



Bharat Heavy Electricals Limited

(High Pressure Boiler Plant)

Tiruchirappalli – 620014, TAMIL NADU, INDIA

CAPITAL EQUIPMENT / MATERIALS MANAGEMENT

An ISO 9001
Company

ENQUIRY	Phone: +91 431 257 79 38 Fax : +91 431 252 00 31 Email : tvenkat@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	2851300024	29.10.2013	04.12.2013

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	10 Ton High Temperature Bogie Hearth Furnace as per the technical specification & commercial conditions applicable (to be downloaded from web site www.bhel.com or http://tenders.gov.in)	1.00 No.

Important points to be taken care during submission of offer

1. Material shall be delivered to
Indigenous Vendors:
FOR, BHEL, Stores
Power Equipment Fabrication Plant
Bharat Heavy Electricals Limited
Mundipar – 441 804, Taluka: Sakoli, District: Bhandara, Maharashtra State
2. Delivery required 8 months from the date of purchase order.
3. Erection and Commissioning period required 8 Weeks from the date of intimation by BHEL.
4. EMD for this Tender will be (INR) : 2,00,000.00
5. Compliance Form No: BND/IND/05 to be filled and enclosed along with the offer failing which, the offer will not be considered for evaluation.
6. 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.

BHEL's General guidelines / instructions (refer **MM / CE / GENL / 001-EMD**) including bank guarantee formats and list of consortium banks, commercial terms check-list 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 "2851300024".

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	Yours faithfully, For BHARAT HEAVY ELECTRICALS LIMITED Sr. Manager / Capital Equipment / MM
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PART A**10Ton High Temperature Bogie Hearth Furnace****SECTION – I: QUALIFYING CRITERIA**

The BIDDER has to compulsorily meet the following requirements to get qualified for considering the technical offer:

S.No.	REQUIREMENTS	VENDOR's RESPONSE
1.0	Only those vendors (OEMs), who have supplied and commissioned at least ONE LPG FIRED HIGH TEMPERATURE BOGIE HEARTH FURNACE with a maximum charge heating capacity of 1150 deg C or higher ,Charge weight carrying capacity of 10Tons or more and furnace for a job envelope of 3.5M(W)X0.6M(H)X8M(L) in the past ten years (on the date of opening of Tender) and such furnace is presently working satisfactorily for a minimum of one year after commissioning (on the date of opening of Tender) should quote.	
1.1	Vendor has to submit at least One Performance Certificate from their customers on customer's letter head, for satisfactory performance of High Temperature Bogie Hearth Furnace as said in 1.0 above which was supplied to them during the past ten years and is working satisfactorily for a minimum period of one year (as on date of opening of this tender). For obtaining the Performance certificate, a suggestive format is provided.	
1.2	The vendor should submit following information of the performance certificate issued customer.	
1.3	Name and postal address of the customer or company where similar furnace is installed.	
1.4	Name and designation of the contact person of the customer.	
1.5	Phone, FAX no and email address of the contact person of the customer.	
1.6	BHEL reserves the right to verify the information provided by vendor. In case the information provided by vendor is found to be false/ incorrect, the offer shall be rejected.	

SECTION – I I

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

S.No.	REQUIREMENTS	VENDOR's RESPONSE
2.0	The BIDDER/VENDOR to furnish Reference List of Customers, with full address, details of contact person, where High Temperature Bogie hearth furnaces have been supplied in the past.	
3.0	Details of High temperature Bogie hearth furnace supplied to other BHEL units, if any. (Year of commissioning, Length, Width, capacity and Operating temperature)	
4.0	Details on SERVICE-AFTER-SALES Set-Up in India including the Address of Agents / Service Centers in Central India.	
5.0	Any Additional Data to supplement the manufacturing capability of the BIDDER for the subject equipment.	

SECTION – III

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

PERFORMANCE CERTIFICATE

1.0	Supplier of the Equipment	
2.0	Make & Model Number	
3.0	Month & Year of Commissioning	
4.0	Application for which equipment is used	
5.0	a) Length of furnace	
	b) Width of furnace	
	c) Height of furnace	
	d) Fuel used	
	e) Operating Temperature	
	f) WT. Carrying Capacity	
	g) Burner type: PID with MFC controlled or pulse fired system	
6.0	Performance of the Equipment (Strike off whichever is not applicable)	Satisfactory/ Not Satisfactory
7.0	After sales service (Strike off whichever is not applicable)	Satisfactory /Not Satisfactory
8.0	Any Other remarks	
Date:		Signature & Seal of the Authority Issuing the Performance Certificate

