



Bharat Heavy Electricals Limited
(A Govt. of India Undertaking)

Piping Centre , 80, G. N. Chetty Road, CHENNAI – 600 017
Phone : 91 (044) 28161245, Fax : 91 (044) 28161341
e-mail: prs@bhelmpc.co.in

REF: ENQ NO: 4101300058

DT:18.09.2013

Sub: Request for quotation – Forged Fittings F91- reg.

Ref: Enquiry No: 4101300058 dt 18.09.2013

Please find the following tender documents enclosed for you to submit offer. The offers should reach us before the time of opening tenders. The offer will be opened at **14.30 hrs** on the **due date 03.10.2013** in the presence of tenderers who may like to be present. Late tenders are liable to be rejected.

1. List of items.
2. Tech. delivery condition TDG: 104: REV 06
3. Terms and conditions. (To be filled and submitted with Technical bid without fail). – **This is a two part bid tender.**
4. Drawings
5. Bank Guarantee Format
6. Edge preparation drawing

Please indicate enquiry no and date and due date in all correspondences. This is only a request for quotation and not an order.

Senior Manager / Purchase
BHEL / Piping Centre
80, GN Road, T. Nagar
Chennai-600017
Ph: 044-28161243
E-mail: varada@bhelmpc.co.in

(TO BE STAMPED IN ACCORDANCE WITH STAMP ACT AND THE EXPIRY DATE OF BG MUST BE AFTER 60 DAYS FROM THE DATE OF COMPLETION OF WARRANTY PERIOD)

PERFORMANCE BANK GUARANTEE

In accordance of M/s. Bharat Heavy Electricals Limited (A Government of India undertaking, a company incorporated under the Companies Act 1956 having its Registered Office at "BHEL House", SIRI Fort, New Delhi 110 049) through its Piping Centre, 80 G.N.Road, T.Nagar, Chennai – 17. (hereinafter called 'the Company') having entered into a contract withhereinafter called ' the said contractor ' which term includes 'suppliers' for the purpose of this Bond and under the terms and conditions of the contract No..... Dt Between BHEL, Trichy and as per the contract, the contractor / supplier is to furnish a performance Bank guarantee for Rs. for the due performance of the equipment to be supplied under the above referred contract and for the fulfillment of all the terms and conditions of the contract, We(indicate the name of the bank) (herein after referred to as the bank) at the request of (Contractor(s)) do here by undertake to pay the company an amount not exceeding Rs.....against any loss or damage caused to or suffered or would be caused to or suffered by the company by reason of any breach by the said contractor (s) of any of the terms and conditions contained in the said agreement.

2. We(indicate the name of the bank with full address), do hereby undertake to pay the amounts due and payable under this guarantee without any demur, merely on a demand from the Company stating that the amount claimed is due by way of loss or damage caused to or would be caused to or suffered by the Company by reason of breach by the said Contractor(s) of any of the terms and conditions contained in the said Agreement or by the reason of the contractor(s) 'failure to perform' the said agreement. Any such demand made on the Bank shall be conclusive as regards the amount due and payable by the Bank under this guarantee. However, our liability under this guarantee shall be restricted to an amount not exceeding Rs._____.

3. We undertake to pay unconditionally to the Company any money so demanded notwithstanding any dispute(s) raised by the Contractor in any suit, or proceedings pending before any Court or Tribunal or Arbitration or before any other authority relating thereto our liability under this present being absolute and unequivocal. The payment under this guarantee would not wait till the disputes have been decided by any Court or Tribunal or in the arbitration proceedings or by any other authority. The payment so made by us under this Bond shall be a valid discharge of liability for payment thereunder and the Contractor(s) shall have no claim against us for making such payment.

4. We.....(indicate the name of Bank), further agree that the guarantee herein contained shall remain in full force and effect during the period that would be taken for the performance of the said Agreement and that it shall continue to be enforceable till all the dues of the Company under or by virtue of the said Agreement have been fully paid and its claims satisfied or discharged or till _____Office / Department/ Division of the Company certifies that the terms and conditions of the said Agreement have been fully and properly carried out by the said Contractor(s) and accordingly discharges this guarantee.

5. (I) Unless a demand or claim under this guarantee is made on us in writing on or before the _____ we shall be discharged from all the liability under this guarantee thereafter. But where such claim or demand has been preferred by the Company with the Bank before the expiry of the said date, the claim shall be enforceable notwithstanding the fact that the said enforcement is effected after the said date.

(ii) For the purpose of this clause, any letter making demand on the Bank by M/s. BHEL dispatched by Registered Post with Ack.Due or by Telegram or by any Electronic media addressed to the above mentioned address of the Bank shall be deemed to be the claim / demand in writing referred to above irrespective of the fact as to whether and when the said letter reaches the Bank, as also any letter containing the said demand or claim is lodged with the bank personally.

