

**ANDHRA PRADESH POWER GENERATION CORPORATION
LTD. (APPDCL)**

1X800 MW APPDCL KRISHNAPATTANAM TPP, STAGE-II

**TECHNICAL SPECIFICATION
FOR
VIBRATION ISOLATION SYSTEM
FOR**

TD BFP (2 NOS) & MD BFP (1 NOS) FOUNDATION

SPECIFICATION NO. : PE-TS-420-614-C001 (Rev 0)



**BHARAT HEAVY ELECTRICALS LIMITED
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA-201301**

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TITLE :
TECHNICAL SPECIFICATION FOR
VIS FOR TD BFP (2 NOS) & MD BFP
(1 NOS) FOUNDATION

SPECIFICATION NO. PE-TS-420-614-C001

SECTION

REV. NO. 0

DATE 17.09.2016

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This Technical Specification consists of two Sections:

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- SPECIFIC TECHNICAL REQUIREMENTS.

SECTION II

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COMPLIANCE CERTIFICATE

The bidder shall confirm compliance to the following by signing/ stamping this compliance certificate and furnishing same with the offer.

01. The scope of supply, technical details, construction features, design parameters etc. shall be as per technical specification & there are no exclusion/ deviation with regard to same.
02. There are no deviation with respect to specification other than those furnished in the 'schedule of deviations.'
03. Only those technical submittals which are specifically asked for in NIT to be submitted at tender stage shall be considered as part of offer. Any other submission, even if made, shall not be considered as part of offer.
04. Any comments/ clarifications on technical/ inspection requirements furnished as part of bidder's covering letter shall not be considered by BHEL, and bidder's offer shall be construed to be in conformance with the specification.
05. Any changes made by the bidder in the price schedule with respect to the description/ quantities from those given in 'BOQ-Cum-Price schedule' of the specification shall not be considered (i.e., technical description & quantities as per the specification shall prevail).
06. QP will be subject to BHEL/Customer approval in the event of order & customer hold points for inspection/ testing shall be marked in the QP at the contract stage. Inspection/ testing shall be witnessed as per same apart from review of various test certificates/ Inspection records etc.

The charges for 3rd party inspection (Lloyds, or equivalent) for imported components shall be included in the base price of the equipment by the bidder.

07. All drawings/data – sheets etc. to be submitted during contract shall be subject to BHEL/Customer review/ approval.
08. GA drawings/ datasheet / QP as submitted with offer at tender stage are for reference purpose only and shall be subject to approval during contract stage.
09. All sub vendors shall be subject to BHEL/CUSTOMER approval.
10. Any special tools & tackles, if required, shall be in bidder's scope.

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PRICE SCHEDULE FOR SUPPLY OF VIS (STEEL HELICAL SPRING AND VISCOUS DAMPER) FOR TD BFP (2 NOS.) MDBFP (1 NOS.) FOUNDATION						
SI.No	DESCRIPTION OF EQUIPMENT / ITEM	Required Load carrying Capacity (kN) for each foundation	No of machine foundation	Ex-Works PRICE(Rs.) per kN load carrying capacity	Total Ex-Works PRICE(Rs.)	REMARKS
1	2	3	4	5	6=3*4*5	
A1.1*	VIS FOR TD BFP FOUNDATION	5,328	2			
A1.2*	VIS FOR MD BFP FOUNDATION	5,994	1			
A1	COST OF VIS (A1.1+A1.2*)	-	-			
A2	PACKING & FORWARDING CHARGES	-	-			
A3	TOOLS FOR ACCESSORIES	-	-			Electric Pump Included
A	TOTAL COST OF VIS, INCLUDING PACKING FORWARDING & TOOLS FOR ERECTION(A1+A2+A3)	-	-			

PRICE SCHEDULE FOR DESIGN ENGINEERING OF TDBFP & MDBFP DECK SUPPORTED ON VIS (SPRING TYPE)			
SI NO.	ITEM	TOTAL PRICE(Rs)	REMARKS
B1.0	CIVIL DESIGN ENGINEERING DOCUMENT FOR TD BFP FOUNDATION RESTING ON VIS		
B2.0	CIVIL DESIGN ENGINEERING DOCUMENT FOR MD BFP FOUNDATION RESTING ON VIS		
B	TOTAL COST OF CIVIL ENGINEERING DOCUMENT(B1.0+B2.0)		
	TOTAL COST OF VIS INCLUDING CIVIL DESIGN ENGINEERING DOCUMENT (A+B)		

