

**TELANGANA STATE POWER GENERATION CORPORATION
LIMITED (TSGENCO)**

5X800 MW TSGENCO YADADRI TPS

***TECHNICAL SPECIFICATION
FOR
LUBE OIL TRANSFER PUMPS***

SPECIFICATION NO.: PE-TS-417-567-A001



**BHARAT HEAVY ELECTRICALS LIMITED
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA (INDIA)**



**LUBE OIL TRANSFER PUMP
PACKAGE
INDEX**

SPECIFICATION NO: PE-TS-417-567-A001

REV : 00

DATE: 04.04.2020

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**TECHNICAL SPECIFICATION FOR
LUBE OIL TRANSFER PUMP
5X800 MW TSGENCO YADADRI TPS**

SPECIFICATION NO. PE-TS-417-166-A001

SECTION 'I'

REVISION 00

DATE:04.04.2020

**SECTION – I
INTENT OF SPECIFICATION**

	TECHNICAL SPECIFICATION FOR LUBE OIL TRANSFER PUMP 5X800 MW TSGENCO YADADRI TPS		SPECIFICATION NO. PE-TS-417-166-A001
			SECTION 'I'
			REVISION 00
			DATE:04.04.2020

1.0 INTENT OF SPECIFICATION

- 1.1 The specification covers design (i.e. Preparation and submission of drawing /documents including “As Built” drawings and O&M manuals), engineering, manufacture, fabrication, assembly, inspection / testing at vendor's & sub-vendor's works, painting, maintenance tools & tackles (as applicable), fill of lubricants & consumables, supervision of E&C, mandatory spares along with spares for erection, start up and commissioning as required, forwarding, proper packing, shipment and delivery at site complete with all accessories for the total scope defined as per BHEL NIT & tender technical specification as specified, amendment & agreements till placement of order, demonstration testing and handing over to BHEL's customer of Lube Oil Transfer Pumps as per details in different sections / volumes of this specification and various pre award agreements for **5X800 MW TSGENCO YADADRI TPS**.
- 1.2 The contractor shall be responsible for providing all material, equipment & services, which are required to fulfil the intent of ensuring operability, maintainability, reliability and complete safety of the complete work covered under this specification, irrespective of whether it has been specifically listed herein or not. Omission of specific reference to any component / accessory necessary for proper performance of the equipment shall not relieve the contractor of the responsibility of providing such facilities to complete the supply, erection and commissioning, demonstration testing of **Lube Oil Transfer Pumps**.
- 1.3 It is not the intent to specify herein all the details of design and manufacture. However, the equipment shall conform in all respects to highest standards of design, engineering and workmanship and shall be capable of performing the required duties in a manner acceptable to purchaser who will interpret the meaning of drawings and specifications and shall be entitled to reject any work or material which in his judgement is not in full accordance herewith.
- 1.4 The extent of supply under the contract includes all items shown in the drawings, notwithstanding the fact that such items may have been omitted from the specification or schedules. Similarly, the extent of supply also includes all items mentioned in the specification and /or schedules, notwithstanding the fact that such items may have been omitted in the drawing. Similarly, the extent of supply also includes all items required for completion of the system and not withstanding that they may have been omitted in drawings / specifications or schedules.
- 1.5 The general term and conditions, instructions to tenderers and other attachment referred to elsewhere are made part of the tender specification. The equipment materials and works covered by this specification is subject to compliance to all attachments referred to in the specification. The bidder shall be responsible for and governed by all requirements stipulated herein.
- 1.6 While all efforts have been made to make the specification requirement complete & unambiguous, it shall be bidders' responsibility to ask for missing information, ensure

	TECHNICAL SPECIFICATION FOR LUBE OIL TRANSFER PUMP 5X800 MW TSGENCO YADADRI TPS	SPECIFICATION NO. PE-TS-417-166-A001	
		SECTION 'I'	
		REVISION 00	DATE:04.04.2020

completeness of specification, to bring out any contradictory / conflicting requirement in different sections of the specification and within a section itself to the notice of BHEL and to seek any clarification on specification requirement in the format enclosed under Vol-III of the specification within 10 days of receipt of tender documents. In absence of any such clarifications, in case of any contradictory requirement, the more stringent requirement as per interpretation of Purchaser / Customer shall prevail and shall be complied by the bidder without any commercial implication on account of the same. Further in case of any missing information in the specification not brought out by the prospective bidders as part of pre-bid clarification, the same shall be furnished by Purchaser/ Customer as and when brought to their notice either by the bidder or by purchaser/ customer themselves. However, such requirements shall be binding on the successful bidder without any commercial & delivery implication.

1.7 The bidder’s offer shall not carry any sections like clarification, interpretations and /or assumptions.

1.8 Deviations, if any, should be very clearly brought out clause by clause along with cost of withdrawal in the enclosed schedule (in Section – III); otherwise, it will be presumed that the vendor's offer is strictly in line with NIT specification. If no cost of withdrawal is given against the deviation, it will be presumed that deviation can be withdrawn without any cost to BHEL/its customer.

1.9 In the event of any conflict between the requirements of two clauses of this specification documents or requirements of different codes and standards specified, Section -I shall prevail over section –II, however more stringent requirement as per the interpretation of the owner shall apply.

1.10 In case all above requirements are not complied with, the offer may be considered as incomplete and would become liable for rejection.

1.11 For definition of word like Contractor, bidder, supplier, vendor, Customer/ Purchaser / Employer, consultant, please referred relevant clause(s) of GCC.

Note:
Bidder to note that BHEL reserves the right for drawing/document submission through web based Document Management System. Bidder would be provided access to the DMS for drawing/document approval and adequate training for the same. Detailed methodology would be finalized during the kick-off meeting. Bidder to ensure following at their end.

- Internet explorer version – Minimum Internet Explorer 7.
- Internet speed – 2 mbps (Minimum preferred).
- Pop ups from our external DMS IP (124.124.36.198) should not be blocked.
- Vendor’s internal proxy setting should not block DMS application’s link (<http://dmserver.bhelpem.com/Wrench%20Web%20Access/Login.aspx>).



TITLE

5X800 MW TSGENCO YADADRI TPS
LUBE OIL TRANSFER PUMP

PROJECT INFORMATION

SPECIFICATION NO. PE-TS-417-567-A001

REV 00

Section – I

Date :04.04.2020

SECTION: I

PROJECT INFORMATION

YADADRI THERMAL POWER STATION

PROJECT INFORMATION

1	Name of the Project	YADADRI Thermal Power Station
2	Station Capacity	5X800 MW (Coal based)
3	Owner	Telangana State Power Generation Corporation Limited (TSGENCO)
4	Site Location	Site is located 7 km from the NH5.
5	Latitude	16° 42'20.40 N
6	Longitude	79° 34'41.56 E
7	Nearest Town	30 Km Miryalaguda
8	Nearest Railway Station	6.5 Km Damercherla
9	Nearest Airport	130 Kms (Vijayawada)
10	Site Conditions	
	Ambient Temperature	
	Daily minimum (average)	10°C
	Daily maximum (average)	47°C
	Design Ambient Temperature	50°C
	Ambient temperature (performance)	38°C
	Relative Humidity for design / efficiency	48-84 %
	Annual rainfall, mm	600 mm
	Plant Elevation above MSL	85 m above MSL
	Wind Pressure	As per the latest revision of IS 875/1987

TELANGANA STATE POWER GENERATION CORPORATION LIMITED

From
Chief Engineer/Civil/ Thermal
TSGENCO, Vidyut Soudha,
Hyderabad – 500082

To
✓ The Dy.General Manager,
M/s.BHEL Camp Office,
Vidyut Soudha,
Khairtabad,
Hyderabad – 500082

Lr.No.CE/C/Thermal/KTPSD/E1/F.YTPS-M/s.BHEL/D.No. 247 /2015-16.Dt. 29.08.2015

Sir,

Sub:- YTPS – 5x800MW- Wind load & Seismic zone details - Reg

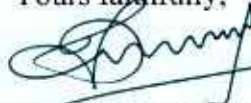
Ref: email: dated.11.08.2015 from M/s.BHEL.

...

With reference to the email cited,the details of wind load & seismic zone pertaining to proposed Yadradri Thermal Power Station (5x800MW) are herewith furnished for taking further action.

Wind load		Seismic zone	
Wind Speed	Terrain category	Seismic zone	Type of soil
44m/Sec	Category-2	Zone-III as per IS 1893:2002	Type of soil may be confirmed at your end after conducting soil investigation in the plant area.

Yours faithfully,



19/8/2015
CHIEF ENGINEER/CIVIL/THERMAL

Copy to the:

Chief Engineer/TPC/TSGENCO/Vidyut Soudha/Hyderabad.

A.S to Director/Projects/ TSGENCO/Vidyut Soudha/Hyderabad

M/s.DESEIN Private Limited, 102, First floor, My Home Sarovar Plaza, Secretariat Road, Hyderabad-500063.

जलवायवी सारणी
CLIMATOLOGICAL TABLE

BACK

स्टेशन : नलगोंदा
STATION : Nalgonda

अक्षांश
LAT. 17°03'
देशांतर
LONG. 79°16'

समुद्री तल माध्य से ऊंचाई
HEIGHT ABOVE M.S.L. 227 METRES

प्रक्षेपों पर आधारित
BASED ON OBSERVATIONS 1975-2000

माह		स्टेशन का सतह दाब	वायु तापमान										आर्द्रता		मेघ की मात्रा		BASED ON OBSERVATIONS 1975-2000							
			माध्य					चरम					सपेक्ष आर्द्रता		समस्त मेघ		मासिक योग	वर्षा के दिनों की संख्या	वर्षा					माध्य पवन गति
			शुष्क बल्व	नम बल्व	दैनिक अधिक नम	दैनिक न्यून तम	माह में उच्चतम	माह में निम्नतम	दिनांक और वर्ष	उच्चतम	निम्नतम	दिनांक और वर्ष							वर्षा सहित सबसे नम महीने का योग	वर्षा सहित शुष्कतम महीने का योग	24 घंटों की सबसे भारी वर्षा	दिनांक और वर्ष		
MONTH		STATION LEVEL PRESSURE	AIR TEMPERATURE						HUMIDITY				CLOUD AMOUNTS		RAINFALL							MEAN WIND SPEED		
			DRY BULB	WET BULB	DAILY MAX	DAILY MIN	HIGHEST IN THE MONTH	LOWEST IN THE MONTH	HIGHEST	DATE AND YEAR	LOWEST	DATE AND YEAR	RELATIVE HUMIDITY	VAPOUR PRESSURE	ALL CLOUDS	LOW CLOUDS	MONTHLY TOTAL	NO. OF RAINY DAYS	TOTAL IN WETTEST MONTH WITH YEAR	TOTAL IN DRIEST MONTH WITH YEAR	HEAVIEST FALL IN 24 HOURS		DATE AND YEAR	
		एच.पी.ए. hPa	डि. से °C	डि. से °C	डि. से °C	डि. से °C	डि. से °C	डि. से °C	डि. से °C	डि. से °C	डि. से °C	डि. से °C	प्रतिशत %	एच.पी.ए. hPa	आकाश के अष्टमारा Oktas of sky	मि.मि. mm		मि.मि. mm	मि.मि. mm	मि.मि. mm	मि.मि. mm	कि.मी. प्र. घं. Km/h		
जनवरी JAN	I II	989.9	21.3	19.3	30.8	18.4	33.8	16.1	36.0	17 1998	14.4	7 1992	82	21.2	2.0 1.8		13.5 0.4	155.7 1978	0.0	55.4	11 1978			
फरवरी FEB	I II	988.0	23.6	21.5	33.5	20.7	36.5	18.0	39.0	26 1980	15.4	5 1988	82	24.1	3.0 2.5		7.2 0.5	14.0 1999	0.0	49.2	20 2000			
मार्च MAR	I II	985.8	26.2	23.7	37.3	22.8	40.9	19.9	42.0	14 1983			80	27.4	1.7 1.4		6.5 0.4	88.5 1981	0.0	43.6	13 1981			
अप्रैल APR	I II	983.6	29.2	25.5	39.6	25.5	43.0	22.4	44.5	30 1991	14.6	15 1987	73	29.7	2.1 2.0		17.6 1.0	65.6 1981	0.0	40.6	24 1981			
मई MAY	I II	980.8	31.9	26.3	41.2	28.2	44.8	23.5	46.1	26 1984			63	29.7	2.7 2.5		27.0 1.4	94.3 1991	0.0	49.0	5 1981			
जून JUN	I II	978.2	29.8	25.7	37.6	27.2	42.6	23.4	46.3	2 1998	21.8	12 1991	71	29.9	5.1 4.4		65.9 3.5	48.2 2000	0.0	81.7	12 1991			
जुलाई JUL	I II	978.8	27.7	24.7	33.9	25.5	37.3	23.2	39.2	7 1992	22.0	2 1992	77	28.6	6.3 5.8		124.6 6.0	176.7 1977	36.8 1979	99.2	24 1977			
अगस्त AUG	I II	979.6	27.1	24.3	32.8	25.0	35.4	22.8	37.5	25 1979	22.0	2 1981	78	28.2	6.1 6.0		133.0 6.7	189.0 1998	33.2 1979	88.2	14 1977			
सितम्बर SEP	I II	982.0	27.4	24.4	33.6	24.9	36.4	22.8	38.5	23 1987	21.6	8 1989	77	28.3	4.9 4.2		145.5 5.8	393.1 1991	20.3 1984	152.2	21 1991			
अक्टूबर OCT	I II	985.3	26.6	23.8	33.1	23.7	36.2	21.4	36.5	1 1987	19.2	28 1980	78	27.2	4.0 3.7		104.3 3.8	333.1 1981	4.2 1984	109.2	6 1987			
नवम्बर NOV	I II	987.9	24.2	21.0	31.1	21.2	33.5	17.9	35.5	7 1996	14.6	27 1981	75	22.6	3.2 2.6		48.1 2.8	66.8 1991	1.1 1981	163.5	4 1987			
दिसम्बर DEC	I II	990.3	21.7	18.6	30.0	18.6	32.2	15.7			12.6	16 1993	73	19.4	2.7 2.3		3.8 0.3	3.1 1987	0.0	3.1	10 1987			
वार्षिक योग या माध्य ANNUAL TOTAL OR MEAN	I II	983.9	26.7	23.4	34.8	23.7	44.3	15.9	46.3	2 1998	12.6	16 1993	75	26.6	3.7 3.2		696.8 32.5	631.7 1982	631.7 1982	163.5	4 1987			
वर्षों की सं NUMBER OF YEARS	I II	19	19	19	19	21	22		19	19			19	19	18 17		20 20	16 16	23					

STATION : नलगोंदा
STATION : Nalgonda

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TITLE

5X800 MW TSGENCO YADADRI TPS
LUBE OIL TRANSFER PUMP

SPECIFICATION NO. PE-TS-417-567-A001

REV 00

Section – IA

Date :04.04.2020

SECTION: IA

SPECIFIC TECHNICAL REQUIREMENT(MECHANICAL)



TITLE

**TECHNICAL SPECIFICATION
FOR
LUBE OIL PUMPS
(Specific Technical Requirements)**

SPECIFICATION NO. PE-TS-417-567-A001

SECTION : I A

REV 00

DATE: 04.04.2020

1.0 SCOPE OF WORK

- 1.1** Design, engineering, manufacturing, inspection and testing at manufacturer's works, painting, supply/delivery duly packed at project site for pump & motor set duly coupled and unitised on a common base frame with coupling guard, foundation bolts, flanges, companion flanges with nuts bolts and gaskets, drip pan with plugged draining arrangement, strainer with flanges, companion flanges, nuts, bolts & gaskets, foundation bolts etc. along with commissioning spares and all accessories as indicated in the **pump Datasheet-C under SECTION -IC.**

The scope of equipment (Quantity, Capacity, Head and the type of strainer) to be supplied shall be as per Data sheet-A (PE-DC-417-100-Q012) given under SECTION- IC.

- 1.2 Mandatory spares:** Applicable (refer section-IA)

- 1.3 Supervision of Erection & Commissioning:** Applicable (refer point no.9.0)

2.0 TERMINAL POINT

- a) Suction strainer nozzle counter flange (suction side)
- b) Pump discharge nozzle's counter flange.

- 2.1** For electrical system, bidder's scope shall terminate at motor terminal box complete with cable glands/ lugs for power cabling. Also refer electrical scope between BHEL & Vendor given under **Electrical portion** of specification under section-IB.

3.0 EXCLUSIONS

- 3.1 Power Cable
- 3.2 Motor starter in MCC
- 3.3 Local Push Button Station
- 3.4 Feeder for motor
- 3.5 Earthing of Pumps. However, earthing conductor is to be provided by the bidder.
- 3.6 Foundation & associated civil works.

4.0 CORROSION PROTECTION/ PAINTING SCHEDULE

	External
Surface preparation	Surface shall be degreased and prepared by brush/mechanical tool/ blasting as per manufacturing guidelines.
Primer Coat	One coat of epoxy based zinc rich primer of minimum DFT 50 micron.
Intermediate coat	One coat of epoxy based TiO ₂ pigmented polyamide cured paint of DFT 50 microns.
Finish	Two coat, each of DFT 50 microns per coat of aliphatic acrylic 2 pack polyurethane finish paint. Thus a total DFT of 200 microns shall be achieved. Paint shade shall be IS-631-LIGHT GREY).

Note:

- I. Any change in painting specification at later date needs to be complied by bidder without any Commercial implication. Bidder to refer **section IA** for detailed painting specification.
- II. Make of paints shall be as Asian Paints, Berger paints or Good lass Nerolac.



TITLE

**TECHNICAL SPECIFICATION
FOR
LUBE OIL PUMPS
(Specific Technical Requirements)**

SPECIFICATION NO. PE-TS-417-567-A001

SECTION : I A

REV 00

DATE: 04.04.2020

5.0 QUALITY REQUIREMENTS

- a) Bidder should maintain excellent quality of works, all supply items shall meet the relevant quality Standards.
- b) The successful bidder shall furnish Quality Plans/ Inspection Check Lists for various item for the Package in line with minimum requirement indicated in specification during detail engineering for Customer's approval.
- c) For other items for which any specific inspection requirement is not indicated in the specification but the same included in scope of work, vendor specific QPs/ CLs shall be furnished by the successful bidder for Customer/Consultant's review and approval. All comments made by customer/ consultant shall be incorporated by the successful bidder without any commercial and delivery implication.

6.0 DRAWINGS AND DOCUMENTS TO BE SUBMITTED WITH THE BID

The drawings and documents to be submitted with the bid shall be as per list given under SECTION-III.A.

7.0 DRAWINGS AND DOCUMENTS REQUIRED DURING DETAIL ENGINEERING

List of drawings / documents required during detail engineering along with submission Schedule is given under SECTION-IA.

Further, bidder to prepare the drawings & docs in line with general Mech. & Elect. guidelines given under Section-I.

8.0 SUB-VENDOR ITEMS

The maker of sub-vendor items indicated under section -IA of specification are subject to acceptance by customer without any additional commercial implication to BHEL.

9.0 SUPERVISION OF ERECTION & COMMISSIONING:

The erection of Lube oil transfer pumps and its accessories will be done by owner as per Erection Manual and check List to be provided by the bidder during detail engineering. However, the bidder shall make visit as per enquiry/PO for the supervision of erection, pre-commissioning & post- commissioning check-up, start-up, testing and trial runs of all the items covered under the scope of supply & Services.

The Scope of Supervision for Erection & commissioning: Tentatively following visits shall be planned by site team which shall be as follows: -

- Two visits (for all agitators) of 7 days each for supervision for erection, pre-commissioning & post-commissioning check-up, start-up, testing and trial runs of all the items covered under the scope of supply & Services.
- The total lump sum price of visit & man days shall include travel expenses to & fro site, insurance (if applicable), boarding & lodging etc. at site including the supervision charges for erection, commissioning, performance testing or any other services at site. The no. of man days shall be decided from the day of actual commencement of supervision at site/availability of site for supervision activity excluding travel to & from site.

Note: Bidder shall be informed at least 10 days in advance for the requirement of visit at site. Visiting team shall consist of one or two expert as deemed necessary by the bidder.

	TITLE 5X800 MW TSGENCO YADADRI TPS LUBE OIL TRANSFER PUMP	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
		Section – IA	Date
SECTION – IA GENERAL TECHNICAL REQUIREMENT			

GENERAL TECHNICAL REQUIREMENTS

1.00.00 CODES AND STANDARDS

1.01.00 Except where otherwise specified, the Plant shall comply with the appropriate Indian Standard or an agreed internationally accepted Standard Specification as listed in the annexure to this Section and mentioned in detailed specifications, each incorporating the latest revisions at the time of tendering. Where no internationally accepted standard is applicable, the Bidder shall give all particulars and details as necessary; to enable the Owner to identify all of the Plant in the same detail as would be possible had there been a Standard Specification.

1.02.00 Where the Bidder proposes alternative codes or standards he shall include in his tender one copy (in English) of each Standard Specification to which materials offered shall comply. In such case, the adopted alternative standard shall be equivalent or superior to the standards mentioned in the specification.

1.03.00 The plant will be designed in compliance with applicable National and International Codes and Standards such as ASME, ASTM, DIN, BS, IEC, IEEE, IS, etc. Wherever specified or required the Plant shall conform to various statutory regulations such as Indian Boiler Regulations, Indian Explosives Act, Indian Factories Act, Indian Electricity Act, Environmental Regulations, etc. Wherever required, approval for the plant supplied under the specification from statutory authorities shall be the responsibility of the Contractor.

1.04.00 In the event of any conflict between the codes and standards referred above, and the requirements of this specification, the requirements, which are more stringent, shall govern.

1.05.00 In case of any change of code, standards and regulations between the date of purchase order and the date the Contractor proceeds with manufacturing the Owner shall have the option to incorporate the changed requirements. It shall be the responsibility of the Contractor to advise Owner of the resulting effect.

1.06.00 Successful Bidder to furnish two (2) sets of latest of national/inter-national codes and standards to owner.

2.00.00 RESPONSIBILITY FOR DESIGN

2.01.00 The Contractor shall assume full responsibility for the design of the whole and every portion of the Plant, whether or not the design work was undertaken specifically in relation to the Contract and whether or not the Contractor was directly involved in the design work.

-
- 2.02.00 Notwithstanding the Owner's wish to receive the benefits of new, advanced and improved technologies, a prime requirement is that all the systems and components proposed shall have been already adequately developed and shall have demonstrated good reliability under similar, or more arduous conditions elsewhere, at least for continuous 2 years in two different power station.
- 2.03.00 The successful bidder shall have to carry out surge analysis, BFP transient analysis and other transient condition studies as may be necessary and as required by the Owner as per proven engineering practice.
- 2.04.00 The Bid shall include a detailed discussion on the development status of, and the reasons for any changes made in proposed systems or components for the Plant, as compared with similar items previously supplied in other installations cited by the bidder as reference plants.
- 2.05.00 The Bidder may also make alternate offers, provided such offers are superior in his opinion in which case adequate technical information, operating feed back, etc. are to be enclosed with the offer, to enable the Owner to assess the superiority and reliability of the alternatives offered. In case of each alternative offer, its implications on the performance, guaranteed efficiency, auxiliary power consumptions, etc. shall be clearly brought out to the Owner to make an overall assessment. In any case, the base offer shall necessarily be in line with the specifications i.e. Base offer shall be as per the technical specifications and the same will be considered for techno-commercial evaluation.
- 3.00.00 **NAME PLATES (RATING PLATES)**
- 3.01.00 Instruction plates, name plates or labels shall be permanently attached to each main and auxiliary item of plant in a conspicuous position. These plates shall be engraved with the identifying name, type and manufacturers serial number, together with the loading conditions under which the item of plant has been designed to operate.
- 3.02.00 Items such as valves, etc. which are subject to hand operation, shall be provided with nameplates so constructed as to remain clearly legible throughout the life of the plant giving due consideration to the difficult climatic conditions to be encountered. Nameplates shall be securely mounted where they will not be obscured in service by insulation, cladding, actuators or other equipment. Direction of flow is also to be engraved.
- 3.03.00 All trade nameplates and labels shall be in English language. All measurements shall be in M.K.S. Units.
- 3.04.00 The size and location of nameplates shall be subject to Approval of the Engineer.
- 4.00.00 **SAFETY AND SECURITY**
- 4.01.00 The design shall incorporate every reasonable precaution and provision for the safety of all personnel and for the safety and security of all persons and

property. The design shall comply with all appropriate statutory regulations relating to safety. All structures and equipment shall be designed and constructed to withstand every foreseeable static and dynamic loading condition, including loading under earthquake conditions, with an adequate margin of safety.

4.02.00 Ready and safe access with clear head room shall be provided to all parts of the plant for operation, inspection, cleaning and maintenance.

4.03.00 Escape routes and clear ways shall be provided to allow speedy evacuation of the plant in the event of fire or explosion, and the plant layout shall allow for ease of access to all parts of the Works by rescue and fire fighting teams. The plant layout shall be designed to localise and minimise the effects of any fire or explosion. The recommendations of NFPA, OSHA, and TAC etc. as necessary shall be followed in all respects.

4.04.00 The use of corrosive, explosive, toxic or otherwise hazardous materials shall be kept to a minimum during construction and the design of the plant shall minimise the requirement for such materials during operation and maintenance. Where such materials must be used, all necessary precautions shall be taken in the design, manufacture and layout of equipment to minimise the resulting hazard, and all equipment necessary for the protection and first-aid treatment of personnel in the event of accidents shall be provided. Particular attention is drawn to avoid the use of materials containing asbestos in any form.

5.00.00 **GUARDS**

5.01.00 Effective guards and fences must be provided to prevent injury to operators through accident or malpractice.

5.02.00 Mesh guards which allow visual inspection of equipment with the guard in place are generally preferable. The guards shall be constructed of mesh attached to a rigid framework of mild steel rod, tube, or angle and the whole galvanised to prevent loss of strength by rusting or corrosion. The guards shall be designed to facilitate removal and replacement during maintenance.

5.03.00 All drive belts, couplings, gears, sharp metallic edges and chains must be safely guarded. Any lubricating nipple requiring attention during normal running must be positioned where they can be reached without moving the guards.

5.04.00 Guards for couplings and rotating shafts shall be in accordance with BS 5304-1975 or similar approved standard. All rotating shafts and parts of shafts must be covered.

5.05.00 Suitable fencing shall be provided to enclose all openings or doorways used for the hoisting and lowering of machinery etc. This fencing must be securely fixed but quickly detachable when required. A secure hand hold must be provided on each side of the opening or doorway.

LOCATION AND LAYOUT REQUIREMENTS

The majority of plant and equipment (excluding steam generator and some other auxiliaries) shall all be of indoor installation. A broad list of buildings housing such equipment is given elsewhere in this specification. Layout should facilitate access for operation-maintenance and inspection of any one or more equipment/components at a time without disturbing the operation or installation of rest of the plant. Further, Bidder should comply with the criteria given under the various equipment and system specifications as well as those stipulated in Annexure-II attached to this section.

Enclosed General Layout and other tender layout drawings show the location of major installations and auxiliary buildings. The Bidder shall try to retain these locations as far as practicable. The layout of equipment within the power house as shown in the tender drawings is indicative. The Bidder may, subject to Owner's approval alter the same to suit the space requirement of the equipment offered.

Bidder may give as an alternative his own preferred layout clearly indicating the advantages and other implications, if any. Such alternative will not be considered for evaluating the bid, but may be considered with the successful Bidder if Owner/Engineer finds the proposal more attractive in terms of techno-economic consideration.

While developing the layout of buildings the following criteria shall be given effect :

- a) The minimum width of clear access corridors around equipment shall be 1.2 meter.
- b) Each building shall have an identified vacant space for equipment unloading and maintenance and preferably a separate bay altogether in buildings housing heavy equipment. Provision for handling equipment by monorail hoist and/or overhead crane shall be made as specified.
- c) The minimum clear height available between two consecutive floor slabs shall not be less than five (5) meters. A clear head room of 2.5m shall be maintained between the floor and any overhead piping/ cables or other obstruction. Adequate provision for natural ventilation and illumination shall be made as per good engineering practices.
- d) There shall be at least two (2) nos. main access doors, one on either side of each building, of which one shall be minimum 3 meters wide with rolling shutters for equipment entry. For multistoried buildings, at least two (2) nos. regular staircases diagonally opposite to each other shall be provided connecting all the floors and roof. These minimum requirements shall be augmented as required depending on the floor area, statutory requirements and TAC recommendations.
- e) All buildings shall have provision for toilet and associated effluent discharge system together with facility for drinking water. The criteria for ventilation, fire protection and illumination of building spaces specified

elsewhere in this specification shall be complied with.

- f) All rail/road crossings for pipe/cable racks shall be done with minimum 8 meters headroom from top of rail/road to bottom of rack. Similarly top cover over underground pipes/cables shall be minimum one (1) meter. For other detail refer to Annexure-II.
- g) Cubicle for operating personnel shall be located at safe place near the equipment.
- h) Interplant cable routing will be on overhead cable trays on pipe cum cable trestle or on cable trestle except where approved by purchaser/consultant. In exceptional case, small stretch of outdoor run of interplant cable routing may be taken through cable trench only with the Employer's prior approval.
- i) Concept of various mechanical and electrical equipment location and building dimensions (including column-row spacing) as shown in Plot Plan/Floor Plan drawing are to be adhered to. Any departure from this suggestive layout is primarily not recommended.

7.00.00 OPERATION, MAINTENANCE & AVAILABILITY CONSIDERATIONS

7.01.00 Equipment/works offered shall be designed for high availability, high reliability, low maintenance and ease of operation & maintenance. The Bidder shall specifically state the design features incorporated to achieve high degree of reliability, availability, operability and ease of maintenance. He shall also furnish details of availability records in plants stated in his experience list.

7.02.00 Ample space for ease of operation and maintenance including equipment removal, tube bundle/cartridge/rotor pulling etc. shall be provided. All valves, gates, dampers and other devices shall be located and oriented in such a way that they are accessible from operating floor levels. Where this cannot be adhered to, platforms and walkways with access ladders shall be provided to facilitate operation and maintenance.

7.03.0 Motorised lifting devices, i.e. hoists, chain pulleys, jacks, etc. shall be provided for handling and carrying out maintenance of any equipment and/or part having weight in excess of 2000 Kg. Suitable beams, hooks etc. for this purpose shall be provided in the buildings.

No lifting arrangement is necessary for part having weight less than 500 Kg. Hoist shall be well protected by environment. Suitable painting and coating covering hoist at outdoor shall be provided.

Lifting devices like lifting tackles, slings, etc. to be connected to hook of the hoist/crane shall be provided by the Bidder for lifting the equipment, accessories covered under this specification.

7.04.00 All similar parts of the equipment shall be made to gauge and shall be interchangeable with and shall be made of same material and workmanship as the corresponding parts of the equipment. Where feasible common

components shall be employed in different pieces of equipment in order to optimize the spares inventory and utilization.

8.00.00 **MATERIALS**

8.01.00 In selecting materials of construction of equipment, the Contractor shall pay particular attention to the atmospheric conditions existing at the Site and the nature of material/fluid handled. Wherever deviations are taken in respect of materials specified, the reasons shall be spelt out clearly in the proposal.

All materials shall be new, and shall be of the quality most suited to the proposed application.

8.02.00 In as far as is possible; materials shall be in accordance with Indian or international standard specifications and shall be used in accordance with Indian or international codes of practice. Where such standards or codes of practice are not available sufficient information shall be provided to allow the Owner to assess the suitability of the material for the particular application.

All materials used shall have performed lengthy satisfactory service in similar or more arduous conditions to those proposed by the Contractor.

8.03.00 All parts which could deteriorate or corrode under the influence of the atmospheric, meteorological or soil conditions at the Site, or under the influence of the working conditions shall be suitably and effectively protected so that such deterioration or corrosion is a minimum over the life of the plant.

9.00.00 **LUBRICATION**

9.01.00 Provision shall be made for suitable efficient lubrication where necessary to ensure smooth operation free from undue wear.

9.02.00 Non ferrous capillary tubing shall be used throughout.

9.03.00 Gear boxes and oil baths shall be provided with filling and drain plugs, both of adequate size. An approved means of oil indication including level switches and temperature indication shall be provided.

9.04.00 All high speed gears shall be oil bath lubricated. Low speed gears shall be lubricated by means of soft grease. Removable and accessible drip pans shall be provided to collect lubricant which may drop from operating parts.

9.05.00 All lubrication points shall be conveniently situated for maintenance purposes. It must be possible to carry out lubrication from a gangway or landing and without the removal of guarding or having to insert the hand into it. Where accessibility to a bearing for oiling purposes would be difficult a method of remote lubrication shall be fitted.

9.06.00 The Contractor shall supply grease gun equipment suitable to service each type of nipple fitted.

10.00.00 **LUBRICANTS AND CONTROL FLUIDS**

10.01.00 The Contractor shall provide a detailed and comprehensive specification for all lubricating oils, greases and control fluids required for the entire plant. A sufficient supply of these shall be provided by the Contractor for initial commissioning, first fill and till COD of the unit.

10.02.00 The Contractor shall supply a detailed schedule giving the lubricant testing, cleaning and replacement procedures. All equipment and facilities necessary for the testing, cleaning and changing of lubricants and control fluids shall be provided. The Contractor shall endeavor to reduce the varieties and grades of required lubricants and control fluids to a minimum, matching them where possible to those already in use in the generating station in order to simplify procurement and minimise storage requirements. All lubricants and control fluids shall be of internationally recognised standards and shall be easily obtainable from a large number of Indian suppliers. Bidder shall also indicate the equivalent Indian Standard for the above for easy procurement in future.

10.03.00 No lubricant or control fluid shall have toxic or other harmful effects on personnel or on the environment.

11.00.00 **OPERATION AND MAINTENANCE**

11.01.00 The plant shall be designed and constructed so that operation and maintenance manpower requirements are minimised.

The design and layout shall facilitate inspection, cleaning, maintenance and repair. The importance of continuity of operation is second only to that of safety.

11.02.00 Spare parts for equipment shall be interchangeable with the original components and, so far as possible, be of common design and manufacture.

11.03.00 All similar standard components/parts of similar standard equipment provided shall be interchangeable with one another. Further identical equipments shall be provided for similar duties so that the same are interchangeable with one another in totality and component wise.

11.04.00 All heavy parts (500 Kg and above) must be provided with a convenient arrangement for slinging and handling during erection and overhaul. Any item of plant normally stripped or lifted during periods of maintenance and weighing one tonne or above, shall be clearly marked with its weight.

11.05.00 On completion of commissioning, a complete set of tools for the maintenance of the entire plant shall be provided by the Contractor. This shall include all necessary spanners, special wrenches, extraction equipment and any special tools reasonably required by the Engineer. Tools used during erection and commissioning shall not be accepted except with the specific approval of the Engineer.

11.06.00 All equipment and major valves should be provided with adequate maintenance approach and facility.

12.00.00

PLANT LIFE AND MODE OF OPERATION

The complete plant including all the equipment and systems individually and collectively shall be designed for continuous operation for an economic service life of thirty (30) years under the prevailing site conditions and for the type of duty intended.

The critical components of the Steam Generator, Turbine-Generator and Auxiliary equipment, the life of which is limited by time and temperature dependent mechanisms such as thermal stress, creep and low cycle fatigue, are to be designed considering expected (hot, warm and cold) start-up, shut-down and cyclic load variations.

The allowable stresses shall be reduced so that life expectancy to minimum 2,00,000 hours of operation can be achieved. The Bidder shall discuss this aspect in his technical proposal.

The unit would be operated on base load with cyclic load variation. The load variation is expected to be as per schedule depending on power demand.

The expected start-ups should be considered as minimum
(Based on HPT metal temperature)

Cold start-up (>72 hrs. shutdown)	:	6 per year
Warm start-up (between 10 to 72 hrs. of shutdown)	:	40 per year
Hot start-up (less than 10 hrs. shutdown)	:	160 per year

13.00.00

PACKAGING & MARKING

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. While packing all the materials, the limitations from the point of view of availability of railway wagon sizes in India should be taken account of. The details of various wagons normally available with Indian Railways for transportation of heavy equipment shall be considered by the Bidder. The Contractor shall be responsible for all loss or damage during transportation, handling and storage due to improper packing.

As per the information available, the dimensions of OD consignment for transportation of the equipment by rail (if any equipment to be handled through rail transportation) are as below :

- | | | | |
|----|---|---|-------------|
| a) | Width of the Package
(from centre-line of rails
- 1.6 metres on both sides) | : | 3.2 Meters |
| b) | Height of the package from rail top | : | 4.47 Meters |

The above indicates the dimensions which can be normally transported on the

wagons without infringement of the "moving gauge". This is however not indicative of the consignment which can be carried out with infringement of "moving gauge" duly authorised and approved by the Indian Railways. There may be difference between the "moving gauge" and the "fixed structure gauge" and consignments infringing the "moving gauge" can be moved after investigation regarding possible infringement with the fixed structures. As the critical fixed structures in each route are different, consignments infringing moving dimensions have to be individually investigated to select a route and also determine the restrictions under which such movement is to be carried out. Such routes selected or other mode of transport envisaged is to be clearly brought out in the proposal wherever transport of over dimensional equipment is involved.

Bidder to consider unloading of material delivered through rail transportation, at near by railway station/ site unloading siding. The subsequent transportation up to project work place shall be considered by road only. All unloading and handling equipment both at railway station siding and at project site shall be arranged by the Bidder. Necessary arrangement to be organized with the railway authority for such purpose shall also be under the scope of services of the Bidder. Bidder may consider entire material delivered up to site through rail transportation only.

The identification marking indicating the name and address of the consignee shall be clearly marked in indelible ink on two opposite sides and top of each of the packages. In addition the Contractor shall include in the marking gross and net weight, outer dimension and cubic measurement. Each package shall be accompanied by a packing note (in weather proof paper) quoting specifically the name of the Contractor, the number and date of contract and names of the office placing the contract, nomenclature of contents and Bill of Material.

For imported equipment and material, suitable port facilities may be used in which case material may be transported from the port by tractor-trailer. Bidder may consider this aspect.