PART B

10 TON HIGH TEMPERATURE BOGIE HEARTH FURNACE

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
1.0	PURPOSE & JOB MATERIAL :		
1.1	PURPOSE : To heat treat Pressure Parts like tubular coils /bends of Utility, Industrial Boilers and super critical Boilers		
1.2	Job Details: 1. Material: Carbon Steel, Alloy Steel & Stainless Steel Configuration: Tubular Coil Assemblies and Loose Coils/ Bends Tube Diameter Range: OD: 28.6 to 76.1 mm Wall Thickness: 2.4 to 18 mm 2. The maximum job envelope size can be taken as 3500 mm (W) x 600 mm (H) x 8000 mm (L) 3. The furnace charge will be loaded in batches within this space and this size has to be considered for designing the furnace. 4. Width W and height H will form the furnace front face. 5. Maximum charge weight: 10 Tons (The specific heat of material shall be considered as 0.14 Kcal/kg degC)	Vendor to note	
2.0	Furnace:		
2.1	Operating Parameters:		
2.1.1	Charge Capacity – Excluding job supports	10 Tons	
2.1.2	Heat Treatment Cycles to be carried out: Solution Annealing, Normalizing & Tempering, Annealing and Stress Relieving.	Vendor to confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.1.3	<p>Maximum Charge Temperature:</p> <p>a. Solution Annealing – Stainless Steel materials Max Heating and soaking temp : 1150 ±10 Deg C Max. soaking time: 45 minutes</p> <p>b. Normalizing and Tempering - High Alloy Steels Normalizing: Max Heating and soaking temperature: 1070 ±10 Deg C Max. Max. soaking time: 60 minutes Tempering: Max Heating and soaking temperature : 745 ±10 Deg C</p> <p>c. Stress Relieving Max Heating and soaking temperature will be: 745 ±10 Deg C Max. soaking time: 60 minutes</p>		
2.1.4	Maximum Furnace Design Temperature: Vendor to specify this temperature in order to attain the Max charge temperature of 1160 deg C	Vendor to specify	
2.1.5	Rate of heating with charge 1. Up to 400 deg C ----- 220 deg C / Hr 2. Above 400 deg C ----- 50 deg C / Hr (selection shall also be infinitely variable in the range 50 degC/Hr to 220 degC/Hr)	Vendor to confirm	
2.1.6	Rate of cooling with charge From soaking temp up to 400 degC -- 220 deg C / Hr (selection shall also be infinitely variable in the range 50 degC/Hr to 220 degC/Hr)	Vendor to confirm	
2.2	Furnace Configuration		
2.2.1	Fuel – LPG(Propane+Butane)/Propane Gas Fired firing system	Vendor to confirm	
2.2.2	Single Bogie Box type Configuration with front door sliding up/down for open/close.	Vendor to confirm	
2.2.3	Car Bottom Bogie Traversing on embedded Rails, through a Rack & Pinion Drive with reduction gear box	Vendor to furnish details	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.2.4	Automatic Zone Temperature Control with Programming of Heat Treatment Cycle	Vendor to confirm	
2.2.5	In case of variations in loading pattern or job thickness, the temperature uniformity should be able to be maintained by manual intervention.	Vendor to confirm	
2.2.6	Ceramic Fiber module refractory system / Monolane system for doors and shell.	Vendor to furnish details	
2.2.7	Hard refractory construction for bogies and side walls up to burner level	Vendor to confirm	
2.2.8	Recuperator System for Energy Conservation	Vendor to confirm	
2.3	Furnace Inside Dimensions: Considering the job envelope size approximate size of the furnace is indicated below. However the vendor has to specify the exact furnace size with design considerations of job envelope size, refractory / insulation thickness, flame length, space for thermocouples and access to maintenance etc.	Vendor to Specify	
2.3.1	Width of furnace (after refractory lining): around 4500mm	Vendor to Specify	
2.3.2	Height of furnace above Bogie top (after refractory linings on bogie and roof): Not less than 1000mm	Vendor to Specify	
2.3.3	Depth/Length of furnace from door to rear wall (after refractory lining): around 8500 mm	Vendor to Specify	
2.4	Combustion System:		
2.4.1	The furnace has to be provided with the required number of nozzle-mix high velocity burners suitably designed for firing LPG(Propane+Butane)/Propane. The positioning of the burners should be designed to create high degree of turbulence in the furnace, increased convection heat transfer to get better uniformity and thermal efficiency even at lower temperature.	Vendor to Confirm	
2.4.2	Fuel	LPG(Propane+Butane) /Propane	
2.4.3	LPG(Propane+Butane)/Propane line Pressure at BHEL: 1.5 to 2.0 kg/cm ²	Vendor to confirm	
2.4.4	Max required flow rate of LPG(Propane+Butane)/Propane (Supporting heat calculation details to be enclosed)	Vendor to Specify	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.4.5	Burners Type - (High Velocity Burner of Kromschroder/Eclipse or any reputed make acceptable to BHEL) (Vendor to furnish model no. and technical details of burners)	Vendor to furnish details	
2.4.6	Number of rows and arrangement of Burners (Schematic drawing should be furnished along with the offer)	Vendor to specify	
2.4.7	Number of Burners (Calculation details should be submitted with the offer)	Vendor to Specify	
2.4.8	Burner Rating	Vendor to Specify	
2.4.9	Burner turn - down ratio (higher ratio is preferred)	Vendor to specify	
2.4.10	Flame Length	Vendor to Specify	
2.4.11	Furnace Control System: The vendor shall offer both the following systems. 1. PID with Mass Flow Control and 2. Pulse-fired system. However the Type of Furnace control system will be finalized by BHEL at the time of technical discussion.	Vendor to Confirm	
2.4.12	No. of Temperature control Zones	Four	
2.4.13	LPG(Propane+Butane)/Propane gas burner material of construction shall be SS 310/Grey Cast Iron inside portion.	Vendor to Confirm	
2.4.14	LPG(Propane+Butane)/Propane gas igniter material of construction shall be SS 310/Kanthal A1 with ceramic body.	Vendor to Confirm	
2.4.15	Two way solenoid valve shall be brass/Aluminium material and should be flame proof as per IS: 2148 gas group class IIA, IIB.	Vendor to Confirm	
2.4.16	Isolation valves shall be fire safe design as per IS: 2148	Vendor to Confirm	
2.4.17	Vent valves opening position to be indicated in the control panel	Vendor to Confirm	
2.4.18	All vent valves shall be routed above roof to better air mix up in atmosphere	Vendor to Confirm	
2.4.19	All valve flanges shall be raised face with serrations.	Vendor to Confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.4.20	Wherever electrical input is available with any instrument in the LPG(Propane+Butane)/Propane line such as Igniter cables, scanner related items, junction boxes, transmitter, limit switches those shall be provided with flame proof enclosure with double compression cable gland provision for cable entry/exit.	Vendor to Confirm	
2.4.21	All cables should be Flame Retardant Low Smoke design only	Vendor to Confirm	
2.4.22	Copper cladded asbestos gasket to be used for valve flanges	Vendor to Confirm	
2.4.23	The complete piping system with all mechanical components should withstand Max 6 bar pressure during initial testing	Vendor to Confirm	
2.4.24	2 Nos. of "y" type / simplex filter with 4 Nos. of isolation valves to be provided.	Vendor to Confirm	
2.4.25	Instrument impulse line shall be SS 316, Sch 40.	Vendor to Confirm	
2.4.26	Copper washer shall be provided to all pressure gauges and switches	Vendor to Confirm	
2.4.27	All Flanges should be provided with copper earthing	Vendor to Confirm	
2.4.28	One spectacle blind shall be provided for each furnace near terminal point at gas train piping.	Vendor to Confirm	
2.4.29	Full TIG welding shall be carried out for all welding joints in LPG(Propane+Butane)/Propane pipe lines.	Vendor to Confirm	
2.4.30	Provide one push button-type isolation valve for all pressure gauge /pressure switch	Vendor to Confirm	
2.4.31	Forced Draught (FD) Fan:	Vendor to Confirm	
a)	FD Fan with VFD of suitable capacity (including excess air) has to be provided to ensure proper combustion and controlled cooling (whenever required)	Vendor to Confirm	
b)	Air flow –Calculation details to be submitted with the offer	Vendor to Specify	
c)	Air Pressure	Vendor to Specify	
d)	Power Rating (KW)	Vendor to Specify	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.4.32	Induced Draught (ID) Fan & Dilution Fan:		
a)	ID Fan and Dilution fan of suitable capacity with VFD has to be provided before the stack to ensure proper combustion and controlled cooling (whenever required)	Vendor to Confirm	
b)	Air flow –Calculation details to be submitted with the offer	Vendor to Specify	
c)	Air Pressure of ID fan	Vendor to Specify	
d)	Air Pressure of Dilution fan	Vendor to Specify	
e)	Power Rating (KW) of ID fan	Vendor to Specify	
f)	Power Rating (KW) of Dilution fan	Vendor to Specify	
2.4.33	Type of all Blower/Fan	Centrifugal	
2.4.34	Make of all Blowers- C-Doctor/ Patel / Flakt India or any other make acceptable to BHEL.	Vendor to Specify.	
2.4.35	The FD Fan and ID Fan have to be suitably sized to ensure a Balanced Draught System. Drive mechanism for FD and ID fans should be of belt drive.	Vendor to confirm	
2.4.36	A standby fan with motor each for the FD, ID & Dilution fan system has to be provided.	Vendor to confirm	
2.4.37	Bell mouth (Silencer) inlet to be provided on the suction side of FD, ID & Dilution fans	Vendor to confirm	
2.4.38	Suitable filter to be provided on the suction side of FD, ID & Dilution fan. Vendor must provide suitable handling facility for cleaning the filter element by ONE person.	Vendor to confirm	
2.4.39	All the motors used for the fans shall be of Energy efficient (EFF1) class conforming to IEC/IS standards. All blower motors should be with VFD drive. VFD drive should be of SIEMENS (preferably Sinamics) / YASKAWA/ ABB /ALLEN BRADLEY/MITSUBHISHI makes only.	Vendor to confirm & specify	