PRICE SCHEDULE FOR SUPERVISION OF ERECTION AND COMMISSIONING OF VIS (STEEL HELICAL SPRING AND VISCOUS DAMPER) FOR TD BFP(2 NOS.) MD BFP(1 NOS.) FOUNDATION					
SI NO.	ITEM	NO OF VISITS	UNIT PRICE(Rs)	TOTAL PRICE(Rs)	REMARKS
C1.0	SUPERVISION OF ERECTION & COMMISSIONING OF VIS FOR TD BFP FOUNDATION	4			One visit consisting of 3 days
C2.0	SUPERVISION OF ERECTION & COMMISSIONING OF VIS FOR MD BFP FOUNDATION	2			One visit consisting of 3 days
C	TOTAL SUPERVISION PRICE (C1.0+C2.0)				

In case of an extra visit, the above charges would be applicable for the visit and if there is any extra stay during the visit at site, the charges shall be @ Rs. ---/- per day

D	TOTAL COST OF PACKAGE (A+B+C)				
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Note:

- Load carrying capacity mentioned for the variable items (* marked) is tentative only and shall be used for bid evaluation and ordering purpose.
- The actual load carrying capacity of the springs may undergo change after ordering, based on springs selected during detailed engineering.
- In such a case, price bid evaluation shall be done again based on revised load carrying capacity of the springs keeping all the prices same as quoted originally. In case of change in L1 status, the quoted price per unit load carrying capacity (kN) of the variable items (i.e. A1.1 & A1.2) of the original L1 vendor shall be proportionately reduced to maintain L1 status.
- Based on above, amendment to PO, if required, shall be issued.
- Generally the damping shall be required in the range of 5% to 20% of critical damping of whole machine foundation system to meet the design requirement. In exceptional case it may vary upto 30 % depending upon the available/selected spring unit as well as layout constraints. The bidder shall accordingly include the cost of damping in their quoted price for Cost of VIS per Unit load carrying capacity(kN). No extra price shall be provided on account of required damping. Cost of dampers is deemed to be included in the quoted rate of VIS (per kN).
- Price per Visit is lumpsum which includes travel and accommodation charge.



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SECTION-I
SPECIFIC TECHNICAL REQUIREMENTS



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1.0 SCOPE

1.01 SUPPLY OF VIBRATION ISOLATION SYSTEM (VIS):

- i) Vibration Isolation System (VIS)
- ii) Tools and facilities required for erection and commissioning including seaworthy packing & transportation etc. complete.

1.02 SUPERVISION OF ERECTION AND COMMISSIONING OF THE VIS.

Vendor shall deploy experienced manpower for setting the VIS in position and final adjustments after machine installation. Vendor shall also confirm the readiness at site before deploying the manpower for supervision of erection. Vendor shall furnish proposed erection strategy of the entire system and procedure for replacement of VIS and downtime involved.

1.03 DESIGN & ENGINEERING FOR THE VIBRATION ISOLATION SYSTEM AND TOP DECK (INCLUDED IN VENDOR'S SCOPE)

Design and engineering shall consist of the following:

- i) Selection of Vibration Isolation System (VIS).
- ii) Static and dynamic analysis and design of RCC deck slab (supporting arrangement for the equipment supported on VIS)
- iii) Calculation of loads on supporting structure along with their points of application and deflection limitations.
- iv) Calculation should establish that not more than 5 % of the dynamic loads are transmitted to the substructure supporting VIS and that the foundation system meets the amplitude/frequency requirements.
- v) Checking of stiffness for structure supported on VIS.

1.04 DOCUMENTATION

Vendor shall furnish following documents:

- i) Bill of materials of various elements included in the supply along with detailed specifications of system and various items included in supply and standards local or international standards to which they conform.
- ii) General Arrangement (GA) drawing showing location and supporting details of VIS. **(Included in vendor's scope).**
- iii) GA and reinforced concrete details drawings for deck slab including bar bending schedule. **(Included in vendor's scope).**
- iv) Embedment drawings showing location of all embedment and their details pertaining to RCC deck slab-**(Included in vendor's scope).**
- v) Design document. **(Included in vendor's scope).**
- vi) Methodology of providing the shuttering and its removal as well as concreting of deck slab, installation of VIS and sequence of above operation.
- vii) Installation and maintenance manual indicating equipment, procedures, etc. necessary for installation/maintenance of VIS.
- viii) List of power plants where such systems have been successfully installed for such applications.
- ix) Performance certificate from the end user/customer for at least two successfully executed contracts for such system.
- x)



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2.0 GENERAL:

- 2.1 In case of any conflict between section –I and section-II, section-I will prevail over section-II.
- 2.2 The vibration isolation system shall consist of steel helical spring units and viscous dampers.
- 2.3 The supplier must have requisite experience and proven track record of similar installation in power plants of unit capacity not less than 500 MW.
- 2.4 Bidder shall quote based on the input drawings as per Table-1 to satisfy the design requirement as per the relevant applicable codes in annexure- A and section - II.