14.00.00

PROTECTION

Equipment having antifriction or sleeve bearings shall be protected by weather-tight enclosures. Coated surfaces shall be protected against impact, abrasion, discoloration and other damages. Surfaces that are damaged shall be repainted.

Electrical equipment, controls and insulations shall be protected against moisture and water damages. All external gasket surfaces and flange faces, couplings, rotating equipment shafts, bearings and like items shall be thoroughly cleaned and coated with rust preventive compound as specified above and protected with suitable wood, metal or other substantial type covering to ensure their full protection. All exposed threaded parts shall be greased and protected with metallic or other substantial type protectors.

All piping, tubing and conduit connections on equipment and other equipment openings shall be closed with rough usage covers or plugs. Female threaded openings shall be closed with rough usage covers or forged steel plugs. The closures shall be taped to seal the interior of the equipment. Open ends of

pipings, tubing and conduit shall be sealed and taped.

Returnable containers and special shipping devices shall be returned by the manufacturer's field representative at the Contractor's expense.

15.00.00 **ENVIRONMENT PROTECTION AND NOISE LEVEL REQUIREMENT**

15.01.00 **Environment Protection**

The plant shall be designed for installation and operation in harmony with the surrounding environment and all measures of pollution control shall be ensured by the Bidder to restrict pollution from the liquid effluent and stack emission within the limits as given below with due consideration of Environment (Protection) Rules 1986 as amended till date.

In case the Ministry of Environment & Forest stipulate any other conditions not specified hereunder while clearing the project shall be complied with the plant by the contractor.

15.01.01 For Liquid Effluent

- a) Provision laid down in schedule-I for Thermal Power Plants and also in Schedule-VI. General Standards for discharge of Environmental pollutants Part-A : Effects of Environmental (protection) Rules 1986, as amended till date.
- b) Any specific requirement of State Pollution Authorities over and above the above stipulation.

15.01.02 For Air Emission

- a) Suspended Particulate Matter i.e. dust burden at chimney outlet - Maximum 50 mg/Nm³ (with worst coal and one field out at TMCR).
- b) NO_x - 365 ppm Max. or 750 mg/Nm³ (Equivalent NO₂).
- c) SO₂ - Concentration based standard 2000 mg/Nm³. Load based standard 0.2 metric tonne /MWe/day (for first 500 MW and 0.1 metric tonne/MWe/day for rest of the capacity above 500 MW)

In absence of Indian Standard for emission from power plants as on date, for certain gaseous effluents, the internationally accepted World Bank Standard is to be followed. Indian Standard for emission of power plants are under formulation. Should this standard is published before finalisation of the contract, the bidder has to comply the more stringent of the above norm or the new Indian Standard.

The bidder shall include in his scope all necessary equipment and measuring instruments to comply with above requirements. Location and accessibility of the instruments shall be properly coordinated.

15.02.00 **Noise Level Requirement**

The plant will be designed, constructed and provided with suitable acoustic measures to ensure the noise level criteria as per the following stipulations.

- a) Maximum noise level shall not exceed 85 dB (A) when measured at 1.0M away from the noise emission source.
- b) Maximum noise level from its source within the premises shall not exceed 70 dB (A) as per Environment (Protection) Rules 1986, Schedule-III, 'Ambient Air Quality Standards' in respect of noise.
- c) Any statutory changes in stipulations regarding noise limitation that may occur in future according to State Pollution Control Board or Central pollution Control Board or Ministry of Environment & Forest regulation during tenure of the contract, the contractor shall comply with the requirement.

An exception will be made for the plant at startup operations and other big pressure reducing devices operating during emergency periods and for the safety valves.

16.00.00 **INSPECTION AND TESTING**

16.01.00 **Inspection and Tests during Manufacture**

- 16.01.01 The method and techniques to be used by the Contractor for the control of quality during manufacture of all plant and equipment shall be agreed with the Owner prior to the Award of Contract.
- 16.01.02 The Owner's general requirements with respect to quality control and the required shop tests are set out elsewhere in this specification.
- 16.01.03 Before any item of plant or equipment leaves its place of manufacture the Owner shall be given the option of witnessing inspections and tests for compliance with the specification and related standards.
- 16.01.04 Advance notice shall be given to the Owner as agreed in the Contract, prior to the stage of manufacture being reached, and the piece of plant must be held at this stage until the Owner has inspected the piece, or has advised in writing that inspection is waived. If having consulted the Owner and given reasonable notice in writing of the date on which the piece of plant will be available for inspection, the Owner does not attend the Contractor may proceed with manufacture having forwarded to the Owner duly certified copies of his own inspection and test results.

The Contractor shall forthwith forward to the engineer duly certified copies of the Test Certificates in six copies (one to the Purchaser and five to the Consulting Engineer) for approval. Distribution of six (6) copies of Test Certificates for approval will be two(2) copies to owner and four(4) copies to consultant. These four(4) copies will be further distributed by consultant after approval to owner, site and bidder. One copy will be retained with the

consultant for record purpose.

Further, nine (9) copies of Shop Test Certificates shall be bound with Instruction Manuals referred to elsewhere. Distribution of nine (9) copies of Shop Test Certificates for approval will be Two (2) copies to owner, Three (3) copies to site, Two (2) copies to consultant, Two (2) copies to owner's library / record.

16.01.05 Under no circumstances any repair or welding of castings be carried out without the consent of the Owner's Engineer. Proof of the effectiveness of each repair by radiographic and/or other non-destructive testing technique, shall be provided to the Engineer along with Defect Map.

16.01.06 All the individual and assembled rotating parts shall be statically and dynamically balanced in the works.

Where accurate alignment is necessary for component parts of machinery normally assembled on site, the Contractor shall allow for trial assembly prior to despatch from place of manufacture.

16.01.07 All materials used for the manufacture of equipment covered under this specification shall be of tested quality. Relevant test certificates shall be made available to the Purchaser. The certificates shall include tests for mechanical properties and chemical analysis of representative material or any other test as required by approved QAP/ Material specification.

16.01.08 All pressure parts connected to pumping main shall be subjected to hydraulic testing at a pressure of 150% of shut-off head for a period not less than one hour. Other parts shall be tested for one and half times the maximum operating pressure or as required by design code of that part, for a period not less than one hour.

16.01.09 All necessary non-destructive examinations shall be performed to meet the applicable code requirements.

16.01.10 All welding procedures adopted for performing welding work shall be qualified in accordance with the requirements of Section-IX of ASME code or IBR as applicable. All welded joints for pressure parts shall be tested by liquid penetrant examination according to the method outlined in ASME Boiler and Pressure Vessel code. Radiography, magnetic particle examination magnuflux and ultrasonic testing shall be employed wherever necessary/recommended by the applicable code. At least 10% of all major butt welding joints shall be radiographed.

16.01.11 Statutory payments in respect of IBR approvals including inspection for design and manufacturer of equipment shall be made by the Bidder. All payment for erection and testing at site (i.e. under IBR jurisdiction) shall also be made by the Bidder. In such case Contractor's scope shall also be extended to preparation of all necessary documents, co-ordination and follow-up with IBR authorities for above approval.

16.02.00 **Performance Tests at Site**

- 16.02.01 The full requirements for testing the system shall be agreed between the Owner and the Bidder prior to Award of Contract. The completely erected System shall be tested by the Contractor on site under normal operating conditions. The Contractor shall also ensure the correct performance of the System under abnormal conditions, i.e. the correct working of the various emergency and safety devices, interlocks, etc.
- 16.02.02 The Bidder shall provide complete details of his normal procedures for testing, for the quality of erection and for the performance of the erected plant. These tests shall include site pressure test on all erected pipe work to demonstrate the quality of the piping and the adequacy of joints made at site.
- 16.02.03 The Contractor shall furnish the quality procedures to be adopted for assuring quality from the receipt of material at site, during storage, erection, pre-commissioning to tests on completion and commissioning of the complete system/equipment.
- 16.03.00 For details of specific tests required on individual equipment refer to respective section of this specification.

17.00.00 **TRAINING OF OWNER'S PERSONNEL**

The Contractor shall extend all possible assistance and co-operation to the Purchaser regarding the transfer of technology and developing expertise in the area of engineering operation and maintenance of the Plant.

Number of man-days of training as mentioned below shall be included in his Tender.

17.01.00 **Training at Contractor's Premises**

The Contractor shall conduct training of sixty (60) engineers of the Owner on engineering, operation and maintenance of the Plant at the Contractor's or Associates or Sub-contractor's premises where adequate training facilities are available during the design and manufacturing stage of the Contractor.

The total man-months for training of engineers shall be maximum sixty (60), having following indicative break-up :

Discipline	No. of Engineers	No. of Man-month
Operation	20 heads	20
Maintenance Boiler, Turbine, Mechanical	20 heads	20
Electrical Maintenance	8 heads	4
Control & Instrumentation	8 heads	4
Maintenance Planning	4 heads	2
	-----	-----

However, the details of the training programme will be discussed and finalised with the successful Bidder.

The training may also be arranged by the Contractor in any Plant where the equipment manufactured by the Contractor or his Associates is under installation, operation or testing to enable the trainees to become familiar with the equipment being furnished by the Contractor. All expenses inherently related to the training shall be borne by the Contractor and shall include but not limited to travel expenses (international and inland fares), lodging and per diem charges as well as medical insurance, instructors fee, programme and miscellaneous cost to be incurred during the training.

The training programme shall be adequate for the trainees to acquire the necessary expertise and competence in the area of engineering, operation and maintenance and as trainers for in-house technology transfer programme of the Purchaser.

The Contractor shall be responsible for the development of the Training Module and Programme Schedule which shall be submitted to the Purchaser for approval.

The components of the training modules shall include but not be limited to the training procedures/methodology, instructional materials such as audio visual materials, CDs and slides and manuals for each trainee.

Three (3) sets of the materials included in the training modules shall be handed over to the Purchaser upon completion of the training. An evaluation shall be jointly undertaken by the Contractor and the Purchaser's representative on the adequacy, appropriateness and relevance of the training and the programme effectiveness after the training. The training material shall be in English language only.

The content of the training programme shall include but not be limited to:

1. Coal fired thermal plant principles in management and practice for operators, technicians and maintenance personnel.
2. Plant operation and systems training for operators including simulator training as applicable.
3. Maintenance training programme covering electrical, mechanical and instrumentation and control.

Said training programme shall be submitted to the Purchaser for approval.

The timing of the training should be such that the participants will be conversant with sufficient know-how to participate in the pre-commissioning and commissioning tests of the Plant.

The Contractor shall provide qualified English speaking instructors and training

coordinator(s) during the tenure of the training programme.

17.02.00 Operation and Maintenance Training at Site

The Contractor shall provide a comprehensive training programme related to design application, plant management, operation and maintenance, including trouble shooting, of the Contractor's supplied system and equipment at the Site starting from Start of Commissioning and thereafter up to the Final Acceptance of the first Unit.

The following instructors shall be at the Site continuously during the training :

- a) One (1) for Steam Generator and Auxiliaries ;
- b) One (1) for Turbine Generator and Auxiliaries ;
- c) One (1) for Electrical Works ;
- d) One (1) for Instrumentation and Control (Boiler and Auxiliaries) ;
- e) One (1) for Instrumentation and Control (Turbine and Auxiliaries).

17.03.00 On-the-Job Training

During the period of pre-commissioning, commissioning and trial operation, the Purchaser shall provide operation and maintenance personnel to assist the Contractor in the operation and maintenance of his supply and work under the direction of the Contractor for the purpose of on-the-job training.

The Purchaser shall have the right to send to the Site his employees later intended to operate and maintain the equipment supplied under this Contract. The Contractor shall, without additional cost, use his site staff to instruct these employees on the operation and maintenance of the equipment. All instructions shall be in the English language.

17.04.00 For detail C&I training refer to Volume-VI, Section-9.

18.00.00 DEVIATIONS

The Bidder is required to submit with his proposal in the relevant schedules a detail list of any and all deviations taken by him clearly without any ambiguity. In the absence of such a list it will be understood and agreed that the Bidder's proposal is based on strict conformance to this specification and no post-contract negotiations would be allowed in this regard.

Unless otherwise specifically indicated in the deviation list, it will be construed and agreed that details indicated in documents & drawings furnished by the Bidder along with the offer is in-line with the specification requirement.

ANNEXURE-I

LIST OF STANDARDS FOR REFERENCE

- a) International Standards Organisation (ISO).
- b) International Electro-technical Commission (IEC).
- c) American Society of Mechanical Engineers (ASME).
- d) American National Standards Institute (ANSI).
- e) American Society for Testing and Materials (ASTM).
- f) American Institute of Steel Construction (AISC).
- g) American Welding Society (AWS).
- h) Architecture Institute of Japan (AIJ).
- i) National Fire Protection Association (NFPA).
- j) National Electrical Manufacturer's Association (NEMA).
- k) Japanese Electro-technical Committee (JEC).
- l) Institute of Electrical and Electronics Engineers (IEEE).
- m) Federal Occupational Safety and Health Regulations (OSHA).
- n) Instrument Society of America (ISA).
- o) National Electric Code (NEC).
- p) Heat Exchanger Institute (HEI).
- q) Tubular Exchanger Manufacturer's Association (TEMA).
- r) Hydraulic Institute (HIS).
- s) International Electro-Technical Commission (IEC) Publications.
- t) Power Test Code for Steam Turbines (PTC).
- u) Applicable German Standards (DIN).
- v) Applicable British Standards (BS).
- w) Applicable Japanese Standards (JIS).

- x) Electric Power Research Institute (EPRI).
- y) Standards of Manufacturer's Standardization Society (MSS).
- z) Bureau of Indian Standards Institution (BIS).
- aa) Indian Electricity Rules.
- bb) Indian Boiler Regulations (IBR).
- cc) Indian Explosives Act.
- dd) Indian Factories Act.
- ee) Tariff Advisory Committee (TAC) rules.
- ff) Emission regulation of Central Pollution Control Board (CPCB).
- gg) Pollution Control regulations of Dept. of Environment, Govt. of India
- hh) Central Board of Irrigation and Power (CBIP) Publications.
- ii) The Air Prevention and Control of Pollution Act.
- jj) The Environmental Protection Act
- kk) The Public Liability Insurance Act.
- ll) The Forest Conservation Act
- mm) The Wildlife protection Act.
- nn) The EIA Notification, 1994.
- oo) IS: 14665-Specification for Electric Traction Lift
- pp) Any other statutory Codes/Standards/Regulations

ANNEXURE-II
CRITERIA FOR LAYOUT

PLOT PLAN LAYOUT REQUIREMENTS

ITEM	SPECIFICATION REQUIREMENT
A. Site conditions to be considered	
1. Prevalent wind direction	See wind-rose in plot plan. Also refer Metrological Data.
B. Layout Requirements	
1. Maximum permissible slope in	
a) Rail track	1 in 400
b) Road	1 in 30
c) Sides of unpaved embankment	1 in 2
2. Required road width	
a) Main roads	As per Civil DBR
b) Auxiliary interconnections	
c) Road to the power house unloading bay :	
• Only for entry to the unloading bay	Yes
• To pass through the unloading bay	No
3. Required minimum horizontal distance between the nearest points of	
a) Plant boundary and the boundary of residential area	(Local municipality/factory rule)
b) Electrical transformer and any other building/facility	As per the Tariff Advisory Committee/ LPA Rules
c) Fire water supply installation and any building/facility subject to fire risk.	As per the Tariff Advisory Committee/ LPA Rules
d) Inflammable liquid (fuel oil, etc.) storage & handling installation and their fencing and other buildings/facilities.	Rules of the Indian Explosive (Indian Explosives Act) and Indian Petroleum Code

ITEM	SPECIFICATION REQUIREMENT
4. Required minimum vertical clearance	
a) Under pipes/cable racks at road crossings	8.0 Metres
b) Soil coverage over underground pipes	1.0 Metre (minimum)
5. Railway Wagon clearance	Rules of the Indian Railways
6. Minimum Clearance between any road edge and building/structure/ any fixed installation.	3 Metres
7. Required level, above the local developed grade level, of	
a) top of all roads	150 mm above FGL
b) all outdoor paved areas	100 mm above FGL
c) Temporary storage areas, workshops, offices, residence etc. required at the time of erection work.	Yes
d) Green belt around power plant area	As per environmental guidelines of MOEF, Govt. of India.

BUILDING/ EQUIPMENT LAYOUT REQUIREMENTS

A. Minimum clear space required at all working and walking areas for operating & maintenance personnel	
1. Horizontal, in all directions	
a) Adjacent to any electrical equipment, electrical cables, running (rotating/reciprocating) equipment, safety valve or vent/drain pipe outlet, pipe/ equipment of surface temperature exceeding 60°C.	1200 mm
b) Adjacent to any other plant facilities (including walls/structures)	1000 mm
2. Vertical (head-room clearance)	
a) Under any pipe/equipment surface of temperature exceeding 60°C and any electrical cables or other electrical items.	2.5 Metre
b) Under any other plant facilities (including structures, pipes etc.)	2.5 Metre

ITEM	SPECIFICATION REQUIREMENT
3. For all areas where any equipment (including trucks, trolleys and other material handling equipment) will move or maneuver.	Minimum 500 mm clear in all direction from the outer edges of the equipment
4. Minimum clear hand space required for	
a) The application of thermal insulation	100 mm
b) Welding work	150 mm
c) Bolt tightening	150 mm
B. Floors, platforms, staircase, ladders, walls, doors & windows	
1. Statutory Requirement	As per the regulations of Tariff Advisory Committee, Indian National Building Code, Indian Factories Act, Local Municipal Rules, etc.
2. Operation & Maintenance Requirement	
a) Adequate floor space shall be kept to permit dismantling, temporary storing and in-situ maintenance of plant & equipment parts, satisfying the clear space requirements stated above. A separate unloading bay for such purpose is required.	Yes
b) Floors or fixed/portable platforms with stairs/ ladders shall be provided for easy approach to any plant item, including valves, instruments, etc. to be operated, observed and/or to be frequently (more than once a month) maintained.	Yes
3. Plinth level of all buildings, above the finished grade level	500 mm
4. Minimum access opening required (with rolling shutter) for transportation, wherever entry of truck for material handling is envisaged	3.5M wide x 4M high or, more depending upon the equipment size to be handled.

ITEM	SPECIFICATION REQUIREMENT
C. Other Maintenance Requirement	
1. Generator stator handling In case the Generator stator cannot be handled by the turbine house crane, all provisions for its overhauling, including the arrangement to slide the stator on the turbine house floor, the foundation work for stator jacking /lowering assembly, dismantling of building end walls/structures etc. shall be kept.	Yes
2. Maintenance of the internals/impellers of all important equipment, like boiler feed pumps, feed water heaters, Surface Condenser, fans of the boiler draft plant, Intake and circulating water pumps, cooling water pumps, coal mills, compressors, blowers, heat exchangers, fuel oil pumps, filters etc.	Shall be possible without disconnecting or dismantling any piping/ducting.
3. Overhauling and handling of the casings for the above items	Shall be possible without disturbing/dismantling any piping/ducting not directly connected to them.
4. Crane Approach	
Wherever required the unobstructed approach of the crane hook/other hoisting equipment hook to various plant & equipment shall be possible.	Yes
D. Central Control Room	
All electronic equipment other than those directly associated with control, operation or presentation of displays shall be mounted external to the control room in air conditioned control equipment room.	Yes
The bidder shall describe in his bid the proposed layout philosophy of the Central Control Room and Control Equipment Room and the arrangement of equipment best suited for the system offered by him and as per good ergonomically consideration.	
However, as a guide line, following features are given :	
a) False ceiling and false flooring shall be provided.	
b) Uniform height, colouring schemes for cabinets etc. shall be available.	

ITEM	SPECIFICATION REQUIREMENT
c) The total area of floor space covered by Control Consoles/Panels in the Control Room shall not exceed 15% of floor area.	
d) No opening shall be provided from Boiler side.	
e) Two double leaf doors, suitably located for entering the Control room shall be provided with opening towards the turbine floor.	
f) Cable entry for the panels/consoles shall be from bottom and suitable openings shall be provided.	
g) The Control Room lighting shall be designed to provide a glare free uniform illumination. The level of illumination shall be minimum 400 LUX.	
h) Necessary Air Conditioning shall be provided for Central Control room, Control Equipment Room and SWAS room etc.	
i) Basic amenities like toilet, Tiffin rooms, wash basins, rest rooms etc. shall be provided near the Control Room.	
E. Toilet and drinking water facility	Required in all buildings and on all floors wherever operating personnel are to be deployed.

PROJECT MANAGEMENT AND SITE SERVICES

CONTENT

CLAUSE NO.	DESCRIPTION
1.00.00	PROJECT MANAGEMENT SERVICES
2.00.00	SITE SERVICES
3.00.00	PROJECT INFORMATION AND MANAGEMENT SYSTEM, INCLUDING DCOUMENT MANAGMENT SERVER (DMS)

PROJECT MANAGEMENT AND SITE SERVICES

1.00.00 PROJECT MANAGEMENT SERVICES

1.01.00 Responsibility

The Bidder shall identify a separate and independent project management team headed by a Project Manager for the execution of this project. Responsibilities of this project Management team shall cover the areas listed below :

- a) Planning and Monitoring
- b) Engineering Management
- c) Contracts Management
- d) Project Safety Management
- e) Quality Assurance, Inspection & Expediting
- f) Construction Management
- g) Spares Management
- h) Erection & Commissioning Management

Detailed responsibilities in the above areas are discussed below :

1.02.00 Organisation

1.02.01 Headquarters

The headquarters of the project management team shall be headed by a senior level executive designated as the Project Manager who shall be responsible to Owner for the execution of the project. He should have adequate financial power and authority to give decision.

Separately, designated leaders shall be identified for each of the areas mentioned under 1.01.00, who, in turn, will report to the Project Manager for all matters relative to this contract.

1.02.02 Central Co-ordination Cell

The central coordination cell shall have sufficient technical personnel to coordinate technical matters and to quickly resolve day to day queries or

	references made by Owner and his Consultants without having the need to refer to his headquarters each time.
1.02.03	Site Organisation The site should have a competent construction manager for all site operations with adequate financial power and sufficient level of authority to take site decisions. The organisation chart for site should indicate the various levels of experts to be posted for supervision in the various fields in civil construction, erection, commissioning etc.
1.02.04	Organisation Chart The Bidder shall furnish a detailed organisation chart for the project management team, clearly identifying the key personnel in each of the areas mentioned at 1.01.00 above. The expected number of executives at different levels shall also be indicated, separately for headquarters, central coordination cell and site organisation.
1.03.00	Implementation Schedule The schedule for the completion of the Project would be as follows : As per project specific special condition of contract. To achieve these targets, the Contractor shall furnish to the Owner, various schedules as defined below:
1.03.01	Engineering Schedules These schedules shall cover various design submissions indicating different engineering activities to be performed. Such schedules shall be furnished by the Bidder for each and every plant/systems/ equipment item covered in the scope of this specification.
1.03.02	Manufacturing Schedule The Contractor shall submit to the Engineer his manufacturing and delivery schedules for all equipment within thirty (30) days from the date of issue of the Letter of Intent (LOI). Such schedules shall be in line with the detailed network for all phases of the work of the Contractor. Such schedules shall be reviewed, updated and submitted to the Engineer, once in every two months thereafter, by the Contractor. Schedules shall also include the materials and equipment purchased from outside suppliers.

1.03.03 Erection Schedules

In order to achieve the overall completion schedule, the Contractor shall provide the Owner all the information covering erection sequence, testing and commissioning activities. These schedules may be based on the recommended erection procedures and will be subject to discussions/agreements with the Owner subsequent to the award of contract.

1.03.04 The successful Bidder shall have to provide all the above schedules (i.e. 1.03.01, 1.03.02 & 1.03.03) in a tabular form in addition to that in the form of L2 & L3 networks and these shall necessarily include information not limited to the earliest and latest dates for various activities/submissions and also any related constraints. However, the Bidder shall include in his proposal a Level-1 (L-1) network showing the major activities and various milestones to achieve the above mentioned completion schedule.

1.03.05 The Contractor shall provide the Owner the original disc/software for all such schedules alongwith requisite no. of copies (as required by the Owner) within an agreed time schedule. This time schedule will be agreed between Owner/Bidder at the time of award of contract. The Contractor's project management software shall be compatible with that of the Owner and the input data shall be furnished to the Owner in a manner compatible with Owner's project management software, SAP.

1.04.00 Detailed Responsibilities

1.04.01 Planning & Monitoring

a) Planning

The Bidder shall prepare a Master Network Schedule in the form of PERT network.

The network shall be prepared on a Work Breakdown Structure for the project which sub-divides the project into a set of manageable systems/sub-systems. The master network will identify milestones of key events for each system/package in the areas of engineering, procurement, manufacture and despatch and erection and commissioning. The master network shall represent the Level-I plan and will form the basis for development of detailed second and third tier execution plans. The master network shall conform to the overall schedule prescribed by Owner.

The master network should be submitted along with the bid which would be mutually discussed and finalised before the Award of Contract. This master network would clearly indicate the responsibility of the Bidder and project management team. This master network would form a part of the contract. The master network shall also identify a complete list of inputs to be furnished by the Owner which may be required for proper interfacing and tie-up. Scheduled dates for providing such inputs shall also be indicated, which will be mutually discussed and finalised.

b) Monitoring & Progress Reporting

The progress reports would be emanated every month, one from the head office of the Contractor and another from the site office. The progress report emanating from the head office should necessarily include the following sections:

- i) Report on key milestones.
- ii) Management summary indicating critical areas with details of actions initiated and effect of any on the project.
- iii) Action needing attention of the Owner/Consultant.
- iv) Detailed packagewise status of engineering submissions, quality plan submissions and approval, procurement manufacture and despatch.

The monthly report generated from the site office should necessarily include:

- i) Report on key milestones.
- ii) Management summary indicating critical areas with details of actions initiated and effect if any on the project.
- iii) Action needing attention of the Owner/Consultant.
- iv) This report would also cover the areas pertaining to the receipt of the equipment at the port, port clearance, transport, receipt at site, erection and commissioning.

In addition to the above, as the project execution progresses, the Contractor shall also be responsible for generating more frequent reports in the form of fax/e-mail information on progress in critical areas so that actions can be expedited. The exact format of the progress report shall be finalised after award of Contract.

1.04.02 Engineering Management

Based on the master network for the project (L-1) the Contractor will prepare an exhaustive list of engineering activities for the equipment/systems covered in his scope and a detailed programme of accomplishing the same within the time frame specified in the master network. This schedule will form the Level-2 (L-2) network for engineering activities.

Based on (L-2) network, the Contractor shall further develop the Level-3 (L-3) network for engineering activities which will indicate schedule for data availability, drawing release date and document submission dates.

Detailed (L-2) and (L-3) networks would be submitted sequentially by the Contractor within two months from the date of issue of Letter of Intent and finalised within one (1) month thereafter.

All such networks shall be provided in MS PROJECT software as well as in other format / software suitable to Owner.

The engineering management team should also co-ordinate all interface engineering activity between the Contractor and the equipment sub-vendors so as to ensure the correctness and completeness of related engineering documentation before the same is submitted to the Owner.

TSGENCO is implementing SAP ERP. Hence the bidder apart from submission of the hard copies shall upload all the documents, drawings etc. in soft format in the relevant C- folder environment (web based) and comply with the additional requirements, if any.

1.04.03 Contracts Management

Based on the master network, the Contractor shall submit L-2 programmes of manufacture and despatch. In addition, the master network shall also include periods considered for site activities viz. erection, commissioning etc. These L-2 programmes would be submitted in 2 months time from the date of award of contract and finalised within one (1) month thereafter. The Contractor will also submit site mobilisation plan. This programme would be submitted at the time of finalisation of award of contract and agreed immediately thereafter so that immediate development of the various activities at site could take place.

The Contractor should also submit L-3 programmes for the manufacturing, despatch of the various items. These networks shall also show the customer hold points (CHP) which have to be cleared by Owner or their authorised representative(s) before further manufacture can take place. These L-3 programmes for the manufacture and despatch would clearly identify responsibilities of the Contractor, sub-Contractor and Owner. These networks shall be submitted within one (1) month of the date of finalisation of the various sub-contracts by the Contractor.

In case all the manufacture is being done by the Contractor then the L-2 programmes would be themselves amplified to cover details of the manufacture, inspection, clearance by Owner and despatch.

The Contractor shall also submit the programme for procurement of boughtout items, detailed shipping schedule and cash flow statement for Owner's approval.

1.04.04 Quality Assurance, Inspection and Expediting

The Contractor shall submit the list of manufacturers/sub-vendors from whom the equipment are expected to be procured and the quality assurance plans thereof for the manufacture shall be approved by the QA group of Owner before the manufacture is commenced. The list of major suppliers would be submitted along with the bid and this shall be mutually discussed and approval will be given by the Owner during contract negotiation meeting prior

to placement of Letter of Intent. This approved list will be binding to the bidder. In the said list, Owner reserves the right to include reputed/reliable vendors of his own choice. Regarding the various other sub-vendors, the list would be submitted within six (6) months of the award of the contract that shall be scrutinized by the Owner to accord approval. In such list Owner reserves the right to include vendors of his own choice. No further vendor approval will be given after twelve (12) months. On the quality plans, the customer hold points will also be identified based on which Owner would give clearance for the manufacture to proceed further.

Quality assurance/Inspection group of Owner or its representative would issue a material despatch clearance certificate (MDCC) after the inspection clearance which will enable the Contractor to despatch the equipment and claim the payment. In the despatch programme, the Contractor shall indicate a schedule of estimated programme, tonnages specifically identifying various oversize dimensioned consignments (ODC). Further the Contractor will also be required to ensure at all stages of shipment that packing of all shipments despatched are suitable for ocean freight to India, handling at the port of entry, inland transportation and preservation at site upto erection. All despatch details & item lists shall be made available to both Owner & site immediately after shipping.

The Contractor shall also expedite all despatches from their own works/works of their sub-vendors, so as to match with the various activities mentioned at 1.04.03 above.

1.04.05 Construction Management

Based on the L-1 Master Network Programme, within two (2) months of the issue of Letter of Intent, the Contractor shall submit a programme of construction/ erection/ commissioning, either in continuation with the manufacture and despatch or separately for the implementation. These programmes would be amplified showing when the civil drawings shall be released by him and construction of civil works shall be completed by him to facilitate start of erection and subsequent activities and shall form the basis for site execution and detailed monitoring. The three monthly rolling programme with the first month's programme being tentative based on the site conditions would be prepared based on these L-3 programmes. The Contractor shall also be involved along with the Owner to tie up detailed resource mobilisation plan over the period of time of the contract matching with the performance targets.

The L-3 programme would be jointly finalised by the site in charge of the Contractor with the Owner's project coordinator as well as the site planning representative. The erection programme will also identify the sequential erectable tonnages that are required for various equipment which should be taken care of in the despatch programmes.

Erection and commissioning of the equipment shall also be done under the supervision of experts from the respective equipment/ system supplier.

1.04.06 Spares Management

Alongwith the proposal for the plant and equipment, the Contractor shall also submit proposals/schedule for the following:

- a) Mandatory spares
- b) Recommended spares

While the award for mandatory spares will be finalised at the time of the award of contract, recommended spares will be finalised thereafter.

1.05.00 Project Progress Review Meetings

Keeping in mind the overall responsibility of the Contractor it is intended that periodic progress reviews on the entire activities of execution of the project will be held initially at least once in two (2) months at Hyderabad/site/ at the discretion of the Owner.. During peak period it may be held once in a month. These meetings will be attended by reasonably higher officials of the Contractor and their leading sub- contractors and will be used as a forum for discussing all areas where progress needs to be speeded up. Actions will be placed on the concerned agencies and decisions will be taken to expedite/speed up the progress. Minutes of such meetings will be issued reflecting the major discussions and decisions taken and circulated to all concerned for reference and action. The Contractor shall be further responsible for ensuring that suitable steps are taken to meet various targets decided upon such meetings.

In addition to the above, and to streamline the construction and erection at site, a suitable frequency and forum of periodic meetings between the Contractor and the Owner will be decided upon as part of erection coordination procedure. Site co-ordination meeting may be held on weekly basis.

1.06.00 Owner's Consultant

The Owner would appoint a consultant to assist him in some of the areas mentioned at 1.01.00 above. The details of interaction and procedures for coordination between Owner / Owner's Consultant and Contractor/ Contractor's project management team shall be finalised during contract negotiations.

1.07.00 Commissioning Management

1.07.01 For commissioning of the various equipment/system covered under the scope of contract, Owner will form an organisation structure which may consist of the following committees. The Contractor shall nominate his representative on one or more of the committee as decided by the Owner:

- a) Steering Committee
- b) Commissioning Panel.
- c) Working Parties
- d) Testing Teams.

1.07.02 Commissioning documents shall be prepared by the Contractor in the

following manner and submitted for Owner's approval :

a) Field Quality Plan

This document shall be prepared for the various equipment/ systems under commissioning and shall have the following objectives to fulfill and shall be submitted for Owner's approval at least six (6) months before their actual commissioning :

- i) Establish design data against which Plant Performance will be compared.
- ii) Set-out the testing objectives and proposals.
- iii) Define the documentation required.

b) Testing/Commissioning Schedule

These shall be prepared for the various equipment/systems under consideration and shall contain sections like detailed testing method, programme, safety, individual responsibility and results.

c) Standard Check Lists

Standard check lists are intended for use at the completion of erection to ensure correct erection, testing and to a limited extent operation for repetitive items.

1.07.03 Test Reports

After the completion of commissioning activity of equipment/ systems, the Contractor shall prepare the test reports which shall include all the relevant information related to various commissioning checks, tests carried out, any deviations/commissions noticed with respect to the intended design requirements, sequence of various commissioning activities as actually adopted vis-a-vis as recommended in the procedures, programme schedules achieved and any other such information as required. These test reports shall be submitted in requisite number of copies to the Owner and this should be duly signed jointly by the Owner/Consultant and the Contractor/Equipment supplier, who are involved during the commissioning activities.

2.00.00 **SITE SERVICES**

These services shall be rendered by the Bidder as part of the overall project management service. The services shall broadly include but not be limited to the following :

2.01.00 Arranging material despatch from the shop by rail/road and/or sea as applicable.

2.02.00 Monitoring movement of materials & follow-up as necessary with Railways, road transport, port clearance etc. from the time of despatch F.O.R. works/ F.O.B. port of shipment by Contractor till receipt of the same at site.

- 2.03.00 Unloading of materials at Railway Station/Railway Siding inside project area/ Road Transportation, transportation to site store, assessment of lost/damaged items in transit and arranging insurance claims and replacement of lost/damaged items. The Contractor shall submit to the Engineer a report detailing all the receipts during the week as well as storing, preservation of material at site.
- 2.04.00 Issuing materials from site store/open yard from time to time for erection as per the construction programme. The Contractor shall be the custodian of all the materials issued till the plant is officially taken over by the Owner after complete erection and successful trial run & commissioning.
- 2.05.00 Transportation of materials to their respective places of erection and erection of the complete plant & equipment as supplied under this specification.
- 2.06.00 Trial run and commissioning of individual equipment/sub-systems and the plant as a whole to the satisfaction of the Owner, including supply of temporary equipment & services for chemical cleaning, steam blowing as well as performance guarantee tests.

Apart from Boiler, proper chemical cleaning shall be carried out in following pipe lines/equipment before commissioning

- a) Deaerator
- b) Boiler feed suction, recirculation leak-off lines
- c) Boiler Feed discharge line by passing heaters
- d) Attenuation lines
- e) Condensate suction & discharge piping upto deaerator by passing the feed water heaters.
- f) Fuel oil lines.

Provision for preservation of individual equipment after trial run and commissioning e.g. Nitrogen blanketing etc. as necessary shall also be in the scope of the Bidder.

Safe disposal of effluent after chemical cleaning shall be done by the contractor.

- 2.07.00 Supply and application of the final paints and first fill lubricants on all the equipment to be erected under this specification. Supply of chemicals, lub oils and other consumables upto COD.
- 2.08.00 For the purpose of erection and commissioning the Contractor's scope of work shall include but not be limited to the following :
- 2.08.01 Deployment of all skilled and unskilled manpower required for erection, supervision of erection, watch & ward, commissioning and other services to

	be rendered under this specification.
2.08.02	Deployment of all erection tools & tackle, construction machinery, transportation vehicles and all other implements in adequate number and size, appropriate for the erection work to be handled under the scope of this specification.
2.08.03	Supply of all consumables, e.g. welding electrodes, cleaning agents, diesel oil, grease, lubricant etc. as well as materials required for temporary supports, scaffolding etc. as necessary for such erection work except those listed under exclusion elsewhere in this specification.
2.08.04	Construction of all civil/structural/architectural works, including construction of foundation for all equipment supplied as required, grouting of equipment on foundation after alignment, and all other incidental civil activities as detailed elsewhere.
2.08.05	All structural steel fabrication and erection work as detailed elsewhere in the specification.
2.08.06	Providing support services for the Contractor's erection staff e.g. construction of site offices, temporary stores, residential accommodation and transport to work site for erection personnel, insurance cover, watch & ward for security and safety of the materials under the Contractor's custody etc. as required.
2.08.07	Maintaining proper documentation of all the site activities undertaken by the Contractor as per the proforma mutually agreed with the Owner; submitting monthly progress reports as also any such document as and when desired by the Owner; taking approval of all statutory authorities e.g. Boiler Inspector, Factory Inspector, Inspector of Explosives, Electrical Inspector etc. for respective portions of work under the jurisdiction of such statutes or laws.
2.08.08	The Contractor shall provide 'Industrial Relations' unit and 'Medical' unit to take care of his erection staff and the Owner shall have no obligation in the regard.
2.08.09	The successful Bidder shall arrange for Tower cranes of adequate capacity for speedy erection activities.
2.09.00	Site Organisation The Contractor shall maintain a site organisation of adequate strength in respect of manpower, construction machinery and other implements at all times for smooth execution of the contract. This organisation shall be reinforced from time to time, as required, to make up for slippages from the schedule without any commercial implication to the Owner. The site organisation shall be headed by a competent construction manager having sufficient authority to take decisions at site.