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2.4.40	<p>All the Fans (FD, ID & Dilution) should comply with the following construction / performance</p> <ol style="list-style-type: none"> 1. Impeller blades are to be fully welded. 2. Availability of sufficient strengthening stiffeners in the body / support structure of the blower. 3. Noise level: Max. 85 ± 3 dBA @ 1.5 meter distance 4. Vibration level: As per ISO-14694. Up to 4.8 mm/sec (RMS) with foundation 5. Dynamic balancing of impeller at rated speed. 	Vendor to confirm	
2.4.41	Dampers :		
a)	Damper has to be provided before the stack in the flue gas path to regulate draught	Vendor to confirm	
b)	The damper has to work on auto mode and its opening should get adjusted automatically depending upon the draught required in the furnace (positive).	Vendor to Confirm with details	
c)	Provision should be there to operate the damper in manual mode also.	Vendor to confirm	
2.5	<p>Refractory Lining: (For Shell and doors) Ceramic fiber block modules / monolane system with back up layer of suitable density and thickness (conforming to ASTM-892 C-1993) to ensure that the skin temperature of the furnace does not exceed 80 deg C; the anchor material should be SS310.</p> <ol style="list-style-type: none"> 1. (Vendor to furnish calculations for choice of insulation material and Data sheet of the insulating materials) 2. The supplier shall provide MSDS for all refractory material (including ceramic wool) – It shall cover “cradle to grave”. 3. The supplier shall indicate the applicability of the ceramic material under Hazardous Wastes (Management, Handling and Tran’s boundary Movement) Rules, 2008. 	Vendor to Specify	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.5.1	Size of Ceramic Fiber Block Modules/ Monolane system (Size should be under the standard manufacturing range of the supplier)	Vendor to Specify	
2.5.2	Density	Vendor to specify	
2.5.3	Thickness	Vendor to Specify	
2.5.4	Maximum Service Temperature	Vendor to specify	
2.5.5	Make: M/s MMTCL or M/s Unifrax only	Vendor to confirm	
2.5.6	Size of Back up Blanket layer / Monolane system (Size should be under the standard manufacturing range of the supplier)	Vendor to Specify	
2.5.7	Density	Vendor to specify	
2.5.8	Maximum Service Temperature	Vendor to specify	
2.5.9	Thickness	Vendor to Specify	
2.5.10	Make: M/s MMTCL or M/s Unifrax only	Vendor to confirm	
2.6	Furnace hearth :		
2.6.1	Side walls are to be constructed with the combination of hard refractory & Insulation brick (Shaped bricks) with Calcium silicate board backup for suitable thickness and leveled equal to the top of bogie refractory. The shaped brick combination between the bogie and the hearth should ensure good thermal sealing between them.	Vendor to Confirm	
2.6.2	Make of Hard refractory materials: M/s ACE, M/s Maithan refractories, M/s TATA refractories, M/s Corborundam Universal or any other make acceptable to BHEL. (Relevant data sheets to be submitted in the offer)	Vendor to confirm	
2.6.3	The peripheral refractory has to be held and supported by a set of heat resisting castings, conforming to IS 4522, Grade-11	Vendor to Confirm	
2.7	Burner blocks: 90% High Alumina or SIC material	Vendor to Confirm	
2.8	Furnace Door: One front door with vertical up/down for open/close.	Vendor to Confirm	
2.8.1	Number of Doors: ONE	Vendor to Confirm	
2.8.2	Operation: Vertical	Vendor to Confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.8.3	Drive: Electric drive with Speed reduction Gear Box, Electromagnetic Brake etc. for the door at ground level	Vendor to confirm	
2.8.4	Pneumatic door locking arrangement along with mechanical lock arrangement has to be provided to press the door against door opening in its closed position. (Complete details should be furnished with the offer)	Vendor to confirm	
2.8.5	All Pneumatic elements used shall be of FESTO/ SMC or any other make acceptable to BHEL.	Vendor to confirm	
2.8.6	BHEL will provide air supply at a pressure of 6 bar only at one point near the furnace. Vendor to provide suitable air drier, filter, regulator, air booster etc for controlling the required air pressure for the pneumatic system.	Vendor to confirm and provide details	
2.8.7	Provision should be made on the door for sand sealing at bottom in the bogie in closed position of the door. (Complete details should be furnished with the offer)	Vendor to confirm	
2.8.8	The periphery of the door has to be designed suitably so that positive sealing is established between the furnace and the door in closed position.	Vendor to confirm	
2.8.9	In the unlocked position, and while lifting the door, it should move away from the furnace opening and move up without interfering on any furnace structure.	Vendor to confirm	
2.8.10	Interlock should be provided so that bogie can be operated only when door is completely open.	Vendor to confirm	
2.8.11	All the pneumatic equipment and interlock elements are to be suitably protected from failure due to heat from the furnace	Vendor to confirm	
2.8.12	Steel construction with ceramic fiber modules / Monolane system lining inside and a set of heat resisting grey cast iron castings, conforming to IS 4522, Grade-11 around the periphery of the door and with suitable counter balance arrangement	Vendor to Confirm	
2.8.13	The counter weight arrangement should be provided on the sides of the door. The counter weight should be positioned in a cage and should be properly guided inside the cage on either sides of the door.	Vendor to Confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.8.14	Vendor to provide suitable interlock for low firing at door open condition and high fire only after closing the door. Provision to override the interlock manually can also be provided.	Vendor to Confirm	
2.9	Furnace Construction (General) :		
2.9.1	The complete furnace structure including the sidewalls and roof are to be manufactured from rolled steel plates and sections of suitable thickness (Minimum 10mm for side walls and minimum 8 mm for roof) (Complete details should be furnished with the offer)	Vendor to confirm	
2.9.2	The various load bearing members are to be designed conservatively to ensure rigidity of the complete casing.	Vendor to confirm	
2.9.3	A schematic diagram showing the layout of the furnace & associated systems with salient dimensions should be furnished along with the offer	Vendor to confirm	
2.10	RECUPERATOR:		
2.10.1	The recuperator shall be of multi tubular metallic construction with counter flow, convective heat transfer arrangement. Material of construction shall be SS310 hot face and SS304 cold face. (Complete details of construction should be furnished with the offer)	Vendor to confirm	
2.10.2	Recuperator has to pre-heat the air to about 350 Deg.C. Thermal calculation to be submitted with the offer. Recuperator bypass with suitable valves to be provided	Vendor to confirm	
2.10.3	The recuperator has to be located suitably in the flue gas path above the ground	Vendor to confirm	
2.10.4	On line indication of inlet, exit temp of air and flue gas to be available.	Vendor to confirm	
2.11	FLUE DUCT:		
2.11.1	Flue duct Position (Suitably insulated preferably with hard refractory). Flue duct routing to be considered on top/rear/side suitably to ensure high furnace efficiency and to maintain uniform temperature inside the furnace; Flue duct routing below the ground level is not acceptable.	Vendor to specify	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.12	STACK :		
2.12.1	Furnace is located inside the shop. So the routing/design of stack for flue gas outlet to take care for passing the stack through the roof. The stack for flue gas outlet has to be designed and constructed with suitable insulation and venture suitably to leave the waste gas at a lowest temperature without dilution. Vendor to provide details.	Vendor to specify	
2.12.2	Stack design should consider the following points <ul style="list-style-type: none"> • The stack will be located approximately at the centre of shop columns and will be passing through the roof • The width/dia of the stack portion located between the columns and passing through the roof should not be more than the width of the column (around 1.2m) • Proper supports for exhaust duct and stack to be provided 	Vendor to provide details	
2.12.3	Chimney/stack height shall satisfy the requirements of Maharashtra Pollution Control Board (MPCB) norms with respect to emission of SO _x ; NO _x and Suspended Particulate Matter (SPM). The guidelines to calculate the chimney height is as follows: $H = 14 (Q)^{0.3}$ Q - SO _x emission rate in Kg/hr; H - Height of stack in meters from ground level. However the chimney/stack shall have a height arrived at by the above formula or 25m(passing through the roof) whichever is higher.	Vendor to confirm	
2.12.4	Four port holes at 90 deg shall be provided at two different elevations around the stack. Each porthole shall be of 100 mm inner diameter, welded with a standpipe 100 mm long fixed with a flange and bolted with a dummy plate. Vendor to specify the height/elevation of port holes based on pollution control	Vendor to Confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	norms. The exact height/elevation shall be decided during technical discussion. Vendor to confirm		
2.12.5	<ul style="list-style-type: none"> Vendor to provide ladder with hand rails to reach both the sampling points/platforms. Platform with toe guard to be provided all around the chimney 1m below the sampling plane preferably. Safe Approach/accessibility to reach the top of the chimney to be provided. 	Vendor to provide details of arrangement	
2.12.6	The stack shall be provided with a weather cowl and red indicating lamp for high rise structure. The lamp should be able to withstand high temperatures of the exhaust/flue gases.	Vendor to Confirm	
2.12.7	The stack shall be provided with complete lightning arrester system including lightning arrester spike, copper conductor tape from spike to test link, test link, earth pit as per Indian standards	Vendor to Confirm	
2.12.8	Exit temperature, Oxygen, SPM (in mg/cu.m), SPM (Microns), SO _x ; NO _x ; CO; flue gas velocity at the outlet tip of the chimney	Vendor to Specify	
2.12.9	The demonstration (proving) of the parameters as per 2.12.8 is in the scope of vendor. Necessary calibrated measuring instruments used for this purpose is in the scope of the supplier. Emission certificate conforming to MPCB norms from authorized body/lab to be provided by the supplier after commissioning the furnace.	Vendor to Confirm	
2.13	FURNACE BOGIES:		
2.13.1	Number of Bogies: One	Vendor to Confirm	
2.13.2	Bogie Dimension a) Width 4500mm approx --- Vendor to specify b) Length 8500 mm approx --- Vendor to specify		
2.13.3	The bogie to be driven by fabricated rack (Pin type) and pinion arrangement motorized with reduction units, couplings and electromagnetic brakes. (Complete details should be furnished with the offer)	Vendor to specify	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.13.4	The complete bogie with refractory to be supported on the set of cast wheels through trolley arrangement - one set of guided wheels (essential) and others - plain wheels 90 lbs parallel rails shall be supplied and erected by supplier.	Vendor to Confirm	
2.13.5	The bogie should be able to be moved out sufficiently for carrying out the maintenance work.	Vendor to Confirm	
2.13.6	Bogie speed	Vendor to specify	
2.13.7	The Bogie refractory has to be constructed with the combination of IS 8 quality firebricks and Insulation bricks for suitable thickness backed by calcium silicate board and ensure that the skin temperature does not exceed 80 deg.C (Complete details with calculation should be furnished with the offer)	Vendor to Confirm	
2.13.8	Around the periphery, special shaped bricks of IS 8 quality have to be positioned. The combination of the shaped bricks in bogie and the hearth should ensure good thermal sealing between them.	Vendor to Confirm	
2.13.9	Heat resisting grey iron castings confirming to IS 4522 - Grade-11 has to be positioned around the periphery of the bogie to support the refractory.	Vendor to Confirm	
2.13.10	The bogie castings shall be of min. 20 mm thick at the base and 16 mm thick on the sides and the width of the base must be more than that of the side.	Vendor to Confirm	
2.13.11	Double Sand sealing has to be provided between bogie and the furnace hearth and it should be ensured that the alignment should not fail due to heat transfer. Complete sand sealing castings shall confirm to IS 4522 - Grade-11	Vendor to Confirm	
2.13.12	The peripheral bottom of the furnace hearth has to be lined with special shaped bricks to match with the shaped bricks on the bogie periphery.	Vendor to Confirm	
2.13.13	The bogie is to be manufactured from rolled steel sections and plates of suitable thickness (Min 10mm). (Complete details should be furnished with the offer)	Vendor to Confirm	
2.13.14	The Bogie structure has to be designed to give minimum deflection under different load conditions.	Vendor to Confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.13.15	It should be ensured that all the wheels share the load uniformly.	Vendor to Confirm	
2.13.16	The wheels are to be mounted on antifriction sealed bearings through non-rotating axles in such a way that heat transfer from bogie structure to the bearings is reduced to the minimum.	Vendor to Confirm	
2.13.17	KW Rating of Bogie Drives	Vendor to specify	
2.13.18	All the Castings in the furnace shall be fixed with respective structures using SS-304 bolts of min. M16 size.	Vendor to Confirm	
2.13.19	All the gear boxes used in the furnace shall be of standard size and of reputed makes of Greaves / Shanthi gears / Radicon / Elecon/Premium or any other make acceptable to BHEL.	Vendor to Specify	
2.14	PIPELINES & VALVES		
2.14.1	BHEL will provide LPG(Propane+Butane)/Propane at one point near the furnace. All piping for LPG(Propane+Butane)/Propane to the furnace gas control valves and to other points is in the scope of the vendor. 1.5 to 2Kg/cm ² Regulator to be provided at the start of the Gas train system for fine tuning.	Vendor to Confirm	
2.14.2	All air piping from the fans to the control valves and to other points is in the scope of the vendor	Vendor to Confirm	
2.14.3	Required valve for control of gas and air is in scope of the vendor	Vendor to Confirm	
2.14.4	All hot air pipe lines to be insulated with LRB mattress and aluminium sheet of suitable thickness.	Vendor to confirm	
2.14.5	All the pipe lines to be installed above ground level	Vendor to confirm	
2.14.6	Make of Gas and Air valves used shall be of Kromschroder/Samson Mumbai/IL Palghat/MIL Chennai/ Fouress Bangalore/Fisher Xomas Chennai/ Eclipse/Dungs/ Audco/ Flowjet	Vendor to Specify	
2.14.7	Gas valves, air valves & field instruments in gas line must be fire proof as per NFPA.	Vendor to confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.15	ELECTRICAL :		
2.15.1	Tropicalization : All electrical / electronic equipment shall be tropicalized.	Vendor to Confirm	
2.15.2	All Electric enclosures shall have IP 54 protection	Vendor to Confirm	
2.15.3	All electrical components in the cabinets should be mounted on DIN Rail	Vendor to Confirm	
2.15.4	415V +/- 10%, 50HZ +/-3 Hz, 3 Phase AC (3 wire system without neutral) power supply will be provided by BHEL at a single point near the furnace in the control room, as per layout recommended by Vendor.	Vendor to Confirm	
2.15.5	All cables, connections, circuit breakers etc. required for connecting BHEL's power supply point to different parts of the equipment/control cabinets, shall be the responsibility of vendor. All cables should be of copper only.	Vendor to Confirm	
2.15.6	Requirement of grounding/earthing with required material details should be informed by vendor well in advance so that it could be incorporated during construction of foundation. BHEL will provide earth pits at pre-designated locations. Vendor has to make all required connections to the earth pit. Separate earthing should be provided for main power panels, Burner control panels and Chimney lightning arrester, each to be terminated at individual earth pits. Earth flats should be GI (25 mm X 3 mm). Appropriate length GI flats for earthing are vendor's scope.	Vendor to Confirm	
2.15.7	All electrical and electronic panels including operator's panel should be provided with fluorescent lamps for sufficient illumination and power receptacles of 220 Volts, 5/15 Amp AC. All adapters / receptacles should have compatibility with Indian equivalents. All single phase power supply/control voltage should be 230 V, 50 Hz.	Vendor to Confirm	
2.15.8	Motors & other electrical components shall conform to IEC or Indian Standards. Motors shall be of energy efficient (EFF1) and makes of ABB / Siemens / Kirloskar / Bharat Bijlee / Hindustan / Crompton Greaves / NGEF or any other make acceptable to BHEL.	Vendor to Specify	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
2.15.9	All the metallic cable trays required for lying of cables should be included in the offer.	Vendor to Confirm	
2.15.10	Vendor should ensure proper earthing for the furnace and its peripherals.	Vendor to Confirm	
2.15.11	All electrical components like contactors and OLRs etc., should be of BCH/Siemens/ Telemecanique /L&T/ SCHNEIDER/GE make and VFD for fans shall be of SIEMENS (preferably Sinamics)/ YASKAWA /ABB/ / ALLEN BRADLEY/MITSUBHISHI make. The VFDs shall take reference from PLC output (4-20mA) to ensure controlled and efficient blower operation during furnace heating and cooling cycles.	Vendor to specify	
2.16	JOB SUPPORTS:		
	<ol style="list-style-type: none"> 1. The job supporting structure shall be in the form of a Grid spread over the Bogie surface. 2. The grid shall be fabricated from Stainless steel of sufficient thickness to have enough strength which can with stand the max furnace temperature. 3. Minimum thickness of section not less than 25 mm and height 80 mm shall be used for fabrication of grid. 4. The pocket size of the matrix shall be around 450x450 mm. 5. The whole bogie surface can be covered by three such grids along the length of the bogie. <p>Any other better design of Job supports which is capable of resisting deformation at high temperature is also welcome from the vendor and that is subject to analysis & approval by technical committee during evaluation of the offer.</p>	Vendor to confirm	
3.0	SAFETY ARRANGEMENTS:		
3.1	Following safety features in addition to other standard safety features should be provided on the machine:		