Table-1

<u>Sl. No</u>	<u>TITLE</u>	<u>DRAWING NO.</u>
1	GENERAL ARRANGEMENT OF TDBFP –A & B SET	HY-DG-1-18000-57756 (R0)
2	FOUNDATION ARRANGEMENT FOR BFP & DRIVE TURBINE (SH 1/3)	HY-DG - 1-31301-15635 (R0)
3	FOUNDATION ARRANGEMENT FOR BFP & DRIVE TURBINE (SH 2/3)	HY-DG - 1-31301-15635 (R0)
4	FOUNDATION ARRANGEMENT FOR BFP & DRIVE TURBINE (SH 3/3)	HY-DG - 1-31301-15635 (R0)
5	FOUNDATION ARRANGEMENT OF MDBFP SET (SH ½)	HY-DG-1-18000-57755(R0)
6	FOUNDATION ARRANGEMENT OF MDBFP SET (SH 2/2)	HY-DG-1-18000-57755(R0)
7	GENERAL ARRANGEMENT OF MDBFP SET	HY-DG-1-18000-57757(R0)

- 2.5 Bidder shall furnish the information about the entire range of spring units, damper units and spring cum damper units, manufactured by the vendor. The information to be furnished should include the load carrying capacity, stiffness (vertical & horizontal), damping resistance, dimension of spring and damper units as well as quality plan.
- 2.6 The steel helical springs and viscous damper supplied should be of proven make.

3.0 DOCUMENTS TO BE SUBMITTED BY VENDOR

- 3.1 Document submission schedule after the award of contract shall be as below:

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PACKAGE	BHEL DRG NO	DRG TITLE	Drg Submission schedule
VIS FOR TD/MD BFP	Primary Documents - affecting Manufacturing/ Delivery Directly		
	PE-V0-420-614-C201	Data sheet of TD/MD BFP	R-0 within Two (02) weeks from LOI/PO & subsequent revisions within 10 days of comments received from BHEL/customer.
	PE-V0-420-614-C202	QAP FOR TD/MD BFP	
	PE-V0-420-614-C203	Test certificate of TD/MD BFP	
	PE-V0-420-614-C205	Static & dynamic Analysis of TD BFP	
	PE-V0-420-614-C204	Static & dynamic Analysis of MD BFP	
	PE-DG-420-614-C004	Civil GA drwg of TD BFP	
	PE-DG-420-614-C001	Civil GA drwg of MD BFP	
	Secondary Documents - NOT affecting Manufacturing / Delivery Directly		
	PE-DG-420-614-C005	RC details of TD BFP	R-0 within Two (02) weeks of Cat-I(or)II approval on GA drawing
	PE-DG-420-614-C002	RC details of MD BFP	

3.2 The documents shall be submitted as mentioned below:

- Soft copy of all documents/drawings shall be furnished in pdf and AutoCAD format as applicable.
- Hard copies shall also be submitted.
- Submission of civil drawings/documents shall be as mentioned in the table-2.

Table-2

	Drawing	Document
For Approval	Soft copy + 6 nos. hard copies	Soft copy + 6 nos. hard copies
For RFC	Soft copy + 6 nos. hard copies	

4.0 SEISMIC LOADING:

The site falls in Zone-III as identified in the map in IS: 1893-2002. Analysis and design of structures to resist the seismic forces will be established in accordance with the recommendations of IS: 1893 (Part IV): 2005. Importance factor to be considered is 1.75 for all structures. Ductile detailing of RCC structures will be as per IS: 13920.

5.0 WIND LOADING:

Wind loading shall be in accordance with Indian Standard Code IS: 875 (Part 3): 1987 for a basic wind speed of 50 m/sec. upto a height of 10 meters above mean ground level. Terrain Category-1 shall be considered for all structures.



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6.0 MATERIAL OF CONSTRUCTION

- i. Minimum grade of concrete: M30.
- ii. Reinforcing bars will be TMT bars of grade Fe500 conforming to IS-1786.

