



An ISO 9001
Company

Bharat Heavy Electricals Limited

(High Pressure Boiler Plant)

Tiruchirappalli – 620014, TAMIL NADU, INDIA

CAPITAL EQUIPMENT / MATERIALS MANAGEMENT

ENQUIRY	Phone: +91 431 257 76 53 Fax : +91 431 252 07 19 Email : skaruna@bheltry.co.in Web : www.bhel.com
NOTICE INVITING TENDER	

TWO PART BID	Enquiry Number:	Enquiry Date:	Due date for submission of quotation:
Tender to be submitted in two Parts	2631500034	05.11.2015	30.11.2015

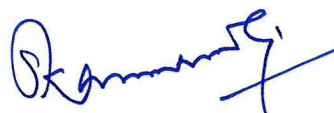
You are requested to quote the Enquiry number date and due date in all your correspondence. This is only a request for quotation and not an order.
Please note that under any circumstances both delayed offer and late offers will not be considered. Hence vendors are requested to ensure that the offer is reaching physically our office before 14.00 hrs on the Date of tender opening.

Item	Description	Quantity
10	IGBT Based Inverter Controlled Welding Power Source for SMAW & TIG Welding (400A, 60% Duty Cycle) as per the technical specification & commercial conditions applicable (to be downloaded from web site www.bhel.com or http://tenders.gov.in)	10 Nos.

Important points to be taken care during submission of offer

1. Compliance Form No: TRY/ IMP/ 04 and TRY/ IND/ 04A to be filled and enclosed along with the offer failing which, the offer will not be considered for evaluation.
2. All updates, amendments, corrigenda, etc., (if any), for each tender will be posted only on the above websites from time to time, as and when required, until each tender is opened. There will be no publication of such updates, amendments, corrigenda, etc., through newspapers or any other media.
3. Delivery required: 4 months from the date of Purchase Order.
4. Erection and Commissioning shall be done by the vendor at BHEL/ Trichy. Time period required for Erection and Commissioning shall be 1 week from the date of intimation from BHEL requesting supplier to depute Service Engineers about site readiness.

BHEL's General guidelines / instructions (refer MM/CE/GENL/001), compliance form and technical specification can be downloaded from BHEL web site <http://www.bhel.com> or from the Government tender website <http://tenders.gov.in> (public sector units > Bharat Heavy Electricals Limited page) under Enquiry reference "2631500034".

<p>Tenders should reach us before 14:00 hours on the due date Tenders will be opened at 14:30 hours on the due date Tenders would be opened in presence of the tenderers who have submitted their offers and who may like to be present</p>	<p>Yours faithfully, For BHARAT HEAVY ELECTRICALS LIMITED</p>  <p>DGM / Capital Equipment / MM</p>
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IGBT BASED INVERTER CONTROLLED WELDING POWER SOURCE FOR SMAW & TIG WELDING (400 A, 60% duty cycle), Qty. 10 nos.

PART A

SECTION 1: Qualifying Criteria

The BIDDER has to compulsorily meet the Qualifying criteria indicated in SECTION 1 to get qualified. Otherwise the technical offer will not be considered.

S. No.	REQUIREMENTS	VENDOR'S RESPONSE
1.1	Only BIDDER /VENDOR (OEM) who have a minimum of last TEN Years (as on date of opening of tender) of Continuous Experience in Design, Manufacture & Supply of “ IGBT based Inverter controlled Welding Power Sources for SMAW & TIG Welding ” for Radiographic Quality SMAW/TIG welding applications, are eligible to quote for this tender. Vendor shall indicate the actual no. of years of experience in the field.	
1.2	Only those vendors (OEMs) should quote, who have commissioned in the last 5 years, at least 20 Nos. of the model quoted against this tender of “IGBT based Inverter controlled Welding Power Source for SMAW & TIG welding” with a rating of 400A - 60% Duty Cycle EITHER (i) in at least one country other than the country of origin to establish vendor's (OEM's) global business activity OR (ii) in India. The name and contact addresses of the customers to whom the machines have been supplied has to be furnished with details. Indicate the number of such welding machines sold in India.	
1.3	Number of “IGBT based Inverter controlled Welding Power Source for SMAW & TIG welding” supplied & commissioned till date.	
1.4	Year of Launch of the Offered Model in this tender.	
1.5	The quoted model of Welding Power Source shall be complying with at least one of the Standards as given below: <ol style="list-style-type: none"> 1. IEC 60974-1:2012 Edition 4.0 2. BS EN 60974-1/2012 3. ANSI/IEC 60974-1: 2008 4. JIS C 9300-1:2006/AMENDMENT 1:2008 5. NEMA EW 9-2012 <p>A document certifying or declaration for complying with the above standards shall be submitted with the technical offer which will be subject to verification by BHEL.</p>	