On award of contract, the Contractor shall submit to the Owner a site organisation chart indicating the various levels of experts to be deployed on the job. The Owner reserves the right to reject or approve the list of personnel

proposed by the Contractor. The persons, whose bio-data have been approved by the Owner, will have to be posted at site and deviations in this regard will not generally be permitted.

The Contractor shall also submit to the Owner for approval a list of construction equipment, erection tools, tackle etc. prior to commencement of site activities. These tools & tackle shall not be removed from site without written permission of the Owner.

2.10.00 General Guidelines for Field Activities

2.10.01 The Contractor shall execute the works in a professional manner so as to achieve the target schedule without any sacrifice on quality and maintaining highest standards of safety and cleanliness.

2.10.02 The Contractor shall co-operate with the Owner and other Contractors working in site and arrange to perform his work in a manner so as to minimise interference with other Contractors' works. The Owner's engineer shall be notified promptly of any defect in other Contractor's works that could affect the Contractor's work. If rescheduling of Contractor's work is requested by the Owner's engineer in the interest of overall site activities, the same shall be complied with by the Contractor. In all cases of controversy, the decision of the Owner shall be final and binding on the Contractor without any commercial implication.

2.10.03 The Engineer shall hold weekly meetings of all the Contractors working at Site at a time and a place to be designated by the Engineer. The Contractor shall attend such meetings and take notes of discussions during the meeting and the decisions of the Engineer and shall strictly adhere to those decisions in performing his Work. In addition to the above weekly meeting, Engineer may call for other meetings either with individual contractors or with selected number of contractors and in such a case the Contractor, if called will also attend such meetings.

2.10.04 Time is the essence of the Contract and the Contractor shall be responsible for performance of his Work in accordance with the specified construction schedule. If at any time the Contractor is falling behind the schedule, he shall take necessary action to make good of such delays by increasing his work force or by working overtime or otherwise accelerate the progress of the work to comply with the schedule and shall communicate such action in writing to the Engineer, satisfying that his action will compensate for the delay. The Contractor shall not be allowed any extra compensation for such action.

2.10.05 The Engineer shall however not be responsible for provision of additional labour and or materials or supply or any other services to the Contractor except for the co-ordination work between various Contractors as set out earlier.

2.10.06 The works under execution shall be open to inspection & supervision by the Owner's engineer at all times. The Contractor shall give reasonable notice to the Owner before covering up or otherwise placing beyond the reach of inspection any work in order that same may be verified, if so desired by the Owner.

- 2.10.07 Every effort shall be made to maintain the highest quality of workmanship by stringent supervision and inspection at every stage of execution. Manufacturer's instruction manual and guidelines on sequence of erection and precautions shall be strictly followed. Should any error or ambiguity be discovered in such documents, the same shall be brought to the notice of the Owner's engineer. Manufacturer's interpretation in such cases shall be binding on the Contractor.
- 2.10.08 The Contractor shall comply with all the rules and regulations of the local authorities, all statutory laws including Minimum Wages, Workmen Compensation etc. All registration and statutory inspection fees, if any, in respect of the work executed by the Contractor shall be to his account.
- 2.10.09 All the works such as cleaning, checking, leveling, blue matching, aligning, assembling, temporary erection for alignment, opening, dismantling of certain equipments for checking and cleaning, surface preparation, edge preparation, fabrication of tubes and pipes as per general engineering practice at site, cutting grinding, straightening, chamfering, filling, chipping, drilling, reaming, scrapping, shaping, fitting-up bolting/welding, etc., as may be applicable in such erection and are necessary to complete the work satisfactorily, are to be treated as incidental and the same shall be carried out by the Contractor as part of the work.
- 2.10.10 In case of any class of work for which there is no such specification as laid down in the contract such as, blue matching, welding of stainless steel parts, etc., the work shall be carried out in accordance with the instructions and requirements of the Engineer and as per the Standards.
- 2.10.11 It may sometimes be necessary to remove some of the erected structural members to facilitate erection of bigger/pre-assembled equipment. In such cases, the removal and re-erection of such members, which are essential, and if so agreed by the Engineer, will have to be done by the Contractor.
- 2.10.12 Attachment welding of necessary instrumentation tapping points, thermocouple pads, root valves, condensing vessels, flow nozzles and control valves etc., both for regular measurement and performance testing to be provided on equipment, its auxiliaries or pipelines covered within the scope of this tender, will also be the responsibility of the Contractor and the same will be done as per the instructions of Engineer. The erection and welding of all above items will be the Contractor's responsibility, even if :
- a) Product groups under which these items are re-leased are not covered in the scope of this tender.
 - b) Items are supplied by an agency other than the Contractor.
- 2.10.13 Preservation of all materials/equipment under custody of the Contractor during storage, pre-assembly & erection, commissioning etc., shall be the responsibility of the Contractor. All necessary preservatives and consumables like paints, etc., shall be arranged by the Contractor. Necessary touch up painting, periodic application of preservatives/paints on pressure parts/other equipment even after erection until completion of work shall be carried out by

the Contractor. The Contractor shall fabricate piping, install lub oil systems and carry out the acid cleaning of fabricated piping. The Contractor shall also service the lub. oil system, carryout the hydraulic test of oil coolers, etc.

2.10.14 It is responsibility of the Contractor to do the alignment etc. if necessary, repeatedly to satisfy Engineer, with all the necessary tools & tackle, manpower, etc. The alignment will be complete only when jointly certified so, by the Contractor's Engineer & Owner. Also the Contractor should ensure that the alignment is not disturbed afterwards.

2.10.15 Additional platforms for approaching different equipment as per site requirement, which may not be indicated in drawings, shall be fabricated and erected by the Contractor. The materials required for these works shall be supplied by the Contractor and he will have to fabricate them to suit the requirement.

2.10.16 Equipment and material which are wrongly installed shall be removed and reinstalled to comply with the design requirement at the Contractor's expense, to the satisfaction of the Owner/ Consultant.

2.10.17 Before erection of any equipment on a foundation, the Contractor shall check and undertake if necessary rectification of foundation bolts, reaming of holes, drilling of dowels, matching of bolts and nuts, making new dowel pin, etc.

2.10.18 Assistance for calibrating/testing the power cylinders, valves, gauges, instruments, etc., and setting of actuators coming under various groups shall be provided by Contractor.

2.10.19 It shall be the responsibility of the Contractor to provide ladders on columns for initial works till such time stairways are completed. For this, the ladder should not be welded on the column and should be prefabricated clamping type. No temporary welding on any structural member is permitted except under special circumstances with the approval of Owner.

2.10.20 Structural materials required for the supporting/operating platforms required for the valves at various levels for the same operation of valves will be arranged by the Contractor.

2.11.00 **Safety**

Safety and overall cleanliness of work site shall be given top priority.

2.11.01 The Contractor shall ensure the safety of all workmen, materials and equipment either belonging to him or to others working at site. He shall observe safety rules & codes applied by the Owner at site without exception.

2.11.02 The Contractor shall notify the Owner of his intention to bring to site any equipment or material which may create hazard. The Owner shall have the right to prescribe the conditions under which such equipment or material may be

handled and the Contractor shall adhere to such instructions. The Owner may prohibit the use of any construction machinery, which according to him is unsafe. No claim for compensation due to such prohibition will be entertained by the Owner.

- 2.11.03 Storage of petroleum products & explosives for construction work shall be as per rules and regulation laid down in Petroleum Act, Explosive Act and Petroleum and Carbide of Calcium Manual. Approvals as necessary from Chief Inspector of Explosives or other statutory authorities shall be the responsibility of the Contractor.
- 2.11.04 The Contractor shall be responsible for safe storage of his and his sub-contractor's radioactive sources.
- 2.11.05 All requisite tests & inspection of handling equipment, lifting tools & tackle shall be done by the Contractor and certified copies shall be supplied to the Owner. Defective equipment shall be removed from service. Any equipment shall not be loaded in excess of its recommended safe working load.
- 2.11.06 All combustible waste and rubbish shall be collected and removed from the worksite at least once each day. Use of undercoated canvas paper, corrugated paper, fabricated carton, plastic or other flammable materials shall be restricted to the minimum and promptly removed.
- 2.11.07 The Contractor shall provide adequate number of fire protection equipment of the required types for his stores, office, temporary structures, labour colony etc. Personnel trained for fire-fighting shall be made available by the Contractor at site during the entire period of the Contract.
- 2.11.08 All electrical appliances used in the work shall be in good working condition and shall be properly earthed. No maintenance work shall be carried out on live equipment. The Contractor shall maintain adequate number of qualified electricians to maintain his temporary electrical installation.
- 2.11.09 All workmen of the Contractor working in construction site shall wear safety helmets, safety boots and safety belts. The Contractor shall take appropriate insurance cover against accidents for his workmen as well as third party.
- 2.11.10 All the worksites shall be provided with adequate lighting facilities e.g. flood lighting, hand lamps, area lighting etc. by the Contractor for proper working environment during night times.
- 2.11.11 All safety precautions shall be taken for welding and cutting operations as per IS-818.
- 2.11.12 All safety precautions shall be taken for foundation and other excavation marks as per IS-3764.
- 2.12.00 **Taking Delivery & Storage**
- 2.12.01 The Contractor shall arrange issue of all equipment and materials to be erected under the contract from the stores/open yard at site by signing on standard indent forms. After completion of work, detailed auditing of the

materials so issued shall be submitted to the Owner.

- 2.12.02 The Contractor shall arrange for proper and safe storage of materials till the same are taken over by the Owner as per terms of the contract. Manufacturer's instructions for preservation shall be strictly followed.
- 2.12.03 All empty containers, packing materials, gunny bags, transport frames and also surplus and unused materials reconciliation prior to completion of contract shall be the property of the Owner and returned to the Owner by the Contractor.
- 2.13.00 **Site Welding & Heat Treatment**
- 2.13.01 Welding shall be done in accordance with IS-813, IS-816, IS-9595 & other relevant IS/International standards and as per instructions of Contractor. Only those welders, who are qualified as per IS-817 for ordinary welds and as per IBR/ASME Section-IX for high pressure welds, shall be employed in the job.
- 2.13.02 All welders shall be tested and approved by Engineer before they are actually engaged on the work even though they may possess the requisite certificates. The Owner reserves the right to reject any welder without assigning any reason. The welder identification code as approved by the Engineer shall be stamped by the welder on each joint done by them. The Contractor will be responsible for the periodic renewal, re-testing of the welders as demanded by Owner.
- 2.13.03 The Engineer is entitled to stop Contractor's any welder from his work if his work is unsatisfactory for any technical reason or there is a high percentage of the rejection of joints welded by him, which in the opinion of Engineer will adversely affect the quality of welding even though the welder has earlier passed the tests. The welders having passed the tests do not relieve the Contractor from his contractual obligations, to check the performance of the welders.
- 2.13.04 All charges for testing of welders including destructive and non- destructive tests if conducted by Owner or by the inspection authority at site shall have to be borne by the Contractor. The necessary test materials and consumables will have to be arranged by the Contractor and all testing facility made available, as required.
- 2.13.05 All welded joints shall be subject to acceptance by Engineer. Inspection of welds shall be in accordance with IS-822 or equivalent code.
- 2.13.06 Preheating/post heating and stress relieving after welding are part of fabrication and erection work and shall be performed by the Contractor in accordance with the instruction of Engineer. Contractor shall arrange to supply heating equipment with automatic recording devices. Also the Contractor shall have to arrange for the labour, heating elements, thermocouples, compensating cables, insulation materials like mineral wools, asbestos cloth, ceramic beads, asbestos rope, etc. required for the heat-treatment and stress relieving works. During pre- heat/stress relieving operations, the temperature shall be measured at one or more points as required by attaching thermocouples and recorded on a continuous printing

type recorder. All the record graphs for the heat treatment works carried out shall be got signed by the Engineer prior to the commencement of each cycle and handed over to Engineer on completion. The graphs will be the property of Owner. The Contractor has to provide thermo-chalks temperature recorders, thermocouple attachments, units, graph sheets, etc. required for the job and maintain them in good condition.

- 2.13.07 All electrodes shall be baked and dried in the electric/electrode drying oven to the required temperature and for the period specified by the Engineer before they are used in erection work. The electrodes used shall be as per IS-814, IS-815, IS-1442, IS-7280 and other codes as applicable, and shall be of approved reputed manufacture. The electrodes shall meet the requirement of the pipe material. No electrode manufactured more than 12 months ago and the type covered under certificate issued after conducting tests more than 6 months ago shall be used. All electrodes shall be preserved at works and at site as per manufacturer's recommendations.
- 2.13.08 Oxy-acetylene flame or Exothermic chemical heating for stress relieving is not permitted. Heating shall be by means, of electric induction coil or electric resistance coil.
- 2.13.09 It may become necessary to adopt inter layer radiography/MPT/UT depending upon the site/technical requirement necessitating interruptions in continuation of the work and making necessary arrangement for carrying out the above work.
- 2.13.10 Gas tungsten arc welding process (TIG) shall be adopted for all root pass welds except for structural works until 4.75 mm thickness is deposited. Subsequent welding after root pass can be carried out by manual metal arc welding with coated electrodes. For pipes of thickness less than 6 mm the entire welding has to be carried out by TIG welding.
- Fillet weld shall be made by shielded metal arc process as per applicable codes.
- However, the Engineer will have the option of changing the method of welding as per site requirement. The method adopted for manual arc welding shall be weaving technique and the width of weaving shall not exceed 1.5 times of the dia. of the electrode.
- In case of deviation from welding process and electrodes, the Contractor shall take approval of the Owner prior to adoption of same.
- 2.13.11 The root pass for butt joints shall be such as to achieve full penetration with complete fusion of root edges.
- 2.13.12 Each pass shall be cleared and freed of slag before the next pass is deposited.
- 2.13.13 On completion of each run, craters, weld irregularities, slag etc. shall be removed by grinding or chipping.
- 2.13.14 Each layer of welding shall have an even and smooth appearance.

- 2.13.15 Welding sequence shall be adjusted in such a way that distortion due to welding shrinkage is minimised. Further any movement, shock or vibration during welding shall be avoided to prevent weld cracks.
- 2.13.16 Proper protection of welders and the work shall be taken during periods of rain. No welding shall be carried out when surface to be welded are wet from any cause.
- 2.13.17 Following will be stages of inspection during welding :
- a) Two pieces to be joined shall be individually checked for the weld edge preparation and profile dimensionally and to the template. Dye penetrant check shall be carried out on edge prepared surfaces at random. The percentage will depend upon on criticality as specified by Engineer.
 - b) Joint fit up will be a stage of inspection. Misalignment after fit up may vary from 0.3 mm to 1.6 mm depending on outside diameter and thickness.
 - c) All joints shall be offered for visual inspection after root run. Subsequent welding should be made only after the approval of root run.
- 2.13.18 All welded joints shall be painted with anti-corrosive paint immediately on completion of radiography and stress-relieving.
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- 3.00.00 **PROJECT INFORMATION AND MANAGEMENT SYSTEM, INCLUDING DCOUMENT MANAGMENT SERVER (DMS)**
- 3.01.00 Contractor shall submit as part of its Work Scope detailed documentation as outlined in this section and / or required by the Technical Requirements. The content and format of the documentation to be submitted are subject to Owner's approval.
- 3.02.00 Contractor shall utilise a computer based system for control and management of project documentation. The system must be capable of producing customized reports and information on demand. This control system should have been successfully applied to similar projects and be familiar to the project control personnel selected. Contractor's detailed project documentation plan shall identify all documentation requirements for the project, the party responsible for production of the document, the basic content of the document and the required timing for issue. This plan shall include, but not be limited to the details of all Drawings to be produced, plant specification / definition documentation, equipment orders and manuals. The documentation identified shall be entered into the computer based control system The database thus created shall be capable of being sorted and

ordered on a variety of selected parameters such as document type, subject description, responsible party, start date and finish date, to enable review and update to be conducted only on those documents which are relevant.

3.03.00 Regular documentation control progress reports shall be prepared by the Contractor to record the status of documentation. In the event either Party or Engineer expresses concern with the content of such progress reports, the accuracy of progress reports, status of documentation production and other such matters, the concern will be identified to the Project Manager. Within five days of notification of this concern, the Project Manager will attend a meeting with relevant Owner Representatives and provide details of specific actions to be initiated to satisfactorily overcome the difficulties identified. It will be the Project Manager's responsibility to initiate whatever action is necessary to ensure that the production of documentation is completely in accordance with Project Information Management System (PIMS).

3.04.00 Within 90 days after Effective Date of Contract, the Contractor shall establish an integrated PIMS which will support the needs of Project and management, detail design and engineering, procurement, construction and operation, and maintenance.

PIMS shall utilise software which links various software and database programs to form a composite system. The typical scope of PIMS shall include, but not be limited to, the following:

- (a) Power plant systems and equipment data, from which Project specific flow diagrams, data sheets and other integrated data are derived. The Power plant systems and equipment data, from which Project specific flow diagrams, data sheets and other integrated data are derived. This data shall include, but not be limited to, the following:
 - (i) System descriptions and design requirements and design criteria
 - (ii) Equipment and material technical specifications for all engineering disciplines
- (b) Detail engineering data to create flow diagrams, plant arrangements, piping configurations, equipment layout and design, electrical and instrumentation systems, structures, and other systems. The software tool used shall be capable of manipulation and storage of plant layout and design information. The 3D model of the plant shall also contain details of the various components like pipe, structural steel work, etc., and relevant information shall be available on-line from relevant data base. Software shall be multi-user, multi-access nature allowing the designers of Contractor and major Sub-Contractors, if required, to work in interactive real time environment and software shall be capable of interference checking. The software shall allow access to different types of information held in the database. It shall estimate the type and quantity of materials required to build the plant and it shall be possible for such data to be taken off the system at any time.

(c) Construction data to monitor and manage site activities, including material control, scheduling and progress, quality control, start-up and testing, operation, maintenance, training, and all other site functions.

(d) Plant design and construction records to provide data for safe and efficient maintenance and operation. Records to include may be maintenance schedule, man power tracking, tools, spare parts, and test equipment inventory, equipment list, drawing, control, technical specifications, and equipment instruction manuals.

3.05.00 The PIMS shall be installed in a distributed processing array system and operated through personal computer work stations at the Contractor's site office. A complete integrated system shall be implemented. This system shall be utilised by Contractor during the Project execution.

ENGINEERING SERVICES

CONTENT

CLAUSE NO.	DESCRIPTION
1.00.00	GENERAL
2.00.00	DESIGN COORDINATION MEETING
3.00.00	CO-OPERATION WITH OTHER CONTRACTORS AND CONSULTING ENGINEERS
4.00.00	GUIDELINES FOR ENGINEERING SERVICES
5.00.00	OPERATING MANUALS AND MAINTENANCE INSTRUCTIONS
6.00.00	PLANT HANDBOOK
7.00.00	CONTRACT STAGE DOCUMENT SUBMISSION AND APPROVAL PROCEDURE
8.00.00	TENDER STAGE DOCUMENT SUBMISSION

ATTACHMENTS

ANNEXURE-1	DISTRIBUTION SCHEDULE
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ENGINEERING SERVICES

1.00.00 GENERAL

1.01.00 As part of the overall project management activity, the Contractor shall be responsible for proper engineering and co-ordination of activities during various phases of execution of the contract. The Contractor shall identify a person, designated as Project Manager, with whom the Owner, the Consulting Engineer or the Review Consultant shall interact on matters related to engineering as well as execution of the contract. The Project Manager shall be the single-point contact person on behalf of the Contractor and shall be responsible for all engineering co-ordination. The Owner/Consultant/Review Consultant shall interact with the Project Manager only on all matters of co-ordination between the Owner and the Contractor or on matters involving the Contractor, his manufacturing units and sub-vendors. For the purpose of expediting the Owner or his representative may sometimes interact with the manufacturing units or sub-vendors of the contractors. However such interaction will not, under any circumstance, dilute the responsibility of the Contractor to provide a fully engineered and co-ordinated package under this contract.

1.02.00 On finalization of the contract, a procedure for exchange of engineering information will be mutually agreed and finalized between the Owner and the Contractor.

2.00.00 DESIGN COORDINATION MEETING

The Contractor and his sub-vendors will be called upon to attend design co-ordination meetings with the Engineer, other Contractors and the Consultants of the Owner during the period of execution of contract. The Contractor including his sub-vendors shall attend such meetings at their own cost at Owner's or Consultant's office in Kolkata or at mutually agreed venue as and when required and fully cooperate with such persons and agencies involved during those discussions.

3.00.00 CO-OPERATION WITH OTHER CONTRACTORS AND CONSULTING ENGINEERS

The Contractor shall agree to cooperate with the Owner's other Contractors and Consulting Engineers and freely exchange with them such technical information as is necessary to obtain the most efficient and economical design and to avoid unnecessary duplication of efforts. The Engineer shall be provided with copies of all correspondences addressed by the Contractor to other Sub- contractors and Consulting Engineers in respect of such exchange of technical information.

- 4.00.00 **GUIDELINES FOR ENGINEERING SERVICES**
- 4.01.00 Prior to commencement of the engineering work as part of design submissions, all aspects of design viz., criteria for selection and sizing of all equipment and systems, design margins etc. including that for structural steel and civil work shall be outlined and these shall form the basis for the detailed engineering work.
- 4.02.00 Engineering work shall be performed on modern and proven concepts and internationally accepted good engineering practices but fully compatible with the Indian environments. Owner shall have the right to review and approve the engineering work by themselves and/or through consultant and ask for any clarifications and changes/modifications to the work performed by Contractor.
- 4.03.00 At any stage during the performance of assignment, the Contractor may be required to make certain changes/modification/improvements in design/drawing/other documents which are applicable to 800 MW Unit, which in the opinion of the Owner could result in better improved design, layout, operability, plant availability, maintainability, reliability or economy of the plant and its systems/sub-systems in view of revised and more accurate information/data available at a later date(s) or feedback(s) received during execution / operation of similar units. Such changes / modifications/improvements required could be identified by Owner and/or consultant and mutually discussed. Owner requires the Bidder to incorporate such action in the subject assignment appropriately without any additional cost liability and time implication to the Owner and same shall be within the responsibilities and scope of the Contractor.
- 4.04.00 During the course of review of detailed engineering stages, it may be essential in the opinion of Owner to obtain certain classified data for review purposes only. In case Owner so desires, the Bidder shall submit such data to Owner.
- 4.05.00 During the course of review of detailed engineering, it may be essential in Owner's opinion to obtain data and information on similar equipment and plants engineered by the Bidder. In case Owner so desires the Bidder shall submit such data and information to the Owner.
- 4.06.00 It is not the intent to give details of every single task covered in the total engineering work to be carried out by Contractor, however, all engineering work required for the satisfactory completion of the plant/systems as specified shall be carried out by the Contractor. Broadly, the following are the minimum requirements in respect of scope of major items of work:
- 4.06.01 Preparation, updating and finalisation of scheme drawings, control and interlock diagrams, detailed and fully dimensioned layout drawings (plant layout and equipment layout detailed plan, elevation and cross-sectional drawings at different elevations / floor levels) covering all mechanical, electrical, C&I, civil and structural items, equipment, systems and facilities. Drawings and Schedules prepared by the Contractor from time to time, as detailed designs are developed, shall be submitted for Owner's / Consultant's

- approval before the work is taken up. Revisions, corrections, additions to drawings and schedules shall not be considered to change the scope of work.
- 4.06.02 Preparation of detailed technical specifications including data sheets, tender drawings and bill of material for all bought out items, as also finalisation of corresponding sub-contractors.
- 4.06.03 Review of sub-contractor's data, drawings, design calculations, schedules, bill of materials, instruction manuals etc. for all equipment, before forwarding them to Owner/Consultant for approval.
- 4.06.04 Preparation of civil construction drawings for all equipment showing foundation details and full details regarding equipment loads, floor openings, details of embedments etc. required for preparation of civil construction drawings and also as referred at relevant sections of Scope, Terminal Points & Exclusions. These documents shall be preceded by appropriate design calculations, static and dynamic analysis as necessary.
- 4.06.05 Preparation and finalisation of process piping and instrumentation diagrams and schematics, complete in all respects for all systems/packages of the power plant.
- 4.06.06 Preparation of consolidated schedules and bills of materials, including line numbers, tag numbers, source of supply, service conditions, specifications, materials, types and connections details, quantities for items of the plant including dampers, steam traps, strainers, instrumentations, ducting.
- 4.06.07 Sizing of all piping and equipment as per the stipulated design criteria; carrying out of flexibility analysis/dynamic analysis as necessary; hangers & support engineering.
- 4.06.08 Final revision of all documents including preparation and compilation of Instruction Manuals for installation, commissioning, operation and maintenance for all equipment and systems. Refer clause 5.00.00 for the specific requirement in this regard.
- 4.06.09 Certification and submission of final as-built drawings for all areas.
- 4.06.10 Preparation and compilation of all drawings, schedules and instructions which may be required at site, whether separately mentioned or not.
- 4.06.11 All erection and assembly drawings which may be required at site.
- 4.06.12 For all bought out item packages, the Contractor shall provide complete material / component list along with detail specification, drawings, component part no. etc. during detail engineering stage prior to final approval. Such approved drawing/document shall be made available at site in adequate number prior to commencement of work. Moreover, such document/drawing shall be provided in soft form (CD)
- 4.06.13 Preparation of necessary documentation, design calculations etc. required for submission to statutory authorities like IBR, Chief Electric Inspector, Factory Inspector etc.
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5.00.00 **OPERATING MANUALS AND MAINTENANCE INSTRUCTIONS**

5.01.00 The Contractor shall provide at least six (6) months before the time of commissioning and before taking over of the plant and equipment, all necessary maintenance manuals and operating instructions. The instruction manual shall be submitted in the form of one (1) soft copy in CD and 15 hard copies as per distribution schedule (Annexure-1).

5.02.00 The information provided, which shall be contained in loose leaf stiff backed covers, shall include :

- a) A complete inventory of all main items of plant, with identification details.
- b) Service manuals for all plant and equipment giving full descriptions of the main items and auxiliary items such as power packs, hydraulic equipment, actuators, lubricating pumps, etc.
- c) A separate electrical manual covering items such as switchgear, cabling, instrumentation, controls, cabling layouts and wiring diagrams.
- d) A schedule of recommendations for routine maintenance of all electrical and mechanical equipment, recommended inspection point, information on detection, cause and rectifications of troubles & faults.
- e) A lubrication schedule with all necessary drawings diagrams to identify the lubrication points.
- f) Manufacturer's literature.

5.03.00 The instruction manual shall be subject to the approval of Owner.

6.00.00 **PLANT HANDBOOK**

The Contractor shall submit to the Engineer, a preliminary plant handbook preferably in A-4 size sheets which shall contain the design and performance data of various plant, equipment and systems covering the complete project including single line flow diagrams, within twenty four (24) months from the date of his acceptance of the Letter of Intent. The final plant handbook complete in all respects shall be submitted by the Contractor six (6) months before start-up and commissioning activities. The plant handbook shall be submitted as per distribution schedule.

7.00.00 **CONTRACT STAGE DOCUMENT SUBMISSION AND APPROVAL PROCEDURE**

7.01.00 Within fifteen (15) days to one month of issue of Letter of Intent (LOI) by the Owner, the Contractor shall furnish a schedule of drawings and design

document to be submitted by him to the Owner/Engineer indicating dates against each document.

The documents shall be divided into two categories : a) for approval and b) for information/further engineering and co-ordination by the Owner.

In preparing this schedule, the Contractor shall allow two (2) weeks from date of receipt for review and comments by the Owner/Engineer for each submission of a document.

This document submission schedule shall require approval by the Owner/Engineer.

7.02.00 All contract documents shall be marked, without fail, with the name of the Owner, the Project, the specification title and number and the unit designation.

All dimensions shall be in metric units.

All notes, markings etc. shall be in English.

7.03.00 Documents/Drawings, submitted during tender stage, shall be revalidated or revised as required and submitted as certified contract document for approval / information of the Owner/Engineer.

7.04.00 Unless specified otherwise, the following categories of documents/drawings would require approval of the Owner/Engineer:

- a) List of sub-vendors (from Owner only)
- b) System scheme and instrumentation diagrams
- c) Design basis justifying selection of equipment & process parameters where not specified in the Contract
- d) Equipment data sheets and general arrangement drawings
- e) Materials of construction
- f) Layout drawings.
- g) Operation logic diagrams.
- h) Typical control circuit.
- i) Drawings of Instrumentation and control.

7.05.00 Unless specified otherwise, the following categories of documents/ drawings would be treated for information/further engineering by the Owner/Engineer. The Contractor shall, however, incorporate all additional information and clarifications in these documents / drawings as and when desired by the Owner/Engineer.

- a) Equipment foundation drawings.
- b) Equipment cross-section drawings, product literature etc. which are of proprietary nature.
- c) Predicted performance curves of equipment.
- d) Various bills of quantity, schedules etc.
- e) Piping fabrication drawings, isometrics etc.
- f) Panel wiring diagrams.
- g) Instruction/Operation manuals.
- h) Service manuals and trouble shooting guide for C & I system including field instruments.
- i) Cable schedule and interconnection chart.
- j) Drive/feederwise control scheme showing all external interfaces.

In essence, the Contractor is solely responsible for corrections and adequacy of design & engineering for documents under this category.

7.06.00

Upon review, the Owner/Engineer shall put his remarks and one of the following action stamps on the drawing/document:

- a) A - Drawing submitted as approved, proceed with fabrication
- b) B - Drawing approved subject to comments noted, proceed with fabrication, considering our comments. Correct as necessary and resubmit for record.
- c) C - See attached memo.
- d) D - Correct your original drawing incorporating our comments and resubmit for approval.
- e) E - Information furnished is noted.
- f) F - Prints not enclosed

For action stamps in category (c) & (d), documents must be resubmitted for review by the Owner/Engineer. For action stamp in category (b), further review by Owner/Engineer would not be necessary provided the Contractor agrees & incorporates the comments made on the document.

Except for action stamp under category (c) & (d), the Contractor can proceed with manufacturing and other sequential activities for those areas of a drawing/document which do not have any review comment by the Owner/Engineer.

The Owner/Engineer may accord approval in category (c) or (d) in more than one submission of a document till he is satisfied that the intent of the specification has been fully complied with. The Contractor shall be responsible for delay in such cases and no extension of time shall ordinarily be allowed on such grounds. Approval of contract documents by the Owner/Engineer shall not relieve the Contractor of his responsibility for any errors and fulfillment of contract requirements.

The Contractor's work shall be in strict accordance with the finally approved drawings and no deviation shall be permitted without written approval of the Owner/Engineer.

- 7.07.00 Except key plan/general yard plan, any layout drawing requiring scrutiny shall not be drawn to a scale less than 1:50.
- 7.08.00 For review by the Consulting Engineer, the Contractor shall furnish soft copies of drawings & documents and three (3) prints of each drawing/document. Two (2) prints of such submission shall also be sent to the Owner. After review, comment/approval will be sent to the Contractor. Upon action under category (a) or (e), the Contractor shall directly distribute the documents to the various offices of the Owner and other agencies in number of copies as specified in the contract document. Such distribution copies shall be marked with the reference and date of the letter by which the Owner/Engineer has accorded his final approval. Penal action shall be taken against the Contractor for any unauthorised revision in the drawings so distributed from the drawings approved by the Owner/Engineer. The contractor shall furnish three (3) CDs of all as built/final drawings for Owner/Consultant site.
- 7.09.00 In case of contradiction between the stipulations above and those stated elsewhere in the specification, the stipulations herein shall prevail.

ANNEXURE-1

DISTRIBUTION SCHEDULE

S. No	Description	TSGENCO										Consultant			Equipment Vendor	Remarks
		Director Projects	Director Technical	CE/Civil Thermal Projects Hyd.	CE/ TPC-I, Hyd	CE/ O&M/	SE/ Civil	SE/E&M /	DE Constr.		HYD	BTPS				
A	Letter Of Intent or Contract Documents	1	1	1	S	1	2	2	1	1	1	1	2			
B	Vendor Drawings															
1.	Preliminary	1	1	1	2	1	1	2	2	12	1	-	S			
2.	Return preliminary with comments	-	-	1	2	1	1	1	1	S	1	-	1			
3.	Final and any revision thereof															
	a. Civil	1	1	6+1T	1	1	6+1T	1	-	2+1T	1	1	S			
	b. E&M	1	1	1	6+1T	1	1	6+1T	1	2+1T	1	1	S			
C.	Design Drawings															
1.	Preliminary															
	a. Civil	1	1	2	1	1	2	1	1	4	1	1	S			
	b. E&M	1	1	1	2	1	1	2	1	4	1	1	S			
2.	Released for construction															
	a. Civil	1	1	2	1	1	6	1	1	1	1	2	S			
	b. E&M	1	1	1	1	2	1	6	1	1	1	2	S			
3.	Return marked 'As built'															
	a. Civil	-	-	1	-	-	1	-	-	1	1	S	1			
	b. E&M	-	-	-	1	-	-	1	1	1	1	S	1			
4.	As built drawings															
	a. Civil	-	-	1+1T	-	2+1T	5+1T	-	1	1+1T	-	1	S			
	b. E&M	-	-	1	2+1T	2+1T	-	5+1T	1+1T	1+1T	-	1	S			

S. No	Description	TSGENCO										Consultant		Equipment Vendor	Remarks
		Director Projects	Director Technical	CE/Civil Thermal Projects Hyd.	CE/ TPC-I, Hyd	CE/ O&M/	SE/ Civil	SE/E&M /	DE Constr.			HYD	BTPS		
D	Progress Report Monthly														
1.	Equipment vendor	1	1	1	2	1	1	2	1	1	1	1	1	S	
2.	Consultant	1	1	2	2	1	1	2	1	S	1	1	1	Nil	
E	Test & Inspection Reports														
1.	Equipment manufacturer														
	a. Civil	1	1	1	2	1	1	1	-	11	1	1	1	S	
s	b. E&M	1	1	-	2	1	-	1	1	11	1	1	1	S	
2.	Consultant	1	1	-	2	1	-	1	1	S	-	1	1	-	
F	Instruction Manuals/Data Books														
1.	Equipment manufacturer														
	a. Civil	1	1	1+1T	1	1	6+1T	1	1	2+1T	1	1	1	S	
	b. E&M	1	1	-	3+1T	1	-	6+1T	2	3+1T	1	1	1	S	
2.	Consultant	1	1	-	10+1T	1	-	15+1T	-	S	1	1	1	Nil	
G	Consultant	1	1	1	8+1T	1	1	2	1	1	1	1	1	S	
H	Design Calculations	1	1	1	8+1T	1	1	2	1	1	1	1	1	S	
I	Final consulting Engineering Report	1	1	1	10	1	1	2	1	S	1	1	1	Nil	

S – Source, T – Transparency & Soft Copy on CD,

TSGENCO : Telangana State Power Generation Corporation Limited
Director, Projects, Hyd : Director/ Projects, TSGENCO, Vidyut Soudha, Hyderabad – 500 082

QUALITY ASSURANCE REQUIREMENTS

CONTENT

CLAUSE NO.	DESCRIPTION
1.00.00	QUALITY ASSURANCE PROGRAMME
2.00.00	GENERAL REQUIREMENTS QUALITY ASSURANCE
3.00.00	QUALITY ASSURANCE DOCUMENTS
4.00.00	INSPECTION, TESTING & INSPECTION CERTIFICATES

ATTACHMENTS

ANNEXURE-I	FORMAT OF QUALITY ASSURANCE PROGRAMME
ANNEXURE-II	FIELD WELDING SCHEDULE

QUALITY ASSURANCE REQUIREMENTS

1.00.00 QUALITY ASSURANCE PROGRAMME

1.01.00 To ensure that the equipment and services under the scope of Contract whether manufactured or performed within the Contractor's works or at his Sub-contractor's premises or at the Owner's site or at any other place or work are in accordance with the specifications, the Contractor shall adopt suitable quality assurance programme to control such activities at all points, as necessary. Such programmes shall be outlined by the Contractor and shall be finally accepted by the Owner/Authorised representative after discussions before the award of contract. A quality assurance programme of the Contractor shall generally cover the following :

- a) His organisation structure for the management and implementation of the proposed quality assurance programme.
- b) Documentation control system.
- c) Qualification data for Bidder's key personnel.
- d) The procedure for purchase of materials, parts, components and selection of Sub-contractor's services including vendor analysis, source inspection, incoming raw-material inspection, verification of materials purchased etc.
- e) System for shop manufacturing and site erection control including process controls and fabrication and assembly controls.
- f) Control of non-conforming items and system for corrective actions.
- g) Inspection and test procedure both for manufacture and all site related works.
- h) Control of calibration and testing of measuring and testing equipments.
- i) System for quality audit.
- j) System for indication and appraisal of inspection status.
- k) System for authorising release of manufactured product to the Owner.
- l) System for handling storage and delivery.
- m) System for maintenance of records.

- n) Furnishing of quality plans for manufacturing and field activities detailing out the specific quality control procedure adopted for controlling the quality characteristics relevant to each item of equipment/component as per format enclosed at Annexure-I to this section for Owners approval
- o) Internal standards, if referred in the quality plans shall generally be compatible with National / International standards and shall be mentioned in the quality plans. Alternatively bidder shall furnish extracts of the internal standards detailing out acceptance norm for the product / material.

2.00.00 **GENERAL REQUIREMENTS - QUALITY ASSURANCE**

2.01.00 All materials, components and equipment covered under this specification shall be procured, manufactured, erected, commissioned and tested at all the stages, as per a comprehensive Quality Assurance Programme. An indicative programme of inspection/tests to be carried out by the Contractor for some of the major items is given in the respective technical specification. This is however, not intended to form a comprehensive programme as it is the Contractor's responsibility to draw up and implement such programme duly approved by the Owner/Consultant. The detailed Quality Plans for manufacturing and field activities should be drawn up by the Bidder, separately in the format attached at Annexure-I and will be submitted to Owner/Authorised representative for approval. Schedule of finalisation of such quality plans will be finalised before award.