7.0 MATERIAL (DESIGN & SUPPLY)

7.1 Steel helical springs and viscous dampers shall consist of:

- i. Steel helical spring units and viscous dampers along with viscous liquid including associated auxiliaries for installation of the spring units and dampers like steel shims, adhesive pads, etc.
- ii. Frames for pre-stressing of spring elements.
- iii. Suitable hydraulic jack system including electric pumps, high pressure tubes etc. required for the erection, alignment etc. of the spring units. One set of extra hydraulic jacks, and hand operated pumps shall also be provided.
- iv. Any other items may be required for the pre-stressing, erection, release of pre-stress, alignment and commissioning of the steel helical springs and viscous dampers.

7.2 The objective of designing the supporting arrangement for any rotating equipment shall be so that the vibration level is maintained as minimum as possible under all operating conditions. Accordingly respective rotating equipment shall be supported on RCC deck slab which in turn shall rest on vibration isolation unit consisting of steel helical springs and viscous dampers, which in turn shall be supported on RCC supporting structure. The above design shall form part of this specification.

7.3 The spring units shall have definite stiffness in both vertical and horizontal directions with the horizontal stiffness not less than 30% of vertical stiffness. The stiffness should be such that the vertical natural frequency of any spring unit at its rated load carrying capacity is not more than 3 to 5 Hz.

7.4 The damper units or spring cum damper units should be of viscous type offering velocity proportional damping. The damper units shall be suitable for temperatures ranging from 0 to 50° c. The damping resistance of the individual damper units shall be such that the designed damping can be provided using reasonable number of units. Damper units shall have damping resistance ranging from 40kNsec/m to 750 kN-sec/m.

7.5 The sizes of the spring units, damper units, spring cum damper units should be such that groups of such units can be accommodated on column heads in case of elevated foundations and on pedestals/walls in case of foundations at ground level.

7.6 The steel helical springs and viscous dampers shall be designed for ensuring "fit and forget" guarantee.

7.7 It shall be ensured that not more than 5% of the dynamic loads are transmitted to the substructure. Necessary provisions of DIN 4042 shall be adhered to while designing the substructure. Substructure shall be designed for static loads.

7.8 For all equipment foundations supported on VIS system, the stiffness of the supporting substructure shall be at least ten (10) times that of spring elements as per DIN 4024.

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8.0 MANUFACTURING & TESTING

8.1 Complete manufacturing and testing of the steel helical springs and viscous dampers shall be done at the manufacturing shop of the vendor. For this purpose the vendor shall submit the detailed programme for approval of customer and take up the manufacturing / testing after approval of such programme. The programme (quality plan) shall include:

- i. Manufacturing schedule and quality check exercised during manufacturing.
- ii. Detail of test to be carried out at the manufacturing shop with its schedule.
- iii. Special requirements, if any, regarding concreting of top deck.
- iv. Complete step- by- step procedure covering the installation and commissioning of the spring system.
- v. Manuals for erection, commissioning, testing and maintenance of the steel helical springs and viscous dampers.
- vi. A checklist for confirming the readiness of the civil fronts for erection of steel helical springs and viscous dampers.
- vii. Checklist for equipment required at each stage of erection.
- viii. Bill of materials (data sheet) of various elements such as spring units, viscous dampers, with their rating, stiffness etc. included in the supply.
- ix. Bill of material (data sheet) for frames for pre stressing, hydraulic jack including electric pump, high pressure tubes, hand operated pump etc. with their rating and numbers.
- x. Any other details which may be necessary to facilitate design and construction of the foundations / structures.

8.2 The springs shall conform to codes DIN 2089 and DIN 2096. The quality assurance and inspection procedure shall be finalised on the basis of the above codes and the quality plans be drawn accordingly.

9.0 ERECTION AND COMMISSIONING AND SUPERVISION

- 9.1 Complete erection and commissioning of the steel helical springs and viscous dampers including pre-stressing of elements, placing of elements in position, checking clearances on the shuttering of the RCC top deck, releasing of pre-stress in spring elements, making final adjustments and alignments etc. all shall be supervised by a specialist supervisor.
- 9.2 The scope of work shall be deemed to include all activities, which may not have been explicitly mentioned but are reasonably implied for the successful commissioning of steel helical springs and viscous dampers.
- 9.3 The vendor shall guarantee the performance of the steel helical springs and viscous dampers for 24 months from the date of commissioning of each machine which shall be termed as "Guarantee Period".

10.0 REALIGNMENT OF SPRING SYSTEM

If any realignment of the steel helical springs and viscous dampers is required to be done for aligning the shaft or for any other reasons during the first one year of operation from the date of commissioning of the machine, the same shall be done by the vendor.

