galvanised mild steel
d).1	Bolts, nuts & Plain washers.	Electro galvanized for sizes below M12, for others hot dip galvanised
d).2	Spring washers for items 'a' to 'c'	Electro-galvanised mild steel suitable for at least service condition-3 as per IS: 1573

- ii) Equipment shall be supplied with the necessary terminals and connectors, as required by the ultimate design for the particular installation. The conductor terminations of equipment shall be either expansion, sliding or rigid type. The requirements regarding external corona and RIV as specified for any equipment shall include its terminal fittings and the equipment shall be factory tested with the connectors in position. In case the connector is not available then equivalent connector may be used. If corona rings are required to meet these requirements they shall be considered as part of that equipment and included in the scope of Work.
- iii) Where copper to aluminium connections are required, bi-metallic clamps shall be used, which have been properly designed to ensure that any deterioration of the connection is kept to a minimum and restricted to parts which are not current t shall be furnished to the Employer.
- iv) Low voltage connectors, grounding connectors and accessories for grounding all equipment as specified are also included in the scope of Work.
- v) No current carrying part of any clamp shall be less than 10 mm thick. All ferrous parts shall be hot dip galvanised. Copper alloy liner of minimum 2mm thickness shall be cast integral with aluminium body for Bi-metallic clamps. When copper alloy is not cast integral with aluminium body, a bimetallic washer or strip shall be used to meet the functional requirement.
- vi) All casting shall be free from blow holes, surface blisters, cracks and cavities. All sharp edges and corners shall be blurred and rounded off.

- vii) Flexible connectors, braids or laminated straps made for the terminal clamps for bus posts shall be suitable for both expansion or through (fixed/sliding) type connection of IPS Aluminium tube as required. In both the cases the clamp height (top of the mounting pad to centre line of the tube) should be same.
- viii) Clamp shall be designed to carry the same current as the conductor and the temperature rise shall be equal or less than that of the conductor at the specified ambient temperature. The rated current for which the clamp/connector is designed with respect to the specified reference ambient temperature, shall also be indelibly marked on each component of the clamp/connector, except on the hardware.
- ix) All current carrying parts shall be designed and manufactured to have minimum contact resistance.

x) TESTS

The following is the list of type tests.

- a) Temperature rise test (maximum temperature rise allowed is 35deg C over 50 deg C ambient)
- b) Short time current test
- c) Dry corona and RIV test as per annexure-A
- d) Resistance test and tensile test

3.14 GALVANIZING

Galvanizing works shall conform in all respect to B.S. 729, B.S. 3083 and B.S.C.P. 2008 and to DIN 50976 whatever requires the higher quality and shall be performed by the hot dip process, unless otherwise specified. It is essential that details of steel members and assemblies which are to be hot-dip galvanized should be designed in accordance with B.S 4479.

Vent-holes and drain-holes should be provided to avoid high internal pressures and air-locks during immersion, which may cause explosions, and to ensure that molten zinc is not retained in pockets during withdrawal.

Careful cleaning of welds is necessary before welded assemblies are dipped. The welds and the surrounding metal should be cleaned separately, preferably be blast-cleaning, because the usual preliminary pickling cannot be relied on to remove the welding slag.

All defects of the steel surface including cracks, surface laminations, laps and folds shall be removed in accordance with B.S. 4360. All drilling, cutting, welding, forming and final fabrication of unit members and assemblies shall be completed, where feasible, before the structures are galvanized. The surface of the steelwork to be galvanized shall be free from paint, oil, grease and similar contaminants in

accordance with DIN 55928, part 4 and DIN 50976. The weight of zinc coating per unit area has to be noted in the manufacturing documents in accordance with DIN 50976.

The minimum average coating weight shall be as specified in Table 1 of B.S. 729 or Table 2, DIN 50976, whatever requires higher quality.

Structural steel items shall be initially grit-blasted to B.S. 4232, second quality, (Sa 21/2) or by pickling in a bath and the minimum average coating weight on steel sections 5 mm thick and over shall be 610 g/m² (DFT = 85μ).

On removal from the galvanizing bath, the resultant coating shall be smooth, continuous, free from gross surface imperfections such as bare spots, lumps, blisters and inclusions of flux, ash or dross.

Galvanized contact surfaces to be joined by high-tensile friction-grip bolts shall be roughened before assembly so that the required slip factor (defined in B.S. 3294, part 1 and B.S. 4604,

part 1) is achieved. Care shall be taken to ensure that the roughening is confined to the area of the mating faces.

Bolts, nuts and washers, including general grade high-tensile friction grip bolts (referred to in B.S. 3139, and B.S.4395 part 1) shall be hot dip galvanized and subsequently centrifuged (according to B.S. 729). Nuts shall be tapped up to 0.4 mm oversize after galvanizing and the threads oiled to permit the nuts to be finger-turned on the bolt for the full depth of the nut. No lubricant, applied to the projecting threads of galvanized high-tensile friction-grip bolt after the bolt has been inserted through the steelwork, must be allowed to come into contact with the mating faces of the steelwork,. A local remelting of the galvanized parts to achieve the nuts to be finger turned on the bolt is possible in accordance with DIN 50976.

Protected slings must be used for offloading and erection. Galvanized work which is to be stored at the works or on site shall be stacked so as to provide adequate ventilation to all surfaces to avoid wet storage staining (white rust).

Small areas of the galvanized coating damaged in any way shall be restored in accordance with DIN 55928, part A and DIN 50976 by:

- Cleaning the area of any weld slag rust and other impurities and by thorough wire brushing to give a metallic clean surface.
- Application of suitable number of coats of zinc-rich paint containing more than 90 % w/w of zinc in dried film. The dry film thickness shall exceed at least 50 % the thickness of the desired galvanization. In case of application of a low melting point zinc alloy repair rod, the rods shall be in accordance with DIN1707, the thickness of the alloy shall be at least as of the desired galvanization.

The restored area is not to exceed 1 % of the galvanized surface. Surface restoration of parts in contact with drinking water is not allowed and the quality of the galvanization is to be in accordance with DIN 2444.

After fixing, bolt heads, washers and nuts shall receive two coats of zinc-rich paint.

Connections between galvanized surfaces and copper, copper alloy or aluminum surfaces shall be protected by suitable preferably hydrophobe tape wrappings to the owner's approval.

3.15 DEGREE OF PROTECTION

The enclosures of the control cabinets, Junction boxes and Marshalling boxes, panels etc. to be installed as detailed here under:

The minimum requirements for panels are as follows:

- Installed out door: IP- 55
- Installed indoors in air-conditioned area: IP-32
- Installed in covered area: IP-52
- Installed indoors in non air-conditioned area where possibility of entry of water is limited: IP-41.
- For LT Switchgear (AC & DC distribution Boards): IP-52.

The degree of protection shall be in accordance with IS:13947 (Part-I) / IEC-947 (Part-I) / IS 12063 / IEC 529. Type test report for degree of protection test, on each type of the box shall be submitted for approval