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
3.2	Furnace should have adequate and reliable safety interlocks / devices to avoid damage to the furnace, work piece and the operator due to the malfunctioning or mistakes. Furnace functions should be continuously monitored and alarm / warning indications through lights/ alarm number with messages on panel should be available.	Vendor to specify	
3.3	A detailed list of all alarms / indications provided should be submitted by the Vendor.	Vendor to specify	
3.4	All the pipes, cables etc. should be well supported and protected.	Vendor to Confirm	
3.5	All the rotating parts should be statically & dynamically balanced to avoid undue vibrations and suitably guarded.	Vendor to Confirm	
3.6	3 emergency switches to be provided to switch off the whole furnace for safety purpose. The locations are 1. In control Panel 2. Either side of the furnaces.	Vendor to Confirm	
3.7	6 Nos Gas leak detector to be provided to cover critical gas leak zone. The system should have independent control with alarm. Alarm should be clearly visible in the furnace control room. Vendor to provide the test certificate with LPG(Propane+Butane)/Propane sample for LEL as per standard. Functional test with same sample to be done after commissioning of the instruments at site. Supply of standard sample gas is under vendor's scope. Ambetronics/Oldham makes gas leak detectors or any other make acceptable to BHEL is preferred.	Vendor to Specify	
4.0	INSTRUMENTATION & CONTROL SYSTEM :		
4.1	All controls will be located in a Control Room (with A.C) adjacent to the furnace. BHEL will construct the Control room based on inputs to be provided by the vendor.	Vendor to Confirm	
4.2	Furnace temperature control : PLC-PC based instrumentation with SCADA software system shall be provided for control of the furnace. The PLC-PC based system shall be based on Redundant system with Master and Slave configuration. It operates through a Personal computer and suitable SCADA software. The control loop with auto tuning	Vendor to specify	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	function to be constituted within the PLC through intelligent software. Suitable interface, required software, programming device to upload, download for PLC program changing in future or up gradation of PLC version. Upgrade software to be supplied by the Vendor. The system to monitor furnace parameters on the SCADA screen, enhanced interlocks for safety of furnaces and process level of furnace automation, continuous and efficient data logging and archiving etc to be provided. Preferable make of the PLC is ABB, Allen Bradley, Siemens. Suitable PC is under the scope of the vendor. Technical specifications of the PC should be submitted by vendor (makes: Dell/Acer/HP or any other make acceptable to BHEL).		
4.3	Furnace over temperature control to be made available at control panel only.	Vendor to confirm	
4.4	Recuperator protection for preheat temperature control.	Vendor to confirm	
4.5	The system shall comprise, but not be limited to the following:		
4.5.1	Zonal Thermocouples: 2 Nos. of Duplex thermocouples to be provided per zone. One thermocouple for temperature controller, second for excess temperature controller 3rd for recorder and 4th as a spare. Thermocouple type-k with protective sheath to be 1 meter long of inconel with adjustable flange. Asbestos compensating cables to be provided for heat resistance.	Vendor to confirm	
4.5.2	K- type Compensating cables of the Temperature recorder to be wired from the control panel to 6 location of each side wall of the furnace for material temperature measurements. Holes for thermocouples to be provided in between the burners at suitable locations approved by BHEL. Thermocouples to be provided by vendor. Supply of suitable length of compensating cables from these locations to the recorder is also in vendor's scope	Vendor to confirm	
4.5.3	Suitable rated modulating motors / Control elements for all the Zones	Vendor to confirm	
4.5.4	Mass flow-based and Pulse firing-based zonal control system for temperature control to be offered. This has been indicated in 2.4.11	Vendor to confirm	
4.5.5	24 Point Micro Processor based temperature recorder with chart width 180 mm along with 50 nos. of chart paper packs.	Vendor to confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	Make: Yokogawa, Eurotherm and Chino.		
4.5.6	Pressure switches with isolation valves, flow transmitters with manifold valves for gas, air and control elements with suitable markings for easy observation of position of the valves to be provided.	Vendor to confirm	
4.5.7	Furnace pressure transmitters and control elements with P&I diagram should be submitted.	Vendor to confirm	
4.5.8	Instruments cables and compensating cables are to be separated from power cables. All cables should be of FRLS design only.	Vendor to confirm	
4.5.9	Piping lines for instruments to be provided with clamps and neatly routed	Vendor to confirm	
4.5.10	Metal Junction boxes with suitable terminal blocks and glands to be provided. All the wires should be with marked ferrules for easy identification both in the control panel and for the field instruments	Vendor to confirm	
4.5.11	Suitable rating UPS with battery to be provided for the Instrument panel, PC and recorder with a minimum backup of 1 hour. Makes: Emerson/APC/Microtek or any other make acceptable to BHEL.	Vendor to confirm	
4.5.12	Any other requirement to complete the system.	Vendor to specify	
4.6	Possibility of over viewing the status in the control room.	Vendor to Confirm	
4.7	For excess temperature control of respective zone, it should be possible to set the limit value of each zone in the Control panel. In case the zonal temperature overshoots the maximum set value, it should control all safety systems along with raising audio visual alarm.	Vendor to Confirm	
4.8	Other features required:		
	a) Alarm annunciation (including LPG(Propane+Butane)/Propane leak)	Vendor to Confirm	
	b) Gas flow measuring system: Orifice type volumetric flow measurement with totalizer to be indicated in the control panel and SCADA	Vendor to Confirm	
	c) Safety system and alarm indication required are to be indicated.	Vendor to Confirm	
4.9	Required Motor Control Centers shall be provided for control of all fans and blowers (This point should be separated from instrumentation and control)	Vendor to confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
4.10	Gas Train System details to be given for all the components with P and I diagram Suitable pressure gauge with isolation valve to be provided in the inlet and outlet of the gas train system. An additional pressure gauge in the gas train system after the main safety valve will be provided. All the field instruments in the gas line should be of flame proof enclosure	Vendor to Confirm	
4.11	Burner purge cycles with adequate purging time for safe operation shall be provided.	Vendor to Confirm	
4.12	Manual Gas Shut Off Valve shall be provided apart from the safety shutoff valve in the gas train.	Vendor to confirm	
4.13	Push button Control Station shall be provided near the furnace for all manual operations (door movement, bogie movement & door locking)	Vendor to confirm	
4.14	Local emergency push button stations shall also be provided for bogie drive, ID fans, FD fans, Dilution fans and door drives	Vendor to Confirm	
4.15	Maintenance platform at suitable height for instrumentation to be provided	Vendor to confirm	
4.16	Instruments Calibration: Calibration certificates to be provided for process values measuring instruments, Transmitters, Thermocouples and compensating cables. Test certificates required for Pressure switches and modulating motors etc. are to be provided at the time of inspection of the furnace at vendor works. Vendor has to carry out re-calibration for all the above calibrated items at BHEL site during commissioning. After placement of order vendor has to provide the Calibration certificate and test certificate as per BHEL format.	Vendor to confirm	
4.17	Ignition & Flame Supervision: Spark igniter of high voltage type (H.V) to be used. The flame monitoring system to be with Ionization Sensor/U.V. scanner for its reliability. In case of U.V Scanner, it must be provided with suitable air cooling. The flame supervision circuit is linked to the gas solenoid valve for each burner. This enables to monitor and control the flame of each burner continuously through PLC.	Vendor to specify	