11.0 TRANSPORTATION

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11.1 Steel helical springs and viscous dampers shall be suitably protected, coated, covered, boxed and crated to prevent damage or deterioration during transit and handling.

11.2 The vendor shall be responsible for any loss or damage during transportation, handling.

12.0 INSPECTION REQUIREMENTS

12.1 Minimum requirement for quality plan shall be as per quality plan attached in section –II of the specification. Quality plan shall be subject to approval during detail engineering. No price implication shall be admissible to QP approval by BHEL/Customer.

12.2 Inspection for imported item shall be done from third party like Lloyd or equivalent and certificate shall be submitted for review of BHEL.

12.3 In case of new bidder, bidder may need to carry out damping test, stiffness test etc. during customer approval stage before price bid opening. No price implication shall be admissible for these tests.

ANNEXURE-A

Codes and Standards

Latest revision of following codes shall be used for the design of the spring-supported foundations:

IS: 456	Codes practice for plain and reinforced concrete.
IS: 2974	Code of practice for design and construction of machine foundations.
IS: 1893	Criteria for earthquake resistant design of structures.
DIN: 4024	Machine foundations; Flexible supporting structures for machine with rotating masses
DIN: 2089	Helical compression springs out of round wire and rod: calculation & design.
DIN: 2096	Helical compression springs out of round wire and rod: quality requirements for hot formed compression springs.
VDI: 2056	Criteria for assessing mechanical vibrations of machine.
VDI: 2060	Criteria for assessing the state of balance of rotating rigid bodies.



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SECTION-II

STANDARD TECHNICAL SPECIFICATION



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1.0 SCOPE :

This section covers supply, supervision of erection commissioning & design engineering of the vibration isolation system (VIS) suitable for ID/PA/FD Fans/ TDBFP/MDBFP/ TURBOGENERATORS/ MILLS. The vibration isolation system shall be of proven make and should be in successful operation for similar machines.

2.0 SUPPLY OF VIBRATION ISOLATION SYSTEM (VIS)

VIS shall be supplied complete along with recommended spares if any. The selection of VIS shall be done by the vendor, in case not done by customer so that the amplitude at bearing locations are within permissible limits as per machine supplier recommendation or ISO 10816 whichever is governing and no dynamic loads are transferred to structure supporting VIS. Minimum 90% isolation shall be achieved and the system shall be capable of withstanding Seismic/Wind forces.

3.0 SUPERVISION OF ERECTION AND COMMISSIONING

3.01 Manual

Vendor shall supply installation and maintenance manual indicating equipment procedures etc. necessary for installation and replacement of VIS with downtime involved.

3.02 Tools and facilities

Vendor shall supply all tools and facilities as required for successful erection and commissioning of VIS. Vendor shall deploy experienced manpower to supervise successful installation of VIS.

4.0 DESIGN ENGINEERING OF VIBRATION ISOLATION SYSTEM

4.01 Dynamic Analysis

The dynamic analysis shall consist of free vibration analysis and forced vibration analysis. Isolation efficiency of at least 90% shall be obtained. The fundamental natural frequency shall be sufficiently above or below the frequency corresponding to operating speed. Vibration amplitude shall be calculated at all bearing locations and shall satisfy the permissible limits as per ISO 10816 or as specified by the machine supplier. Transient analysis shall be carried out for the short circuit / blade failure condition with an appropriate force function if required by the machine supplier. The forces for which substructure is to be designed shall be furnished.

4.02 Static Analysis

The static analysis shall include the

- a) Dead weights of machine stationary parts
- b) Dead weights of machine rotary parts
- c) Loads due to machine power torque
- d) Loads due to maximum allowable unbalance
- e) Temperature loads
- f) Loads due to blade unbalance/short circuit
- g) Erection loads
- h) Seismic loads
- i) Any other loads given by the supplier

Various loads combinations must be investigated to obtain the most severe loads for

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foundation design purpose as per relevant IS codes or as per machine supplier recommendation whichever is more critical.

4.03 CHECK FOR SHAFT MISALIGNMENT

Foundation deck must be adequately stiff to withstand all operating load combinations without excessively upsetting the rotor shaft alignment. The structural design must carefully be analysed for relative deflection for the members supporting machine shaft to satisfy the limits as given by machine supplier if any.

4.04 DESIGN OF RCC DECK SUPPORTED ON VIS

Vendor shall provide General arrangement drawing of deck showing location and supporting detail of VIS, all embedment and their details as per the machine supplier drawing.