Contractor shall furnish list of Manufacturing Quality Plans of major equipments indicating proposed inspection categorisation indicating items that will be offered for Owner's inspection etc and the Field Quality Plans

2.02.00 Manufacturing Quality Plan for all the major equipment will detail out their respective important components, their in-process various tests/inspection & final inspection / tests, to be carried out as per the requirements of this specification and standards mentioned therein and quality practices and procedures followed by Contractor's Quality Control organization. The relevant reference documents and standards, acceptance norms, inspection documents raised etc., during all stages of materials procurement, manufacture, assembly and final testing/performance testing are to be comprehensively documented by Contractor.

Manufacturing Quality Plan for all major equipments/ items will be approved by owner. In these approved quality plans, Owner / Authorised representative shall identify customer hold points (CHP), test / checks which shall be carried out in presence of the Owners Engineer or his authorised representative and beyond which the work shall not proceed without consent of Owner / Authorised representative in writing. Inspection/ Test reports are to be submitted to owner as specified in final approved Manufacturing Quality Plans.

2.03.00 Field Quality Plans / Procedures for all field activities shall be submitted to

	owner for review / approval. These Quality Plans / procedures will detail out, for all equipment, the quality practices and procedures etc. to be followed by the Contractor's site Quality Control organisation, during various stages of site activities from receipt of materials/ equipment at site.
2.04.00	The Bidder shall also furnish copies of the reference documents/plant standards/acceptance norms/tests and inspection procedure etc., as referred in Quality Plans along with Quality Plans. These Quality plans and reference documents/standards etc. will be subject to Owner's approval without which manufacture shall not proceed. These approved documents shall form a part of the contract. In these approved quality plans, Owner/Authorised representative shall identify customer hold points (CHP), test/checks which shall be carried out in presence of the Owners Engineer or his authorised representative and beyond which the work will not proceed without consent of Owner/Authorised representative in writing. All deviations to this specification, approved quality plans and applicable standards must be documented and major deviations in the form of Non Conformity Report shall be referred to Owner/Authorised representative for approval and dispositioning.
2.05.00	No material shall be despatched from the manufacturer's works before the same is accepted subsequent to pre-despatch final inspection including verification of records of all previous tests/inspections by Owner's Engineer/ Authorised representative for "CHP" and "W" points marked in quality plans , and duly authorised for despatch by issuance of Material Despatch Clearance Certificate (MDCC). For items which is not under owner's inspection the contractor shall apply for despatch clearance (MDCC) from owner by submitting their internal inspection reports and quality records
2.06.00	All materials used or supplied shall be accompanied by valid and approved materials certificates and tests and inspection report. These certificates and reports shall indicate the sheet serial numbers or other such acceptable identification numbers of the material. The material certified shall also have the identification details stamped on it.
2.07.00	Castings and forgings used for construction shall be of tested quality. Details of results of chemical analysis, heat treatment record, mechanical property test results shall be furnished.
2.08.00	All welding and brazing shall be carried out as per procedure drawn and qualified in accordance with requirements of ASME Section - IX (latest edition) or other International equivalent standard acceptable to the Owner. All brazers, welders etc. employed on any part of the contract at Contractor's/ Sub-Contractor's works or at site shall be qualified as per ASME Section-IX (latest edition) or equivalent international standard approved by the Owner. Such qualification tests shall be conducted in presence of Owner / his authorised representative or owner approved Third Party Inspection Agency(TPIA). Previously qualified WPS & PQR shall be acceptable if witnessed by owner's approved TPIA. For welding of pressure parts and high pressure piping coming under IBR purview, the requirements of IBR shall also be complied with.

2.09.00	All non-destructive examination (NDT) shall be carried out in accordance with LIST OF STANDARDS FOR REFERENCE as given below in this section. The NDT operator shall be qualified as per SNT-TC-IA (of American Society of non- destructive examination). Results of NDT for the list major equipments / items identified for owner's inspection shall be properly recorded and submitted for review and approval. Other items not covered under owner's inspection, contractor shall review and approve the NDT results and such reports shall be submitted to owner in the final documentation of the items / equipments
2.10.00	All the sub-vendors proposed by the Contractor for procurement of major bought out items including castings, forgings, semi-finished and finished components/equipment list of which shall be drawn up by the Contractor and finalised with the Owner shall be subject to Owner's approval. Quality Plans of the successful vendors shall be discussed, finalised and approved by the Owner/Authorised representative and form part of the Purchase Order between the Contractor and the Vendor.
2.11.00	All the purchase specifications for the major bought-out items, list of which shall be drawn up by the Contractor and finalised with the Owner shall be furnished to the Owner for comments and subsequent approval before orders are placed. Owner reserves the right to carry out quality audit and quality surveillance of the systems and procedures of the Contractor's or their sub-vendor's quality management and control activities. The Contractor shall provide all necessary assistance to enable the Owner carry out such audit and surveillance. Quality audit/approval of the results of tests and inspection will not prejudice the right of the Owner to reject equipment not giving the desired performance after erection and shall not in no way limit the liabilities and responsibilities of the Contractor in earning satisfactory performance of equipment as per specification.
2.12.00	Quality requirements for main equipment shall equally apply for spares and replacement items.
2.13.00	Repair/rectification procedures to be adopted to make any job acceptable shall be subject to the approval of the Owner.
2.14.00	For quality assurance of all civil works refer to the specifications for civil works.
3.00.00	QUALITY ASSURANCE DOCUMENTS
3.01.00	The Contractor shall be required to submit two (2) copies and two (2) sets of microfilms / CDs of the following Quality Assurance documents within three (3) weeks after despatch of the equipment: a) Material mill test reports on components as specified by the specification.

- b) The inspection plan with verification, inspection plan check points, verification sketches, if used and methods used to verify that the inspection and testing points in the inspection plan were performed satisfactorily.
- c) Non-destructive examination results /reports including radiography interpretation reports.
- d) Factory tests results for testing required as per applicable codes and standards referred in the specification.
- e) Welder identification list listing welder's and welding operator's qualification procedure and welding identification symbols.
- f) Sketches and drawings used for indicating the method of traceability of the radiographs to the location on the equipment.
- g) Stress relief time temperature charts.
- h) Inspection reports duly signed by QA personnel of the Owner and Contractor for the agreed inspection hold points. During the course of inspection, the following will also be recorded :
 - i) When some important repair work is involved to make the job acceptable.
 - ii) The repair work remains part of the accepted product quality.
- i) Letter of conformity certifying that the requirement is in compliance with finalised specification requirements.

4.00.00 **INSPECTION, TESTING AND INSPECTION CERTIFICATES**

4.01.00 The Owner's Engineer, or his duly authorised representative and/or an outside inspection agency acting on behalf of the Owner shall have access inside the workshops, test labs, establishments at all reasonable times to inspect and examine the materials and workmanship of the works during its manufacture or erection and if part of the works is being manufactured or assembled on other premises or works, the Contractor shall obtain for the Owner's Engineer and for his duly authorised representative permission to inspect as if the works were manufactured or assembled on the Contractor's own premises or works.

4.02.00 The Contractor shall give the Owner's Engineer/ Authorized Inspector twenty one (21) days written notice for "CHP" / "W" points of any material being ready for testing by owner' engineer / Authorized inspector. Such tests shall be to the Contractor's account except for the expenses of the Inspector. The Engineer/ Inspector, unless the witnessing of the tests is virtually waived, will attend such tests within fifteen (15) days of the date on which the equipment is notified as being ready for test/inspection. If owner's Engineer / Authorised Inspector fail to attend the inspection, next mutually convenient date for test shall be agreed with Contractor. Contractor shall, in

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- no case proceed with the test without owner or his authorized inspectors, unless the witnessing is officially waived and advised Contractor to proceed with the test. Contractor shall forthwith forward duly certified completed test report and a product quality certificate in six (6) copies to owner upon completion of such test.
- 4.03.00 The Engineer or Inspector shall within fifteen (15) days from the date of Inspection as defined herein give notice in writing to the Contractor, or any objection to any drawings and all or any equipment and workmanship which is in his opinion not in accordance with the contract / QAP or other approved quality documents. The Contractor shall give due consideration to such objections and shall either make modifications that may be necessary to meet the said objections or shall confirm in writing to the Engineer/Inspector giving reasons therein, that no modifications are necessary to comply with the contract / QAP or other approved quality documents.
- 4.04.00 When the factory tests have been completed at the Contractor's or sub-contractor's works, the Engineer/Inspector shall issue a certificate to this effect fifteen (15) days after completion of tests excluding the test completion date subject to submission of all certified documents related to the test, If the tests are not witnessed by the Engineer/Inspectors, the certificate shall be issued within fifteen (15) days of the receipt of the Contractor's test certificate by the Engineer/Inspector. Failure of the owner's Engineer/Inspector to issue such a certificate shall not prevent the Contractor from proceeding with the works. The completion of these tests, or the issue of the certificates shall not bind the Owner to accept the equipment should it, on further tests after erection be found not to comply with the contract / QAP or other approved quality documents.
- 4.05.00 In all cases where the contract provides for tests whether at the premises or works of the Contractor or any sub-contractor, the Contractor, 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 owner's Engineer/Inspector or his authorised representatives to carry out effectively such tests on the equipment in accordance with the Contract / QAP or other approved quality documents. Contractor and shall give facilities to the owner's Engineer/ Inspector or to his authorised representative to accomplish testing.
- 4.06.00 To facilitate advance planning of inspection in addition to giving inspection notice as per Clause 4.02.00, the Contractor shall furnish quarterly inspection programme indicating proposed schedule dates of inspection at customer hold point and final inspection stages. Updated quarterly inspection plans will be made for each three consecutive months and shall be furnished before beginning of each calendar month.

LIST OF STANDARDS FOR REFERENCE

- a) International Standards Organisation (ISO).
- b) International Electro-technical Commission (IEC).
- c) American Society of Mechanical Engineers(ASME)
- d) American National Standards Institute (ANSI).
- e) American Society for Testing and Materials (ASTM).
- f) American Institute of Steel Construction (AISC).
- g) American Welding Society (AWS).
- h) Architecture Institute of Japan (AIJ).
- i) National Fire Protection Association (NFPA).
- j) National Electrical Manufacturer's Association (NEMA).
- k) Japanese Electro-technical Committee (JEC).
- l) Institute of Electrical and Electronics Engineers (IEEE).
- m) Federal Occupational Safety and Health Regulations (OSHA).
- n) Instrument Society of America (ISA).
- o) National Electric Code (NEC).
- p) Heat Exchanger Institute (HEI).
- q) Tubular Exchanger Manufacturer's Association (TEMA).
- r) Hydraulic Institute (HIS).
- s) International Electro-Technical Commission Publications.
- t) Power Test Code for Steam Turbines (PTC).
- u) Applicable German Standards (DIN).
- v) Applicable British Standards (BS).
- w) Applicable Japanese Standards (JIS).
- x) Electric Power Research Institute (EPRI).
- y) Standards of Manufacturer's Standardization Society (MSS)

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- z) Bureau of Indian Standards Institution (BIS).
 - aa) Indian Electricity Rules.
 - bb) Indian Boiler Regulations (IBR).
 - cc) Indian Explosives Act.
 - dd) Indian Factories Act.
 - ee) Tariff Advisory Committee (TAC) rules.
 - ff) Emission regulation of Central Pollution Control Board (CPCB).
 - gg) Pollution Control regulations of Dept. of Environment, Govt. of India
 - hh) Central Board of Irrigation and Power (CBIP) Publications

ANNEXURE-I

VENDOR'S LOGO , NAME & ADDRESS				MANUFACTURING QUALITY ASSURANCE PLAN							DOC NO:		XXXXX-CAL-QAP-M-0001												
ITEM :				-				LOCATION :				REV NO :				0		1		2		3		4	
												DATE :													
CLIENT :																									
PROJECT :				REFERENCE PURCHASE ORDER NO. & DT :																					
VENDOR :				REFERENCE APPROVED DATA SHEET :																					
SUB VENDOR :				REFERENCE APPROVED DRAWING. NO. :																					
ABBREVIATIONS :				GENERAL REMARKS																					
QAP - QUALITY ASSURANCE PLAN,				1 THE ITEMS WHICH ARE FALLING UNDER ANY STATUTORY AUTHORITY'S (LIKE I.B.R. ETC.) SCOPE SHALL BE SUBJECTED TO THAT STATUTORY AUTHORITY'S INSPECTION CLEARENCE.																					
CR - CRITICAL,																									
MA - MAJOR,																									
MI - MINOR																									
SPEC - SPECIFICATION,																									
TC - TEST CERTIFICATES																									
P - PERFORM																									
W - WITNESS																									
V - VERIFY																									
CHP - CUSTOMER HOLD POINT																									
NOTES:																									
1. EXACT MATERIAL / PROCESS / INSPECTION / TESTS FOLLOWED BY THE MANUFACTURER SHALL BE SPECIFIED																									
2. EXACT REFERENCE DOCUMENT/ACCEPTANCE STANDARD SHALL BE SPECIFIED																									
3. IN CASE SPECIFIED ACCEPTANCE STANDARD / NORMS IS OTHER THAN NATIONAL / INTERNATIONAL STANDARDS																									
STANDARD / COPY OF THE ACCEPTANCE NORMS FOLLOWED BY THE MANUFACTURER SHALL BE SUBMITTED FOR REVIEW RECORD																									
4 FINAL INSPECTION DOSSIER SHALL BE PREPARED BY MANUFACTURER & SHALL BE ENDORSED BY INSPECTIONION AGENCY																									
Prepared by				Checked by				Approved By																	
Revision				R0		R1		R2		R0		R1		R2		R2									
DATE																									

ANNEXURE-II

FIELD WELDING SCHEDULE

PROJECT : FWS NO :
 CONTRACTOR : REV NO. :
 PACKAGE : FIELD WELDING CODE :
 SYSTEM : PAGE NO. :

Sl No.	Drawing No. for Weld Locations & Identification mark	Description of parts to be welded	Material specification	Dimensions	Process of Welding	Type of Weld	Electrode Filler Specification	WPS No.	Minimum Pre-heat Temperature	Heat Treatment Temperature [Holding Time in secs]	NDT Method	NDT Specification Number	Acceptance Norm Ref.	Remarks
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The Field Welding Schedule should be submitted for :

- o Pressure Parts
- o Tanks/Vessels
- o Piping
- o Heavy/Important Structural Steel
- o Heat Exchangers
- o Bus Ducts

REQUIREMENTS OF SPARES, TOOLS & TACKLE, LUBRICANTS/OIL/CONSUMABLES

CONTENT

CLAUSE NO.	DESCRIPTION
1.00.00	TOOLS AND TACKLE
2.00.00	SPARES
	ATTACHMENT
ANNEXURE-I	MANDATORY SPARE LIST

REQUIREMENTS OF SPARES, TOOLS & TACKLE, LUBRICANTS/OIL/CONSUMABLES

1.00.00 TOOLS & TACKLE

The Contractor shall supply with the equipment one complete set of special tools and tackle as required for the erection, assembly, dismantling & maintenance of the equipment. These special tools will also include special material handling equipment, jigs & fixtures for maintenance and calibration/readjustment, checking & measurement aids etc. A list of such tools & tackle shall be submitted by the Bidder along with the offer. Detailed description of each tools/tackle, its function along with the equipment/part for which it is meant for and the price of each tools/tackle shall also be indicated in the offer. These tools & tackle shall be separately packed and sent to site before the first unit commissioning. The Bidder shall also ensure that these tools are not used for erection purpose.

2.00.00 SPARES

2.01.00 General

The Bidder shall indicate and include in his scope of supply all the necessary start-up, commissioning and recommended spares in addition to mandatory spares as specified elsewhere in the specification. The Owner reserves the right to buy any or all mandatory and recommended spares. The Contractor shall also state for each item of spares both mandatory and recommended, the normal expected service life.

2.01.01 All spares supplied under this contract shall be strictly interchangeable with the parts for which they are intended to replace. The spares shall be treated and packed for long storage under the climatic conditions prevailing at the site, e.g. small items shall be packed in sealed transparent plastic bags with dessicator packs as necessary.

2.01.02 Each spare part shall be clearly marked or labelled on the outside of the packing with the description. When more than one spare part is packed in a single case, a general description of the contents shall be shown on the outside and a detailed list enclosed. All cases, containers and other packages must be suitably marked and numbered for the purposes of identification.

2.01.03 All cases, containers or other packages are liable to be opened for examination as may be considered necessary by the Engineer.

2.01.04 All mandatory spares shall be delivered to site within one to three months prior to the scheduled date of the trial operation of the plant. However, they shall not be despatched before the despatch of the associated main equipment.

2.01.05 The Bidder shall also guarantee supply of spare parts, which will be made, based on manufacturer's drawings on special order from the Purchaser for 30 years after commissioning of the plant.

2.02.00 **Recommended Spares**

2.02.01 The Contractor shall provide a list of recommended spares giving unit prices and total prices for 2 years of normal operation of the plant for spares of indigenous origin, and for 5 years of normal operation for spares of non-indigenous origin. This list shall take into consideration the mandatory spares specified elsewhere in the specification and should be a separate list.

2.02.02 The price of recommended spares will not be used for the evaluation of bids. The price of these spares shall remain valid for a period as specified elsewhere in the specification from the date of Award of the Contract. Where the recommended spares are the same as mandatory spares, the prices shall be the same. The prices of any recommended spares, which are not common with mandatory spares, shall be subject to review by the Owner, and shall be finalised after mutual discussion.

2.03.00 **Start-up Commissioning Spares**

2.03.01 Start-up commissioning spares are those spares which may be required during the start-up and commissioning of the equipment/system. All spares used until the plant is handed over to the Owner shall come under this category. Said spares, properly marked, shall be supplied together with the main equipment and shall be used by the Contractor, if needed, during erection & commissioning stage. All such spares which remain unused till issuance of Taking Over Certificate by the Owner, along with an equipment-wise quantitative consumption report shall be returned to the Owner during time of handover. The list of commissioning spares to be brought by the Contractor to ensure smooth commissioning of the plant shall be subject to the Engineer's approval.

2.03.02 The Contractor shall submit a complete BBU list inclusive of recommended, mandatory, initial start-up and commissioning spares. Costs of the above spares, which are consumed before the handing-over of the plant, shall be deemed to have been included in the lump sum proposal price of the package, and the Contractor shall have no claim on this account to the Owner.

2.04.00 **Mandatory Spare Parts**

2.04.01 The Owner considers some of the spares are essential for running the equipment irrespective of whether they are included in the list of recommended spares by the Bidder as mentioned above.

Since the components involved can not be foreseen at the bidding stage, only

broad requirements of the Owner in this respect are outlined hereinafter. The bidder shall include his proposal, on the basis of this guideline, an item-wise list of all components and the quantity, unit prices & total price thereof, offered as mandatory spares for each and every equipment. This list shall be separate from the list of recommended spares and shall be used for bid evaluation purposes. Any clarification in this respect may be obtained by the Bidder at the pre-bidding stage.

- 2.04.02 The mandatory spares should be supplied to the Owner at least one month before the trial run. The despatch programme is subject to approval of the Owner/Consultant after award of contract.

	TITLE 5X800 MW TSGENCO YADADRI TPS LUBE OIL TRANSFER PUMP QUALITY ASSURANCE PLAN	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
		Section – IA	Date
SECTION – IA QUALITY ASSURANCE PLAN			

	MANUFACTURER/BIDDER/VENDOR NAME & ADDRESS		STANDARD QUALITY PLAN						SPEC. NO: PE-TS-XXX-567-A001		DATE:XXXX		
			CUSTOMER:						QP NO.: PE-QAP-XXX-567-A001		DATE: 5.5.2020		
			PROJECT:						PO NO.: LATER		DATE: XXXX		
			ITEM: LUBE OIL PUMP				SYSTEM:		SECTION:	SHEET 1 OF 4			
SL NO.	COMPONENT & OPERATIONS	CHARACTERIST-ICS	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
					M	C/N				D	M	C	N

1.0	RAW MATERIAL & BOUGHT OUT ITEMS												
1.1	PUMP CASING	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	REPORT	√	P	V	-
1.2	END COVER	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	REPORT	√	P	V	-
1.3	SHAFT	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V	-
		INTERNAL DEFECTS	MA	UT	100%		ASTM-E 388 100% BACK WELL ECHO	FALL IN BACK ECHO 20% ,MAX DEFECT ECHO M20% MAX B.W.E	UT REPORT	√	P	V	-
		HARDNESS	MA	HARDNESS	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V	-
1.4	GEARS (DRIVING AND DRIVEN)	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V	-
		HEAT TREATMENT	MA	HEAT TREATMENT	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	HT CHART	√	P	V	-
		INTERNAL DEFECTS	MA	UT	100%		ASTM-E 388 100% BACK WELL ECHO	FALL IN BACK ECHO 20% ,MAX DEFECT ECHO M20% MAX B.W.E	UT REPORT	√	P	V	-
		HARDNESS	MA	HARDNESS	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V	-
1.5	RELIEF VALVE BODY	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V	-
1.6	FLANGES(COMPANION)	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V	-
1.7	BEARINGS, OIL SEALS, MECHANICAL	MAKE, SIZE , BEARING NUMBER,FINISH,FITME NT	MA	VISUAL,FITM ENT	100%		MANUFACTURING DRAWING	MANUFACTURING DRAWING	COC	√	P	V	-

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
	Sign & Date	Name		Sign & Date	Name	Seal			Sign & Date	Name	Seal
Prepared by:	S.K. Yadav		Checked by:		Ashish Panigrahi			Reviewed by:			
Reviewed by:	Sayan Roy		Reviewed by:		R K Jaiswal			Approved by:			

	MANUFACTURER/BIDDER/VENDOR NAME & ADDRESS		STANDARD QUALITY PLAN							SPEC. NO: PE-TS-XXX-567-A001		DATE:XXXX	
			CUSTOMER:							QP NO.: PE-QAP-XXX-567-A001		DATE: 5.5.2020	
			PROJECT:							PO NO.: LATER		DATE: XXXX	
			ITEM: LUBE OIL PUMP				SYSTEM:			SECTION:	SHEET 2 OF 4		
SL NO.	COMPONENT & OPERATIONS	CHARACTERIST-ICS	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
					M	C/N					D	M	

	SEALS								Page 89 of 200							
1.8	ELECTRIC MOTOR	REVIEW OF ROUTNE TEST CERTIFICATE	MA	REVIEW	100%	100%	IS 325 /IEC -34 FOR EXPORT MOTOR	APPROVED DRAWING/DATA SHEET		IR	LINE TEST REPORT	√	P	V	-	
2.0	IN PROCESS INSPECTION															
2.1	ALL COMPONENT	WORKMANSHIP & FINISH	MA	VISUAL/MEA SUR EMENT	100%		MANUFACTURING DRAWING	MANUFACTURING DRAWING	IR	√	P	V	-			
		DIMENSIONS	MA	VISUAL/MEA SUR EMENT	100%		MANUFACTURING DRAWING	MANUFACTURING DRAWING	IR	√	P	V	-			
2.2	PUMP CASING, COVERS,RELIE F VALVES HOUSING & CURING OF PUMP CASING GASKETS	LEAK TIGHTNESS	CR	HYDRO TEST AT 2X MAXIMUM ALLOWABLE WORKING PRESSURE FOR 30 MINUTES	100%	100%	APPROVED DRAWING/DATA SHEET	NO LEAKAGE	IR	√	P	W	-			
2.3	GEARS/SCREW & SHAFT	INTERNAL DEFECTS	MA	DPT	100%		ASTM E 165	NO DEFECTS	IR	√	P	V	-			
2.4	GEARS/SCREW - INDUCTION HARDENING	HARDNESS	MA	HARDNESS MEASUREME NT	100%		APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V	-			
3.0	SUB-ASSEMBLY /ASSEMBLY CONTROL/FINAL INSPECTION AND TESTING															
3.1	ROTOR ASSEMBLY	STATIC RESIDUAL DYNAMIC BALANCING	CR	STATIC RESIDUAL DYNAMIC BALANCING	100%		ISO -1940 GR 6.3	ISO -1940 GR 6.3	IR	√	P	V	-			
3.2	PUMP ASSEMBLY	COMPLETENESS	MA	VISUAL,MEAS UREMENT	100%		APPROVED GA DRAWING	MANUFACTURING DRAWING	IR	√	P	V	-			
3.3	COMPLETE PUMP WITH JOB MOTOR	1. PERFORMANCE H V/S Q, H V/S p, PH VS PUMP EFFICIENCY	CR	PERFORMANC E TEST	100%	100%	HYDRAULIC INSTITUTE STANDARD OF USA	HYDRAULIC INSTITUTE STANDARD OF USA	TEST REPORT	√	P	W	-	PUMP TO BE TESTED WITH OIL OF VISCOSITY CLOSEST TO THE LUBE OIL		

BHEL					
ENGINEERING			QUALITY		
	Sign & Date	Name		Sign & Date	Name
Prepared by:	S.K. Yadav		Checked by:		Ashish Panigrahi
Reviewed by:	Sayan Roy		Reviewed by:		R K Jaiswal

BIDDER/ SUPPLIER	
Sign & Date	
Seal	

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:			
	Sign & Date	Name	Seal
Reviewed by:			
Approved by:			

	MANUFACTURER/BIDDER/VENDOR NAME & ADDRESS		STANDARD QUALITY PLAN						SPEC. NO: PE-TS-XXX-567-A001		DATE:XXXX		
			CUSTOMER:						QP NO.: PE-QAP-XXX-567-A001		DATE: 5.5.2020		
			PROJECT:						PO NO.: LATER		DATE: XXXX		
			ITEM: LUBE OIL PUMP			SYSTEM:			SECTION:		SHEET 3 OF 4		
SL NO.	COMPONENT & OPERATIONS	CHARACTERIST-ICS	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
					M	C/N				D	M	C	N

	AND STRAINER								Page 90 of 200						@RATES VISCOSITY FOR PRESSURE @LOWEST VISCOSITY FOR CAPACITY @ HEIGHESTVISCO SITY FOR POWER
		VIBRATION/NOISE	MA	MEASURE MENT	100%	100%	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET		TEST REPORT	√	P	W	-	
		RELIEF VALVE SET PRESSURE	MA		100%	100%	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET		TEST REPORT	√	P	W	-	
		LEAKAGE	MA	LEAK TEST	100%	100%	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET		TEST REPORT	√	P	W	-	
		TEMPERATURE	MA	MEASURE MENT	100%	100%	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET		TEST REPORT	√	P	W	-	
		OVERALL DIMENTIONS	MA	MEASURE MENT	100%	100%	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET		TEST REPORT	√	P	W	-	
		ORENTATION	MA	MEASURE MENT	100%	100%	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET		TEST REPORT	√	P	W	-	
		STRIP TEST	CR	VISUAL	100%	100%	NO VISIBLE DAMAGE	NO VISIBLE DAMAGE		TEST REPORT	√	P	W	-	
3.4	CLEANING , PROTECTION , PAINTING & PACKING	ACTVITY COMPLIANCE	MI	VISUAL	100%		TECHNICAL /MFG SPEC FOR PACKING,APPROVED DRAWING FOR CLEANING PROTECTION AND PAINTING	TECHNICAL /MFG SPEC FOR PACKING,APPROVED DRAWING FOR CLEANING PROTECTION AND PAINTING		IR	√	P	V	-	

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
	Sign & Date	Name		Sign & Date	Name	Seal			Sign & Date	Name	Seal
Prepared by:	S.K. Yadav		Checked by:		Ashish Panigrahi			Reviewed by:			
Reviewed by:	Sayan Roy		Reviewed by:		R K Jaiswal			Approved by:			

	MANUFACTURER/BIDDER/VENDOR NAME & ADDRESS		STANDARD QUALITY PLAN						SPEC. NO: PE-TS-XXX-567-A001		DATE:XXXX		
			CUSTOMER:						QP NO.: PE-QAP-XXX-567-A001		DATE: 5.5.2020		
			PROJECT:						PO NO.: LATER		DATE: XXXX		
			ITEM: LUBE OIL PUMP			SYSTEM:			SECTION:		SHEET 4 OF 4		
SL NO.	COMPONENT & OPERATIONS	CHARACTERIST-ICS	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
					M	C/N				D	M	C	N

NOTES:

1. In case of foreign supplier, all test certificates shall be furnished by the supplier, duly witnessed/verified by supplier's TPI.
2. Following to be noted for packing:
 - a. Material shall be packed suitably in order to avoid damage of paint and valve during transit and also during storage at site in tropical climate conditions for a period of 15-18 months.
 - b. Photographs of the packing just before dispatch for information of PEM.
3. The latest revisions/year of issue of all the standard indicated in the QP shall be referred.
4. Project specific QP will be prepared based on customer requirement.
5. BHEL reserves the right for conducting repeat test, if required.

LEGENDS:

*RECORDS, IDENTIFIED WITH "TICK"(√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION,
 ** **M**: SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, **C**: MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, **N**: CUSTOMER,
P: PERFORM, **W**: WITNESS, **V**: VERIFICATION, AS APPROPRIATE, **D**: DOCUMENTATION
MA: MAJOR, **MI**: MINOR, **CR**: CRITICAL, **MTC**: Mill Test Certificate, **RT**: Radiographic Test, **PT**: Penetrant Test

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
	Sign & Date	Name		Sign & Date	Name	Seal			Sign & Date	Name	Seal
Prepared by:	S.K. Yadav		Checked by:		Ashish Panigrahi			Reviewed by:			
Reviewed by:	Sayan Roy		Reviewed by:		R K Jaiswal			Approved by:			

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN					SPEC. NO : PE-TS-XXX-567-A001			DATE:xx.xx.xxxx	
			CUSTOMER :					QP NO.: PE-QAP-XXX-567-A001(S)			DATE: 5.5.2020	
			PROJECT:					PO NO.:LATER			DATE: xx.xx.xxxx	
			ITEM: BASKET DUPLEX STRAINER		SYSTEM: LUBE OIL PUMPS			SECTION:			SHEET 1 OF 3	

SL NO	COMPONENT & OPERATIONS	CHARACTERISTI CS	CL AS S	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANC E NORMS	FORMAT OF RECORD		AGENCY			REMARKS
1	2	3	4	5	6		7	8	9	*	**			
					M	C/ N				D	M	C	N	

Page 92 of 200														
1.0	RAW MATERIAL & BOUGHT OUT ITEMS													
1.1	STRAINER BODY , FLANGE BOTTOM PLATE, TOP COVER	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%	--	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V		
1.2	3 WAY VALVE HOUSING CASTING, BACKING PLATE	PHYSICAL AND CHEMICAL PROPERTIES	MA	LAB TEST	100%	--	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V		
1.3	SCREEN	CHEMICAL PROPERTIES	MA	LAB TEST	100%	--	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DATA SHEET	LAB REPORT	√	P	V		
2.0	IN PROCESS CONTROL													
2.1	WELDING PROCEDURE	CORRECTNESS /WELDING PARAMETER S	MA	REVIEW	100%	--	ASME SEC IX	ASME SEC IX	QW 482	√	P	V		
2.2	PQR & WELDERS QUALIFICATION	WELD SOUNDNESS	MA	PHYSICAL TEST/RT	100%	---	APPRVED WPS/APPROVED DWG	APPROVED WPS	QW 482	√	P	V		
2.3	WELD FIT UPS	DIMENSIONS & ALIGNMENT ORIENION	MA	MEASUREMENT VISUAL	100%	--	APPROVED DRAWINGS	APPROVED DRAWINGS	IR	√	P	V		
2.4	WELDMENTS -ROOT & FINAL RUN(AS APPLICABLE)	WELD DEFECTS	MA	PANETRATION TEST	100%	--	ASME E 165	NO DEFECT	IR	√	P	V		
2.5	ASSEMBLY OF INTERNAL BASKET	DIMENSION & FITTING OF INTERNAL	MA	VISUAL & PROPERFITMENT	100%	--	APPROVED DRAWING/DATA SHEET	APPROVED DRAWING/DAT A SHEET	IR	√	P	V		
3.0	FINAL INSPECTION AND TESTING													
3.1		COMPLETENESS,	MA	VISUAL &	100%	--	APPROVED	APPROVED	IR	√	P	V		

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL					
ENGINEERING				QUALITY		Sign & Date		Doc No:					
Sign & Date		Name		Sign & Date		Name		Sign & Date		Name		Seal	
Prepared by:	S K Yadav		Checked by:			Ashish Panigrahi		Reviewed by:					
Reviewed by:	Sayan Roy		Reviewed by:			R K Jaiswal		Approved by:					

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN				SPEC. NO : PE-TS-XXX-567-A001		DATE:xx.xx.xxxx	
			CUSTOMER :				QP NO.: PE-QAP-XXX-567-A001(S)		DATE: 5.5.2020	
			PROJECT:				PO NO.:LATER		DATE: xx.xx.xxxx	
			ITEM: BASKET DUPLEX STRAINER		SYSTEM: LUBE OIL PUMPS		SECTION:		SHEET 2 OF 3	

SL NO	COMPONENT & OPERATIONS	CHARACTERISTI CS	CL AS S	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANC E NORMS	FORMAT OF RECORD		AGENCY			REMARKS
1	2	3	4	5	6		7	8	9	*	**			
					M	C/ N				D	M	C	N	
		CLEALINESS, DIMENSION OF SCRFEN & OTHER PARTS		MEASUREMENT			DRAWING/DATA SHEET	DRAWING/DATA SHEET						
		LEAK TIGHTNESS	MA	HYDRO TEST AT 1.5 TIMES THE DESIGN PRESSURE ; HOLDING TIME 30 MINUTES	100%	--	APPROVED DRAWING/DATA SHEET	NO LEAKAE	IR	√	P	V		
		FLOW V/S PRESSURE DROP TEST	MA	MEASUREMENT VISUAL	ONE/TYPE/ SET		APPROVED DRAWING/DATA SHEET	NO LEAKAE	IR	√	P	V		
3.2	CLEANING , PROTECTION , PAINTING & PACKING	ACTVITY COMPLIANCE	MI	VISUAL	100%	--	TECHNICAL /MFG SPEC FOR PACKING,APPR DRAWING FOR CLEANING PROTECTION AND PAINTING	TECHNICAL /MFG SPEC FOR PACKING,APPR DRAWING FOR CLEANING PROTECTION AND PAINTING	IR	√	P	V		

NOTES:

- In case of foreign supplier, all test certificates shall be furnished by the supplier, duly witnessed/verified by supplier’s TPI.
- Following to be noted for packing:
 - Material shall be packed suitably in order to avoid damage of paint and valve during transit and also during storage at site in tropical climate conditions for a period of 15-18 months.
 - Photographs of the packing just before dispatch for information of PEM.
 - The latest revisions/year of issue of all the standard indicated in the QP shall be referred.

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
	Sign & Date	Name		Sign & Date	Name	Seal			Sign & Date	Name	Seal
Prepared by:		S K Yadav	Checked by:		Ashish Panigrahi			Reviewed by:			
Reviewed by:		Sayan Roy	Reviewed by:		R K Jaiswal			Approved by:			

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN				SPEC. NO : PE-TS-XXX-567-A001		DATE:xx.xx.xxxx	
			CUSTOMER :				QP NO.: PE-QAP-XXX-567-A001(S)		DATE: 5.5.2020	
			PROJECT:				PO NO.:LATER		DATE: xx.xx.xxxx	
			ITEM: BASKET DUPLEX STRAINER		SYSTEM: LUBE OIL PUMPS		SECTION:		SHEET 3 OF 3	

SL NO	COMPONENT & OPERATIONS	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	*	**	
						M	C/ N			D	M C N	

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- Project specific QP will be prepared based on customer requirement.
- BHEL reserves the right for conducting repeat test, if required

LEGENDS:

*RECORDS, IDENTIFIED WITH "TICK"(√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION,
 ** **M**: SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, **C**: MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, **N**: CUSTOMER,
P: PERFORM, **W**: WITNESS, **V**: VERIFICATION, AS APPROPRIATE
MA: MAJOR, **MI**: MINOR, **CR**: CRITICAL

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
	Sign & Date	Name		Sign & Date	Name	Seal			Sign & Date	Name	Seal
Prepared by:		S K Yadav	Checked by:		Ashish Panigrahi			Reviewed by:			
Reviewed by:		Sayan Roy	Reviewed by:		R K Jaiswal			Approved by:			

	MANUFACTURER'S NAME & ADDRESS BHEL APPROVED VENDOR		STANDARD QUALITY PLAN					PROJECT				
			ITEM : BASKET (SIMPLEX/DUPLEX) OIL STRAINER SUB-SYSTEM: LUBE OIL			QP NO. PE:QP:STD:567:A0 012 DATE 07/07/07 REV. 00 PAGE 3 of 3		PACKAGE LUBE OIL PUMPS CONTRACT NO LOI No. CONTRACTOR BHARAT HEAVY ELECTRICALS LTD.				
SR. NO.	COMPONENT & OPERATIONS	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	D*	M	C	N
						shade	shade					

		LEGEND : * RECORDS IDENTIFIED WITH "TICK" SHALL BE ESSENTIALLY INCLUDED BY CONTRACTOR IN QA DOCUMENTATION ** M: MANUFACTURER/SUB CONTRACTOR ,C: CONTRACTOR /NOMINATED INSPECTION AGENCY ,N: DVB/NTPC INDICATE 'P'-PERFORM, 'W'-WITNESS AND 'V'-VERIFICATION AS APPROPRIATE, 'CHP' SHALL BE IDENTIFIED IN COLUMN "REMARKS" BY DVB/NTPC	FOR DVB/NTPC USE	DOC.NO.:	
MANUFACTURER / SUBCONTRACTOR	CONTRACTOR				
SIGNATURE			REVIEWED BY	NAME & SIGN OF APPROVING AUTHORITY	

	TITLE 5X800 MW TSGENCO YADADRI TPS LUBE OIL TRANSFER PUMP MASTER DRAWING LIST	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
		Section – IA	Date
SECTION – IA MASTER DRAWING LIST			



TITLE:

**TECHNICAL SPECIFICATION
LUBE OIL TRANSFER PUMPS
5X800 MW TSGENCO YADADRI TPS**

SPEC. NO.: PE-TS-417-567-A001

SECTION-IA

REV. NO.: 00

DATE :04.04.2020

DRAWINGS/ DOCUMENTS REQUIRED DURING DETAIL ENGINEERING

The successful bidder shall submit the following drawings / documents during detail engineering for approval / information / reference (as the case may be):-

Sl. No.	BHEL Drawing / Document No.	Title	Schedule Date	Resubmission after incorporating comments
1	PE-V0-417-567-A001	Data sheet & GA of LOP	4 weeks from LOI	Within 1 week
2	PE-V0-417-567-A002	Data sheet & GA of Strainer	4 weeks from LOI	Within 1 week
3	PE-V0-417-567-A003	Data sheet & GA of lube oil pump motor	4 weeks from LOI	Within 1 week
4	PE-V0-417-567-A004	QAP of Lube oil pump and strainer	4 weeks from LOI	Within 1 week
5	PE-V0-417-567-A005	O & M Manual of lube oil pumps	8 weeks from LOI	Within 1 week



TITLE:

**TECHNICAL SPECIFICATION
LUBE OIL TRANSFER PUMPS
5X800 MW TSGENCO YADADRI TPS**

SPEC. NO.: PE-TS-417-567-A001

SECTION-IA

REV. NO.: 00

DATE :04.04.2020

NOTE : Drwg/ Document shall be uploaded by the successful bidder on WRENCH /DMS.Procedure for the same will be informed after award of contract.