S. No.	REQUIREMENTS	VENDOR'S RESPONSE
1.6	<p>Vendor to submit Performance certificate satisfying all the following conditions (as on original date of opening tender) (suggestive format is given as annexure):</p> <p>a) At least ONE Performance Certificate from any of the customers for satisfactory performance of minimum 5 Nos of the quoted model against this tender, for a minimum period of one year from the date of commissioning (as on original date of opening of tender), supplied in the last five years, EITHER (i) in the country other than the country of origin OR (ii) in India, especially from Heavy Engineering / Fabrication Public/Private sector companies like Utility Boiler Manufacturers, Ship Building, Heavy duty Site fabrication, Large Heat Exchanger & Pressure Vessels manufacturers etc.</p> <p>b) Performance certificates to be submitted as Original Certificate or through E-mail directly from the customer. The original performance certificate may be returned after verification by BHEL, if required.</p> <p>c) Full contact details of the customers from whom the performance certificates are obtained are to be provided.</p> <p>d) For obtaining the Performance certificate, a suggestive format is provided.</p>	
1.7	<p>Indian bidders shall submit Audited financial results for the past three financial years (2012-13, 2013-14, 2014-15) and Foreign bidders shall submit D&B report covering past three financial years. The financial results shall be verified and evaluated to examine the financial health of the company.</p> <p>BHEL reserves the right to accept or reject the OEMs based on the assessment of their financial capability.</p>	
1.8	<p>Servicing facility to be available in India. Details on Service-After-Sales Set-Up in India (Address of Agents / Service Centres), to be furnished compulsorily.</p>	
1.9	<p>BHEL reserves the right to accept or reject the OEMs based on the assessment of their technical capability.</p> <p>BHEL reserves the right to verify the information provided by the Vendor for the referred machine at their referred customer's works. It shall be the responsibility of the vendor to facilitate the visit of BHEL's team at their referred customer works .The Travel, Board & Lodging expenses for BHEL Personnel shall be borne by BHEL. In case the information provided by vendor is found to be false/ incorrect, the offer shall be rejected.</p>	

SECTION 2

The BIDDER / VENDOR is requested to provide the following information:

S. No.	REQUIREMENTS	VENDOR'S RESPONSE
2.1	Details of Design Set-Up and Technology Back-Up (R & D Centre) available with the OEM.	
2.2	Details on Standards followed in Design and Testing of Welding Machines (Copy of English Version of Standards / Design Codes followed shall be furnished with the Technical Offer).	
2.3	Details of Quality System followed (Furnish the salient aspects of the Quality Assurance System followed)	
2.4	Comprehensive Details, on Performance Testing of Welding Machines carried out at the Factory, to be furnished with the Technical Offer.	
2.5	The BIDDER shall give details about supply of similar welding machines to BHEL units if any with Make, Model and Year of Supply & Commissioning etc.	
2.6	A complete reference list of Customers shall be furnished (preferably of Heavy Engg. Companies) to whom such offered model has been supplied in the last ten years with PO details, Qty., Year of commissioning with contact details of the customers.	
2.7	Any Additional Data to supplement the manufacturing capability of the BIDDER.	

SECTION 3

The BIDDER to note:

S. No.	PARTICULARS	VENDOR'S RESPONSE
3.1	The BIDDER shall submit the offer in Two Parts – 1. Technical [with PART A & PART B] & 2. Commercial and Price Bid.	
3.2	The VENDOR'S RESPONSE against each clause in PART A & B of the offer should be filled by the BIDDER compulsorily with complete details.	
3.3	The BIDDER shall assure a continuous support for Spares and Service for Ten Years, from the date of commissioning of the equipment at BHEL Works.	
3.4	The Technical Offer shall be supported by Product Catalogue and Data Sheets in original and complete technical details / literature on the quoted models of Welding Power sources.	
3.5	The Commercial Offer (given with the Technical Offer) shall contain the Scope of Supply and the Un-Priced Part of the Price-Bid, for confirmation.	