RCC design shall be done by working stress method for all machine foundations. Minimum reinforcement shall be governed by IS: 2974 as well IS:456.

All documents/drawings shall be supplied in 25 (twenty five) prints. All calculations shall be supplied in 6 (six) sets. Soft copy of the drawings in Auto Cad shall be supplied along with the soft copy of the documents supplied. All documentation shall be in English language and all RCC/structural design shall be conforming to the relevant Indian Standard Code of practice.

5.0 QUALITY PLAN AND TEST CERTIFICATE

Vendor shall furnish the quality plan and Test certificate for the hardware in their scope of supply. The quality plan shall be reviewed by BHEL/Consultant wherein the inspection and hold points shall be indicated. Vendor shall submit test certificate based on approved quality plan. Despatch of material by the vendor shall only take place after the receipt of Material Dispatch Clearance Certificate (MDCC) issued by BHEL/Consultant on the basis of test reports/test certificates submitted by the Vendor after manufacture.

6.0 ENVIRONMENTAL PROTECTION

VIS shall be suitably protected against environmental damages e.g. abrasion, discolouration, corrosion, oily water etc. to give a prolonged service matching the plant life.



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REFERENCE QUALITY PLAN

Manufacturer's logo		Manufacturer's name and Address				MANUFACTURING QUALITY PLAN (I-QAP)				Project: Main supplier: BHEL BHEL P.O NO:											
Sl. No.		Component and Operation		Characteristics		Class		Type of Check		Quantum of Check		Reference Document		Acceptance Norms		Format of Record		Agency		Remarks	
1		2		3		4		5		6		7		8		9		10		11	
ITEM : Vibration isolation system Equipment: Spring Unit: Module name as per Vendor QP No: Rev : Date : Page :																					
1	Materials																				
1.1	For boxes	Chemical/Mechanical	Minor	Verify	One / Heat	IS 2062/DIN EN 10025/ JVHT 02/JVHHT 01B00/SAILMA 350 HI/SAILMA 350 or equivalent															
1.2	For Springs	a) Chemical	Major	Verify	One / Lot	50 Cr V 4 As per DIN 17221 or 51 Cr V 4 As per EN10089 or Equivalent															
		b) Grain Size	Major	Verify	One / Lot	ASTM E 112															
		c) NMI	Major	Verify	One / Lot	IS 4163															
		d) Micro structure	Major	Verify	One / Lot	DIN 17221or equivalent															
1.3	Spring at Manufacturer's end	Hardness	Major	Test	One/Lot	IS 1500															
1.4	Spring at Manufacturer's end	Decarburization	Major	Test	One / Lot	IS 6396															
1.5	Spring at Manufacturer's end	NDE after compression	Major	Test	100%	IS 3703															
1.6	Spring (at vendor end)	Spring Rate	Major	Test	AQL 4.0	DIN 2096															
1.7	Adhesive pads (Jute), 4mm thick, Steel shims	Dimensions (mm)	Minor	Measure / Visual	5 %	Drawing															
1.8	Viscoliquid	Viscosity/ Penetration speed (mm/sec)	Major	Test	Sample	DIN 53019 or equivalent															
1.9	Studs & Nuts	Chemical Dimensions (mm)	Minor	Verify Measure	One / Lot 5%	IS 1367 (Grade 6.8 & Class 6) IS 4218 (Tolerance Class 6g & 6H)															
2	In Process Inspection																				
2.1	Welding	Visual / Surface exam (mm)	Major	Visual / Measure	10% on welds	Annexure-1(attached)															
2.2	Boxes	NDE	Major	DPT	10% Random	ASTM / E 165															
3	Final Inspection																				
3.1	Shot Blasting	Picture	Major	Compare	10%	EN ISO12944-4															
3.2	Painting	Thickness (180 microns)	Major	Measure / Visual	10%	Annexure-2(attached)															
3.3	Spring Unit	Dimensions (Except HF&HV)	Minor	Measure	10%	Drawing / Datasheet															
3.4	Constant of Spring Units (Vertical, Kv)	Load Vs Displacement (kN/mm)	Critical	Test	10%	DIN 2096 & DIN 2089															
3.5	Document Control	Verification of above documents (TC/IR)	Major	Compare	All	MQP															
3.6	Packing / Marking	Visual	Major	Visual / Compare	100%	As per vendor's standard															
MANUFACTURER/ SUB-CONTRACTOR		CONTRACTOR		LEGEND: # RECORDS, IDENTIFIED WITH 'TICK' SHALL BE ESSENTIALLY INCLUDED BY MANUFACTURER IN QA DOCUMENTATION M: MANUFACTURER/ SUB-CONTRACTOR C: MAIN SUPPLIER, B: CUSTOMER INDICATE 'P' PERFORM 'W' WITNESS AND 'V' VERIFICATION																	
SIGNATURE		NAME & SIGNATURE OF APPROVING AUTHORITY WITH SEAL																			