6. We(indicate the name of Bank), further agree with the company that the Company shall have the fullest liberty without our consent and without affecting in any manner our obligations hereunder to vary any of the terms and conditions of the said agreement or to extend time of performance by the said Contractor (s) from time to time or to postpone for any time or from time to time any of the powers exercisable by the Company against the said Contractor(s) and to forbear or enforce any of the terms and conditions relating to the said Agreement and we shall not be relieved from our liability by any reason of any such variation or extension being granted to the said Contractor(s) or for any forbearance, act or omission on the part of the company or any indulgence by the company to the said Contractor(s) or by any such matter or thing whatsoever which under the law relating would, but for this provision, have effect of not so relieving us.

7. This guarantee will not be discharged due to the change in the constitution of the Bank or the Contractor(s).

8. It shall not be necessary for the company to proceed against the contractor before proceeding against the guarantor-bank and the guarantee herein contained shall be enforceable against them notwithstanding any security, which the company may have obtained or obtain from the Contractor shall, at the time when proceedings are taken against the guarantor hereunder be outstanding or unrealised.

9. Any claim or dispute arising under the terms of this document shall only be enforced or settled in the Courts at Tiruchirapalli.

10. The guarantor hereby declare that it has power to execute this guarantee and the executant has full powers to do so on its behalf under the proper authorities granted to him/them by the guarantor.

11. We(indicate the name of Bank) lastly undertake not to revoke this guarantee during its currency except with the previous consent of the company in writing.

In witness whereof we....., (indicate the name of Bank) have hereunto setout Bank Seal the _____ day _____ month 200
BANK E-MAIL ID:
BANK PHONE NO.
BANK FAX NO:



1.0 GENERAL

Materials shall meet Indian Boiler Regulations, (IBR) in addition to the latest version of SA105, SA 182 & Code Case 2179 (for SA182 F92) as on date specified in the Purchase Order (PO).

2.0 RAW MATERIAL

- (a) The raw material used shall meet the respective specification and the test certificate shall be furnished.
- (b) Raw material steel for SA 182 if indigenously procured, to be procured from IBR approved creep resistant steel makers. Necessary certificates shall be submitted along with the offer.
- (c) For SA 105 : Carbon : 0.25% max.
For SA182 F92 : Si: 0.10-0.50%; Ni: 0.30 max and Cu: 0.25 max.

3.0 PROCESS

- (a) Process of manufacture shall conform to applicable standards.
- (b) Unless otherwise specified in the P.O, SA182 F11/12 items shall be supplied as per class 2 and SA182 F22 shall be of Class 3 only.
- (c) Dimensions shall be as per Purchase Order.
- (d) Steel for forging for IBR items to be inspected at Mill & test certificate countersigned by IBR / IBR approved authority, if the mill is not approved under IBR as well known steel maker.
- (e) **Creep testing (type test) for SA 182 F91 & F92 (IBR & Non-IBR) :-**
 - (i) The Steel maker shall have done minimum 10000 hr creep test (or) The Forge shop shall have done minimum 10000 hr creep test.
 - (ii) **Import and indigenous suppliers** shall have creep test report (type test) for raw material steel or/and for forge shop separately, which shall be signed by concerned lab personnel.
 - (iii) Creep test for indigenous steel makers and forgers shall only be done at the following labs :- **NML Jamshedpur or BHEL R&D Hyderabad.**
- (f) **Forging:** to ensure uniformity of structure & strength with reduction ratio in area 4: 1 min from ingot to final forging, close to final size & shape. Flow lines to be parallel to axis of openings.
- (g) **Blooms / Billets** used for forgings (Side Length, Dia \geq 50mm) shall be UT tested & for acceptance norm refer sl.5(i). For finished bars this can be done at Final stage.

4.0 HEAT TREATMENT

4.1 All items shall be heat treated as below:

- SA 105 - Normalised
SA 182 F11/ F12/ F22 - Normalised & Tempered

4.2 SA182 F91 & F92 shall be normalised at 1040 to 1070 deg C (for wall thickness larger than 75 mm, accelerated cooling may be done to obtain a fully martensitic structure) and tempered at 760 \pm 10 deg C. Soaking time: minimum 1 hour per 25mm thickness. Still air cooling.

5.0 TESTING

- (a) **Product analysis:-** Product analysis shall be carried out on One piece / Heat / HT lot / Size.