The performance certificate should be produced **on Customer’s Letter Head.**

Suggestive Format of Performance Certificate

(On Customer’s letter head)

PERFORMANCE CERTIFICATE

1. Supplier of the machine :
2. Make & Model of the m/c :
3. Month & Year of Commissioning :
4. Quantity :
5. Machine Details
 - a) Type :
 - b) Capacity in Amp. :
 - c) Duty Cycle :
6. Application of the welding power sources:
7. Performance of the Machine : Satisfactory / Good / Average / Not Satisfactory
(Strike off whichever is not applicable)
8. After sales service : Satisfactory / Good / Average / Not Satisfactory
(Strike off whichever is not applicable)
9. Any Other remarks :

Date:

Signature & Seal of the Authority
Issuing the Performance Certificate

IGBT BASED INVERTER CONTROLLED WELDING POWER SOURCE FOR SMAW & TIG WELDING (400 AMPS, 60% DUTY CYCLE)

Qty. 10 nos.

PART B - Technical Specification

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
1.0	APPLICATION: The proposed Welding Machine is intended for Manual Arc Welding Process (SMAW) and Manual TIG welding process for producing Radiographic Quality Welds like Butt Joints, Fillet Welds and Double Groove Welds coming in High Pressure Vessels using 2.5 mm to 5.0 mm dia. basic coated stick electrodes.		
2.0	POWER SOURCE FEATURES		
2.1	Type	Power source shall be IGBT based Inverter Controlled and capable of delivering a Constant Direct Current (in DCEP and DCEN modes of welding operations).	
2.2	Switching Frequency	BIDDER has to indicate the Switching Frequency of the Inverter Circuit and the make of IGBT used. IGBTs used in the welding power sources shall be of HITACHI, JAPAN/ DYNEX, U.K/ FUJI, JAPAN/ IXYS, USA/ POWEREX, USA/ MITSUBISHI, JAPAN/ TOSHIBA, JAPAN / INFINEON, GERMANY/ SEMIKRON, GERMANY make only.	
2.3	Current Rating	400 A @ 60 % Duty Cycle	
2.4	Operating Range for Welding Current	20 A to 400 A (with step less variation Continuously adjustable)	
2.5	Open Circuit Voltage	Preferred OCV is 70 to 75V. BIDDER to specify the Open Circuit Voltage for the offered Power source	
2.6	Current Setting Variation	The variation in the set value of the welding current to the actual value shall not exceed 1 %.	
2.7	Current Control	Current control shall be provided in the Front Panel of Power source and also in the Remote Control Unit by knob control.	

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
2.8	Control Panel Switches	Power ON/OFF, Remote ON/OFF, Ampere Control, Hot Start Control, Arc Dynamics Control, GTAW/SMAW mode selection etc. Also, the Vendor shall list out the display provisions like welding current display etc. available in the front Control panel for Operators / Maintenance convenience.	
2.9	Voltmeter & Ammeter	<p>Factory Installed Digital Ammeter & Voltmeter on the front panel with easy removal and replacement (i.e., without lifting the top cover of the Welding Power source) for periodic instrument calibration.</p> <p><u>Calibration procedure:</u> Details of Input Source like voltage or current, Full scale reading shall be furnished along with the offer which is necessary for calibration.</p> <p>If the input connections to the ammeter and volt meter are taken from PCB, then Calibration kit shall be supplied.</p> <p>The calibration kit shall be comprising of Digital Ammeter, Digital Voltmeter as per specification and a shunt which is connected to the machine output terminals in series with a Load (arranged by BHEL). The Current & Voltage Output of this calibration kit is compared with that of the meters in the Welding Machine.</p> <p>Calibration certificate has to be provided for the display meters.</p>	
2.10	SMAW Arc Strike	Selection for Instantaneous Arc Strike with Hot Start for SMAW Process.	
2.11	TIG Arc Ignition	Arc ignition through an "In-Built" High Frequency unit for GTAW. Vendor to confirm and give details.	
2.12	Arc Dynamics Control - Electronic Inductance Variable Control	Arc dynamics Control shall be built in the machine for minimising the spatter and optimising weld-bead wetting action during welding of special materials like Stainless Steel, T91/P91, Inconel, in addition to Carbon and Low Alloy Steels.	
2.13	Insulation	Class "H" – shall be provided to suit Tropical Working Conditions.	