ANNEXURE - 1

WELDING

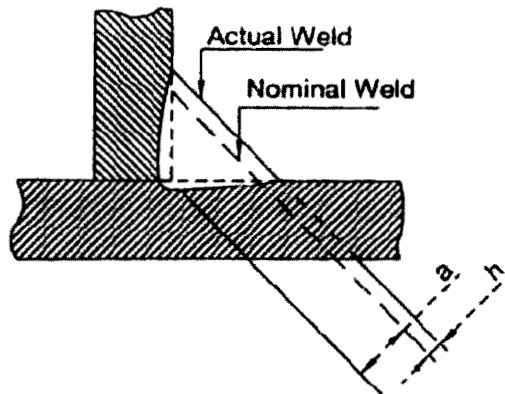
WELDING DETAILS

SI
No Imperfection
 Designation

Outside status

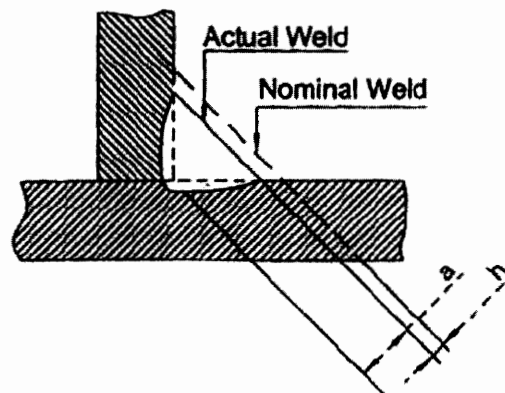
Limits for Imperfection with
reference to quality level:
DIN EN 25817 / D

1. Excessive convexity



$$h \leq 1\text{mm} + 0.25\text{ } b ; \text{max. } 5\text{mm}$$

2. Fillet weld having a throat
thickness smaller than the
nominal value

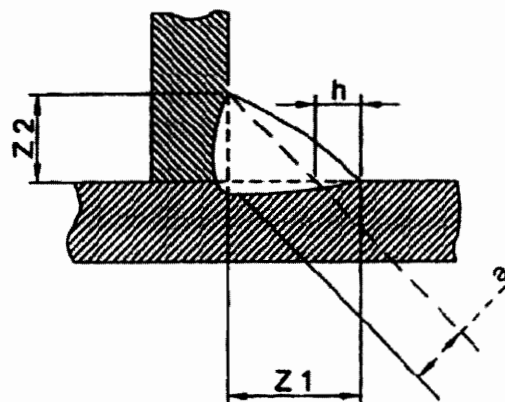


A fillet weld with an apparent throat thickness smaller than that prescribed should not be regarded as being imperfect if the actual throat thickness with a compensating greater depth of penetration complies with the nominal value.

Short imperfections: $h \leq 0.3\text{ mm} + 0.1.a$; max. 2mm

Long imperfections:
Not Permitted

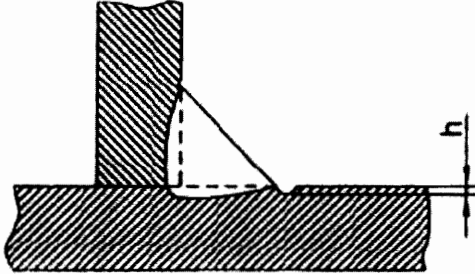
3. Excessive asymmetry
of fillet weld



It is assumed that the asymmetric fillet weld has not been expressly prescribed.

