

BHEL :: PIPING CENTRE :: CHENNAI – 600017

OPEN TENDER : 4601200030

QUESTIONS :

- (1) Please confirm if PWHT thru' resistance heating machines, for P11/P22 material only, is acceptable?
- (2) Please provide us BHEL document no. SIP:PP:02 applicable for weld inspection (refer clause 2.2.7 in QP).
- (3) LTPC has OMNI SCAN MX machine for UT, which fulfills all requirements as per Note No 15 & 16 (i) of QPG 73 R3. Request your acceptance for the same.
- (4) Refer point 6 in QPG 73 regarding internal cleaning. While we understand that all bends surface shall be checked visually for cleaning, request you to elaborate "hard scale".
- (5) The painting schemes specifies paint DFT requirements of 60 microns (2x30 mic.). This shall require surface finish of SA2 for proper adherence of paint which seemingly is not achievable thru' power tool cleaning (specified in QPG73 R3). Kindly clarify.
- (6) Additionally please confirm if PWHT is acceptable thru' resistance heating machines is acceptable?

ANSWERS :

1) Post Weld Heat Treatment (PWHT) using Resistance Heating M/Cs for Pipes (P22) with Stubs & Carrier plates is acceptable for the indicated range in tender.

Vendor shall submit the procedure for Resistance heating for BHEL's review & approval.

First Off Trail (FOT) inspection for PWHT by Resistance heating shall be done in presence of BHEL.

After successful completion of FOT, this can be applied to actual production.

2) BHEL doc No : SIP:PP:02 enclosed.


3) The equivalance of the proposed make shall be verified by vendor; if the vendor is successful, the same shall be submitted to BHEL for review and acceptance.

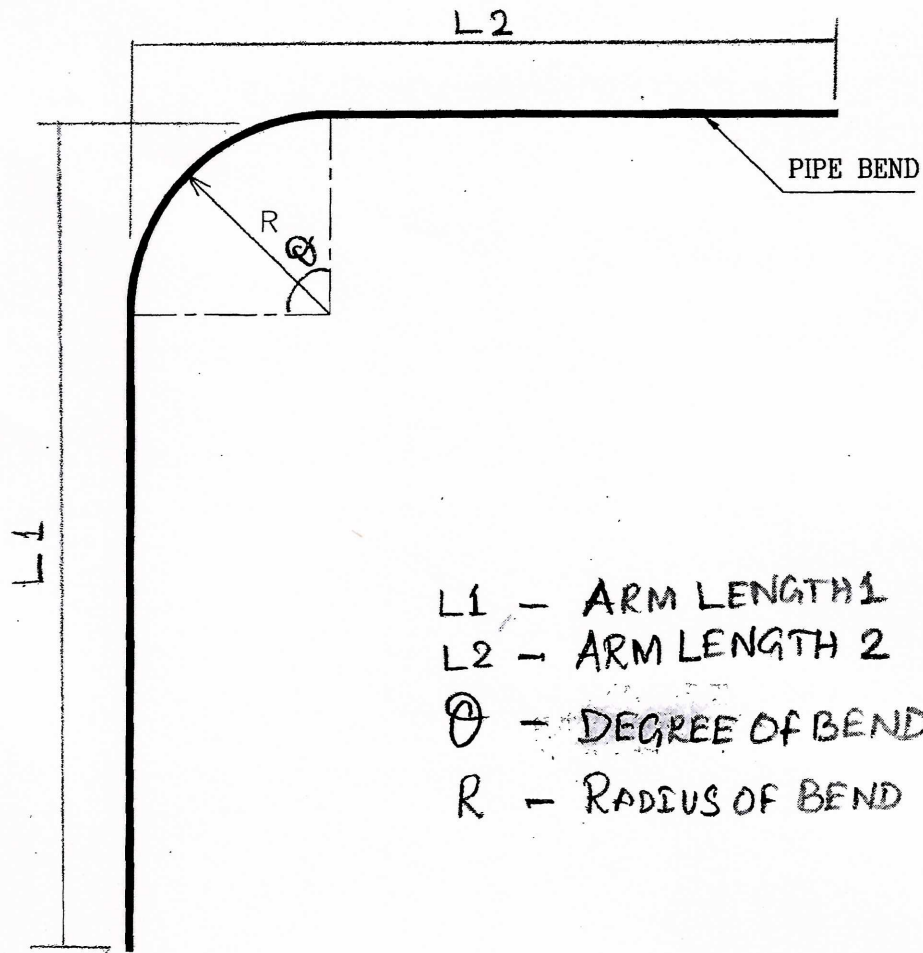
4) Please note that all the pipes shall be free of scale,dirt and other foreign material. Also refer ASME SA335 specification.

5) Painting :- Please note that Power Tool cleaning is minimum requirement for indicated paint. And also SA2 is acceptable as given by vendor.

6) PWHT :- PWHT by Resistance Heating method is not acceptable.

NOTE : Please find the illustrative sketch for Arm length L1 & Arm length L2


K BALASUBRAMANIAN
SENIOR MANAGER
OUTSOURCING
BHEL, PIPING CENTRE
CHENNAI - 600017
PH : 044-28161297



- L_1 - ARM LENGTH 1
- L_2 - ARM LENGTH 2
- θ - DEGREE OF BEND
- R - RADIUS OF BEND