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
2.14	Machine Protection	IP 23 – Degree of Protection.	
2.15	Machine Cooling	The Power source shall feature a forced air cooling system that ensures adequate cooling of the components while preventing dust and metal particles from being drawn in.	
2.16	Functional / Elemental Design Protection/ operator safety	<ul style="list-style-type: none"> a) Inbuilt protection for the IGBT/Power source against Thermal / Overload / Short-Circuit / Single or Two Phase Power Input Conditions. b) All PCBs shall be sprayed with mould coating to prevent damage from dust and grinding particles. c) Machine Design to ensure proper earthing for the machine and its peripherals. d) Protection against electric shock from input supply as well as HF source for ensuring operator safety. e) Safety Provision in the form of VRD (Voltage Reducing Device) to reduce the OCV voltage to a safer level at the machine terminals automatically, when no welding operation is being carried out for a specified time. f) Protection against accidental short circuit of welding cable & return current cables. Vendor to give details. 	
2.17	Electromagnetic Interference (EMI) Suppression	<ul style="list-style-type: none"> a) Power source shall be equipped with a suitable Filter Network connected to the input Power Line, to prevent propagation of EMI / HF noise either into or out of the Power source. b) All metal enclosures and internal shields shall prevent radiated EMI. c) BIDDER has to elaborate the design features to meet the above requirements. 	
2.18	Power Source Terminals	The power source should have preferably Heavy Duty rugged lug type terminals to connect Welding Cable (for SMAW Electrode Holder) and Return Current Cable.	

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
2.19	SMAW Current Cable	SMAW (current) Cable with a minimum cross sectional area of 50mm ² , 20 m in length, with one end connected to the Power source and the free end provided with a female Connector to connect to the male Connector of the Manual Welding Electrode Holder.	
2.20	Return Current Cable	Welding Current return cable, 20m in length, with one end connected to the Power source and the other end provided with a Screw Type Earth Clamp.	
2.21	Load Compensation	Output variation in terms of fluctuation in line voltage, cable heating or drift caused due to usage of 20m long welding cable, shall be compensated suitably.	
2.22	Torch connection	Facility to connect gas cooled TIG torch through suitable adapters to prevent leakage of gas for GTAW.	
2.23	Input Power Cable	5m long electric input power cable with protective sheathing (for 3phase with potential earth) to be provided with the power source.	
2.24	Power Rating	BIDDER to indicate the Maximum Power Rating (kVA) of the Power source and the no-load Power consumption in Watts.	
2.25	Power Source Model	To Specify the Model of Power source Offered. (Metallic name plate of the machine shall also include details like name of manufacturer, Serial no, Model No., Year of Mfg input power in kVA, input voltage, No. of phase, operating frequency, weight of the unit etc.)	
2.26	Input Power Supply	3 Phase AC 415 V \pm 10%, 50 Hz \pm 2%, through a 3 Wire System (4 th wire for Earthing) – No Neutral Conductor.	
2.27	Portability	Under-Carriage with hard rubber lined caster wheels for portability of the power source by manual pushing and bottle rack for holding one Argon Gas cylinder.	

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
2.28	Ambient Conditions	Temperature up to 50°C; Humidity up to 90% but both upper limits do not occur simultaneously.	
3.0	REMOTE CONTROL UNIT FEATURES		
3.1	Application	Remote control unit shall be provided for setting welding current from a distant work place, in addition to that provided in the front panel of the welding power source.	
3.2	Type	Hand Operated control with 10 m long control cable with quick-fix end connectors. Type of remote control (analog or digital) may be specified.	
3.3	Current Control	Step less regulation of Welding Current.	
4.0	TIG WELDING TORCHES		
4.1	Application	Suitable for GTAW process and for the nature of welding works listed under S. no. 1.0 and compatible to the welding power source offered.	
4.2	Make	Preferred makes are Weld Craft, Abicor Binzel or any other reputed make acceptable to BHEL.	
4.3	Torch configuration	<p>The torch Head-gas lens & nozzles configuration shall be suitable for performing the following:</p> <ul style="list-style-type: none"> a) Tube butt welds in close pitch tubular panels with a minimum clear gap of 12mm between the adjacent tubes(gas nozzle end diameter is to be 11mm for a length of 25mm). b) Root GTAW pass welding in a 90mm (wall thickness) pipe butt welds (gas nozzle end dia. is to be 11mm for a length of 45mm). <p>Max. Tungsten electrode dia. 2.4 mm.</p>	
4.4	Cable sheathing	Protective sheathing to be provided for the entire length of TIG Torch cables & Hoses, to withstand shopfloor rough usage.	
4.5	Gas cooled Torch	<ul style="list-style-type: none"> a) Current rating: 140 to 180 A @ 100% Duty Cycle. b) Cable length: Around 8 m. 	