COMPANY SEAL

SIGNATURE : _____

NAME : _____

DESIGNATION: _____

COMPANY: _____

DATE: _____



**TECHNICAL SPECIFICATION FOR
LUBE OIL TRANSFER PUMPS
SUB-VENDOR LIST**

SPECIFICATION NO. PE-TS-417-567-A001

SECTION IA

REVISION 00

DATE:04.04.2020

PAGE 1 of 3

**SECTION - IA
LIST OF MAKES OF SUB-VENDOR ITEMS
LUBE OIL TRANSFER SYSTEM**

	TECHNICAL SPECIFICATION FOR LUBE OIL TRANSFER PUMPS SUB-VENDOR LIST	SPECIFICATION NO. PE-TS-417-567-A001	
			SECTION IA
		REVISION 00	DATE:04.04.2020
		PAGE 2 of 3	

SUB-VENDORS - LUBE OIL TRANSFER PUMPS					
S. NO	CATEGORY OF INSPECTION	ITEM	SUB-VENDORS	PLACE	REMARKS
1	II	LUBE OIL TRANSFER PUMPS	UT PUMPS & SYSTEMS LTD.	FARIDABAD	
	II		MATZ PUMPS PVT. LTD.	AHMEDABAD	
	II		DELTA PD PUMPS PVT LTD	MUMBAI	
	II		TUSHACO PUMPS PVT.LTD.	NEW DELHI	
2	II	SIMPLEX STRAINERS	JAYPEE INDUSTRIES PVT. LTD.	NEW DELHI	
	II		MULTITEX FILTRATION ENGINEERS LIMITED,	NEW DELHI	
	II		OTOKLIN GLOBAL BUSINESS LIMITED	MUMBAI	
	II		BHATIA ENGINEERING CO.	NEW DELHI	
	II		FILTRATION ENGINEERS (I) PVT. LTD.	MUMBAI	
	II		SUNGOV ENGINEERING PVT. LTD.	CHENNAI	
	II		GRAND PRIX	FARIDABAD	
	II		SAROJINI ENTERPRISE	HOWRA	
	II		TUSHACO PUMPS PVT LIMITED	NEW DELHI	SELF MAKE- SUPPLIED IN DADRI
	II		RELIABLE ENGINEERS		SUBSIDIARY OF MATZ PUMP: SUPPLY STRAINER IN ALL PROJECT. ONLY FOR LOP
2	II	DUPLEX STRAINERS	JAYPEE INDUSTRIES PVT. LTD.	NEW DELHI	
	II		MULTITEX FILTRATION ENGINEERS LIMITED,	NEW DELHI	
	II		OTOKLIN GLOBAL BUSINESS LIMITED	MUMBAI	
	II		SUNGOV ENGINEERING PVT. LTD.	CHENNAI	
	II		GRAND PRIX	FARIDABAD	
	II		TUSHACO PUMPS PVT LIMITED	NEW DELHI	SELF MAKE- SUPPLIED IN DADRI
	II		RELIABLE ENGINEERS		SUBSIDIARY OF MATZ PUMP: SUPPLY STRAINER IN ALL PROJECT. ONLY FOR LOP
3	III	MOTORS	CROMPTON GREAVES LIMITED	AHMEDNAGAR	
	III		KIRLOSKAR ELECTRIC COMPANY	BANGALORE / HUBLI	
	III		SIEMENS	MUMBAI	
	III		ABB	BANGALORE / FARADABAD	
	III		BHARAT BIJLEE	MUMBAI	
	III		JYOTI	VADODARA	
	III		MARATHON	KOLKATA	
	III		Bharat Electric (BHEL)		

	TECHNICAL SPECIFICATION FOR LUBE OIL TRANSFER PUMPS SUB-VENDOR LIST	SPECIFICATION NO. PE-TS-417-567-A001	
			SECTION IA
		REVISION 00	DATE:04.04.2020
		PAGE 3 of 3	

	III		NGEF	BANDALORE / HUBLI	
	III		LHP	SOLAPUR	
4	III	PAINT	ASIAN PAINT		
	III		BERGER		
	III		KANSAI NEROLAC		
	III		JOTUN		
	III		SHALIMAR		
	III		JENSON & NICHOLSON (I) LTD		
	III		CDC CARBOLINE (I) LTD.		
	III		ADDISON PAINTS LTD		
	III		GRAND POLYCOAT		
	III		BOMBAY PAINTS		
	III		HEMPLE PAINTS (SINGAPORE)		
	III		AKZONOBEL COATINGS		
	NOTES	INSPECTION CATEGORIZATION			
	1	CAT I :INSPECTION BY OWNER, BHEL/BHEL NOMINATED TPJA & VENDOR .MDCC WILL BE ISSUED BASED ON INSPECTION REPORT IN LINE ITH APPROVED QAP.			
	2	CAT II: INSPECTION BY BHEL/BHEL NOMINATED TPJA & VENDOR. MDCC WILL BE ISSUED BASED ON INSPECTION REPORT IN LINE ITH APPROVED QAP.			
	3	CAT III: MDCC WILL BE ISSUED BASED COC & MTC ISSUSD BY VENDOR AND VERIFICATION BY BHEL/OWNER IN LINE WITH APPROVED QAP/CHECK LIST			

The make of Sub-vendor items shall be generally as indicated above which is subject to customer / BHEL approval during detail engineering.

Make of any unlisted items shall be subject to customer / BHEL approval during detail engineering. For such items, bidder to furnish list of sub-vendors during detail engineering stage for Customer / BHEL's review and approval. Bidder shall furnish following supporting documentation within 1 month of placement of LOI. Thereafter no request for additional sub-vendor shall be entertained.

- Documentation to show that the equipment /system has been supplied for a plant of similar or higher capacity.
- Documentation in the form of certificate that the equipment/system has been operating satisfactorily for two years as on the scheduled date of bid opening.

The successful bidder will get the makes of all items approved from Customer/ Consultant during detail engineering within two months of placement of LOI. The complete list will be necessarily be submitted within one month of placement of LOI to ensure timely placement of order for BOIs

Bidder to assess the capability of their proposed sub-vendors in terms of preparation of drawings, calculations, documents, quality assurance, supply of material etc. as per project schedule before placing the order on them.

Dealers are not acceptable for any item of the package. Bidder shall procure all items including plates, structural, flanges; counter flanges etc. from approved sub vendor only.

SUB-VENDOR LIST FOR ELECTRICAL ITEMS

ITEM DESCRIPTION	SL NO.	VENDOR NAME
CABLE GLANDS	1	ALLIED TRADERS & EXPORTERS
	2	ARUP ENGG & FOUNDRY WORKS
	3	BALIGA LIGHTING EQPT.PVT.LTD.
	4	COMMET BRASS PRODUCTS
	5	DOWELLS
	6	ELECTROMAC INDUSTRIES
	7	INCAB
CABLE LUGS	1	DOWELLS
	2	UNIVERSAL MACHINES LTD.
LV MOTORS (NON FLAME PROOF)	1	ABB
	2	BHARAT BIJLEE LTD.
	3	CROMPTON GREAVES
	4	GE-POWER
	5	KIRLOSKAR ELECTRIC CO LTD.
	6	LAXMI HYDRAULICS PVT. LTD
	7	MARATHON
	8	NGEF
	9	RAJINDRA ELECT INDUSTRIES
	10	SIEMENS

**TITLE**

5X800 MW TSGENCO YADADRI TPS
LUBE OIL TRANSFER PUMP
MANDATORY SPARE LIST

SPECIFICATION NO. PE-TS-417-567-A001

REV 00

Section – IA

Date :04.04.2020

SECTION: IA

MANDATORY SPARE LIST

MANDATORY SPARES LIST

1	415 Volt Motor (Upto 30KW Rating)	QUANTITY
1.1	Driving End & Non-Driving End Bearing	6 Set for each type and rating of Motor
1.2	Cooling Fan	4 Nos. for each type and rating of Motor
1.3	Terminal block for motors up to 30 Kw each rating	10 Nos. for each type and rating of Motor
1.4	Complete Set of Coupling	2 Set for each Application

	TITLE 5X800 MW TSGENCO YADADRI TPS LUBE OIL TRANSFER PUMP MASTER DRAWING LIST	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
		Section – IA	Date
SECTION – IA PAINTING SPECIFICATION			

TECHNICAL SPECIFICATION

FOR

PROTECTIVE LINING AND PAINTING

1.00.00 INTENT OF SPECIFICATION

1.01.00 This specification addresses the requirements of all labour, material, and appliances necessary with reference to preparations for lining / painting, application as well as finishing of all lining / painting for all mechanical and electrical equipment, piping and valves, structures etc. included under the scope of this Package.

1.02.00 The Bidder shall furnish and apply all lining, primers including wash primers if required, under-coats, finish coats and colour bands as described hereinafter or necessary to complete the work in all respects.

2.00.00 CODES & STANDARDS

2.01.00 The Bidder shall follow relevant Indian and International Standards wherever applicable in cleaning of surface, selection of lining material / paints and their application. The entire work shall conform to the following standards / specifications (latest revision or as specified).

- a) SSPC SP 10 / NACE 2 / : Near White Blast Cleaning
- b) SSPC PA 2 : Measurement of dry film Coating Thickness with magnetic gauges.
- c) ASTM D 4541 : Method for pull off strength using portable Adhesion Tester.
- d) NACE RP 0274 – 2004 : High-Voltage Electrical Inspection of Pipeline Coatings
- e) NACE SP 0188 – 2006 : Discontinuity (Holiday) Testing of New Protective Coatings on Conductive Substrates

- f) NACE RP 0169 – 2002 : Control of External Corrosion on Underground or Submerged Metallic Piping Systems
- g) AWWA C 210 – 2007 : Liquid-Epoxy Coating Systems for the Interior and Exterior of Steel Water Pipelines
- h) IS 3589:2001 Annexure B : Steel Pipes for Water and Sewage Specification.
- i) AWWA C222-2000 : Polyurethane Coating for the Interior and Exterior of Steel Water Pipe and Fittings.
- j) IS 13213 : 2000 : Polyurethane Full Gloss Enamel (Two pack)

3.00.00 GENERAL REQUIREMENTS

- 3.01.00** The steel surface preparation prior to actual commencement of coating shall conform to SSPC SP 10 / NACE 2 / Sa2½ (near white metal) with sand blasting.
- 3.02.00** The contractor shall submit a detailed written description in the form of a manual covering coating equipment, procedures, materials inspection test, and repair etc. to Owner/Consultant for approval.
- 3.03.00** The contractor shall also provide copies of test reports from NABL approved laboratory (like National Test House, Kolkata) in support of the paint/primer materials to be used shall conform to the specification requirement.
- 3.04.00** The contractor shall also provide certificates from paint/primer manufacturer mentioning the batch numbers, date of manufacture and shelf life etc. of the materials to be used. In addition to that Manufacturing Quality Plan (MQP) and Field Quality Plan (FQP) shall also be submitted prior to commencement of supply of material and field application.
- 3.05.00** Paint/coating application work at site shall be done either by paint manufacturer or by their authorized applicator. The authorized applicator shall have proper training & certification from manufacturer. Applicator shall possess all the necessary specialized equipment and manpower experienced in similar job.

- 3.06.00 Applied coating shall be tested for dry film thickness, holiday (electrical inspection for continuity) and adhesion as per relevant standard such as SSPC PA 2, NACE RP 0274 and ASTM D 4541.
- 3.07.00 If necessary, the material may be heated and applied by airless spray / plural component spray system.
- 3.08.00 Manufacturer's specific recommendation, if any, shall be followed during application of lining / paints.
- 3.09.00 In areas where there is danger of spotting automobiles or other finally finished equipment or building by wind borne particles from paint spraying, a Purchaser approved method shall be adopted.
- 3.10.00 The colour scheme of the entire Plant, covered under this specification shall be approved by the Purchaser in advance before application.
- 3.11.00 All indoor and outdoor piping, insulated as well as uninsulated will have approved colour bands painted on the pipes at conspicuous places throughout the system, as approved by Purchaser.
- 3.12.00 Inside surfaces of vessels / tanks shall be protected by anticorrosive paints or rubber lining as required / specified elsewhere in the specification. External surfaces of all vessels / tanks shall be protected by anti corrosive painting.
- 3.13.00 For vessels / tanks requiring lining and epoxy painting all inside surface shall be blast cleaned using non-siliceous abrasive after usual wire brushing.
- 3.14.00 Natural rubber lining shall be provided on the inside of vessels / tanks as required / specified elsewhere in the specification, in three layers resulting in a total thickness not less than 4.5 mm.
- 3.15.00 Surface hardness of rubber lining shall be 65 +/- 5 deg. A (shore).
- 3.16.00 After the lining is completed, the vessels / tanks shall not be subjected to any prolonged exposure to direct sunlight in course of its transportation, erection etc. They shall not be stored in direct sunlight. No further lining or burning shall be carried out on the vessel, after application of the lining.

- 3.17.00 All lining projecting outside of the vessel shall be protected adequately from mechanical damages during shipment, handling storage etc.
- 3.18.00 Suitable warnings, indicating the special care that must be taken with respect to these lined vessels shall be stenciled on their outside surface with the letters at least 12 mm high.
- 3.19.00 All insulated piping shall have aluminium sheet jacketing.

4.00.00 EQUIPMENT, MATERIAL AND SERVICES TO BE FURNISHED BY THE BIDDER

- 4.01.00** After erection at site, the outside surfaces of all equipment having a shop coat shall be given further priming coat and finished coats of paint as detailed in following clauses. However, if the painting system is such that the shop coat and primer coat to be applied at site are not compatible, then shop coat has to be removed from the surface of equipment before application of primer coat with prior blasting.

All factory finished paints shall be touched up at site as required.

All uninsulated piping shall be finished with final paintings after use of proper wash primer and primer. Aluminium sheet jacketed piping need not be painted. Colour bands of Purchaser's approved shade shall however be applied on jacketed piping near walls or partitions, at all junctions, near valves and all other places as instructed by the Purchaser. All structures shall be painted with approved paint.

4.02.00 Surface Preparation

- 4.02.01 Unless mentioned otherwise, all rust and mill scale shall be removed by blasting to Sa 2-1/2 Swiss Standard before applying the primer.
- 4.02.02 Special care shall be taken to remove grease and oil by means of suitable solvents like Trichloroethylene or Carbon Tetrachloride.
- 4.02.03 The minimum degree of surface preparations for all equipment, piping, fittings, valves, structures etc. shall be "Near White" according to Steel Structure, Painting Council-SSPC-SP-10 before application of any primer/paint.

4.03.00 Painting

- 4.03.01 Specification for application of paints for external surfaces protection of vessels / tanks / equipment / piping / fittings / valves etc. to be installed indoor shall be as follows :
- a) Surface preparation shall be done either manually or by any other approved method.
 - b) Primer Coat shall consist of one coat (minimum DFT of 50 microns) of chlorinated rubber based zinc phosphate.
 - c) Intermediate Coat (or Under Coat) shall consist of one coat (minimum DFT of 50 microns) of chlorinated rubber based paint pigmented with Titanium Dioxide.
 - d) Top Coat shall consist of one coat (minimum DFT of 50 microns) of chlorinated rubber paint of approved shade and colour with glossy finish.
 - e) Total DFT of paint system shall not be less than 150 microns.

- 4.03.02 Specification for application of paints for external surfaces protection of vessels / tanks / equipment / piping / fittings / valves etc to be installed **outdoor** shall be as follows :
- a) Surface preparation shall be done by means of sand blasting, which shall conform to Sa 2-1/2 Swiss Standard.
 - b) Primer Coat shall consist of one coat (minimum DFT of 100 microns) of epoxy resin based zinc phosphate primer.
 - c) Intermediate Coat (or Under Coat) shall consist of one coat (minimum DFT of 100 microns) epoxy resin based paint pigmented with Titanium Dioxide.
 - d) Top Coat shall consist of one coat (minimum DFT of 75 microns) of epoxy paint of approved shade and colour with glossy finish. Additional one coat (minimum DFT of 25 microns) of Finish Coat of polyurethane shall be provided.
 - e) Total DFT of paint system shall not be less than 300 microns.

- 4.03.03 Specification for application of paints for external surfaces protection of steel pipes and fittings which are **buried underground / laid inside a hume pipe & or submerged Under Water and laid under Pipe Trenches** (in road/rail/pipe or trench crossings) shall be as follows :

The no. of coats and DFT specified above is minimum. However to achieve above specified DFT, no of coats can be increased as per paint manufacture's recommendation.

External surface of the pipe, fittings, specialties etc. handling raw water/clarified water/filter water shall be painted with one coat of two part chemically cured polyurethane primer of min 50 micron dry film thickness followed by three or maximum four coats of two part solvent less polyurethane to build up coating of dry film thickness of 2000 micron including primer coat.

4.03.04 Specification for application of paints for **internal surface protection of large diameter pipes** (sizes above 600 mm NB and above) if any, shall be as follows :

- a) All Internal surfaces of steel pipes, fittings, specialties etc. buried underground or located within pipe trenches shall be given epoxy coating to protect them from (except for drinking water service, where the compatible painting shall be so selected to meet relevant quality standards) corrosion.
- b) Internal surface of the pipe should be coated with one coat of two part epoxy primer with not less than 50 micron DFT (dry film thickness) followed by two part polyamide cured solvent less epoxy.
- c) The minimum dry film thickness (DFT) of internal lining shall be 600 micron.

4.03.05 Specification for application of paints for protection of **internal surfaces of DM Water Storage Tank(s)** shall be as follows :

- a) Primer - One coat of epoxy primer containing high level of Zinc Phosphate anticorrosive pigment. Total Dry Film Thickness (DFT) of primer shall not be less than 125 microns.
- b) Finish Paint - Three (3) coats Polyamine HB Epoxy Paint. Total Dry Film Thickness (DFT) of finish paint shall not be less than 125 microns per coat.
- c) Total thickness of primer and paint should not be less than 500 microns.

4.03.06 All motors, local push button stations, cable racks, structures used for supports etc. are to be painted with acid proof paint.

4.03.07 The following surfaces shall not be painted - stainless steel, galvanized steel, aluminum, copper, brass, bronze and other nonferrous materials.

4.03.08 No painting or filler shall be applied until all repairs, hydrostatic tests and final shop inspection are completed.

The no. of coats and DFT specified above is minimum. However to achieve above specified DFT, no of coats can be increased as per paint manufacture's recommendation.

4.03.09 All machined surfaces shall have two (2) coats of water repellant grease after thorough cleaning.

5.00.00 COATING PROCEDURE AND APPLICATION

5.01.00 Surface Preparation :

Pipe shall be blast cleaned by sand. The cleanliness achieved prior to application shall be in accordance with the requirement of SSPC SP 10 / NACE 2 / Sa2½ of ISO 8501 (near white metal)

- a) The blast pattern or profile depth shall be 40 to 100 micron and shall be measured by dial micrometer.
- b) Before sand blasting is started or during blasting or coating, temperature of the pipe surface should be more than 3°C above dew point temperature. Blast cleaned surface should be primed within 4 hours and shall be protected from rainfall or surface moisture and shall not be allowed to flash rust. If the rust occurs, the surface again to be prepared by sand blasting or wire brushing.

5.02.00 Application of Epoxy Coating

- a) Coating shall be applied when
 - i) When the pipe surface temperature shall be atleast 3°C above dew point temperature.
 - ii) The temperature of mixed coating material and the pipe at the time of application shall not be lower than 10°C or greater than 50°C.
- b) Material preparation shall be in accordance with manufacturer's recommendations.
- c) Application of epoxy coating system :

The epoxy coating system shall be applied as per recommendation of the manufacturer and shall be applied by airless spray / plural component spray machine. For more than one coat, the second shall be applied with the time limits as recommended by the manufacturer.

5.03.00 Application of PU Coating

- a) PU coating shall be applied when the pipe surface temperature atleast 3°C above dew point temperature (when R.H is more than 85%).
- b) Material preparation and application shall be done as per manufacturer recommendation.

6.00.00 TEST REQUIREMENTS :

6.01.00 Measurement of dry film thickness

Measurement of dry film thickness of coating : Coating thickness shall be in the range of $\pm 20\%$ and as per SSPC PA 2.

6.01.01 Apparatus / Instrument:-

The instrument used for dry film thickness may be Type 1 pull of gauges or Type 2 electronic gauges.

6.01.02 Procedures:-

- a) Number of measurements:
For 100 square feet (9.29 square meters), five (5) spots per test area (each spot is 3.8 cm) in diameter. Three gauge readings per spot (average becomes the spot measurement).
- b) If the structure is less than 300 square feet, each 100 square feet should be measured.
- c) If the structure is between 300 and 1000 sq ft, select 3 random 100 square feet test areas and measure.
- d) For structure exceeding 1000 square feet, select 3 random 100 square feet testing areas for the first 1000 sq ft and select 1 random 100 square feet testing area for each additional 1000 square feet
- e) Coating thickness Tolerance: Individual reading taken to get a representative measurement for the spot are unrestricted (usually low or high readings are discarded). Spot measurements (the average of 3 gauge readings) must be within 80% of the minimum thickness and 120% of the maximum thickness.
Area measurement must be within specified range.

6.02.00 Electrical Inspection (Holiday) Test

- 6.02.01 All the coated / lined pipes shall be tested with an approved high voltage holiday detector preferably equipped with an audio visual signaling device to indicate any faults, holes, breaks or conductive particles in the protective coating.
- 6.02.02 The applied output voltage of holiday detector shall have a spark discharge of thickness equal to at least twice the thickness of the coating to assure adequate inspection voltage and compensate for any variation in coating thickness. The electrode shall be passed over the coated surface at approximately half the spark discharge distance from the coated surface only one time at the rate of approximately 10 to 20m/min. The edge effect shall be ignored. Excessive voltage shall be avoided as it tends to induce holiday in the coated surface thereby giving erroneous readings.
- 6.02.03 While selecting test voltages, consideration should be given to the tolerance on coating thickness and voltage should be selected on the basis of maximum coating thickness likely to be encountered during testing of a particular pipe.
- The testing voltage shall be calculated by using following formula. (as per NACE 0274 : 2004)
- Testing Voltage $V = 7900 \sqrt{T} \pm 10$ percent where T is the average coating thickness in mm.
- 6.02.04 Any audio visual sound or spark leads to indicate pinhole, break or conductive particle.
- 6.03.00 Adhesion Pull off Test :**
- After holiday the coated surface is subjected to adhesion pull off test as per ASTM D 4541.
- 6.03.01 Apparatus / Instrument: Adhesion tester consists of three basic components:
- A hand wheel, a black column containing a dragging indicator pin and scale in the middle and a base containing three legs and a pulling "Jaw" at the bottom and also dollies.
- 6.03.02 Prepare the test surface :
- Once test area is selected, test area shall be free of grease, oil, dirt, water. The area should be flat surfaces and large enough to accommodate the specified number of replicate test.
- 6.03.03 Prepare Dolly (Test Pull Stub) :

The dolly is a round, two sided aluminium fixture. Both sides of the dolly looks same, however, one side sloped on top surface while flat on bottom surface. As the surface of the dolly is polished aluminium, roughen the same using a coarse sand paper.

6.03.04 Select an adhesive:

Use araldite, a 100% solid epoxy adhesive. This adhesive requires at least 24 hours at room temperature to cure.

6.03.05 Attach the dolly to the surface.

- a) Using a wooden stick, apply an even layer of adhesive to the entire contact surface area of the dolly.
- b) Carefully remove the excessive adhesive by using a cotton swab. Allow the adhesive to fully cure before performing the adhesion test.
- c) Attach the dolly to the coated surface and gently push downward to displace any excessive adhesive.
- d) Push the dolly inward against the surface, then apply tape across the head of the dolly.

6.03.06 Adhesion Test Procedure

- a) Attach the adhesion tester to the dolly by rotating the hand wheel counter clockwise to lower the jaw of the device.
- b) Slide the jaw completely under the head of the dolly. Position the three legs of the instruments so that they are sitting flat on the coated surface.
- c) Slide the dragging indicator pin on the black column to zero by pushing it downward.
- d) Firmly hold the base of the instrument in one hand and rotate the handwheel clockwise to raise the jaw of the device that is attached to the head of the dolly. The dragging indicator pin will move upward on the black column as the force is increased and will hold the reading. Apply the tension using a moderate speed. Continue to increase the tension on the head of the dolly until (a) the minimum PSI/MPa/Kg/cm² required by project specification is exceeded and the test is discontinued, (b) the maximum PSI/MPa/Kg/cm² of adhesion tester has been achieved and dolly is still attached, (c) The force applied by the adhesion tester causes the dolly to dislodge.

e) Read the scale and record the adhesion value.

6.04.00 Coating Repair

Defective Coating shall be repaired in accordance with the following subsections.

6.04.01 Surface Preparation:

Accessible areas of pipe requiring coating repairs shall be cleaned to remove debris and damaged coating using surface grinders or other means. The adjacent coating shall be feathered by sanding, grinding or other method. Accumulated debris shall be removed by blowing with contaminant free air or wiping with clean rags.

6.04.02 Areas not accessible for coating repair such as interior surfaces of small diameter pipe shall be reprocessed and recoated.

6.04.03 Coating Application :

The coating system shall be applied to the prepared areas in accordance with procedure.

6.04.04 Repair Inspection :

Repaired portion shall be electrically inspected using a holiday detector.

6.05.00 Welded Field Joints

6.05.01 Preparation :

The weld joints shall be cleaned so as to be free from mud, oil, grease, welding flux, weld spatter and other foreign contaminants. The cleaned metal surfaces of the weld joint shall then be blasted or abraded using rotary abrading pads. The adjacent liquid Epoxy / PU coating shall be feathered by abrading the coating surface for a distance of 25 mm.

6.05.02 Electrical Inspection :

After curing the coating system applied to the welding joints shall be holiday tested. Any holidays indicated by the detector shall be marked with chalk to identify the area of repair.

7.00.00**INFORMATION/DATA REQUIRED**

The Bidder shall submit complete list of paints and primers proposed, giving detail information, such as, chemical composition, drying time etc. and also unit rates for application of each type of paint along with supply shall be furnished.



**TECHNICAL SPECIFICATION FOR
LUBE OIL TRANSFER PUMP
5 X 800MW YADADRI TPS**

SPECIFICATION NO. PE-TS-417-567-A001

SECTION 'I-A'

REVISION 00

DATE:04.04.2020

PAGE 1 of 2

SECTION: I-A

DRAWINGS / DOCUMENTS SUBMISSION PROCEDURE

DISTRIBUTION SCHEDULE

S.No .	Description	TSGENCO									Consultant			Equipm ent Vendor	Remarks
		CMD Hyd	Director (Projects)	ED/ Civil Hyd.	ED (TPC) Hyd	CE/TPC	CE/ YTPS	SE (Civil) YTPS	SE (E&M) YTPS	EE YTPS	Head Office	HYD	YTPS Site		
A.	Vendor Drawings														
1.	Preliminary	-	1	1	2		1	1	2	-	10	1	-	S	
2.	Return preliminary with comments	-	1	1	2		1	1	1	-	S+2	-	-	1	
3.	Final and any revision thereof	1	1	1	3		1	1	3	-	2	1	1	S	
B.	Progress Report Monthly														
1.	Monthly progress report	1	1	1	2		1	1	1	1	1	1	1	S	
C.	Instruction Manuals/ Data Books/As built drawings														
1.	Equipment manufacturer	-	-	-	2		1	-	2	4	2	1	1	S	
S : Source															

Hard copy distribution schedule shall be as above, Further following may please be noted

- a) Vendor Drawings mentioned at Sl.no."A" above shall covered all drawings, documents, QAP, PG test and O& M Manual etc.
- b) Monthly progress report mentioned at Sl.no."B" above shall be submitted to BHEL Units and PMG instead of TSGENCO/Consultant specified above.
- c) 5 nos. hard copies of vendor drawings in addition to those mentioned in above table along with soft copy shall be submitted to BHEL. Further distribution to BHEL units shall be informed during detail engineering.
- d) Equipment Vendor/Manufacturer means BOP contractor.
- S: Indicated against agency responsible for submission of respective department

S. No	Description	TSGENCO								CONSULTANT			Equipment Vendor	Remarks
		Director Projects	Director Technical	CE/Civil Thermal Projects Hyd.	CE/ TPC-I, Hyd	CE/ O&M/ YTPS	SE/ Civil YTPS	SE/E&M / YTPS	DE Constr. YTPS	Kolkata	HYD	YTPS		
D	Progress Report Monthly													
1.	Equipment vendor	1	1	1	2	1	1	2	1	1	1	1	S	
2.	M/s DCPL, Kolkata	1	1	2	2	1	1	2	1	S	1	1	Nil	
E	Test & Inspection Reports													
1.	Equipment manufacturer													
	a. Civil	1	1	1	2	1	1	1	-	11	1	1	S	
s	b. E&M	1	1	-	2	1	-	1	1	11	1	1	S	
2.	M/s DCPL, Kolkata	1	1	-	2	1	-	1	1	S	-	1	-	
F	Instruction Manuals/Data Books													
1.	Equipment manufacturer													
	a. Civil	1	1	1+1T	1	1	6+1T	1	1	2+1T	1	1	S	
	b. E&M	1	1	-	3+1T	1	-	6+1T	2	3+1T	1	1	S	
2.	M/s DCPL, Kolkata	1	1	-	10+1T	1	-	15+1T	-	S	1	1	Nil	
G	M/s DCPL, Kolkata Criteria	1	1	1	8+1T	1	1	2	1	1	1	1	S	
H	Design Calculations	1	1	1	8+1T	1	1	2	1	1	1	1	S	
I	Final consulting Engineering Report	1	1	1	10	1	1	2	1	S	1	1	Nil	

S – Source, T – Transparency & Soft Copy on CD,

**TELANGANA STATE POWER GENERATION
CORPORATION LTD
TELANGANA STATE, INDIA**

5x800 MW YADADRI TPS

SECTION – IB

**LUBE OIL TRANSFER PUMP TECHNICAL
SPECIFICATION
(ELECTRICAL PORTION)**



**BHARAT HEAVY ELECTRICALS LIMITED
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT,
NOIDA, U.P., INDIA**



TITLE: LUBE OIL TRANSFER PUMP TECHNICAL SPECIFICATION (ELECTRICAL PORTION) 5X800 MW YADADRI TPS	SPECIFICATION NO.
	VOLUME NO. : II-B
	SECTION: I
	REV NO. : 00 DATE: 03/04/2020 SHEET: 1 OF 1

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ELECTRICAL SCOPE BETWEEN BHEL & VENDOR	1
ELECTRICAL LOAD DATA FORMAT	1
DATASHEET-A	1
DATASHEET-C	2
CABLE SCHEDULE FORMAT	1
EXPLANATORY NOTES FOR CABLE LISTING	2
QUALITY PLAN (FOR MOTORS ABOVE & 55 KW)	9
QUALITY PLAN (FOR MOTORS BELOW 55 KW)	2
TOTAL	31

NOTE: THE REQUIREMENTS MENTIONED IN SECTION-I SHALL PREVAIL AND GOVERN IN CASE OF CONFLICT BETWEEN THE SAME AND THE CORRESPONDING REQUIREMENTS MENTIONED IN THE DESCRIPTIVE PORTION IN SECTION-II.

	TECHNICAL SPECIFICATION FOR LUBE OIL TRANSFER PUMP 5X800 MW YADADRI TPS (ELECTRICAL PORTION)	SPECIFICATION NO.
		VOLUME NO. : II-B
		SECTION : I
		REV NO. : 00 DATE: 03/04/2020
		SHEET : 1 OF 3

SPECIFIC TECHNICAL REQUIREMENTS **FOR LV MOTORS (ELECTRICAL)**

SECTION-I

	TECHNICAL SPECIFICATION FOR LUBE OIL TRANSFER PUMP 5X800 MW YADADRI TPS (ELECTRICAL PORTION)	SPECIFICATION NO. VOLUME NO. : II-B SECTION : I REV NO. : 00 DATE: 03/04/2020 SHEET : 1 OF 3

SPECIFIC TECHNICAL REQUIREMENTS: ELECTRICAL

1.0 EQUIPMENT & SERVICES TO BE PROVIDED BY BIDDER:

- a) Services and equipment as per “Electrical Scope between BHEL and Vendor”.
- b) Any item/work either supply of equipment or erection material which have not been specifically mentioned but are necessary to complete the work for trouble free and efficient operation of the plant shall be deemed to be included within the scope of this specification. The same shall be provided by the bidder without any extra charge.
- c) Supply of mandatory spares as specified in the specifications of mechanical equipment's.
- d) Electrical load requirement for LUBE OIL TRANSFER PUMP.
- e) All equipment shall be suitable for the power supply fault levels and other climatic conditions mentioned in the enclosed project information.
- f) Bidder to furnish list of makes for each equipment at contract stage, which shall be subject to customer/BHEL approval without any commercial and delivery implications to BHEL.
- g) Various drawings, data sheets as per required format, Quality plans, calculations, test reports, test certificates, operation and maintenance manuals etc. shall be furnished as specified at contract stage. All documents shall be subject to customer/BHEL approval without any commercial implication to BHEL.
- h) Motor shall meet minimum requirement of motor specification.
- i) Vendor to clearly indicate equipment locations and local routing lengths in their cable listing furnished to BHEL.
- j) Cable BOQ worked out based on routing of cable listing provided by the vendor for “both end equipment in vendor's scope” shall be binding to the vendor with +10 % margin to take care of slight variation in routing length & wastages.

2.0 EQUIPMENT & SERVICES TO BE PROVIDED BY PURCHASER FOR ELECTRICAL & TERMINAL POINTS:

Refer “Electrical Scope between BHEL and Vendor” Annexure - I.

3.0 DOCUMENTS TO BE SUBMITTED ALONG WITH BID

- 3.1 The electrical specification without any deviation from the technical/quality assurance requirements stipulated shall be deemed to be complied by the bidder in case bidder furnishes the overall compliance of package technical specification in the form of compliance certificate/No deviation certificate.
- 3.2 No technical submittal such as copies of data sheets, drawings, write-up, quality plans, type test certificates, technical literature, etc., is required during tender stage. Any such submission even if made, shall not be considered as part of offer.

	TECHNICAL SPECIFICATION FOR LUBE OIL TRANSFER PUMP 5X800 MW YADADRI TPS (ELECTRICAL PORTION)	SPECIFICATION NO.
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4.0 List of enclosures:

- a) Electrical scope between BHEL & vendor (Annexure –I)
- b) Technical specification for motors.
- c) Datasheets for motors.
- d) Electrical Load data format (Annexure –II)
- e) BHEL cable listing format (Annexure –III)
- f) Quality plan for motors.

BASIC TECHNICAL FEATURES FOR LT MOTORS

(FOR BHEL-PEM SCOPE PACKAGES)

 CUSTOMER: TELANGANA STATE POWER GENERATION CORPORATION LTD TELANGANA, INDIA 5 x 800 MW YADADRI TPS, NALGONDA OWNER'S CONSULTANT: TATA CONSULTING ENGINEERS LTD BANGLORE INDIA BHARAT HEAVY ELECTRICALS LTD POWER SECTOR PROJECT ENGINEERING MANAGEMENT NOIDA										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 any way detrimental to the interest of the company.																			
										DEPT CODE DRN HC s.d. 07.12.17 DESN HC s.d. 07.12.17 CHD AS s.d. 07.12.17 APPD PD s.d. 07.12.17																			
										NAME HC s.d. 07.12.17 AS s.d. 07.12.17 PD s.d. 07.12.17																			
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REV. 02 DATE 16.08.2018 ALTD HC CHD AS APPD PD REVISED IN LINE WITH CUSTOMER COMMENTS DT. 13.08.2018					REV. 01 DATE ALTD CHD APPD REVISED IN LINE WITH CUSTOMER COMMENTS DT. 19.04.2018					TITLE BASIC TECHNICAL FEATURES FOR LT MOTORS																			
										DEPT. SCALE SIGN										DRAWING NO. PE-DC-417-565-E003									
										SHEET 1 OF 7										REV. 02									



**5 x 800 MW YADRADRI TPS
BASIC TECHNICAL FEATURES
FOR LT MOTORS
(FOR BHEL-PEM SCOPE PACKAGES)**

Doc. No.	PE-DC-417-565-E003
Rev. No.	02
Dated	16-08-2018
Page	2 of 7

- 1.0 This document covers the basic technical features of low tension (LT) squirrel cage induction AC motors employed for driving auxiliaries of BHEL-PEM scope packages in **5 x 800 MW YADRADRI TPS**.

2.0 CODES AND STANDARDS

All motors shall conform to the latest applicable standards as listed below;

- 1) Three phase induction motors: IS: 12615, IEC: 60034
- 2) Single phase AC motors: IS: 996, IEC: 60034
- 3) Crane duty motors: IS: 3177, IEC: 60034
- 4) Energy Efficient motors: IS 12615 or IEC: 60034-30 with Efficiency class IE3

3.0 DESIGN REQUIREMENTS

3.1 Service Conditions

The motors will be installed in hot, humid and tropical atmosphere highly polluted at places with coal dust and/or fly ash. For motor installed outdoor and exposed to direct sunrays, the effect of solar heat shall be considered in the determination of the design ambient temperature.