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4.18	O₂ ANALYZER: (Optional) High temperature Oxygen analyzer shall be quoted as optional in the supply. It shall be capable of withstanding temperature in the range of 1250 to 1300 deg C. This Analyzer will be installed in the furnace atmosphere and should display the Oxygen level on the monitor. Vendor to provide details and specifications of the offered model in the offer.	Vendor to Confirm & Provide details.	
5.0	LEVELLING & ANCHORING SYSTEM		
5.1	Complete anchoring system including foundation bolts, anchoring materials, leveling shoes etc should be supplied by the supplier	Vendor to Confirm	
6.0	TOOLS FOR ERECTION, OPERATION & MAINTENANCE:		
6.1	Vendor shall bring special tools required for erection of the Furnace, Tools like Torque Wrench, Keys, Spanners, and Grease Guns etc. for Furnace operation & maintenance tools shall be supplied & list shall be submitted with offer. EOT crane service inside the shop floor for erection will be provided by BHEL. Any Mobile crane arrangements for erection of furnace and its other components are under supplier's scope.	Vendor to Confirm	
7.0	SPARES :		
7.1	Itemized breakup of mechanical, pneumatic, electrical, electronic and Refractory spares used on the furnace in sufficient quantity as per recommendation of Vendor for 2 years of trouble free operation on three shifts continuous running basis should be offered by vendor. The list to include following, in addition to other recommended spares : (Unit Price of each item of spare should be quoted)	Vendor to Confirm	
7.2	Following spares to be quoted compulsorily a. Burner -- 20% of total quantity b. Burner Blocks -- 20% of total quantity c. Gas Solenoid Valve for burners-- 20% of total quantity d. UV Flame Detector/Ionization sensor--20% of total quantity e. Thermocouple-duplex -- 4 Nos. f. Flow transmitter for gas: 1 No.	Vendor to Confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	<p>g. Flow transmitter for air: 1 No. h. Pressure switch for gas: 1 No. i. Pressure switch for air: 1 No. j. Furnace Pressure transmitter: 1 No. k. Actuator for gas: 2 No. l. Actuator for air 2 No. m. Seal kit for pneumatic cylinder: 1 Set. n. PLC analog input module: 1 No. o. PLC analog output module: 1 No. p. PLC digital input module: 1 No. q. PLC digital output module: 1 No. r. PLC thermocouple module: 1 No. s. PLC power supply unit: 1 No. t. Indication lamp : 1 Set u. Limit switches: 4 Nos. v. Ribbon cartridge: 3 Nos. w. Excess temp controller: 1no. x. All type of Air valves: 10% of quantity in each type used in the furnace y. All type of Castings: 10% of quantity in each type used in the furnace z. All type of Gas valves: 10% of quantity used in the furnace aa. All types of refractory bricks (Standard bricks and special shaped bricks): 10% of quantity each used in the furnace bb. All types of ceramic fiber modules and blankets used in the furnace: 10% of quantity in each type(max. temp and density) used in the furnace cc. Couplings used in door and bogie drive assembly – 1No each dd. Plummer block with bearing of each type used in the furnace – 1set. ee. Pneumatic valves – 1no of each type ff. Gas filter – 1 no gg. Gas filter element – 5 no's hh. GVT line Pressure Regulator – 1 no</p>		