S. No.	BHEL SPECIFICATION	OFFER BY BIDDER
5.0	SCOPE OF SUPPLY : [The scope of supply shall consist of the following, for each machine]	
5.1	Welding Power source with Transport Trolley with wheels and integrated Argon gas Cylinder Cart (one gas cylinder/bottle only) along with 5m long input power cable with protective sheathing.	
5.2	Control Unit Integrated with Power source.	
5.3	Power source suitable for TIG/GTAW with high frequency Arc ignition.	
5.4	Hand Operated Remote Control Unit.	
5.5	Set of Inter-Connecting Cables, Adapters , hoses etc.	
5.6	SMAW Welding Cable with electrode Holder	
5.7	Return Current Cable with Screw Type Earth Clamp.	
5.8	Gas cooled TIG welding torch with around 8m long cables.	
5.9	Calibration certificate for Display meters.	
5.10	Calibration kit if necessary	
5.11	OPTIONAL: Program loader shall be supplied if the power source is pre-programmed.	
5.12	Electrical & Mechanical Spares for Power source & Control Unit	

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
6.0	SPARES :		
6.1	Power Source	All type of Spare Parts required for 2 years of trouble free operation on three shift basis including the following items are to be compulsorily quoted (with Unit Rate): IGBT Kit, All Types of Fuses, Control Transformers, Printed Circuit Boards / PCBs – All Types, Rectifiers, Thermistors, Capacitors, Switches and Knobs, Cooling Fan Motor, Ammeter & Voltmeter, Potentiometer / other Panel components, Relays & Timers, Receptacles, Control Cable with End Connectors, Filters, Welding & Return Cable Connectors at the power source side.	
6.2	TIG Torch consumables	Complete set of consumable spares for ϕ 2.4mm Tungsten electrode, 'O' Rings, Gas lens, nozzle/diffusers, ceramic nozzles (both types), collet bodies, etc. for one year trouble free operation are to be offered with unit price.	
6.3	Remote Control Unit	Complete Set of Spares for Remote Control Unit to be offered.	
7.0	O & M MANUALS :		
7.1	No. of Copies	3 hard copies for each machine	
7.2	Language	English	
7.3	Soft Copy	One soft copy in CD-ROM or pen drive is to be given for each machine, containing the details mentioned under Clause Sl. No. 7.4	

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
7.4	Manual Details :	a) Manual shall contain all instructions for machine installation and welding current range selection, in sequence. b) Manual to give general circuit diagrams, showing the interconnection of various elements and also details on PCBs [Printed Circuit Board] like tapping voltages, main electronic elements' specifications and ratings, etc. c) Manual to give other details like trouble shooting chart, weld parameters selection for various base metals, calibration procedure & certificates for digital ammeter/voltmeter etc. d) Master List of Parts & Spares used in the machine with Make, Model, Rating, Part number etc.	
8.0	GENERAL POINTS :		
8.1	Bought-Out Items	a) The Bought-Out Items - like Motors, Relays, Contactors, Switches, Electronic Elements, etc., used in the Power source & Control Unit shall be of reputed makes acceptable to BHEL. b) BIDDER has to furnish the make of Bought-Out Items, along with the offer.	
8.2	Weight	Bidder to specify the Weight of single power source	
8.3	Pre-dispatch Inspection	The welding machines shall be offered for inspection by BHEL Engineers at supplier's works for performance evaluation prior to despatch.	
8.4	Commissioning	Commissioning and performance prove out of the offered equipment at BHEL works, by the supplier's representative.	

S. No.	BHEL SPECIFICATION		OFFER BY BIDDER
8.5	Performance prove out at BHEL works	a) Welding Trials are to be taken on butt joints of carbon & alloy steel tubes (Tube OD 38.1 mm x Th 4mm to 10mm wall thickness), S.S. tubes (OD 17.0mm X Th 2.0 mm) & Titanium Tubes (OD 18 mm x Th 2.5 mm) and subjected to radiographic tests for acceptance. b) BHEL will provide necessary jobs and consumables for SMAW and TIG welding trials.	
8.6	Training	The Supplier's Service Engineer shall give training in the Operation and Maintenance (mainly on electric/electronic troubleshooting) of the Machine to BHEL Staff, during commissioning of the Welding Machines.	
8.7	Guarantee	The machine shall be guaranteed for a minimum of 24 months from the date of commissioning at BHEL.	