The design ambient temperature shall be 50 deg C.

3.2 Supply system and rated voltage of motors

KW rating	Supply system	Rated voltage of motor
Upto 0.2 kW	240V/415 V	240V/415 V
Above 0.2 kW & up to 175kW	415 V	415 V

3.2.1 Supply voltage & variations shall be as follows:-

Voltage variation (AC Supply): (+/-) 10%

Frequency variation : (+) 3% to (-) 5%

Combined V & F variation : 10% (sum of absolute values)

During starting of large motor, the voltage may drop to 80% of the rated voltage for a period of 60 seconds. All electrical equipment while running shall successfully ride over such period without affecting system performance.

3.2.2 Motors shall be capable of running continuously at rated output for each of the conditions specified.

3.3 Motor Rating

All motors shall be rated for continuous duty. They shall also be suitable for long period of inactivity. LT motor rating at 50 degree C shall have at least 15% margin over the input power requirement of the driven equipment at rated duty point unless stated otherwise in driven equipment specification. The motor characteristics shall match the requirements of the driven equipment so that adequate starting, accelerating, pull up, break down and full load torques are available for the intended service.

3.4 Starting Requirements

3.4.1 Motor shall start smoothly and rapidly. Motor characteristics such as speed, starting torque, break away torque and starting time shall be properly co-ordinated with the requirements of driven equipment. The

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accelerating torque at any speed with the minimum starting voltage shall be at least 10% higher than that of the driven equipment.

- 3.4.2 Motors shall be capable of starting and accelerating the load with direct on line starting without exceeding acceptable winding temperature.

The limiting value of voltage at rated frequency under which a motor will successfully start and accelerate to rated speed with load shall be taken to be a constant value of 85 (eighty five) percent rated voltage.

- 3.4.3 Continuous duty LT motors up to 175 KW Output rating (at 50 deg. C ambient temperature), shall be Premium efficiency (IE3) as per IEC: 60034-30/ IS: 12615 and the locked rotor current of motors shall as per IS 12615.
However, as per system requirement drives rated in the range of 160-210 KW may be considered in either 415V or 3.3 KV

- 3.4.4 Pump motor subject to reverse rotation shall be designed to withstand the stresses encountered when starting with shaft rotating at 125% rated speed in reverse direction. The motors shall be designed to withstand 120% of rated speed for 2 minutes without any mechanical damage.

- 3.4.5 The following frequency of starts shall apply

- i) Three cold starts in succession with the motor being initially at a temperature not exceeding the ambient temperature.
- ii) Two hot starts in succession with the motor being initially at a temperature not exceeding the rated load temperature.
- iii) Three equally spread starts in an hour the motor being initially at a temperature not exceeding the rated load operating temperature (not to be repeated in the second successive hour)

- 3.4.6 Locked motor withstand time of hot motors at 110% rated voltage shall be as follows:

- a) For motors with starting time upto 20 sec.
 - at least 3 sec. more than starting time.
- b) For motor with starting time above 20 secs but not exceeding 45 secs.
 - at least 5.0 sec. more than starting time.
- c) For motors with starting time above 45 secs.
 - at least 10%. more than starting time.

The starting time of the motor referred above is at minimum permissible voltage. Wherever the above requirements are not complied with, speed switches of approved make & type shall be provided to bypass the locked rotor protection for a pre-selected time during starting of motors. The speed switches shall have one NO & one NC contacts having maximum interrupting capacity of 5 Amps at 240V AC and 0.25 amps at 220 V DC.

Hot thermal withstand curve shall have a margin of at least 10% over the full load current of the motor to permit relay setting utilising motor rated capacity.

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3.5 Running Requirements

- 3.5.1 Motor shall run continuously at rated output over the entire range of voltage and frequency variations as given above.
- 3.5.2 The motor shall be capable of operating satisfactorily at full load for 5 minutes without injurious heating with 75% rated voltage at motor terminals.
- 3.5.3 The motor shall be designed to withstand momentary overload of 60% of full load torque for 15 second without any damage.

3.6 Stress during bus Transfer

- 3.6.1 The motor may be subjected to sudden application of 150% rated voltage during bus transfer, due to the phase difference between the incoming voltage and motor residual voltage.
- 3.6.2 The motor shall be designed to withstand any torsional and/or high current stresses, which may result, without experiencing any deterioration in the normal life and performance characteristics.

4.0 SPECIFIC REQUIREMENTS

4.1 Enclosure

All motor enclosures for outdoor, semi-outdoor & indoor application shall conform to the degree of protection IP-55 unless otherwise specified. Motor for outdoor or semi-outdoor service shall be of weather-proof construction with canopy. For hazardous area approved type of increased safety enclosure shall be furnished.

4.2 Cooling

- 4.2.1 The motor shall be self-ventilated type, either totally enclosed fan cooled IC 411(TEFC), totally enclosed tube ventilated IC 511(TETV) or closed air circuit air- cooled IC 611(CACA).

4.3 Winding and Insulation

All insulated winding shall be of copper. All motors shall have class F insulation but limited to class B temperature rise. Windings shall be impregnated to make them non-hygroscopic and oil resistant.

Tropical Protection

All motors shall have fungus protection involving special treatment of insulation and metal against fungus, insects and corrosion.

All fittings and hardware shall be corrosion resistant.

4.4 Bearings

- 4.4.1 Motor shall be provided with antifriction bearings, unless sleeve bearings are required by the motor application. Bearings shall be rated for minimum service life of 40,000Hrs.
- 4.4.2 Vertical shaft motors shall be provided with thrust and guide bearings. Thrust bearing of tilting pad type is preferred.

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- 4.4.3 Bearings shall be provided with seals to prevent leakage of lubricant or entrance of foreign matters like dirt, water etc. into the bearing area.
- 4.4.4 Sleeve bearings shall be split type, ring oiled, with permanently aligned, close running shaft sleeves.
- 4.4.5 Grease lubricated bearings shall be pre-lubricated and shall have provisions for in-service positive lubrication with drains to guard against over lubrication. LT motors 15kW and above shall be provided with external greasing arrangement.
- 4.4.6 Oiled bearing shall have an integral self-cooled oil reservoir with oil ring inspection ports, oil sight glass with oil level marked for standstill and running conditions and oil fill and drain plugs.
- 4.4.7 Forced lubricated or water cooled bearing shall be used as per requirement.
- 4.4.8 Lubricant shall not deteriorate under all service conditions. The lubricant shall be limited to normally available types with IOC equivalent.
- 4.4.9 Bearings shall be insulated as required to prevent shaft current and resultant bearing damage.

4.5 **Noise & Vibration**

- 4.5.1 For 415V motors, maximum double amplitude vibrations upto 1500 rpm shall be 40 microns and 15 microns upto 3000 rpm.
- 4.5.2 The noise level shall not exceed 85db (A) at 1.5 meters from the motor.

4.6 **Motor Terminal Box**

- 4.6.1 Motor terminal box shall be detachable type and located in accordance with Indian Standards clearing the motor base- plate/ foundation
- 4.6.2 Terminal box shall be capable of being turned 360 deg in steps of 90 Deg. for LT motors unless otherwise approved.
- 4.6.3 The terminal box shall be split type with removable cover with access to connections and shall have the same degree of protection as motor.
- 4.6.4 The terminal box shall have sufficient space inside for termination/connection of XLPE insulated armoured aluminium cables.
- 4.6.5 Terminals shall be stud or lead wire type, substantially constructed and thoroughly insulated from the frame.
- 4.6.6 The terminals shall be clearly identified by phase markings, with corresponding direction of rotation marked on the non-driving end of the motor.
- 4.6.7 The terminal box shall be capable of withstanding maximum system fault current for a duration of 0.25 sec.
- 4.6.8 Motor terminal box shall be furnished with suitable cable lugs and double compression brass glands to match with cable used.
- 4.6.9 The gland plate for single core cable shall be non-magnetic type. A suitable cable adopter box shall be provided if the cable size does not allow the direct termination in the main TB.

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4.6.10 Minimum clearances to be provided between phase to phase and phase to earth shall be as under-

Voltage Rating of Motor Minimum Ph-Ph & Ph-Earth clearance

0.415 kV : 25 mm

Note: In case it is not possible to maintain these clearances, the live parts shall be totally insulated from earth and other Phases. Adequate clearances shall be provided for cable connections.

4.7 **Grounding**

The frame of each motor shall be provided with two separate and distinct grounding pads complete with tapped hole, GI bolts and washer.

The cable terminal box shall have a separate grounding pad.

4.8 **Rating Plate**

In addition to the minimum information required by IS, the following information shall be shown on motor rating plate:

- Temperature rise in Deg.C under rated condition and method of measurement.
- Degree of protection.
- Bearing identification no. and Type of lubrication, Quantity and frequency/ time interval
- Location of insulated bearings.

5.0 **ACCESSORIES**

5.1 **SPACE HEATERS**

Motor of rating 30 kW and above shall be provided with space heaters, suitably located for easy removal or replacement. The space heater shall be rated 240 V, 1 Phase, 50Hz and sized to maintain the motor internal temperature above dew point when the motor is idle. The minimum cable size for space heater shall be 2.5 sq.mm copper cable.

5.2 **DELETED**

5.3 **INDICATOR/ SWITCH**

5.3.1 Dial type local indicator with alarm contacts shall be provided for the following:

Hot and cold air temperature of the closed air circuit for CACA motor.

5.3.2 Alarm switch contact rating shall be minimum 2.0 A at 220V D.C. and 10A at 240V A.C.

5.4 **ACCESSORY TERMINAL BOX**

5.4.1 All accessory equipment such as space heater, temperature detector, current transformers etc., shall be wired to and terminated in terminal boxes, separate from and independent of motor (power) terminal box.

5.4.2 Accessory terminal box shall be complete with double compression brass glands and pressure type terminals to suit owner's cable connections.

DRAIN PLUG

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Motor shall have drain plugs so located that they will drain the water, resulting from the condensation or other causes from all pockets of the motor casing.

5.5 LIFTING PROVISIONS

Motor weighing 25 Kg. or more shall be provided with eyebolt or other adequate provision of lifting.

5.6 DOWEL PINS

The motor shall be designed to permit easy access for drilling holes through motor feet or mounting flange for installation of dowel pins after assembling the motor and driven equipment.

7.0 PAINTING

Colour scheme for motors shall be shade 631 of IS-5.

8.0 TESTING

8.1 Type Tests

For LT Motors, type test reports for type tests as per IS: 12615/ IEC: 60034 conducted on equipment similar to those proposed to be supplied shall be submitted. The type Test should have been conducted within last 5 years from enquiry date.

8.2 Routine Tests

All motors shall be subjected to routine tests as per IS: 12615/ IEC: 60034 in the presence of customer or customer representative.

9.0 Variable Frequency Drive motor details:

- i) The motor shall be suitable for operation with a solid-state power supply consisting of an adjustable frequency inverter for speed control.
- ii) The motor shall be suitable for the current waveforms produced by the power supply including the harmonics generated by the drive.
- iii) The Motor shall be designed to operate continuously at any speed over the range 20-100 % of rated speed.
- iv) The permitted voltage variation should take into account the steady state voltage drop across the AC drive and all other system components upstream of the motor.
- v) Motors required to be transferred to DOL, by-pass mode shall be rated for specified variations in system line voltage and frequency. Starting current of motor in DOL, bypass mode shall be limited to value in motor specifications.
- vi) The motor shall be constructed to withstand torque pulsations resulting from harmonics generated by the solid-state power supply.
- vii) The motor insulation shall be designed to accept the applied voltage waveform, within the V_{peak} and dv/dt limits as per IEC-61800-4.
- viii) The drive manufacturer shall be solely responsible for proper selection of the motor for the given load application and the output characteristics of the drive.

STANDARD ELECTRICAL SCOPE BETWEEN BHEL AND VENDOR (FOR EPC PROJECTS)
PACKAGE: LUBE OIL TRANSFER PUMP (Supply Package)

PROJECT: 5x800 MW YADADRI TPS

<u>S.NO</u>	<u>DETAILS</u>	<u>SCOPE SUPPLY</u>	<u>SCOPE E&C</u>	<u>REMARKS</u>
1	415 V MCC	BHEL	BHEL	240 V AC (supply feeder)/415 V AC (3 PHASE 4 WIRE) supply shall be provided by BHEL based on load data provided by vendor at contract stage for all equipment supplied by vendor as part of contract. Any other voltage level (AC/DC) required will be derived by the vendor.
2	Local Push Button Station (for motors)	BHEL	BHEL	Located near the motors.
3	Power cables, control cables and screened control cables	BHEL	BHEL	Incoming cable from BHEL supplied MCC will be informed by BHEL. Screened control cable between DCS & field equipment will also be informed by BHEL. Vendor shall provide lugs & glands accordingly.
4	Cable trays, accessories & cable trays supporting system	BHEL	BHEL	
5	Cable glands and lugs for equipment's supplied by Vendor	Vendor	BHEL	1. Double compression Ni-Cr plated brass cable glands 2. Solder less crimping type heavy duty tinned copper lugs for power and control cables.
6	Conduit and conduit accessories for cabling between equipment's supplied by vendor	BHEL	BHEL	
7	Equipment grounding & lightning protection	BHEL	BHEL	
8	Below grade grounding	BHEL	BHEL	
9	LT Motors with base plate and foundation hardware	Vendor	BHEL	Makes shall be subject to BHEL approval at contract stage.
10	Mandatory spares	Vendor	-	Vendor to quote as per specification.
11	Recommended O & M spares	Vendor	-	As per specification
12	Any other equipment/material/service required for completeness of system but not specified above (to ensure trouble free and efficient operation of the system).	Vendor	BHEL	
13	Electrical equipment GA drawing	Vendor	-	For necessary interface review.

NOTES:

1. Make of all electrical equipments/items supplied shall be reputed make & shall be subject to approval of BHEL after award of contract.
2. All QPs shall be subject to approval of BHEL after award of contract without any commercial implication.

	TITLE	LV MOTORS DATA SHEET-A	SPECIFICATION NO.	
			VOLUME	II B
			SECTION	C
			REV NO. 00	DATE 19.01.2018
			SHEET 1	OF 1

1.0	Design ambient temperature	:	50 °C
2.0	Maximum acceptable kW rating of LV motor	:	175 KW
3.0	Installation (Indoors/ Outdoors)	:	As required
4.0	Degree Of Protection	:	IP55
5.0	Details of supply system		
	a) Rated voltage (with variation)	:	240V, 415V ± 10%
	b) Rated frequency (with variation)	:	50 Hz (Variation: +3% TO –5%)
	c) Combined voltage & freq. variation	:	10% (sum of absolute values)
	d) System fault level at rated voltage	:	50 kA for 1 sec
	e) Short time rating for terminal box	:	50 kA for 0.25 sec
	f) LV System grounding	:	Solidly
6.0	Class of insulation	:	Class ‘F’,with temp rise limited to class B.
7.0	Minimum voltage for starting (As percentage of rated voltage)	:	80% of rated voltage
8.0	Power cables data	:	Shall be given during detailed engg.
9.0	Earth Conductor Size & Material	:	Shall be given during detailed engg.
10.0	Space heater supply (30KW & ABOVE)	:	240 V, 1Φ , 50 Hz
11.0	Rating up to which Single phase motor	:	Acceptable below 0.20 Kw
12.0	TYPE OF STARTER PROVIDED IN MCC	:	DOL
13.0	Locked rotor current		
	a) Limit as percentage of FLC	:	As per IS-12615
	b) Permissible tolerance, if any	:	As per IS-12615
14.0	Terminal box	:	Suitable to rotate at 90 degrees
15.0	Paint shade	:	Shade 631 of IS-5

	TITLE	MOTOR DATA SHEET – C 5 X 800 MW YADADRI TPS	SPECIFICATION NO.	
			VOLUME	II B
			SECTION D	
			REV NO. 00 DATE	
			SHEET	1 OF 2

S. No.	Description		Data to be filled by successful bidder	
A.	General			
1	Manufacturer & country of origin			
2	Motor type			
3	Type of starting			
4	Name of the equipment driven by motor & Quantity			
5	Maximum Power requirement of driven equipment			
6	Rated speed of Driven Equipment			
7	Design ambient temperature			
B.	Design and Performance Data			
1	Frame size & type designation			
2	Type of duty			
3	Rated Voltage			
4	Permissible variation for			
5	a	Voltage		
6	b	Frequency		
7	c	Combined voltage & frequency		
8	Rated output at design ambient temp (by resistance method)			
9	Synchronous speed & Rated slip			
10	Minimum permissible starting voltage			
11	Starting time in sec with mechanism coupled			
12	a) At rated voltage			
13	b) At min starting voltage			
14	Locked rotor current as percentage of FLC (including IS tolerance)			
15	Torque			
	a) Starting			
	b) Maximum			
16	Permissible temp rise at rated output over ambient temp & method			
17	Noise level at 1.0 m (dB			
18	Amplitude of vibration			
19	Efficiency & P.F. at rated voltage & frequency			
	a) At 100% load			
	c) At 75% load			

NAME OF VENDOR			SEAL	REV.	
NAME	SIGNATURE	DATE			

	TITLE	MOTOR DATA SHEET – C 5 X 800 MW YADADRI TPS	SPECIFICATION NO.	
			VOLUME	II B
			SECTION D	
			REV NO. 00	DATE
			SHEET 2	OF 2

S. No.	Description	Data to be filled by successful bidder
	c) At starting	
C.	Constructional Features	
1	Method of connection of motor driven equipment	
2	Applicable Standard	
3	DOP of Enclosure	
4	Method of cooling	
5	Class of insulation	
6	Main terminal box	
	a) Type	
	b) Power Cable details (Conductor, size, armour/unarmour)	
	c) Cable Gland & lugs details (Size, type & material)	
	d) Permissible Fault level (kArms & duration in sec)	
7	Space heater details (Voltage & watts)	
8	Flame proof motor details (if applicable)	
	a) Enclosure	
	b) suitability for hazardous area	
	i Zone	O / I / II
	ii Group	IIA / IIB / IIC
9	No. of Stator winding	
10	Winding connection	
11	Kind of rotor winding	
12	Kind of bearings	
13	Direction of rotation when viewed from NDE	
14	Paint Shade & type	
15	Net weight of motor	
16	Outline mounting drawing No (To be enclosed as annexure)	
D.	Characteristic curves/ drawings (To be enclosed for motors of rating $\geq 55\text{KW}$)	
	a) Torque speed characteristic	
	b) Thermal withstand characteristic	
	c) Current vs time	
	d) Speed vs time	

NAME OF VENDOR			SEAL	REV.	
NAME	SIGNATURE	DATE			

CABLE SCHEDULE FORMAT

ANNEXURE III

[illegible]

Explanatory notes for filling up cable list for routing through WinPath, the cable routing program (developed by Corporate R&D) being used in PEM.

1. For the purpose of clarity, it may please be noted that the information given in regard to the cables to be routed through WinPath as per the system elaborated below is called "Cable List", while the term "Cable Schedule" applies to the cable list with routing information added after routing has been carried out.
2. The cable list shall be entered as an MS Excel file in the format as per enclosed template EXT_CAB_SCH_FORMAT.XLS. No blank lines, special characters, header, footer, lines, etc. shall be introduced in the file. No changes shall be made in the title line (first line) of the template.
3. The field properties shall be as under:
 - a. UNITCABLENO: A/N, up to sixteen (16) characters; each cable shall have its own unique, unduplicated cable number. In case this rule is violated, the cable cannot be taken up for routing.
 - b. FROM: A/N, up to sixty (60) characters; the "From" end equipment/ device description and location to be specified here. Information in excess of 60 characters will be truncated after 60 characters.
 - c. TO: A/N, up to sixty (60) characters; the "To" end equipment/ device description and location to be specified here. Information in excess of 60 characters will be truncated after 60 characters.
 - d. PURPOSE: A/N, up to sixty (60) characters; the purpose (i.e. power cable/ indication/ measurement, etc.) to be specified here. Information in excess of 60 characters will be truncated after 60 characters.
 - e. REMARKS: A/N, up to forty (40) characters; Any information pertinent to routing to be specified here (e.g., cable number of the cable redundant to the cable number being entered). Information in excess of 40 characters will be truncated after 40 characters.
 - f. CABLESIZE: A/N, 7 characters exactly as per the codes indicated below shall be specified here. The program cannot route cables described in any other way/ format.
 - g. PATHCABLENO: Field reserved for utilization by the program. User shall not enter any information here.
4. One list shall be prepared for each system/ equipment (i.e., separate and unique cable lists shall be prepared for each system).
5. The cables shall be described as per the scheme listed below:

A	NN	A	NNN
Cable	No. of cores	Cable code	Cable size
Voltage	(e.g. 01,03,3H, 07)	(See C below)	(e.g. 035,185,2.5, 0.5)
Code (see B below)			

(A) SYSTEM VOLTAGE CODES:

(ac) A = 11KV, B = 6.6KV, C = 3.3KV, D = 415V, E = 240V, F = 110V

(dc) G = 220V, H = 110V, J = 48V, K = +24V, L = -24V

(B) CABLE VOLTAGE CODES:

A = 11KV (Power cables)

Explanatory notes for filling up cable list for routing through WinPath, the cable routing program (developed by Corporate R&D) being used in PEM.

B = 6.6KV (Power cables)
C = 3.3KV (Power cables)
D = 1.1KV (LV & DC system power & control cables)
E = 0.6KV (0.5 sq. mm. Control cables)

(C) CABLE CODES

PVC Copper

A = Armoured FRLS	B = Armoured Non-FRLS
C = unarmoured FRLS	D = Unarmoured Non-FRLS

PVC Aluminium

E = Armoured FRLS	F = Armoured Non-FRLS
G = unarmoured FRLS	H = Unarmoured Non-FRLS

XLPE Copper

J = Armoured FRLS	K = Armoured Non-FRLS
L = unarmoured FRLS	M = Unarmoured Non-FRLS

XLPE Aluminium

N = Armoured FRLS	P = Armoured Non-FRLS
Q = unarmoured FRLS	R = Unarmoured Non-FRLS

S = FIRE SURVIVAL CABLES
T = TOUGH RUBBER SHEATH
U = OVERALL SCREENED
V = PAIRED OVERALL SCREENED
W = PAIRED INDIVIDUAL SCREENED
Y = COMPENSATING CABLES
I = PRE-FABRICATED CABLES
Z = JELLY FILLED CABLES

6. Once a cable list has been given to PEM for routing, any subsequent changes required in the cable list (which may be in the form of addition of cables, deletion of cables, change of type or size of cable, etc.) must be informed as specific changes (as a separate file MS Excel of the same format as the original file) to the cable list given earlier if the cable list has been routed and cable schedule generated. The routing status of the cable list shall be got confirmed from PEM by the agency that has prepared the cable list before the changes are intimated. In case PEM confirms that the cable list in question has not been taken up for routing, and the revised cable list is acceptable, the same may be sent. Since cable routing through the program involves adding each cable list to the project cable schedule database, the original cable schedule shall not be furnished to PEM with revisions incorporated within.

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS	STANDARD QUALITY PLAN		SPEC. NO. :		DATE:17.04.2020
		CUSTOMER :		QP NO.: PE-QP-999-Q-007, REV-04		
		PROJECT:		PO NO.:		
		ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))		SYSTEM:		SECTION: II

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check		Reference Document	Acceptance NORMS	FORMAT OF RECORD		AGENCY			
1	2	3	4	5	6		7	8	9	.	..			
					M	C/N				D	M	C	N	
1.0	RAW MATERIAL & BOUGHT OUT CONTROL													
1.1	SHEET STEEL, PLATES, SECTION, EYEBOLTS	1.SURFACE CONDITION	MA	VISUAL	100%	-	-	FREE FROM BLINKS, CRACKS, WAVINESS ETC	LOG BOOK	P	-	-		
		2.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	LOG BOOK	P	-	-		
		3.PROOF LOAD TEST (EYE BOLT)	MA	MECH. TEST	SAMPLE	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	TEST REPORT	P/V	-			
1.2	HARDWARES	1.SURFACE CONDITION	MA	VISUAL	100%	-		FREE FROM CRACKS, UN-EVENNESS ETC.	TEST REPORT	P	-	-		
		2.PROPERTY CLASS	MA	VISUAL	SAMPLES	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	TC	P/V	-	-	PROPERTY CLASS MARKING SHALL BE CHECKED BY THE VENDOR	
1.3	CASTING	1.SURFACE CONDITION	MA	VISUAL	100%	-	MANUFACTURER'S DRG./SPEC	FREE FROM CRACKS, BLOW HOLES ETC.	LOG BOOK	P/V	-			
		2.CHEM. & PHY. PROP.	MA	CHEM & MECH TEST	1/HEAT NO.	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	TC	P/V	-		HEAT NO. SHALL BE VERIFIED	
		3.DIMENSIONS	MA	MEASUREMENT	100%	-	MANUFACTURER'S DRG.	MANUFACTURER'S DRG.	LOG BOOK	P/V	-			
1.4	PAINT & VARNISH	1.MAKE, SHADE, SHELF LIFE & TYPE	MA	VISUAL	100% CONTINUOUS	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	LOG BOOK	P/V	-			

BHEL					
ENGINEERING			QUALITY		
	Sign & Date	Name		Sign & Date	Name
Prepared by:		HEMA KHUSHWAHA	Checked by:		KUNAL GANDHI
Reviewed by:		PRAVEEN DUTTA	Reviewed by:		R K JAISWAL

BIDDER/ SUPPLIER	
Sign & Date	
Seal	

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:			
	Sign & Date	Name	Seal
Reviewed by:			
Approved by:			

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS	STANDARD QUALITY PLAN		SPEC. NO.:		DATE:17.04.2020
		CUSTOMER :		QP NO.: PE-QP-999-Q-007, REV-04		
		PROJECT:		PO NO.:		
		ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))		SYSTEM:		
		SECTION: II		SHEET 2 OF 9		

SI No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check		Reference Document	Acceptance NORMS	FORMAT OF RECORD		AGENCY			
1	2	3	4	5	6		7	8	9	.	..			
					M	C/N				D	M	C	N	
1.5	SHAFT (FORGED OR ROLLED)	1. SURFACE COND.	MA	VISUAL	100%	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK		P	-	-	VENDOR'S APPROVAL IDENTIFICATION SHALL BE MAINTAINED
		2. CHEM. & PHYSICAL PROPERTIES	MA	CHEM. & PHYSICAL TESTS	1/HEAT NO. OR HEAT TREATMENT BATCH NO	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURER'S DRG./ STD.	TC		P/V	-		
		3. DIMENSIONS	MA	MEASUREMENT	100%	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURER'S DRG.	LOG BOOK		P/V	-		
		4.INTERNAL FLAWS	CR	ULTRASONIC TEST	100%	-	ASTM-A388	MANUFACTURER'S STD.	INSPECTION REPORT	✓	P/W	V	-	FOR DIA OF 55 MM & ABOVE
1.6	SPACE HEATERS, CONNEC-TORS, TERMINAL BLOCKS, CABLES, CABLE LUGS, CARBON BRUSH TEMP. DETECTORS, RTD, BTD'S	1. MAKE & RATING	MA	VISUAL	100%	-	MANUFACTURER'S DRG./STD.	MANUFACTURER'S DRG./STD.	INSPECTION REPORT		P/V	-	-	
		2. PHYSICAL COND.	MA	VISUAL	100%	-	MANUFACTURER'S DRG./STD.	NO PHYS. DAMAGE, NO ELECTRICAL DISCONTINUITY	INSPECTION REPORT		P/V	-	-	
		3.DIMENSIONS (WHEREVER APPLICABLE)	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S DRG./ STD	MANUFACTURER'S DRG. / STD.	INSPECTION REPORT		P/V	-	-	
		4.PERFORMANCE/ CALIBRATION	MA	TEST	100%	-	MANUFACTURER'S DRG/ STD	MANUFACTURER'S DRG. / STD.	TEST REPORT		P/V	-	-	

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Prepared by:		HEMA KHUSHWAHA	Checked by:		KUNAL GANDHI
Reviewed by:		PRAVEEN DUTTA	Reviewed by:		R K JAISWAL

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1	2	3	4	5	6		7	8	9	.	..			
					M	C/N				D	M	C	N	
1.7	OTHER INSULATING MATERIALS LIKE SLEEVES, BINDINGS CORDS, PAPERS, PRESS BOARDS ETC.	1. SURFACE COND. ETC.	MA	VISUAL	100%	-	-	NO VISUAL DEFECTS	TEST REPORT		P/V	-	-	
		2.DIMENSION(BORE DIA, WALL THICKNESS, BDV AS RECEIVED, BDV AFTER FOLDING AT 180°	MA	TEST	SAMPLE	-	MANUFACTURER'S STD.	MANUFACTURER'S STD.	LOG BOOK AND OR SUPPLIER'S TC		P/V	-	-	
1.8	SHEET STAMPING (PUNCHED)	1. SURFACE COND.	MA	VISUAL	100%	-	-	NO VISUAL DEFECTS (FREE FROM BURS)	LOG BOOK		P	-	-	
		2.DIMENSIONS INCLUDING BURS HEIGHT	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S DRG. .	MANUFACTURER'S DRG.	LOG BOOK		P/V	-	-	
		3. ACCEPTANCE TESTS	MA	ELECT. & MECH TESTS	SAMPLE	-	MANUFACTURER'S DRG./ STD.	MANUFACTURER'S DRG./ STD.	TC		P/V	-	-	
1.9	CONDUCTORS	1. SURFACE FINISH	MA	VISUAL	100%	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK		*P/V	-	-	* MOTOR MANUFACTURER TO CONDUCT VISUAL CHECK FOR SURFACE FINISH ON RANDOM BASIS (10% SAMPLE) AT HIS WORKS AND MAINTAIN RECORD FOR VERIFICATION BY
		2.ELECT. PROP. & MECH. PROP	MA	ELECT. & MECH.TEST	SAMPLES	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURER'S / SPEC.	TC & VENDOR'S TEST REPORTS		P/V	-	-	

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					M	C/N				D	M	C	N
1.10	BEARINGS	3.DIMENSIONS	MA	MEASUREMENT	SAMPLES	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURER'S / SPEC.	LOG BOOK		P/V	-	-
		1.MAKE & TYPE	MA	VISUAL	100%	-	MANUFACTURER'S DRG./ APPROVED DATASHEET	MANUFACTURER'S DRG./ APPROVED DATASHEET	LOG BOOK		P/V	-	-
		2.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	APPROVED DATASHEET	APPROVED DATASHEET/ BEARING MANUF'S CATALOGUES	LOG BOOK		P/V	-	-
		3.SURFACE FINISH	MA	VISUAL	100%	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK		P/V	-	-
1.11	SLIP RING (WHEREVER APPLICABLE)	1.SURFACE COND.	MA	VISUAL	100%	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK		P	-	-
		2.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S DRG	MANUFACTURER'S DRG	LOG BOOK		P	-	-
		3.TEMP WITH-STAND CAPACITY	MA	ELECT.TEST	SAMPLE	-	MANUFACTURER'S STD./ APPROVED DATASHEET	MANUFACTURER'S STD./ APPROVED DATASHEET	LOG BOOK		P/V	-	-
		4.HV/IR	MA	-DO-	100%	-	MANUFACTURER'S STD./ APPROVED DATASHEET	MANUFACTURER'S STD./ APPROVED DATASHEET	LOG BOOK		P/V	-	-
1.12	OIL SEALS & GASKETS	1.MATERIAL OF GASKET	MA	VISUAL	100%	-	MANUFACTURER'S DRG/SPECS	MANUFACTURER'S DRG./ SPECS.	LOG BOOK		P	-	-
		2.SURFACE COND.	MA	VISUAL	100%	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK		P	-	-
		3.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S DRG	MANUFACTURER'S DRG	LOG BOOK		P	-	-

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					M	C/N				D	M	C	N	
2.0	IN PROCESS													
2.1	STATOR FRAME WELDING (IN CASE OF FABRICATED STATOR)	1.WORKMANSHIP & CLEANNESS	MA	VISUAL	100%	-	MANUFACTURER'S DRG	GOOD FINISH	LOG BOOK		P/W	-	-	
		2.DIMENSIONS	MA	MEASUREMENT	100%	-	MANUFACTURER'S DRG	MANUFACTURER'S DRG	LOG BOOK		P	-	-	
2.2	MACHINING	1.FINISH	MA	VISUAL	100%	-	-DO-	GOOD FINISH	LOG BOOK		P	-	-	
		2.DIMENSIONS	MA	MEASUREMENT	100%	-	MANUFACTURER'S DRG	MANUFACTURER'S DRG	LOG BOOK		P	-	-	
		3.SHAFT SURFACE FLOWS	MA	PT	100%	-	MANUFACTURER'S STD./ ASTM-E165	MANUFACTURER'S STD./ APPROVED DATASHEET.	LOG BOOK	✓	P	V	-	
2.3	PAINTING	1.SURFACE PREPARATION	MA	VISUAL	100%	-	MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK		P	-	-	
		2.PAINT THICKNESS (BOTH PRIMER & FINISH COAT)	MA	MEASUREMENT BY ELCOMETER	SAMPLE	-	MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK		P	-	-	
		3.SHADE	MA	VISUAL	SAMPLE	-	MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK		P	-	-	
		4.ADHESION	MA	CROSS CUTTING & TAPE TEST	SAMPLE	-	MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK		P	-	-	

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					M	C/N				D	M	C	N	
2.4	SHEET STACKING	1.COMPLETENESS	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S STD.	MANUFACTURER'S STD.	LOG BOOK		P	-	-	
		2.COMPRESSION & TIGHTENING	MA	MEASUREMENT	100%	-	MANUFACTURER'S STD.	MANUFACTURER'S STD.	LOG BOOK		P	-	-	
2.5	WINDING	1.COMPLETENESS	CR	VISUAL	100%	-	MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK		P	-	-	
		2.CLEANLINESS	CR	VISUAL	100%	-	MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK		P	-	-	
		3.IR-HV-IR	CR	ELECT. TEST	100%	-	IS-325//IS-12615//IEC-60034 PART-1	IS-325//IS-12615//IEC-60034 PART-1	TEST//INSPC. REPORT	✓	P	V	-	
		4.RESISTANCE	CR	ELECT. TEST	100%	-	IS-325//IS-12615//IEC-60034 PART-1	IS-325//IS-12615//IEC-60034 PART-1	TEST//INSPC. REPORT	✓	P	V	-	
		5.INTERTURN INSULATION	CR	ELECT. TEST	100%	-	IS-325//IS-12615//IEC-60034 PART-1	IS-325//IS-12615//IEC-60034 PART-1	TEST//INSPC. REPORT		P	-	-	
2.6	IMPREGNATION	1.VISCOSITY	MA	PHY. TEST	AT STARTING	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK		P	-	-	
		2.TEMP. PRESSURE VACCUUM	MA	PROCESS CHECK	CONTINUOUS	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK		P	-	-	
		3.NO. OF DIPS	MA	PROCESS CHECK	CONTINUOUS	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK	✓	P	V	-	THREE DIPS TO BE GIVEN

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					M	C/N				D	M	C	N	
2.7	COMPLETE STATOR ASSEMBLY	4.DURATION 1.COMPACTNESS & CLEANLINESS	MA MA	PROCESS CHECK VISUAL	CONTINUOUS 100%	- -	MANUFACTURER'S STANDARD MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD MANUFACTURER'S STANDARD	LOG BOOK LOG BOOK	✓ -	P P	V -	- -	
2.8	BRAZING/COMPRESSION JOINT	1.COMPLETENESS 2.SOUNDNESS	CR CR	VISUAL MALLET TEST & UT	100% 100%	- -	MANUFACTURER'S STANDARD MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD MANUFACTURER'S STANDARD	LOG BOOK TEST/INSPC. REPORT	- ✓	P P	- V	- -	
2.9	COMPLETE ROTOR ASSEMBLY	3.HV 1.RESIDUAL UNBALANCE	MA CR	ELECT. TEST DYN. BALANCE	100% 100%	- -	MANUFACTURER'S STANDARD MANUFACTURER'S SPEC./ ISO 1940	MANUFACTURER'S STANDARD MANUFACTURER'S DWG.	TEST/INSPC. REPORT LOG BOOK	✓ -	P P	V -	- -	
2.10	ASSEMBLY	2.SOUNDNESS OF DIE CASTING 1.ALIGNMENT 2.WORKMANSHIP 3.AXIAL PLAY 4.DIMENSIONS 5.CORRECTNESS, COMPLETENESS TERMINATIONS/ MARKING/ COLOUR CODE 6. RTD, BTD & SPACE HEATER MOUNTING.	CR MA MA MA MA MA	ELECT. (GROWLER TEST) MEAS. VISUAL MEAS. MEAS. VISUAL	100% 100% 100% 100% 100%	- - - - -	MANUFACTURER'S SPEC. MANUFACTURER'S SPEC. MANUFACTURER'S SPEC. MANUFACTURER'S DRG./ MANUFACTURER'S SPEC. MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC. MANUFACTURER'S SPEC. MANUFACTURER'S SPEC. MANUFACTURER'S DRG./ MANUFACTURER'S SPEC. MANUFACTURER'S SPEC.	TEST/INSPC. REPORT LOG BOOK LOG BOOK LOG BOOK LOG BOOK	✓ - - ✓ -	P P P P P	V - - V -	- - - - -	

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					M	C/N				D	M	C	N	
3.0	TESTS	1.TYPE TESTS INCLUDING SPECIAL TESTS	MA	ELECT.TEST	1/TYPE/SIZE	1/TYPE/SIZE	IS-325//IS-12615/APPROVED DATASHEET	IS-325//IS-12615/APPROVED DATASHEET	TEST REPORT	✓	P	W*	-	* NOTE - 1
		2.ROUTINE TESTS INCLUDING SPECIAL TEST	MA	ELECT.TEST	100%	-	IS-325//IS-12615/APPROVED DATASHEET	IS-325//IS-12615/APPROVED DATASHEET	TEST REPORT	✓	P	V ^s	-	^s NOTE - 2
		3.VIBRATION & NOISE LEVEL	MA	ELECT.TEST	100%	-	IS: 12075 / IEC 60034-14 & IS-12065	IS: 12075 / IEC 60034-14 & IS-12065	TEST REPORT	✓	P	V ^s	-	^s NOTE - 2
		4.OVERALL DIMENSIONS AND ORIENTATION	MA	MEASUREMENT & VISUAL	100%	100%	APPROVED DRG/DATA SHEET	APPROVED DRG/DATA SHEET &	TEST/INSPC. REPORT	✓	P	W	-	
		5.DEGREE OF PROTECTION	MA	ELECT. & MECH. TEST	1/TYPE/ SIZE	-	IEC 60034-5/IS-12615	APPROVED DATASHEET	TC	✓	P	V	-	TC FROM AN INDEPENDENT LABORATORY, REFER NOTE-3
		6. MEASUREMENT OF RESISTANCE OF RTD & BTD	MA	ELECT. & MECH. TEST	100%	-	IS-325//IS-12615/IEC-60034 PART-1/IS: 12802	IS-325//IS-12615/IEC-60034 PART-1/IS: 12802	TC	✓	P	V ^s	-	^s NOTE - 2
		7. MEASUREMENT OF RESISTANCE, IR OF SPACE HEATER	MA	ELECT. & MECH. TEST	100%	-	IS-325//IS-12615/IEC-60034 PART-1	IS-325//IS-12615/IEC-60034 PART-1	TC	✓	P	V ^s	-	^s NOTE - 2
		8. NAME PLATE DETAILS	MA	VISUAL	100%	-	IS-325//IS-12615& DATA SHEET	IS-325//IS-12615 & DATA SHEET	TEST/INSPC. REPORT	✓	P	V ^s	-	^s NOTE - 2
		9.EXPLOSION FLAME PROOF NESS (IF SPECIFIED)	MA	EXPLOSION FLAME PROOF TEST	1/TYPE	-	IS 2148 / IEC 60079-1	IS 2148 / IEC 60079-1	TC	✓	P	V	-	TC FROM AN INDEPENDENT LABORATORY, REFER NOTE-3
		10. PAINT SHADE, THICKNESS & FINISH	MA	VISUAL & MEASUREMENT BY ELKOMETER	SAMPLE	SAMPLE	APPROVED DATASHEET	APPROVED DATASHEET	TC	✓	P	W ^s	-	SAMPLING PLAN TO BE DECIDED BY INSPECTION AGENCY ^s NOTE - 2

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					M	C/N				D	M	C	N
4.0	PACKING	SURFACE FINISH & COMPLETENESS	MA	VISUAL	100%	100%	AS PER MANUFACT. STANDARD / (#)	AS PER MANUFACT. STANDARD / (#)	INSPC. REPORT	✓	P	W	-
											(#): REFER NOTE-8		

NOTES:

- 1 DEPENDING UPON THE SIZE AND CRITICALLY, WITNESSING BY BHEL SHALL BE DECIDED.
- 2 ROUTINE TESTS ON 100% MOTORS SHALL BE DONE BY THE VENDOR. HOWEVER, BHEL/CUSTOMER SHALL WITNESS ROUTINE TESTS ON RANDOM SAMPLES. THE SAMPLING PLAN SHALL BE MUTUALLY AGREED UPON.
- 3 IN CASE TEST CERTIFICATES FOR THESE TESTS ON SIMILAR TYPE, SIZE AND DESIGN OF MOTOR FROM INDEPENDENT LABORATORY ARE AVAILABLE, THE SAME IS VALID FOR 5 YEARS.
- 4 BHEL RESERVES THE RIGHT TO PERFORM REPEAT TEST, IF REQUIRED.
- 5 AFTER PACKING AND PRIOR TO ISSUE MDCC, PHOTOGRAPHS OF ITEMS TO BE DESPATCHED SHALL BE SENT TO BHEL PURCHASE GROUP FOR REVIEW.
- 6 IN CASE , ANY CHANGES IN QP COMMENTED BY CUSTOMER AT CONTRACT STAGE SHALL BE CARRIED OUT BY BIDDER WITHOUT ANY IMPLICATION TO BHEL/ CUSTOMER.
- 7 PROJECT SPECIFIC QP TO BE DEVELOPED BASED ON CUSTOMER REQUIREMENT.
- 8 FOR EXPORT JOB, BHEL TECHNICAL SPECIFICATION FOR SEAWORTHY PACKING TO BE FOLLOWED.
- 9 PACKING SHALL BE SUITABLE FOR STORAGE AT SITE IN TROPICAL CLIMATE CONDITIONS.
- 10 LATEST REVISION/ YEAR OF ISSUE OF ALL THE STANDARDS (IS/ ASME/ IEC ETC.) INDICATED IN QP SHALL BE REFERRED.