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	ii. Chain used in bogie drive – 1no jj. Bogie drive gearbox with motor – 1set kk. Gas leak detector – 1 no ll. Burner Controllers –20% of total Qty		
7.3	Vendor to confirm that complete list of spares for machine and accessories, along with item part no / specification / type / model, and name & address of the spare supplier shall be furnished along with documentation to be supplied with the machine.	Vendor to Specify	
8.0	DOCUMENTATION		
8.1	Documents to be submitted along with offer for technical Evaluation:		
8.1.1	<p>The vendor to submit the following drawings / details along with offer for technical evaluation:</p> <ol style="list-style-type: none"> 1. P&I Diagram with bill of materials 2. General Arrangement diagram 3. Schematic Instrument circuit diagram 4. Electrical circuit diagram (power and control circuit) with detailed BOM 5. Electrical component layout drawings of all control panels and operator pendants. 6. Heat load calculation 7. Furnace efficiency calculation 8. Complete list of components in Each Burner Assembly 9. Burner capacity selection method 10. LPG(Propane+Butane)/Propane consumption in Nm3/hr under following conditions, which shall be verified at the time of commissioning: <ol style="list-style-type: none"> a) at No load after soaking for 3 hrs at maximum furnace temperature. b) at 50% load and operating the furnace for one complete cycle from start to end of soaking cycle. 11. Burner arrangement layout drawing. 12. Drive arrangement drawings for Bogie drive & door drive with bill of materials. 13. Counterbalance & door locking arrangement drawing 	Vendor to enclose	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	14. FD, Dilution & ID Fan calculation 15. Refractory arrangement with Bill of materials 16. Casting arrangements. 17. Recuperator selection and heat transfer calculation. 18. Piping routing diagram 19. Quality action plan 20. MSDS for all insulation and refractory items used in the furnace. 21. Panel layout 22. Pneumatic Circuit with bill of materials. 23. Job support pedestal drawing.		
8.2	Documents to be submitted for BHEL approval before manufacturing:		
8.2.1	The vendor to submit the following drawings / details for BHEL approval before manufacturing (drawing should be submitted for approval within 1 month of placing PO and approval of drawings should be obtained by vendor within 30 days from the date of submission of drawings to BHEL for approval by providing required details/clarifications by BHEL if any): <ol style="list-style-type: none"> 1. P&I Diagram with bill of materials 2. General Arrangement diagram 3. Schematic Instrument circuit diagram 4. Electrical circuit diagram (power and control circuit) with detailed BOM 5. Electrical component layout drawings of all control panels and operator consoles 6. Heat load calculation 7. Furnace efficiency calculation 8. Skin temperature calculation 9. Complete list of components in Each Burner Assembly 10. Burner capacity selection method 11. LPG(Propane+Butane)/Propane consumption in Nm³/hr under following conditions, which shall be verified at the time of commissioning: <ol style="list-style-type: none"> a) at No load after soaking for 3 hrs at maximum furnace temperature. 	Vendor to confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	b) at 50% load and operating the furnace for one complete cycle from start to end of soaking cycle. 12. Burner arrangement layout drawing. 13. Drive arrangement drawings for Bogie drive & door drive with bill of materials. 14. Counterbalance & door locking arrangement drawing 15. FD, Dilution & ID Fan calculation 16. Refractory arrangement with Bill of materials and special shaped brick drawings 17. Casting arrangements and casting drawings. 18. Panel layout 19. Pneumatic Circuit with bill of materials. 20. Job support pedestal drawing. 21. Quality plan. 22. Recuperator selection and heat transfer calculation 23. Piping routing diagram 24. MSDS for all insulation and refractory items used in the furnace.		
8.3	Documents to be submitted along with Equipment:		
8.3.0	Three sets of O&M manuals (3 Hard copies) in English language having the following documents should be supplied along with the furnace. Apart from the hard copies, vendor to provide the entire documentation in a single PDF including the catalogues of all bought items and the same shall be provided in a pen drive.	Vendor to confirm	
8.3.1	The O&M Manual should contain the following	Vendor to confirm	
A	One copy of ALL approved drawings		
B	P&I Drawing of furnace		
C	Electrical Wiring Drawings – Power & Control Circuits		
D	Terminal drawings with check points shall be provided for Electronic Controls		
E	Trouble Shooting Chart for Main and all Sub-Systems		

