

MATERIAL CODE EL8431800020	 EPD 1800-01 REV.00	PURCHASE SPECIFICATION FOR LIQUOR AMMONIA SERVICE TANK		ISSUE NO : 06	
				DOC.NO: SCR-UT-015	
		REV : 00		AUG 2019	
PURPOSE: SS Liquor Ammonia Service tank will be used for day storage of Ammonium hydroxide which will be used in production of SCR catalyst.					
SCOPE: Scope involves supply of liquor ammonia service tank of capacity 600 Litres of required parameters as detailed below :					
COPY RIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in anyway detrimental to the interest of the company.	A FABRICATION OF SS LIQUOR AMMONIA SERVICE TANK AS PER FOLLOWING SPECIFICATION				
	SL NO	PARAMETERS	REQUIREMENT OF BHEL		
	1	Capacity and Orientation	600 Ltrs / VERTICAL		
	2	Design Code	ASME SEC VIII DIV I		
	3	Design Pressure (Kg/sq.cm)	Atmospheric pressure		
	4	Design temperature (Deg C)	- 33 Deg C to + 55 Deg C		
	5	Inside Diameter	As per drawing		
	6	Hydro Test Pressure (Kg/sq cm)	2.0 kg/ sq. cm		
	7	Corrosion allowance (mm)	NIL		
	8	Radiography (%)	Shell 10% , Dished end 100%		
	9	Joint Efficiency	As per ASME Code		
	10	Heat Treatment	NIL		
	11	Dished end type	Toro spherical		
	12	Shell thickness	As per drawing		
	13	Dished end thickness	Minimum 4 mm		
	14	Overall tank length	As per drawing		
	15	Leg Support	As per drawing		
	16	Pre dispatch inspection	BHEL or authorized testing agency		
	17	Painting	2 coats of Red oxide primer will be applied on MS parts. Acid cleaning & buffing of SS304 Parts.		
	18	Discharge Valve	25 NB – Flange Type Ball valve – 2 No		
	19	Inlet Valve	25 NB – Flange Type Ball valve – 3 No.		
	20	Level Gauge	Glass Tube level gauge to be supplied by bidder		
	B MATERIAL OF CONSTRUCTION				
	1	MATERIALS	As Specified in drawing		
	TESTING				
	1	Quality Assurance plan (QAP) shall be made and submitted for approval of BHEL. The same shall also duly verified during pre-dispatch inspection by BHEL or authorized inspection agency.			
	2	Test certificates of third party inspection shall be submitted			
	Rev.00:	Issued By	Prepared By	Checked By	Approved By
1 st Issue	SCR PROD GROUP	CHETAN BHAWSAAR	PRATAP MUKHERJEE	K S. RAVISHANKAR	31-08-2019

MATERIAL CODE EL8431800020	 EPD 1800-01 Rev. 00		PURCHASE SPECIFICATION FOR LIQUOR AMMONIA SERVICE TANK		ISSUE NO : 06 DOC.NO: SCR-UT-015 REV : 00 AUG 2019 Page 2 of 2	
	DOCUMENTATION 1 3 sets of hard copies for all the tank related documents, tank file folder, inspection release note & as built drawings of the tank shall be provided. Also, foundation details are to be provided.					
TRANSPORTATION 1 Transportation is in the scope of the supplier						
WARRANTY 1 12 months from the date of commissioning or 18 months from the date of supply whichever is earlier. 2 Supplier to indicate replacement parts and consumables for 2 years continuous operation (24 hours/ day basis). During the period of warranty, these spares and consumables are in the scope of supplier 3 List of spares and consumables to be provided along with techno-commercial offer.						
QUALIFICATION 1 Bidder should be Original Equipment Manufacturer of the quoted item. Bidder to submit company credentials to prove as OEM registration certificate as a manufacturer or any other document to establish that the Bidder is an OEM. 2 Bidder should have manufactured, supplied and successfully commissioned Stainless Steel tank of rated capacity or more minimum of 3 numbers in the last 3 years. Bidder to submit a copy of relevant documents of supply/manufacturing of similar items in the past. Bidder to submit a copy of purchase orders and commissioning certificates for the supply with contact details of the customer. BHEL reserves the right for independent verification of the reference provided. 3 Offer shall be for new tank and not for any refurbished or used tank.						
Rev.00: 1st Issue Issued By: SCR PROD GROUP Prepared By: CHETAN BHAWSAR Checked By: PRATAP MUKHERJEE Approved By: K.S. RAUVISHANKAR Date: 31-08-2019						