LEGENDS:

*RECORDS, IDENTIFIED WITH "TICK"(✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION,
 ** M: SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, B: MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, C: CUSTOMER,
 P: PERFORM, W: WITNESS, V: VERIFICATION, AS APPROPRIATE
 MA: MAJOR, MI: MINOR, CR: CRITICAL
 D: DOCUMENT

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Approved by:			

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS	STANDARD QUALITY PLAN		SPEC. NO :	DATE:
		CUSTOMER :		QP NO.: PE-QP-999-Q-006, REV-02	DATE: 17.04.2020
		PROJECT:		PO NO.:	DATE:
		ITEM: AC ELECT. MOTORS UPTO 55KW (LV (415V))	SYSTEM:	SECTION: II	SHEET 1 of 2

S. NO.	COMPONENT & OPERATIONS	CHARACTERISTI CS	CLA SS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENC Y			REMARKS
1	2	3	4	5	6		7	8	9	*	**			
					M	C/ N					D	M	C	
1.0	ASSEMBLY	1.WORKMANSHI P	MA	VISUAL	100%	-	MFG. SPEC.	MFG. SPEC.	LOG BOOK		P	-	-	
		2.DIMENSIONS	MA	VISUAL	100%	-	MFG. DRG./ MFG. SPEC.	MFG. DRG./ MFG. SPEC.	LOG BOOK		P	-	-	
		3.CORRECTNESS COMPLETENESS TERMINATIONS/ MARKING/ COLOUR CODE	MA	VISUAL	100%	-	MFG.SPEC./	MFG.SPEC.	LOG BOOK		P	-	-	
2.0	PAINTING	1.SHADE	MA	VISUAL	SAM PLE	-	MFG. SPEC/ APPROVED DATASHEET	MFG. SPEC/ APPROVED DATASHEET	LOG BOOK	✓	P	V	-	
3.0	TESTS	1.ROUTINE TEST INCLUDING SPECIAL TEST	MA	VISUAL	100%	-	IS-325 / IS-12615/ APPROVED DATA SHEET	IS-325 / IS-12615/ APPROVED DATA SHEET	TEST/ INSPN. REPORT	✓	P	V *	-	* NOTE -1
		2.OVERALL DIMENSIONS & ORIENTATION	MA	MEASUREME NT & VISUAL	100%	-	APPROVED DRG/ DATA SHEET	APPROVED DRG/ DATA SHEET	TEST/ INSPN. REPORT	✓	P	V *	-	* NOTE -1 & NOTE-2

BHEL					
ENGINEERING			QUALITY		
	Sign & Date	Name		Sign & Date	Name
Prepared by:		HEMA KHUSHWAHA	Checked by:		KUNAL GANDHI
Reviewed by:		PRAVEEN DUTTA	Reviewed by:		RITESH KUMAR JAISWAL

BIDDER/ SUPPLIER	
Sign & Date	
Seal	

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:			
	Sign & Date	Name	Seal
Reviewed by:			
Approved by:			

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS	STANDARD QUALITY PLAN		SPEC. NO :	DATE:
		CUSTOMER :		QP NO.: PE-QP-999-Q-006, REV-02	DATE: 17.04.2020
		PROJECT:		PO NO.:	DATE:
		ITEM: AC ELECT. MOTORS UPTO 55KW (LV (415V))	SYSTEM:	SECTION: II	SHEET 2 of 2

		3.NAMEPLATE DETAILS	MA	VISUAL	100%	-	IS-325 / IS-12615 / APPROVED DATA SHEET	SAME AS COL. 7	TEST/ INSPN. REPORT	✓	P	V	-	
4.0	PACKING	SURFACE FINISH & COMPLETENESS	MA	VISUAL	100%	100%	AS PER MFG. STANDARD / (#)	AS PER MFG. STANDARD / (#).	INSPC. REPORT	✓	P	W	-	(#) REFER NOTE-8

NOTES:

1. Routine tests on 100% motors shall be done by the vendor. However, BHEL/ Customer shall witness routine tests on random samples. The sampling plan shall be mutually agreed upon.
2. For exhaust/ventilation fan motors of rating up to 1.5 KW, only routine test certificates shall be furnished for scrutiny.
3. In case test certificates for these tests on similar type, size and design of motor from independent laboratory are available, the same is valid for 5 years.
4. BHEL reserves the right to perform repeat test, if required.
5. After packing and prior to issue MDCC, photographs of items to be despatched shall be sent to BHEL for review.
6. In case of any changes in QP commented by customer at contract stage, same shall be carried out by bidder without any implication to BHEL/ Customer.
7. Project specific QP to be developed based on customer requirement.
8. For export job, BHEL technical specification for seaworthy packing to be followed.
9. Packing shall be suitable for storage at site in tropical climate conditions.
10. Latest revision/ year of issue of all the standards (IS/ ASME/ IEC etc.) indicated in QP shall be referred.

LEGENDS:

*RECORDS, IDENTIFIED WITH "TICK"(✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION,

** **M:** SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, **B:** MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, **C:** CUSTOMER,

P: PERFORM, **W:** WITNESS, **V:** VERIFICATION, AS APPROPRIATE

MA: MAJOR, **MI:** MINOR, **CR:** CRITICAL

D: DOCUMENTATION

BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING			QUALITY			Sign & Date		Doc No:			
	Sign & Date	Name		Sign & Date	Name	Seal			Sign & Date	Name	Seal
Prepared by:		HEMA KHUSHWAHA	Checked by:		KUNAL GANDHI			Reviewed by:			
Reviewed by:		PRAVEEN DUTTA	Reviewed by:		RITESH KUMAR JAISWAL			Approved by:			

	TITLE 5X800MW YADADRI TPS LUBE OIL TRANSFER PUMP DATA SHEET	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
		Section – IC	Date
SUB-SECTION – IC DATA SHEET-A			

BHEL PEM	DATA SHEET FOR LUBE OIL PUMPS		DOC. NO. PE-DC-417-100-Q012
			SHEET NO. 01 OF 01
	PROJECT TITLE : 5X800 MW YADADRI TPS, NALGONDA		
1.0	SERVICE IDENTIFICATION	CLEAN OIL PUMP	DIRTY OIL PUMP
2.0	DRAWING NO.	PE-DG-417-100-N108	PE-DG-417-100-N108
3.0	SYSTEM	CENTRAL LUBE OIL SYSTEM	CENTRAL LUBE OIL SYSTEM
4.0	TYPE	ROTARY POSITIVE DISPLACEMENT	ROTARY POSITIVE DISPLACEMENT
5.0	NUMBER REQUIRED	TWO (02) NO. FOR THE STATION	TWO (02) NO. FOR THE STATION
6.0	FLOW RATE (MAX.)	8250 LPH	8250 LPH
7.0	DISCHARGE PRESSURE	2.0 KG/CM ² (g)	2.0 KG/CM ² (g)
8.0	SUCTION CONDITION	FLOODED	FLOODED
9.0	LOCATION OF INSTALLATION	INDOOR	INDOOR
10.0	LIQUID PUMPED	TURBINE LUBE OIL (TURBINOL-46-HPC / SERVOPRIME 46-IOC)	TURBINE LUBE OIL (TURBINOL-46-HPC / SERVOPRIME 46-IOC)
11.0	PROPERTIES OF FLUID	DENSITY- 0.9 GM/CC AT 15°C FLASH POINT - 210 °C VISCOSITY -28 CST AT 50 °C / 48 CST AT 37.8°C / 140 CST AT 20°C	DENSITY- 0.9 GM/CC AT 15°C FLASH POINT - 210 °C VISCOSITY -28 CST AT 50 °C / 48 CST AT 37.8°C / 140 CST AT 20°C
12.0	TEMPERATURE NORMAL / MAX	AMBIENT / 70 ⁰ C	AMBIENT / 70 ⁰ C
13.0	SUCTION / DISCHARGE PIPING CONNECTION	OD 88.9 X 5.49 / OD 88.9 X 5.49	OD 88.9 X 5.49 / OD 88.9 X 5.49
14.0	RELIEF VALVE	BUILT-IN ON EACH PUMP	BUILT-IN ON EACH PUMP
15.0	SUCTION STRAINER	DUPLEX TYPE STRAINER WITH CHANGE-OVER VALVE, SS ELEMENT MESH SIZE 20 & BLOW DOWN VALVE	DUPLEX TYPE STRAINER WITH CHANGE-OVER VALVE, SS ELEMENT MESH SIZE 20 & BLOW DOWN VALVE
16.0	MATERIALS OF CONSTRUCTION CASING GEARS SHAFT	CAST IRON - IS 210 - FG260 EN-8/9 EN-8/9	CAST IRON - IS 210 - FG260 EN-8/9 EN-8/9
17.0	APPLICABLE CODES / STATUTORY REGULATIONS	AS APPLICABLE IS, BS, API STANDARDS	AS APPLICABLE IS, BS, API STANDARDS
18.0	DRIVE TYPE	INDUCTION MOTOR 415 V, 50 Hz	INDUCTION MOTOR 415 V, 50 Hz
NOTE : ALL OTHER GENERAL TECHNICAL REQUIREMENTS / ACCESSORIES & SPARES AS PER CUSTOMER TENDER SPECIFICATION.			

	TITLE 5X800MW YADADRI TPS LUBE OIL TRANSFER PUMP DATA SHEET	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
		Section – IC	Date
SUB-SECTION – IC DATA SHEET-C			



TITLE

**DATA SHEET-C
FOR LUBE OIL PUMPS**

SPECIFICATION NO. PE-TS-417-167-A001

SECTION : I C

REV 00

DATE :24.01.2019

SHEET 1 of 5

“*” marked details will be furnished by the bidder for review and approval by customer

1.00 Project Information

1.01 Enquiry No. *

1.02 Project *

2.00 Service Condition

2.01 Service Clean Oil/ Dirty Oil/Drain Oil (*bidder to tick mark the applicable service)

2.02 No. of units *

2.03 Location Indoor

2.04 Duty Intermittent

3.00 Operating Condition

3.01 Liquid to be pumped Turbine Lube Oil

3.02 Pumping Temperature Ambient/70°C

3.03 Viscosity

a) Highest 140cSt @20°C

b) Lowest 28cSt @50°C

c) Normal 48cSt @37.8°C

3.04 Design Viscosity of oil (cSt) 28cSt for capacity , 140cSt for power consumption

3.05 Specific Gravity 0.9

3.06 Suction Conditions available Flooded

3.07 i) Rated capacity (LPM) *

ii) Pump Maximum flow (LPM) & corresponding head (kg/cm² (g)) *3.08 Rated head – kg/cm² (g) *

3.09 R..V.Press.Setting *

4.00 Pump

4.01 Manufacturer *

4.02 Type External gear with herringbone gears

4.03 Model No. *

4.04 (i) Design & Manufacturing Standard API 676

4.04 (ii) Testing Standard HIS (ANSI/HI-3.6-2000 /

	TITLE DATA SHEET-C FOR LUBE OIL PUMPS		SPECIFICATION NO. PE-TS-417-167-A001	
			SECTION : I C	
			REV 00	DATE :24.01.2019
SHEET 2 of 5				
VDMA 24284 , Accuracy Class-2, Group-II (* Bidder to tick the standard adopted)				
4.05	Rotation (Viewed from pump shaft end)	*		
4.06	Shut off head, if applicable	Not applicable		
4.07	Suction flange	Size 80 NB Standard ANSI B 16.5 Rating 150 lb Facing RF Location (as viewed from drive end) -*(Bidder to tick the applicable) Top End Side		
4.08	Discharge flange	Size 80 NB Standard ANSI B 16.5 Rating 150 lb Facing RF Location (as viewed from drive end) -*(Bidder to tick the applicable)		
4.09	Timing Gear	Not applicable for gear pumps		
4.10	Relief Valve	Built-in		
	a) Manufacturer	Pump manufacturer (OEM)		
	b) Type	*		
	c) Size (NB)	*		
	d) Capacity, litre/min	110% of the pump max. flow		
	e) Valve, setting pressure adjustable & range of adjustability, in case adjustable	Yes/No (* bidder to indicate the applicable) - *		
	f) Material			
	g) Spring, Material	Spring Steel		
	h) Relief valve cover-Material	Same as MOC of pump body		
	i) Bonnet-Material	Same as MOC of pump body		
4.11	Shaft Sealing	Mechanical seal		
4.12	Bearing			
	a) Type	*		
	b) Nos. Provided	*		
	c) Method of lubrication	*		
	d) Temperature rise over oil temperature	*		
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	TITLE DATA SHEET-C FOR LUBE OIL PUMPS	SPECIFICATION NO. PE-TS-417-167-A001	
		SECTION : I C	
		REV 00	DATE :24.01.2019
		SHEET 3 of 5	
4.13	Type of Coupling	*	
4.14	Type of Impeller	External gear- Herringbone profile	
4.15	BHP consumed at Rated viscosity (at pump shaft)	*	
4.16	BHP consumed at Max. viscosity (at pump shaft)	*	
4.17	BHP consumed at Min. viscosity (at pump shaft)	*	
4.18	BHP consumed at the R.V. Set Pressure (at pump shaft) @ 48 cSt at maximum value of set pressure range	*	
4.19	Pump Efficiency at rated condition @ 48 cSt		
	a) Mechanical	*	
	b) Volumetric	*	
	c) Overall	*	
4.20	Recommended motor rating at 50 ° C ambient (kw)	*	
4.21	Motor RPM	*	
4.22	Design pressure of the pump body and end covers - kg/cm ² (g)- (Should be at least 6 kg/cm ² (g))	*	
5.00	Material of Construction		
5.01	Casing and End covers	CAST IRON IS210 FG 260	
5.02	VOID		
5.03	Rotor/Gear	EN-8 BS 970 Part-I Hardness- *	
5.04	Shaft/Shaft Sleeve	SS 316	
5.05	Seal	*	
5.06	Gasket	GRAFOIL/ Any other asbestos free material subject to customer acceptance (* bidder to indicate)	
5.07	Bearing	*	
5.08	Relief Valve Components	*	
5.09	Base Plate	MS to IS 2062	
6.00	Spares		
6.01	Commissioning Spares	1 set of gaskets/1 no. gasket compound tube 1 No. mechanical seal	
6.02	Essential Spares for Pump, if applicable	*(Project specific)	
D:\SKY -New\Project\Contract\Yadadri 5X800 MW\Package\LOTP\contract\Technical spec of LOTP\Yadadri LOP\11-DATA SHEET- PUMP & STRIANER.DOC			



TITLE

**DATA SHEET-C
FOR LUBE OIL PUMPS**

SPECIFICATION NO. PE-TS-417-167-A001

SECTION : I C

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DATE :24.01.2019

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6.03	Essential Spares for Motor, if applicable	* (Project specific)
6.04	Recommended Spares for Pump for 3 Years	*
6.05	Recommended Spare for Motor for 3 Years	*
7.00	Weight of	
7.01	Pump	*
7.02	Motor	*
7.03	Base plate	*
7.04	Other Accessories (Please specify)	*
8.00	Strainer/Filter	
8.01	Manufacturer Bhatia Engineering Company/ Filtration Engineers (I) Pvt.Ltd / Jaypee Industries Pvt. Ltd./Multitex Filtration Engineers/ Otoklin Plants & Equipment Ltd/ OEM subject to condition that strainer of similar type & capacity have been working satisfactorily at least two plants. (Bidder to tick the make considered)	*
8.02	Type & Size	* (Type -Project specific; size –to match pump suction)
8.03	Nos. provided	* (Project specific)
8.04	Size of Screen mesh & wire dia (min)	40 mesh & 34 SWG
8.05	Design Pressure (kg/cm ²) (Should be at least 4 kg/cm ²)	*
8.06	Capacity (LPM)	To match pump flow
8.07	Design Viscosity	140cSt @ 20 °C
8.08	End Connection	Flanged ANSI B 16.5, Class –150 lb



TITLE

**DATA SHEET-C
FOR LUBE OIL PUMPS**

SPECIFICATION NO. PE-TS-417-167-A001

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8.09 Maximum Pressure drop at design viscosity (kg/cm²)

a) Clean

*

b) Dirty (50% clogged)

*

8.10 Material of construction

a) Strainer body

*

b) Screen

SS316

c) Gaskets

GRAFOIL/ Any other asbestos free material subject to customer acceptance (* bidder to indicate)

8.10 a) Inlet pipe Area

*

b) Free straining area

*

c) Ration of Free straining area to inlet pipe area (should be $\geq 6:1$)

*

9.00 Accessories to be provided

Common base plate
plate

Yes- MS fabricated from IS 2062

Common for pump & motor

Coupling & Coupling Guard

Yes

Foundation bolts & nuts

Yes

Flanges & Companion flanges

Yes, Class 150 lb, RF to ANSI B 16.5

Nuts, bolts & gaskets

Yes

Lifting lugs, Eye bolts etc

Yes

Name plate for all the equipment

Yes

	TITLE 5X800MW YADADRI TPS LUBE OIL TRANSFER PUMP STANDARD TECHNICAL REQUIREMENT	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
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SECTION – II

STANDARD TECHNICAL REQUIREMENT



TITLE	SPECIFICATION NO. PE-TS-417-567-A001	
	SECTION :II	
	REV 00	DATE 24.01.2019
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TECHNICAL SPECIFICATION (GENERAL) FOR LUBE OIL PUMPS

1.0 GENERAL

This specification covers the design material constructional features manufacture assembly inspection & testing at manufacturer's or his subcontractor's works, suitable painting & packing requirements of Lube Oil transfer pumps and drives along with all accessories as specified hereinafter.

2.0 CODES & STANDARDS

All equipment, systems and works covered under this specification shall comply with all currently applicable statutes regulations and safety codes in the locality where they will be installed. They shall comply with the latest editions of the codes and standards as given below.

- a) American National Standards Institute (ANSI)
- b) American Society of Testing & Materials (ASTM)
- c) American society of Mechanical Engineers (ASME)
- d) Hydraulic Institute Standards (HIS)
- e) American Petroleum Institute (API)
- f) American Gear Manufacturer's Association (AGMA)
- g) National Electrical Manufacturer's Association (NEMA)
- h) National Fire Protection Association (NFPA)
- i) Indian Standards Institute (ISI)

Other International/National standards such as DIN, VDI, BS, IS etc. shall also be accepted subject to the owner's approval for which the bidder shall furnish along with the offer adequate information to justify that these standards are equivalent or superior to the standards mentioned above. In all such cases the Bidder shall furnish specifically the variations and deviations from the standards mentioned above together with the complete word to word translation of the standard that are normally not published in English. In the event of any conflict between the Codes and Standards and their requirements of this specification, the requirement of this specification shall govern.

All equipment covered by this specification shall comply with all applicable laws and regulations of the Republic of India.

In case of any change in code, standards and regulations between the date of purchase order and the date when vendors proceeds with fabrication the purchaser shall have the option to incorporate changed requirements without additional commercial implication. It shall be the responsibility of vendor to advise purchaser of the resulting effect.

3.0 DESIGN REQUIREMENTS & CONSTRUCTIONAL FEATURES



TITLE

TECHNICAL SPECIFICATION (GENERAL) FOR LUBE OIL PUMPS

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3.1 Casting

The pump shall be horizontal, positive displacement type, designed for oil service and suitable for occasional dry running. The casing shall also have end plates/pump cover which close the ends of the body to form the pumping chamber. The casing shall house rotating assembly. Gear type with a drive shaft.

3.2 Rotor

The rotor shall constitute of a shaft on which either Gear are mounted. The rotating assembly shall be encased in the casing and shall be properly sealed. Mechanical Seal could be offered for sealing purpose. The seal material shall have low coefficient of friction and shall be suitable for the fluid handled.

3.3 Bearing & Lubrication

Bearings of adequate design shall be provided for taking the entire pump load arising from all probable conditions for continuous operation throughout its range of operation. The bearing shall be designed on the basis of 20,000 Working hours minimum for the load corresponding to the duty point. Proper Lubricating arrangement for the bearing shall be provided. Bearings shall be easily accessible without disturbing the pump assembly. The pump bearings shall be antifriction ball/ roller type of adequate size to carry both radial and axial loads. Any other type of bearing may be accepted subject to acceptance by customer.

3.4 Coupling

The pumps shall be directly coupled to their drives through a flexible coupling. Suitable coupling guards also shall be provided along with the coupling. The pump and its drive motor shall be mounted on machined base frame.

3.5 Base Frame

Common/individual base frame shall be provided for pump and motor. The base frame shall be fabricated/casted construction providing rigidity and stability and shall be capable of supporting the weight and reactions of the pump & motor. The base plate will have a drip pan with suitable draining arrangement and shall be suitably drilled for the anchor bolts. The material of construction shall be of tested quality structural steel as per IS-2062 or equivalent.

Anchor bolts, nuts, lock nuts, seating steel work as required shall be supplied with the equipment. Only hexagonal nuts shall be used for holding down the equipment.

3.6 Lifting Arrangement

Each pump shall incorporate suitable lifting attachments e.g. lifting lugs or eye bolts etc. to facilitate erection & maintenance.

3.7 Rating Plates & Name Plate

Each equipment shall have permanently attached to it in a conspicuous position, a rating plate of non-corrosive material upon which shall be engraved manufacturers name, equipment type or serial number.

4.0 OTHER TECHNICAL / DESIGN & GENERAL REQUIREMENTS

	TITLE TECHNICAL SPECIFICATION (GENERAL) FOR LUBE OIL PUMPS	SPECIFICATION NO. PE-TS-417-567-A001	
		SECTION :II	
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		SHEET OF	
4.1	The data sheets for Pump and motors placed under vol-III of specification forms part of specification. The “*” marked details are to be filled up by the bidder without altering the data already filled up.		
4.2	The material of construction of Strainer body will be either ASTM A 106 Gr.B pipe or ASTM A216 WCB or fabricated from IS 2062 plates. However, the exact MOC is subject to acceptance by customer and there will be no additional commercial implication on account of above.		
4.3	The driving motor power shall be selected based on highest viscosity of oil. The selection of pump motor rating shall be based on criterion given in the electrical portion of the specification.		
4.4	VOID.		
4.5	The pump shall be designed for the normal operating temperature specified in the data sheet. However, the pump should be able to perform without any malfunctioning at the maximum temperature also as indicated in the data sheet.		
4.6	VOID.		
4.7	VOID.		
4.8	VOID.		
4.9	Pumps shall be designed for smooth pulsation and noise free operation. Pump shall be designed to have maximum efficiency at the normal duty point.		
4.10	The design of pump shall be so as to minimize the end thrust.		
4.11	The pump shall have minimum vibration, noise and capacity reduction even when the viscosity of oil increases during winter season. The maximum permissible noise level of the pump set shall be 85 dBa measured at a distance of 1 metre horizontal and 1.5 metre vertical from the edge of pump motor set.		
4.12	Material of construction for the vital parts shall be as shown in data sheet or elsewhere in the specification. The material of construction of the other parts of the pump shall be subject to Customer's approval during detail engineering and any changes therein as required by the customer shall be provided by the successful bidder without any commercial implication. All materials used for manufacture of the pump and its components shall be of tested quality. Relevant test certificates shall be made available to the purchaser before taking up fabrication work. In the absence of such certificates the vendor shall arrange to carry out necessary tests required by the code at his cost.		
4.13	The revision made by successful bidder in any drawings and documents shall be highlighted by indicating the no. of revisions in a triangle without fail so that the minimum time is required by customer to review the drawings and documents.		
4.14	If required by the customer during detail engineering, the successful bidder will submit separate drawing of various assembly / sub - assembly in addition to GA drawing without any commercial implication to the customer.		
4.15	The recommended civil foundation drawing to be furnished by the bidder during detail engineering shall include the followings:-		

	TITLE TECHNICAL SPECIFICATION (GENERAL) FOR LUBE OIL PUMPS	SPECIFICATION NO. PE-TS-417-567-A001 SECTION :II REV 00 DATE 24.01.2019 SHEET OF
a) Scope of work by BHEL and vendor shall be indicated with different legend or in the form of note. b) Weight of moving parts, its frequency and its height from floor shall be furnished. c) Recommended location of cable trench for feeding cable to machine along with the details of cable entry. d) Civil loads per bolt / pocket (static and dynamic) in tabular form considering worst case. 4.16 The successful bidder will have to depute competent designer (s) at BHEL's office during detailed engineering stage to discuss drawings and other technical documents as and when required by BHEL. However, the vendor will be informed in advance by minimum 7 days. 4.17 All the drawings required to be furnished to customer during detailed engineering stage shall include technical parameters, details of paints and lubrication, hardness and BOQ / BOM in tabular form indicating all major components including bought out items and their quantity, material of construction indicating its applicable code / standard, weight, make etc. 4.18 All the drawings and documents including general arrangement drawing, data sheet, calculation etc. shall be furnished to the customer during detailed engineering stage and include / indicate the following details for clarity w.r.t. Inspection, construction, erection and maintenance and information etc.:- a) All drawings and documents shall bear BHEL's title block and drawing / document number. However, BHEL's drawing / document-numbering scheme shall be furnished to the successful bidder after the placement of L.O.I. b) All drawings and documents shall indicate the list of all reference drawings including general arrangement. c) All drawings shall include / show plan, elevation, side view, cross - section, skin section, blow - up view of all major self manufactured and bought out items shall be labelled and included in BOQ / BOM in tabular form. d) Specification of painting shall be made as a part of general arrangement drawing of each equipment / items indicating at least 3 trade name. e) Technical parameters of the equipment (capacity, pressure, fluid handled, vibration limit, noise level at a distance of 1.0 meter at a level of 1.5 meters above ground, details of coupling, details of motor, details of gears of pump, recommended capacity of hoist, weight of heaviest (single) part / component of the equipment and total weight etc.) in general arrangement drawing and these shall be indicated in the drawing with dimensions to the extent possible. f) The supplier's drawings and data shall set forth overall and detailed dimensions; location and centre lines; pipe conduit and other connections schematic and wiring diagrams; clearance and load points; space required for withdrawal or removal of equipment or parts and such information as will be needed by Owner in order to provide adequate space for and connection to the equipment. g) Details of cable entry for pump shall be shown in all the 3 views (plan, elevation and side view) indicating dimensions from a reference point.		



TITLE

**TECHNICAL SPECIFICATION
(GENERAL) FOR
LUBE OIL PUMPS**

SPECIFICATION NO. PE-TS-417-567-A001

SECTION :II

REV 00

DATE 24.01.2019

SHEET OF

- 4.19 All calculations which are required to be submitted shall be done manually and necessarily in SI units and the same shall be furnished along with the copy of authentic supporting literature e.g. Code, Hand book, National / international Standards etc.

5.0 TESTING & INSPECTION AT MANUFACTURE'S WORKS

5.1 VOID

- 5.2 The supplier shall provide inspection to establish and maintain quality of workmanship in his works and that of his subcontractors to ensure the mechanical accuracy of components, compliance with drawings, identity and acceptability of all materials, part and equipment. He shall conduct all tests required to ensure that the equipment and material furnished shall conform to the requirements of the applicable codes. All tests and test procedure proposed by the manufacturer shall be submitted to the purchaser for his prior approval. The purchaser shall be notified well in advance of the fabrication and major shop test of the equipment for the purpose of making general inspections and for the progress report. The purchaser's representative shall be given full access to the shop in which the equipment is being manufactured or tested and all test records shall be made available to him. A final inspection will be made by the purchaser's representative before the dispatch of the equipment. Final performance tests for the complete units shall be carried out in the presence of purchaser's representative.

All material used for manufacture of the equipment covered under this specification shall be of tested quality. Relevant test certificate shall be made available to the purchaser before the final shop inspection. In case the relevant correlating test certificates are not available, the supplier shall arrange to carry out the necessary tests required by code at his cost.

- 5.3 Steel forging used in pumps shall be tested for both physical properties and chemical composition.
- 5.4 The castings shall be sound, clean and free from porosity blowholes, hard duration and other harmful defect.

Areas, which in the opinion of the purchaser will create doubts about soundness to the castings, shall be subjected to dye-penetration test as per ASTM Specification A-165-95.

No welding or repairs shall be carried out without prior permission of the purchaser. The entire surface of the castings shall be subjected to Dye penetrant test as per ASTM A-165-95. Evaluation of indication shall be as per relevant standard.

- 5.5 Welding procedure, equipment, welders and operators shall be qualified, prior to taking Up any welding. Liquid penetrant examination shall be carried out on the weldments in accordance with the requirement of ASME Code.

The welding procedures shall clearly state the type of material thickness joint details, preheat temperature maintained, post weld heat treatment given, welding current & voltage used during qualification of welding procedure. For all pressure parts and high-pressure weld joints, the latest applicable requirement of the code must be complied with. All records in line with the above shall be maintained and made available to the purchaser. The welding test shall be carried out on the following:

- i) Root pass of single groove welded but joint.



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- ii) Finish surfaces of all fillet weld.
- iii) Before weld repair after defect has been rouged out and grounded to ensure removal of defect.
- iv) On impellers after any heat treatment.
- v) Radiography of butt weld joints shall be carried out in accordance with the relevant code.

5.6 Heat treatment operations including stress relieving shall be performed in accordance with the applicable codes. Recording of temperature with thermocouples placed in direct contact with the job for recording the metal temperature during heat treatment shall be done.

5.7 Ultrasonic examination of pump shaft above 50 mm diameter as per the governing specifications. In absence of these, ultrasonic testing should conform to ASTM A 388 and evaluation of indications as per relevant standard.

5.8 All the impellers shall be statically and dynamically balanced at the operating speed as per the requirement of ISO 1940 G 6.3.

5.9 Performance Tests

Performance tests shall be conducted for each of the pump with unit motor at the manufacturer's works in the presence of the purchaser or his authorized agent in accordance with relevant Indian/ equivalent standards. At least 5 points, approximately equally spaced on the characteristic curve including relief valve set pressure, rated flow & pressure shall be tested and acceptance will be determined as per the relevant standard. These tests shall be conducted with actual drive motor being furnished. In general, performance tests shall include the following tests.

- a) Establish flow and pressure characteristic
- b) Establish flow and power characteristic
- c) Establish flow and efficiency characteristic

Purchaser or their authorized representative shall have access to all the tests. Prior intimation shall be given allowing adequate time for preparation of the witness of the test. After the performance testing, the observations noted and the computation of results for rated performance shall be submitted to purchaser for approval. On approval the pump shall be undertaken for strip testing and its components shall be examined for visual and other tests before being taken for dispatch in the presence of purchaser or their authorized inspection agencies.

Test on each pump for vibration level in the transverse, horizontal and vertical directions shall be carried out. Noise level shall be measured at the rated speed. Measurement of oil leakage at seal/stuffing box shall be recorded if any.

5.10 Test at Site

The pumps will be tested at site to verify its mechanical performance and checking the vibration and noise level. If the pumps fail to operate smoothly then such deficiencies shall be



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rectified by the supplier by making suitable alterations in the pump set and additional tests required to show the effect of such alterations shall be performed by him. The change made in the pump shall be certified with technical back up information to the satisfaction of the purchaser.

5.11 Performance Guarantee

The vendor shall *guarantee* the material and workmanship of all equipment as well as the operation of the pump as per requirement of this specification.

The vendor shall also *guarantee* for each pump the discharge pressure at the specified rated capacity and also corresponding efficiency, brake horsepower and relief valve set pressure .

6.0 CLEANING PROTECTION & PAINTING

Before shipment of the equipment to be supplied under this specification, internal surfaces of all parts shall be cleaned to remove loose dirt, weld rod stubs and other foreign objects prior to final assembly of the equipment.

Liquid used for hydro testing or cleaning shall be drained from the parts. Excess oil and grease shall be removed by wiping. All openings shall be covered to guard against damage and entrance of foreign objects during shipment. Hydraulic tested parts shall not be packed till the inside surface becomes dry.

Particular care shall be taken to ensure that all foundry sand and loose material is properly removed by fettling.

Ends shall be protected from external damage and sealed against the ingress of dirt.

A thin short steel circular blanking plate of a diameter 1/4" less than the bolt holes inner PCD shall be firmly fixed to the flange faces by the application of adhesive after first ensuring that the flange faces have been thoroughly degreased. A wooden blank should then be bolted to the flange using a minimum of four bolts.

All piping shall be closed after shop assembly by shot blasting or other means approved by owner. Lube oil piping or carbon steel piping shall be pickled.

The metal surface shall be painted with two (2) coats of approved anti-corrosive primer paint as per paint supplier's instruction. All machined surface shall have two (2) coats of water repellent grease after thorough cleaning. All exposed surfaces shall have two (2) coats of approved finish paint in addition to primer as per paint supplier's instruction.

All parts shall be properly boxed, crated or otherwise protected for transportation. All openings should be properly covered before crating/boxing to prevent ingress of dirt/dust/moisture and other undesirables. Spare parts shall be packed for long storage without injury.

For export jobs, seaworthy packing shall be used. Details of Seaworthy packing will be either project specific. In case there is no specification for seaworthy packing, the same shall be furnished by the bidder for BHEL's approval. However, there will not be any additional cost implication on account of the same.