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
F	Specifications, Catalogues, O&M Manuals and Engineering manuals of all bought out items including drawings, wherever applicable.		
G	All Mechanical drawings for the items manufactured / covered under scope of vendor. Mechanical drawing includes GA & Sub-assembly drawings with major and critical dimensions, material and weight.		
H	Furnace Operation Procedure for startup, purging, shutdown, Power failure interruption, Gas fluctuation condition, etc. with all safety instructions. PLC ladder diagrams (both in hard and soft copy), Additional licensed software for SCADA should be provided.		
I	Complete refractory lay out and shaped brick drawings with dimensions, including specification of refractory materials used.		
J	Complete Casting lay out and individual casting drawings with dimensions, including specification of casting materials used.		
K	Drive arrangement drawings for Bogie drive & door drive with bill of materials including specification of materials used.		
L	Counterbalance and door locking arrangement drawings for door with bill of materials including specification of materials used.		
M	Bogie sealing, Door sealing arrangement drawings.		
N	Complete details of Combustion system- Operation and maintenance.		
O	Complete Master List of spare parts used along with item part number/ specification/ type, name and address of the spare supplier		
P	Calibration certificates for all the Panel instruments, Transmitters, Flow meters, Thermocouples and test certificates for Pressure switches, modulating motors and regulators.		
Q	Complete Printed Circuit Board Schematics indicating check points (Test Points) for Electronic Controls.		
R	Complete calculations for heat load, skin temperature, burner selection, FD fan selection, refractory selection, efficiency, fuel consumption, etc.		