$$h \leq 2\text{mm} + 0.2\text{ } a$$

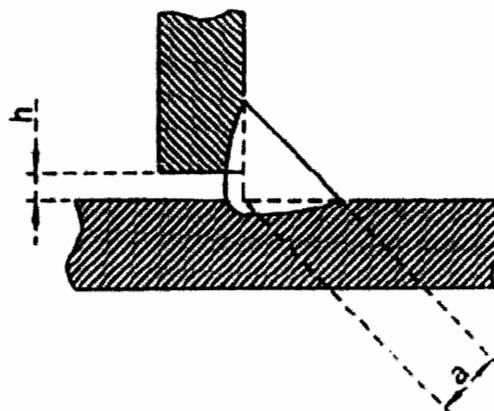
WELDING DETAILS

SI No	Imperfection Designation	Outside status	Limits for Imperfection with reference to quality level: DIN EN 25817 / D
4.	Undercut	 Smooth transition is required	$h \leq 1.5\text{mm}$
5.	Gas pores and porosity	The following conditions and limits for imperfections shall be fulfilled a) Maximum dimension of the summation of the projected or surface crack area of the imperfection. b) Maximum dimension of a single pore for -butt welds -fillet welds c) Maximum dimension for a single pore	4% $d \leq 0.5 s$ $d \leq 0.5 a$ 5 mm
6.	Localised (clustered) porosity	The total pore area within the cluster should be summed and calculated as a percentage of the greater of the two areas; an envelop surrounding all the pores or a circle with a diameter corresponding to the weld width. The permitted porous area should be local. The possibility of masking other imperfections should be taken into consideration. The following conditions and limits for imperfections shall be fulfilled: a) Maximum dimension of the summation of the projected or surface crack area of the imperfection b) Maximum dimension of a single pore for -butt weld -fillet weld c) Maximum dimension for localised clustered porosity.	16% $d \leq 0.5 s$ $d \leq 0.5 a$ 4mm

WELDING DETAILS

Sl No	Imperfection Designation	Outside status	Limits for Imperfection with reference to quality level: DIN EN 25817 / D
7.	Elongated cavities, worm holes	Long imperfections for -butt welds -fillet welds In any case, maximum dimension for elongated cavities, worm holes	$h \leq 0.5 s$ $h \leq 0.5 a$ 2mm
		Short imperfections for -butt welds -fillet welds In any case, maximum dimension for elongated cavities, worm holes	$h \leq 0.5 s$ $h \leq 0.5 a$ 4mm or Not Larger Than Thickness (NLTT)
8.	Solid inclusions (other than copper)	Long imperfections for -butt welds -fillet welds In any case, maximum dimension for elongated cavities, worm holes	$h \leq 0.5 s$ $h \leq 0.5 a$ 2mm
		Short imperfections for -butt welds -fillet welds In any case, maximum dimension for elongated cavities, worm holes	$h \leq 0.5 s$ $h \leq 0.5 a$ 4mm or Not Larger Than Thickness (NLTT)
9.	Lack of fusion (Incomplete fusion)		Permitted, but only intermittently and not breaking the surfaces

10. Bad fit-up, fillet weld

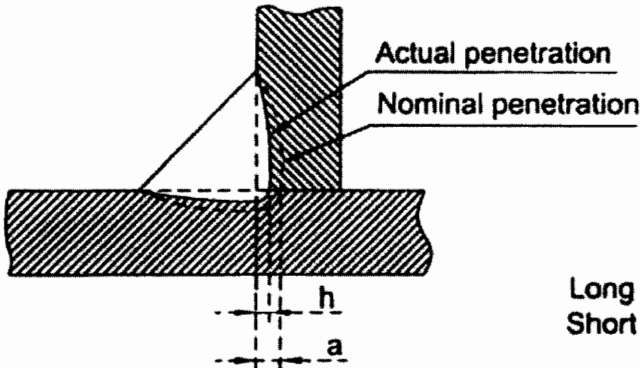


An excessive or insufficient gap between the parts to be joined. Gaps exceeding the appropriate limit may in cases be compensated for by a corresponding increase in the throat.

$$h \leq 1\text{mm} + 0.3 a$$

max. 4mm

WELDING DETAILS

SI No	Imperfection Designation	Outside status	Limits for Imperfection with reference to quality level: DIN EN 25817 / D
11.	Incomplete penetration	 Long imperfections: Not permitted Short imperfections: $h \leq 0.2 s$, max. 2mm	
12.	Cracks	All types of cracks	Not Permitted
13.	Crater cracks		Permitted
14.	Spatters	Fused welding splashes are material trickless (drops) fused to the basic material or welding seam.	Permssible
15.	Stray flash or arc strike	Ignition points are local fuses caused by the electric arc on the surface of the basic material or welding seam.	Permssible

Abbreviations

- a nominal fillet weld throat thickness (fillet thickness), in mm
- b width of weld reinforcement, in mm
- d pore diameter in mm
- h size (height or width) of imperfection, in mm
- l length of imperfection, in mm
- s nominal butt weld thickness or, in the case of partial penetration, the prescribed depth of penetration, in mm
- t tube-wall- or plate thickness, in mm
- z leg length of fillet welds (in case of isoscele-right angle triangular section $z = a \cdot \sqrt{2}$) in mm