7.0 DRAWINGS/DOCUMENTS TO BE SUBMITTED WITH THE BID:

- i) Clarification Schedule as per format given under Vol-III



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ii) Deviation Schedule as per format given under Vol-III

8.0 DRAWINGS/DOCUMENTS AND DATA TO BE FURNISHED BY VENDOR AFTER AWARD OF THE CONTRACT.

After award of Contract, the vendor will give following drawings for all the configurations for Pump- Motor Set and Strainers leaving project specific details as blank which can be filled up depending upon project requirement.

i) Fully dimensional outline General Arrangement drawings along with foundation details of the pump with motor assembly unit.

ii) Fully dimensional outline General Arrangement and foundation arrangement drawings of the strainer unit.

iii) Cross sectional drawing of the equipment showing the details of assembly of components and their material of construction with standard applicable codes.

iv) Characteristic curves of pump at minimum, maximum and rated viscosity of oil showing the following:

- a) Flow Vs. Pressure
- b) Flow Vs. Power
- c) Flow Vs. Efficiency

v) Duly filled up data sheet of Pump, Motor

vi) Calculation for selection of Motor Rating

vii) Pressure drop calculation across strainer

viii) Operation maintenance manual .

ix) Quality plans duly corrected in line with customer's comments, if any.

9.0 MANUFACTURERS NAME AND TAG PLATES:

Each pump shall have a permanently attached brass metal tag on the body indicating the following information both in Hindi and English:

- a) Manufacturer's name and trade mark.
- b) Capacity and Pressure.
- c) Design Pressure.
- d) Equipment tag no as furnished during the contract.

The equipment tag no will be indicated by the engineer on the drawing submitted for approval by the vendor.

**TITLE****5X800 MW TSGENCO YADADRI TPS****LUBE OIL TRANSFER PUMP****STANDARD TECHNICAL REQUIREMENT**

SPECIFICATION NO. PE-TS-417 -567-A001

REV 00

Section – II

Date

SECTION – II

O & M MANUAL FORMAT

Format for Operation & Maintenance Manual

Project name :

Project number :

Package Name :

PO reference :

Document number :

Revision number :

Sl.no. & Sections	Description	Tick (√)if included in Manual			Remarks
		Yes	No	Not Applicable	
1.	Cover page				
1.1	Project Name				
1.2	Customer/consultant Name				
1.3	Name of Package				
1.4	Supplier details with phone, FAX ,email address , Emergency Contact number				
1.5	Name and sign of prepared by , checked by & approved by				
1.6	Revision history with approval Details				
2.0	Index				
2.1	showing the sections & related page nos All the pages should be numbered section wise				
3.0	Description of Plant/System				
3.1	Description /write up of operating principle of system equipment/ associated sub-systems & accessories/controls system , operating conditions, performance parameters under normal , start up and special cases				
3.2	Equipment list and basic parameter with Tag numbers				
3.3	Data sheets approved by Customer/for information and catalogues provided by original manufacturer				
3.4	Associated other packages and Interface /terminal points				
3.5	P&ID & Process Diagrams				
3.6	GA Layout drawings, As-built drawings , Actual photograph of items/system (Drawings of A2 & bigger sizes are to be attached in the last)				
3.7	Single line/wiring diagrams				
3.8	Control philosophy /control write-ups				

4.0	Commissioning Activities (if not covered in separate document i.e. erection manual, commissioning manual)				
4.1	Pre-Commissioning Checks				
4.2	handling of items at site				
4.3	Storage at site				
4.4	Unpacking & Installation procedure				
5.0	Operation Guidelines for plant personal/user/operator				
5.1	Interlock & Protection logic along with the limiting values of protection settings for the equipment along with brief philosophy behind the logic, drawings etc. to be provided.				
5.2	Start up, normal operation and shut down procedure for equipments along with the associated systems in step by step mode. Valve sequence chart, step list, interlocks etc. with Equipment isolating procedures to be mentioned.				
5.3	Do's & Don't of the equipments.				
5.4	Safety precautions to be taken during normal operation. Safety symbols, Emergency instructions on total power failure condition/lubrication failure/any other condition				
5.5	Parameters to be monitored with normal values and limiting values				
5.6	Trouble shooting with causes and remedial measures				
5.7	Routine operational checks, recommended logs & records				
5.8	Changeover schedule if more than one auxiliary for the same purpose is given				
5.9	Painting requirement and schedule				
5.10	Inspection, repair , Testing and calibration procedures				
6.0	Maintenance guidelines for plant personal				
6.1	List of Special Tools and Tackles required for Overhaul/Trouble shooting including special testing equipment required for calibration etc.				
6.2	Stepwise dismantling and re-assembly procedure clearly specifying the tools to be used, checks to be made, records to be maintained, clearances etc. to be mentioned. Tolerances for fitment of various components to be given.				

6.3	Preventive Maintenance & Overhauling schedules linked with running hours/calendar period along with checks to be given				
6.4	Long term maintenance schedules especially for structural, foundations etc.				
6.5	Consumable list along with the estimated quantity required during commissioning, normal running and during maintenance like Preventive Maintenances and Overhaul. Storage/handling requirement of consumables/self-life.				
6.6	List of lubricants with their Indian equivalent, Lubrication Schedule, Quantity required for each equipment for complete replacement is to be given				
6.7	List of vendors & Sub-vendors with their latest addresses, service centres ,Telephone Nos., Fax Nos., Mobile Nos., e-mail IDs etc.				
6.8	List of mandatory and recommended spare parts list				
6.9	Tentative Lead time required for ordering of spares from the equipment supplier				
6.10	Guarantee and warranty clauses				
7.0	Statutory and other specific requirements considerations.				
8.0	List of reference documents				
9.0	Binding as per requirement				

5X800 MW TSGENCO YADADRI TPS

TECHNICAL SPECIFICATION

FOR

LUBE OIL TR. PUMPS

SECTION-II

(SITE STORAGE AND PRESERVATION MANUAL)



BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR PROJECT ENGINEERING MANAGEMENT
PPEI, NOIDA-INDIA

SITE STORAGE AND PRESERVATION GUIDELINES

FOR

MECHANICAL BOPs

(Doc No: PE-DC-SSG-A001 REV.00)



PROJECT ENGINEERING MANAGEMENT, POWER SECTOR
BHARAT HEAVY ELECTRICALS LIMITED-NOIDA

CONTENT

- 1 SCOPE OF THE DOCUMENT
- 2 PURPOSE OF STORAGE & PRESERVATION
- 3 MEASURES TO BE TAKEN FOR STORAGE AND PRESERVATION
 - a) GENERAL STORAGE REQUIREMENTS
 - b) GENERAL PRESERVATION REQUIREMENTS
 - c) GENERAL INSPECTION REQUIREMENTS
- 4 TYPE OF STORAGE FOR VARIOUS EQUIPMENT
5. CONCLUSION
6. STACKING ARRANGEMENT FOR PLATES AND STRUCTURAL STEEL

1. SCOPE OF THE DOCUMENT

This guideline is prepared in intent to provide proper site storage and preservation of the Mechanical, Electrical and C & I items / equipment supplied under various bought out packages/items. This storage procedure shall be followed at different power plant sites by concerned agency for storage and preservation from the date of equipment received at site until the same are erected and handed over to the customer.

2. PURPOSE OF STORAGE & PRESERVATION

Many of the items may be required to be kept in stores for long period. It shall therefore be essential that proper methods of storage and preservation be applied so that items do not deteriorate, loose some of their properties and become unusable due to atmospheric conditions and biological elements.

3. MEASURES TO BE TAKEN FOR STORAGE, HANDLING & PRESERVATION

a) GENERAL STORAGE REQUIREMENTS

1. To the extent feasible, materials should be stored near the point of erection. The storage areas should have adequate unloading and handling facilities with adequate passage space for movement of material handling equipment such as cranes, fork lift trucks, etc. The storage of materials shall be properly planned to minimise time loss during retrieval of items required for erection.
2. The outdoor storage areas as well as semi-closed stores shall be provided with adequate drainage facilities to prevent water logging. Adequacy of these facilities shall be checked prior to monsoon.
3. The storage sheds shall be built in conformity with fire safety requirements. The stores shall be provided with adequate lights and fire extinguishers. 'No smoking' signs shall be placed at strategic locations. Safety precautions shall be strictly enforced.
4. Adequate lighting facility shall be provided in storage areas and storage sheds and security personnel positioned to ensure enforcement of security measures to prevent theft and loss of materials.
5. Adequate number of competent stores personnel and security staff shall be deployed to efficiently store and maintain the equipment / material.
7. The equipment shall be stored in an orderly manner, preserving their identification slips, tags and instruction booklets, etc., required during erection. The storage of materials shall be equipment-wise. Loose parts shall be stored in sheds on racks,

preserving the identification marks and tags in good condition. The group codes shall be displayed on the racks

6. At no time shall any materials be stored directly on ground. All materials shall be stored minimum 200 mm above the ground preferably on wooden sleepers

b) GENERAL PRESERVATION REQUIREMENTS

1. All special measures to prevent corrosion shall be taken like keeping material in dry condition, avoiding the equipment coming in contact with corrosive fluid like water, acid etc.
2. Materials which carry protective coating shall not be wrapped in paper, cloth, etc., as these are liable to absorb and retain moisture. The material shall be inspected and in case of signs of wear or damages to protective coating, that portion shall be cleaned with approved solution and coated with an approved protective paint. Complete record of all such observations and protective measures taken shall be maintained.
3. Generally equipment supplied at site are properly greased or rust protective oil is applied on machined/ fabricated components. However periodic inspection shall be carried out to ensure that protection offered is intact.
4. While handling the equipment, no dragging on the ground is permitted. Avoid using wire rope for lifting coated components. Use polyester slings (if possible) otherwise protective material (e.g. clothes, wood block etc.) should be used while handling the components with rope / slings
5. For Equipment supplied with finished paint, touch paint shall be done in case any surface paint gets peeled off during handling. Otherwise such surfaces shall necessarily be wrapped with polythene to avoid any corrosion. Further for equipment wherein finish coat is to be applied at site, site to ensure that equipment is received with primer coat applied.
6. It shall be ensured by periodic inspection that plastic inserts are intact in tapped holes, wherever applicable.
7. Pipes shall be blown with air periodically and it shall be ensured that there is no obstruction.
8. Silica gel or approved equivalent moisture absorbing material in small cotton bags shall be placed and tied at various points on the equipment, wherever necessary.
9. Heavy rotating parts in assembled conditions shall be periodically rotated to prevent corrosion/jamming due to prolonged storage.

10. All the electrical equipment such as motors, generators, etc. shall be tested for insulation resistance at least once in three months and a record of such measured insulation values shall be maintained.
11. Following preservatives/preservation methods can be used depending upon type of equipment
 - a. Rust preventive fluid (RPF)
 - b. Rust protective paints
 - c. Tarpaulin covers, in case of outdoor storage
 - d. De-oxy aluminate for weld-ments

c) GENERAL INSPECTION REQUIREMENTS

1. Period inspection of materials with specific reference to –
 - Ingress of moisture and corrosion damages.
 - Damage to protective coating.
 - Open ends in pipes, vessels and equipment -
 - In case any open ends are noticed, same shall be capped.
2. Any damages to equipment / materials.
 - In case of any damages, these shall be promptly notified and in all cases, the repairs / rectification shall be carried out.
 - Any items found damaged or not suitable as per project requirements shall be removed from site. If required to store temporarily, they shall be clearly marked and stored separately to prevent any inadvertent use.

4. TYPE OF STORAGE FOR VARIOUS EQUIPMENT

The types of storage are broadly classified under the following heads:

i **Closed storage with dry and dust free atmosphere. (C)**

The closed shed can be constructed by using cold-rolled / tubular components for structure and corrugated asbestos sheets / galvanised iron sheets for roofing. Brick walls / asbestos sheets can be used to cover all the sides. The floor of the shed can be finished with plain cement concrete suitably glazed. The shed shall be provided with proper ventilation and illumination.



ii **Semi-closed storage. (S)**

The semi closed shed can be constructed by using cold-rolled / tubular components for structure and corrugated / asbestos sheets for roofing. The floor shall be brick paved. If required a small portion of sides can be covered to protect components from rainwater splashing onto the components.





iii Open storage (O)

The open yard shall be levelled, well consolidated to achieve raised ground with the provision of feeder roads for crane approach along with access roads running all sides. One part of the open yard shall be stone pitched, levelled and consolidated with raised ground suitable for storing / stacking heavier and critical components with due space to handle them by cranes etc . Adequate number of sleepers, concrete block etc. to be provided to make raised platforms to stack critical materials.

A separate yard to be identified as “scrap yard” slightly away from main open yard to store wooden/steel scraps, which are to be disposed off. This is required to avoid mix up with regular components as well as to avoid fire hazard.

Some of the components, which are having both machined & un-machined surfaces and are bulky, shall be stored in open storage area on a raised ground and suitably covered with water proof / fire retardant tarpaulin.



The equipment listed below shall be stored and inspected as per requirement mentioned in the table below.

Sl. No.	Description of the equipment	Type of Storage	Check for	Remarks
Raw material /mechanical items like pipes, plates, structure sections etc.)				
1.	Steel pipes (lined/unlined)	S	Damage , paint, corrosion, rubber lining peeling	Provide end cap
2.	MS Plates	S	Damage, paint, corrosion	
3.	SS Plates	S	Damage	
4.	Non-metallic pipes	S	Damage, cracks	Provide end cap
5.	Stainless steel pipes	S	Damage ,	Provide end cap
6.	MS sections, beams	S	Damage, paint, corrosion	
7.	Cable trays	S	Damage, condition of preservations	
8.	Insulation sheets	S	Damage	
9.	Insulation	C	Damage, packing	
10.	Hangers Rods	S	Damage, paint, packing	
11.	Tubes	S	Damage, paint , packing	Provide end cap
12.	Hume pipes	O	Damage	
13.	Castings	O	Damage, paint, corrosion	
Fabricated mechanical items (pressure vessels, tanks etc.)				
14.	Pressure vessels (unlined)	O	Damage, paint, corrosion,	Covered nozzles
15.	Atmospheric storage tanks (unlined)	O	Damage, paint, corrosion	Covered nozzles

Sl. No.	Description of the equipment	Type of Storage	Check for	Remarks
16.	Pressure vessels (lined)	S	Damage, paint, corrosion, rubber lining	
17.	Atmospheric storage tanks(lined)	S	Damage, paint, corrosion, rubber lining	
18.	Support structures	O	Damage , paint, corrosion	
19.	Flanges	C	Damage , paint, corrosion	
20.	Fabricated pipes	S	Damage , paint, corrosion	Provide end cap
21.	Vessels internals	C	Damage , paint, corrosion ,packing	
22.	Grills	S	Damage , paint, corrosion	
23.	Angles	S	Damage , paint, corrosion	
24.	Bridge mechanism/clarifier mechanism	O	Damage , paint, corrosion	
25.	Cranes, rails	S	Damage , paint, corrosion	
26.	Stair cases	O	Damage , paint, corrosion	
27.	Ladders/handrails	O	Damage , paint, corrosion	
28.	Fabricated ducts	S	Damage , paint, corrosion	
29.	Isolation Gates	O	Damage , paint, corrosion	
30.	Fabricated boxes/panels	S	Damage , paint, corrosion	
Mechanical components like valves, fittings, cables glands, spares etc.)				
31.	Valves	S	Damage , packing	

Sl. No.	Description of the equipment	Type of Storage	Check for	Remarks
32.	Fittings	S	Damage , packing	Provide end cap
33.	Cable glands	C	Damage , packing	
34.	Tools & tackles	C	Damage , packing	
35.	Nut , bolts, washers,	C	Damage , packing	
36.	Gasket & Packings	C	Damage , packing	
37.	Copper tubes	C	Damage , packing, corrosion	Provide end cap
38.	SS tubing	C	Damage , packing	Provide end cap
Rotating assemblies (pumps, blowers, stirrers, fans, compressors etc.)				
39.	Pumps	S	Damage , packing, corrosion	Shaft rotation
40.	Blowers/Compressors	S	Damage , packing, corrosion	Shaft rotation
41.	Agitators/stirrers/radial launders	C	Damage , packing, corrosion	Shaft rotation
42.	Rollers for chlorine tonner mounting	C	Damage , packing, corrosion	
43.	Centrifuge	S	Damage , packing,	
44.	Gear box	C	Damage , packing, corrosion	
45.	Bearings	C	Damage , packing, corrosion	
46.	Fans	S	Damage , packing, corrosion	
47.	Dosing skids	S	Damage , packing, corrosion	
48.	Pump assemblies	S	Damage , packing, corrosion	
49.	Air washers(INTERNALS)	S	Damage , packing	
50.	Air conditioners (split)	C	Damage , packing	

Sl. No.	Description of the equipment	Type of Storage	Check for	Remarks
51.	Elevators(CONTAINERIZED)	O	Damage , packing, corrosion	
52.	Chillers/VA machines	S	Damage , packing	
53.	Air handling Unit/Package unit	S	Damage , packing	
54.	Chlorinators & Evaporators	C	Damage , packing	
55.	Ejectors	C	Damage , packing	
56.	Electrolyser	C	Damage , packing	
Miscellaneous items like chain pulley blocks, hoists etc.				
57.	Chain pulley blocks	S	Damage, Packing	
58.	Electric hoists	S	Damage, Packing	
59.	Fire extinguishers	C	Damage, expiry date	
60.	Fork Lift Truck	S	Damage, Packing	
61.	Hydraulic Mobile Crane	O	Damage, Packing	
62.	Mobile Pick Up & Carry Crane	O	Damage, Packing	
63.	Motor boats	O	Damage, Packing	
64.	Safety showers	S	Damage, Packing	
65.	Diffusers/dampers	S	Damage, Packing	
Chemicals and consumables (acid, alkali, paints, oils, reagents and special chemicals)				
66.	Hydro Chloric Acid (HCl)	Store in canes/ storage tank in dyke area	Date of production/ leakage/fumes	hazardous chemical
67.	Sulphuric acid (H ₂ SO ₄)	Store in canes/ storage tank in dyke area	Date of production/ leakage/fumes	hazardous chemical

Sl. No.	Description of the equipment	Type of Storage	Check for	Remarks
68.	Sodium hydroxide (NaOH)	Store in canes/ storage tank in dyke area	Date of production/ leakage/ fumes/ breather	hazardous chemical ,breather to be checked for air ingress
69.	Sodium hypo chlorite	To be stored under shed	Date of production/ leakage/ fumes	hazardous chemical ,self-life normally 15-30 days after which strength of chemical decays
70.	Ammonia	S	Date of production/ leakage/ fumes	Store in closed storage tanks, hazardous chemical
71.	CW treatment chemicals	S	Date of production , Self-life	Store in closed canes
72.	RO/UF cleaning chemicals	S	Date of production , Self-life	Store in closed canes
73.	Lime	C	Damage to packing , seepage	Prevent moisture, rain
74.	Alum bricks	C	Damage to packing	Prevent moisture, rain
75.	Poly electrolyte	S		Store in closed storage tanks
76.	Laboratory chemicals(powder)	C	Damage, Packing self-life	
77.	Laboratory chemicals(liquid)	C	Damage, Packing self-life	
78.	Lubrication oils	C	Leakage	
79.	Paints	S	Leakage ,air tightness	
80.	Sand	O	Damage of packing	No hooks
81.	Salt (NaCl)	C	Damage of packing, water ingress	Prevent moisture, rain
82.	Anthracite	S	Damage of packing	
83.	Activated carbon	S	Damage of packing	

Sl. No.	Description of the equipment	Type of Storage	Check for	Remarks
84.	Thermal insulation	S	Damage of packing	
85.	Cement	C	Damage of packing	Prevent moisture, rain
86.	Gravels	O	Damage of packing	
87.	ION exchange resins	C	Damage , packing	Refer manufacturer guidelines
88.	RO membranes	C	Damage , packing	Refer manufacturer guidelines
89.	UF membranes	C	Damage , packing	Refer manufacturer guidelines
90.	Cleaning chemicals	C	Damage , packing	Refer manufacturer guidelines
91.	Chemicals for analysers/calibration	C	Damage , packing	Refer manufacturer guidelines
Electrical and C & I items (motors, cables etc.)				
92.	Motors	C	Damage , packing	
93.	Cable drums	O	Damage	
94.	Control Panel /control desk, UPS ,JB	S	Damage, Packing	
95.	Instruments(gauges/analysers)	C	Damage	
Special items		As per Manufacturer's item, like Hydrogen cylinders, Ozonator, Analyser, Chlorine dioxide generators etc.		

5. CONCLUSION

Concerned storage agency at site should make sure that loss in equipment performance and wear & tear are minimised through proper storage and preservation. The above are broad guidelines and cover major equipment / materials. However specific storage practices shall be followed as per manufacturer recommendation. All the necessary measures even in addition to the ones mentioned above, if found necessary, should be taken to achieve the objective.

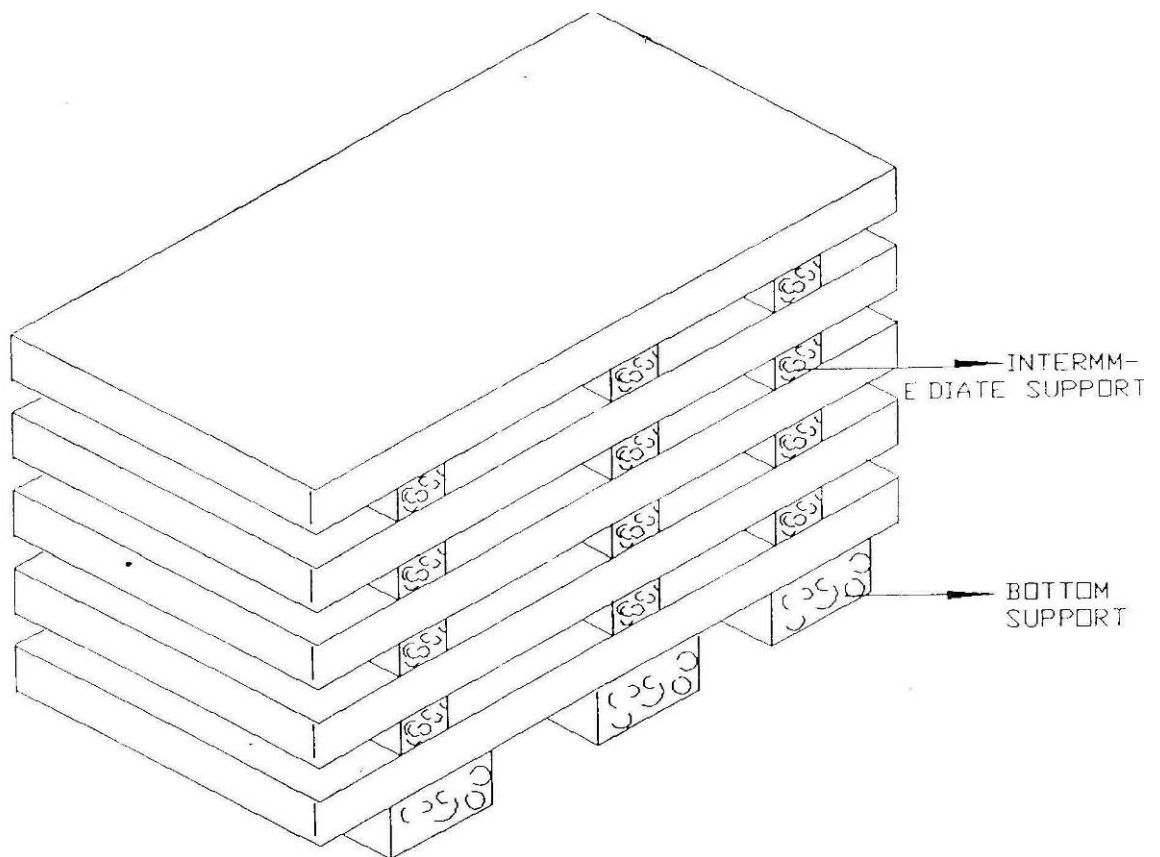


Figure – 1 – PLATE STACKING ARRANGEMENT

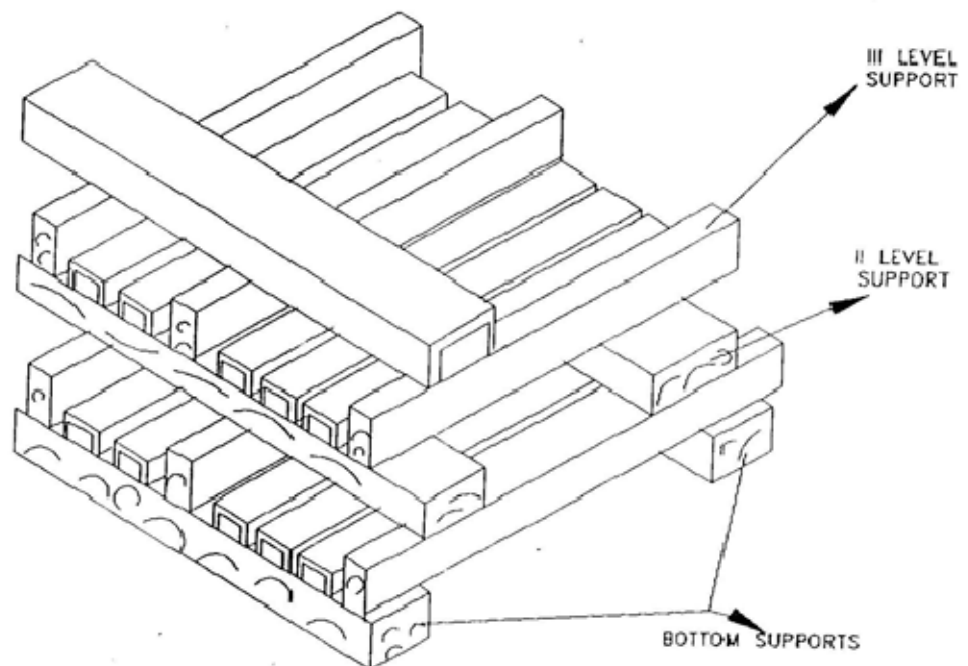


Figure – 2 – STRUCTURAL STEEL STACKING ARRANGEMENT

5 X 800MW YADADRI TPS

TECHNICAL SPECIFICATION
FOR
LUBE OIL TRANSFER PUMPS

SECTION - III

DOCUMENTS TO BE SUBMITTED BY BIDDER



BHARAT HEAVY ELECTRICALS LTD
POWER SECTOR PROJECT ENGINEERING MANAGEMENT PPEI,
NOIDA-INDIA

**TITLE**

5X800 MW TSGENCO YADADRI TPS
LUBE OIL TRANSFER PUMP

SPECIFICATION NO. PE-TS-417-567-A001

REV 00

Section – IIIA

Date : 04.04.2020

SUB-SECTION – IIIA

LIST OF DOCUMENTS TO BE SUBMITTED WITH BID



**TECHNICAL SPECIFICATION FOR
LUBE OIL TRANSFER PUMPS
5X800 MW TSGENCO YADADRI TPS**

SPECIFICATION NO. PE-TS-417-567-A001

SECTION IIIA

REV – 00

DATE .04.04.2020

LIST OF DOCUMENTS TO BE SUBMITTED WITH THE BID

- a. Prebid clarification schedule as per format given under Section-IIIC, in case of any clarifications.
- b. Deviation schedule as per format given under Section-IIID, in case of any deviations by bidder.
- c. Compliance cum confirmation certificate as given under Section-IIIB.
- d. Unpriced price schedule

In addition to the above, docs required along with bid given under **electrical portion of specification** shall be furnished by bidder.

NOTES:

OFFER WILL BE CONSIDERED AS INCOMPLETE IN ABSENCE OF ANY OF THE ABOVE DOCUMENTS.

DOCUMENTS OTHER THAN ABOVE, IF ANY, SUBMITTED WITH THE OFFER WILL NOT FORM PART OF CONTRACT AND ACCORDINGLY WILL NOT BE CONSIDERED FOR BID EVALUATION.



**5X800 MW TSGENCO YADADRI TPS
LUBE OIL TRANSFER PUMP**

**DOCUMENTS TO BE SUBMITTED BY
BIDDER**

SPECIFICATION No: PE-TS-417-567-A001

SECTION-III

SUB-SECTION-IIIB

REV 00

DATE 04.04.2020

SUB SECTION-IIIB

COMPLIANCE CUM CONFIRMATION CERTIFICATE

	TITLE:	SPEC. NO.: PE-TS-417 -567-A001
	TECHNICAL SPECIFICATION	
		SECTION: III B
	COMPLIANCE CUM CONFIRMATION CERTIFICATE	REV. NO. 0 DATE 04.04.2020
		SHEET 1 OF 2

COMPLIANCE CUM CONFIRMATION CERTIFICATE

The bidder shall confirm compliance with following by signing/ stamping this compliance certificate (every sheet) and furnish same with the offer.

- a) The scope of supply, technical details, construction features, design parameters etc. shall be as per technical specification & there are no exclusions other than those mentioned under "exclusion" and those resolved as per 'Schedule of Deviations', if applicable, with regard to same.
- b) There are no other deviations w.r.t. specifications other than those furnished in the 'Schedule of Deviations'. Any other deviation, stated or implied, taken elsewhere in the offer stands withdrawn unless specifically brought out in the 'Schedule of Deviations'.
- c) Bidder shall submit QP in the event of order based on the guidelines given in the specification & QP enclosed therein. QP will be subject to BHEL/ CUSTOMER approval & 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. This shall be within the contracted price with no extra implications to BHEL after award of the contract.
- d) All drawings/ data-sheets/ calculations etc. submitted along with the offer shall be considered for reference only, same shall be subject to BHEL/ CUSTOMER approval in the event of order.
- e) The offered materials shall be either equivalent or superior to those specified in the specification & shall meet the specified/ intended duty requirements. In case the material specified in the specifications is not compatible for intended duty requirements then same shall be resolved by the bidder with BHEL during the pre - bid discussions, otherwise BHEL/ Customer's decision shall be binding on the bidder whenever the deficiency is pointed out.

For components where materials are not specified, same shall be suitable for intended duty, all materials shall be subject to approval in the event of order.
- f) The commissioning spares shall be supplied on 'As Required Basis' & prices for same included in the base price itself.
- g) All sub vendors shall be subject to BHEL/ CUSTOMER approval in the event of order.
- h) Guarantee for plant/equipment as applicable, shall be as per relevant clause of GCC /SCC /Other Commercial Terms & Conditions.
- i) In the event of order, all the material required for completing the job at site shall be supplied by the bidder within the ordered price even if the same are additional to approved billing break up, approved drawing or approved Bill of quantities. This clause will apply in case during site commissioning additional requirements emerges due to customer and/ or consultant's comments. No extra claims shall be put on this account.
- j) Schedule of drawings submissions, comment incorporations & approval shall be as stipulated in the specifications. The successful bidder shall depute his design personnel to BHEL's/ Customer's/ Consultant's office for across the table resolution of issues and to get documents approved in the stipulated time.

	TITLE:	SPEC. NO.: PE-TS-417-567-A001
	TECHNICAL SPECIFICATION	VOLUME: III
		SECTION:
	COMPLIANCE CUM CONFIRMATION CERTIFICATE	REV. NO. 0 DATE 04.04.2020
		SHEET 2 OF 2

k) As built drawings shall be submitted as and when required during the project execution.

l) The bidder has not tempered with this compliance cum confirmation certificate and if at any stage any tempering in the signed copy of this document is noticed then same shall be treated as breach of contract and suitable actions shall be taken against the bidder.

SIGNATURE: _____

NAME : _____

DESIGNATION: _____

COMPANY: _____

DATE: _____

COMPANY SEAL



**5X800 MW TSGENCO YADADRI TPS PROJECT
LUBE OIL TRANSFER PUMP**

**DOCUMENTS TO BE SUBMITTED BY
BIDDER**

SPECIFICATION No: PE-TS-417-567-A001

SECTION-III

SUB-SECTION-III C

REV 00

DATE 04.04.2020

SUB SECTION-III C PRE BID CLARIFICATION SCHEDULE



5X800 MW TSGENCO YADADRI TPS PROJECT
LUBE OIL TRANSFER PUMP

DOCUMENTS TO BE SUBMITTED BY
BIDDER

SPECIFICATION No: PE-TS-417-567-A001

SECTION-III

SUB-SECTION-III C

REV 00

DATE 04.04.2020

PRE-BID CLARIFICATION SCHEDULE

S. No.	Section/Clause /Page No.	Statement of the referred clause	Clarification Required

The bidder hereby certifies that above mentioned are the only clarifications required on the technical specification for the subject package.

SIGNATURE: _____

NAME: _____

DESIGNATION: _____

COMPANY: _____

DATE: _____

COMPANY SEAL



**5X800 MW TSGENCO YADADRI TPS PROJECT
LUBE OIL PUMPS PACKAGE**

**DOCUMENTS TO BE SUBMITTED BY
BIDDER**

SPECIFICATION No: PE-TS-417-567-A001

SECTION-III

SUB-SECTION-IIID

REV 00

DATE 04.04.2020

SUB SECTION-III D SCHEDULE OF TECHNICAL DEVIATION

DEVIATION SHEET (COST OF WITHDRAWAL)



**TITLE: TECHNICAL SPECIFICATION FOR CHEMICAL DOSING SYSTEM.
PROJECT: 5X800 MW TSGENCO YADADRI TPS**

TECH SPC NO: PE-TS-417-567-A001

TENDER ENQUIRY REFERENCE:-

NAME OF BIDDER:-

SL NO	VOULME/ SECTION	PAGE NO.	CLAUSE NO.	TECHNICAL SPECIFICATION/ TENDER DOCUMENT	COMPLETE DESCRIPTION OF DEVIATION	COST OF WITHDRAWAL OF DEVIATION	REFERENCE OF PRICE SCHEDULE ON WHICH COST OF WITHDRAWAL OF DEVIATION IS APPLICABLE	NATURE OF COST OF WITHDRAWAL OF DEVIATION (POSITIVE/ NEGATIVE)	REASON FOR QUOTING DEVIATION
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TECHNICAL DEVIATIONS

COMMERCIAL DEVIATIONS

PARTICULARS OF BIDDERS/ AUTHORISED REPRESENTATIVE

NAME	DESIGNATIONS	SIGN & DATE

NOTES:

- Cost of withdrawal of deviation will be applicable on the basic price (i.e, excluding taxes, duties & freight) only.
- All the bidders has to list out all their Technical and Commercial Deviations (if any) in detail in the above format.
- Any deviation not mentioned above and shown separately of found hidden in offer, will not be taken cognizance of.
- Bidder shall submit duly filled unpriced copy of above format indicating "quoted" in "cost of withdrawal of deviation" column of the schedule above along with their Techno-commercial offer, wherever applicable. in the absence of same, such deviation(s) shall not be considered and offer shall be considered in total compliance to NIT
- Bidder shall furnish price copy of above format along with price bid.
- The final decision of acceptance/ rejection of the deviations quoted by the bidder shall be at discretion of the Purchaser.
- Bidders to note that any deviation (technical/commercial) not listed in above and asked after Part-I opening shall not be considered.
- For deviations w.r.t. Credit Period, Liquidated damages, Firm prices if a bidder chooses not to give any cost of withdrawal of deviation loading as per **Annexure-VII of GCC, Rev-07** will apply. For any other deviation mentioned in un-priced copy of this format submitted with Part-I bid but not mentioned in priced copy of this format submitted with Priced bid, the cost of withdrawal of deviation shall be taken as NIL.
- Any deviation mentioned in priced copy of this format, but not mentioned in the un-priced copy, shall not be accepted.
- All techno-commercial terms and conditions of NIT shall be deemed to have been accepted by the bidder, other than those listed in un-priced copy of this format.
- Cost of withdrawal is to be given separately for each deviation. In no event bidder should club cost of withdrawal of more than one deviation else cost of withdrawal of such deviations which have been clubbed together shall be considered as NIL.
- In case nature of cost of withdrawal (positive/negative) is not specified it shall be assumed as positive.
- In case of discrepancy in the nature of impact (positive/ negative), positive will be considered for evaluation and negative for ordering.

	TITLE 5X800 MW TSGENCO YADADRI TPS LUBE OIL TRANSFER PUMP	SPECIFICATION NO. PE-TS-417 -567-A001	
		REV 00	
		Section III	Date
SECTION – IIIE ELECTRICAL LOAD DATA			

LOAD TITLE	RATING (KW / A)		UNIT (U)/STN (S)	Nos.		VOLTAGE CODE*	FEEDER CODE**	EMER. LOAD (Y)	CONT.(C)/ INTT.(I)	STARTING TIME >5 SEC (Y)	LOCATION	BOARD NO.	CABLE		BLOCK CABLE DRG. No.	CONTROL CODE	REMARKS	LOAD No.
	NAME PLATE	MAX. CONT. DEMAND (MCR)		RUNNING	STANDBY								SIZE CODE	NOS				
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19
CLEAN OIL TRANSFER PUMP	3.7 KW		-	2	-	D	U	-	-	-	TG hall							
DIRTY OIL TRANSFER PUMP	3.7 KW		-	2	-	D	U	-	-	-	TG hall							

Note:

- Bidder to confirm that the system provided by them would be catered by the above loads considered by BHEL. In case there is any variation; the same should be clearly stated in the technical offer. No changes would be admissible during detailed engineering stage.
- Bidder to note that for the system being supplied by them, only the above loads will be provided. In case any other load is required the same would be derived /multiplied by bidder on their own from these feeders only.

NOTES:

1. COLUMN 1 TO 12 & 18 SHALL BE FILLED BY THE REQUISITIONER (ORIGINATING AGENCY); REMAINING COLUMNS ARE TO BE FILLED UP BY PEM (ELECTRICAL)

2. ABBREVIATIONS : * VOLTAGE CODE (7):- (ac) A=11 KV, B=6.6 KV, C=3.3 KV, D=415 V, E=240 V (1 PH), F=110 V (cc): G=220 V, H=110 V, J=48 V, K=+24V, L=-24 V

: ** FEEDER CODE (8):- U=UNIDIRECTIONAL STARTER, B=BI-DIRECTIONAL STARTER, S=SUPPLY FEEDER, D=SUPPLY FEEDER (CONTACTER CONTROLLED)

	LOAD DATA (ELECTRICAL)	JOB NO.	ORIGINATING AGENCY		PEM (ELECTRICAL)		
		PROJECT TITLE	5X800 MW TSGENCO YADADRI TPS	NAME		DATA FILLED UP ON	
		SYSTEM	LUBE OIL PUMPS	SIGN.		DATA ENTERED ON	
		DEPTT. / SECTION	ELECTRICAL	SHEET 1 OF 1	REV. 00	DE'S SIGN. & DATE	