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
S	Panel layout with details for panel size, Painting, Cable entry, etc. Details and specification for contactor, MCB, Push buttons, OLR, Indication lamps, ON/OFF rotary switches, Isolators, selector switches, safety devices, etc to be provided.		
T	List of all alarms / indications / annunciator.		
U	The vendor shall submit complete Master List of parts used in the machine.		
8.4	One set of all the documents (hard copy and soft copy) to be shown to the BHEL inspector at the time of inspection at vendor's works.	Vendor to confirm	
9.0	TRAINING:		
9.1	The Vendor shall impart training to BHEL's Operators and Maintenance crew in Operation and Maintenance (Mechanical, Electrical / Electronics and Control system) after the commissioning of the Machine at BHEL works for not less than 15 working days	Vendor to confirm	
10.0	FOUNDATION:		
10.1	Vendor shall submit the preliminary foundation drawing of furnace, blowers, chimney , bogey and static and dynamic load for getting BHEL's approval within one month from the date of Ordering. The layout should consist of all requirements pertaining to complete furnace including space requirement for Control Room, Blowers, and Stack, Rails etc. BHEL shall design and construct complete foundation for the furnace as per the Vendor's recommendation. Supplier is requested to confirm the leveling of rails for bogie along with BHEL at site during execution of civil foundation.		
11.0	ERECTION & COMMISSIONING		
11.1	Vendor to take full responsibility for carrying out the erection, start up, testing & commissioning of the furnace & its control & all types of other supplied equipment. The Vendor shall arrange manpower & tools for the same	Vendor to Confirm	
11.2	Service requirement like power, air & water shall be provided by BHEL at only one point to be indicated by Vendor in their foundation/layout drawings free of cost. Fabrication requirements like gas, three phase welding machine, welding electrodes and mobile crane at site are in the scope of vendor. Welding electrode used for Mild Steel should be of 7018 grade and for other alloy	Vendor to Confirm	

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
	materials & pipeline welding suitable grade electrodes acceptable to BHEL should be used.		
11.3	Successful proving of BHEL components by the Vendor shall be considered as part of commissioning. All tests, as mentioned in clause 12.0 (Furnace Acceptance) shall form part of the commissioning activity.	Vendor to confirm	
11.4	The Vendor should bring tools, Tackles and other necessary equipment required to carry out all above activities.	Vendor to confirm	
11.5	The Vendor shall bring commissioning spares required for commissioning of the machine within stipulated time	Vendor to Confirm	
11.6	Schedule of Erection and Commissioning shall be submitted with the offer	Vendor to Confirm	
11.7	Vendor should furnish charges, duration, terms & conditions for E & C in detail separately along with offer.	Vendor to Confirm	
12.0	FURNACE INSPECTION & ACCEPTANCE		
12.1	Inspection at Vendor's works: The furnace materials and bought-out items shall be offered for inspection to BHEL for completeness of supply at supplier's works prior to dispatch.	Vendor to Confirm	
12.1.1	Complete sub-systems as per the contract - verification of functions to the extent possible.		
12.1.2	Blowers (FD, Dilution & ID fans) to be offered for checking the performance. If required it shall be offered at blower supplier's works.		
12.1.3	Verification of Calibration certificates of instruments.		
12.1.4	Verification of Documents as per clause (8.4)		

S.No.	DESCRIPTION	PARAMETERS	BIDDER'S OFFER
12.2	<p>Inspection at BHEL Works After erection of the furnace, the furnace shall be tested by the vendor for its performance prove-out as per BHEL Specifications as follows: 1. Air leak test at 6 bar pressure for all gas and air lines (no leak permitted)</p> <p>The furnace should be tested and proved for 2 cycles in each of following category and as per condition stated in clause 12.2.1.</p> <p>1. Solution annealing (Max soaking temperature 1150 deg C) 2. Normalizing & Tempering (Max soaking temperature 1070 degC)</p> <p>The heat treatment charts have to be approved by BHEL.</p>		
12.2.1	Verification of Calibration certificates of instruments.		
12.2.2	Verification of Control logic for all functions by simulation.		
12.2.3	Verification of Pollution control norms, skin temperature, etc.		
12.2.4	Verification of Documents as per clause (8.3.1)		
13.0	PAINTING:		
13.1	For Furnace, Recuperater & Bogies & Stack		
13.1.1	Primer painting: One coat of primer painting at vendor's works and one coat of primer after erection	Vendor to Confirm	
13.1.2	Final painting: Vendor to paint the complete furnace chamber with 2 coats of heat resistant Al paint (of grade 250 deg C) and the entire chimney, recuperator & flue path with 2 coats of heat resistant Al paint (of grade 600 deg C).	Vendor to Confirm	
13.2	For Fans, Control Panel : Two coats of Synthetic Enamel Apple Green Color Paint IS 5/1994. Shade :(ISC) NO-281.	Vendor to Confirm	
13.3	Air & Gas Pipelines : White & Yellow or as per instructions of BHEL and with indication of direction of flow marked at suitable intervals	Vendor to Confirm	
13.4	Any painting rubbed off / peeled off during transit or erection should be repainted and merged with the original paint by the vendor.	Vendor to Confirm	

S.No.	DESCRIPTION		PARAMETERS	BIDDER'S OFFER
14.0	PACKING :			
14.1	Rigid packing for items like fans, blowers, Refractories, drives, electric / electronic panels and controls and such other items susceptible to damage during transit.		Vendor to confirm	
15.0	GENERAL			
15.1	Furnace Model No.		Vendor to specify	
15.2	Total Connected load (KVA)		Vendor to specify	
15.3	Approximate Floor area required(Length x Width) and Height for complete Furnace & accessories.		Vendor to specify	
15.4	Total weight of the furnace		Vendor to specify	
16.0	Performace Gurarantee:			
	The complete furnace with accessories and all systems shall be guaranteed for a period of 12 months from commissioning or 18 months from date of dispatch whichever is earlier.		Vendor to confirm	
17.0	SCOPE OF SUPPLY			
17.1	Supplier Scope	<ol style="list-style-type: none"> 1. Design, Manufacture, Supply, Erection, Commissioning and prove out of 10Ton LPG(Propane+Butane)/Propane Fired Bogie Hearth High Temperature furnace 2. All anchoring & foundation bolts, levelling plates for the complete furnace and its accessories and chimney 3. Supply of 90lbs rail for bogie 4. Levelling Instruments, Power Tools / Hand Tools for erection. 5. Mobile Crane / Winches for erection and other peripherals where there is no reach of shop EOT crane. 6. Welding machines and consumables required for erection 7. Commissioning Engineer with erection crew 8. Furnace calibration and Heat treatment cycles prove out 	Vendor to confirm	

S.No.	DESCRIPTION		PARAMETERS	BIDDER'S OFFER
17.2	BHEL Scope	<ol style="list-style-type: none"> 1. Drawings approval 2. Civil foundation work as per manufacturer's drawing 3. Jobs for prove out 4. EOT Crane inside shop 5. Compressed air supply and LPG(Propane+Butane)/Propane supply at one location as indicated in the drawing 6. Electrical Power Supply point at one location as indicated in the drawing 	Vendor to confirm	