G. Venkataramani, Engg & Quality

P. Elangovan, Quality

Approved by

G. Panneerselvam, MM

K. Ganeshan, OPC & MPL



- (b) **Corrosion test:-** Corrosion test (IGC) shall be carried out on one piece / Heat / HT lot / Size for SS items.
- (c) **MPI (After Heat Treatment) :100%:** As per ASTM E 709. Linear Indications like cracks, folds & other injurious defects are unacceptable.
- Dry MPI : CS, AS (other than F91, F92) : all sizes.
- Wet MPI : SA182 F91, F92 : all sizes.
- (d) **LPI (After Heat Treatment) :100%** for SS as per ASTM E165, No linear indications acceptable.
- (e) **Tension test:-**Tension test shall be carried out on one Test piece for each specification, heat, heat treatment lot and size.
- (f) **Bend test:-** (a) Bend test for CS (SA 105) : One sample of 19 mm thick and 25mm width to be bent 180 deg around mandrel of radius 6.35mm.
(b) Bend test for AS (SA182): One Sample of 25.4 mm width and thickness = t to be bent 180 deg around mandrel of radius =1.5 t. Test on representative sample is also acceptable.
- (g) **Photomicrograph test for F91 & F92 :-** Photomicrograph test shall be carried out on one per heat, per size. Acceptance norms - The Material shall be free from any micro fissures. Microstructure shall show tempered martensite and also to be examined for any grain growth. Photomicrograph with 500x (Min) magnification along with Photomicrograph report to be provided. The actual magnification shall be indicated.
- (h) **Hardness test:-** (i) For SA 182 F91 :- 100% of items; Value: 191-250 BHN
(ii) For SA 182 F92 :- 100% of items; Value: 196-250 BHN
(iii) For other specn :- 10% of items; Value - As per specn.
The hardness test values shall be indicated in the Test certificate.
- (i) **Ultrasonic Test:-** All items shall be ultrasonically tested as per SA388 and acceptance norms shall be as per ASME Sec VIII Div .2 Cl. 3.3.4.

6.0 POSITIVE MATERIAL IDENTIFICATION (PMI) FOR ALLOY STEEL FITTINGS.

Each alloy steel item shall be checked for the correctness of the material during manufacturing and final inspection using X-ray fluorescence principle or spark emission spectrography.

7.0 WORKMANSHIP, FINISH AND REPAIR

All items shall have smooth, workman like finish, and to be free from scale & defects like laps, seams, folds, cracks, etc. Surface defects can be removed by mechanical means and defective areas smoothly dressed up with the adjacent surface. Minimum dimension after repair shall meet drawing / Specification. Repairs by fusion welding are prohibited.

G. Venkataramani, Engg&Quality

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8.0 PAINTING, COLOUR CODING, MARKING, PACKING & END PROTECTION

8.1 **PAINTING:** All items except SS to be applied with resin type rust preventive coating with visibility to punched and stenciled details on outside and either with rust preventive coating or rust inhibitor inside. SS items to be surface treated as per ASTM A380 both inside and outside.

8.2 **COLOUR CODING:** All items shall be colour coded circumferentially at ends as given below.

SA105	=	Blue
SA182 F11	=	Green & White
SA182 F12	=	Black & Red
SA182 F22	=	Blue & Red
SA182 F91	=	Brown & Red
SA182 F92	=	Brown & Blue
SA182 F316	=	Black & Blue
SA182 F316L	=	Blue, Brown & Yellow

8.3 **MARKING** (In English only) :-

8.3.1 The items dispatched to **BHEL Stores** shall be hard punched / etched with Material code, Heat number, material specification, maker's emblem, Inspectors seal and Statutory authorities seal (as applicable).

In addition, the above details along with size shall be paint stencilled on the fittings.

8.3.2 The items dispatched directly to project site as **DTS** shall be hard punched and paint stencilled with DU code (16 digit work order du detail) as given by purchase in addition to marking done as per para 8.3.1.

8.4 **PACKING AND END PROTECTION:** Machined ends of the items shall be well protected using end caps and shall be suitably packed in box / crate to avoid transit & other damages.

9.0 **INSPECTION & CERTIFICATION** (In English only) :-

All items are to be Inspected at the manufacturer's works by the Inspection agencies / authorities as per IBR and as indicated in the P.O. Inspection certificate in IBR Form IIIC (Form IIIF for well known forger under IBR) shall be submitted along with the Work Test Certificate countersigned by any of the above authorities and shall include the following.

1. Test Certificate Number & date.
2. BHEL P.O Number & Amendment Number(if any)
3. BHEL P.O. Serial Number
4. BHEL TDC Number
5. Size-wise Quantity
6. Specification, Grade & Year of code.
7. Heat/Melt Number

G. Venkataramani, Engg&Quality

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8. Steel making / forming process
9. Ladle and product Analysis of Raw Material.
10. IBR approved certificate for manufacturing creep resistance steel in case of indigenous steel makers.
- *11. Product analysis report.
12. Creep test reports (refer SI 3.0) from steel maker or/and forge shop shall be submitted along with offer and shall be part of final product certification.
- *13. Heat Treatment Chart.
14. NDE report. (VISUAL.MPI, LPI, UT)
- *15. Tensile Test report
- *16. Bend Test report.
- *17. Hardness Test report
- *18. Intergranular corrosion test report for SS
19. Photomicrograph test report along with photomicrograph with 500x (min) magnification.
- *20. Dimensional conformance.
- *21. Repair details if any, Certified copy of TC for starting material.
- *22. Guarantee of HTP shall be given in the test certificate as follows if hydro test is not carried out :- "Forgings are capable of with standing without failure, breakage or impairment of their serviceability a hydrostatic test pressure equal to that prescribed for the specified matching pipe of equivalent material".

*Details furnished in the Test certificate in lieu of chart/report is acceptable.

10.0 AUDIT CHECKS AT BHEL

BHEL reserves the right to carry out audit checks for chemistry, HT condition, mechanical test and NDT on representative test bars or job.

Supplies found defective during check or subsequent processing at BHEL are liable for rejection.

11.0 Records of Revisions:-

Revision 02 : Material specification SA 182 F316 added.

Revision 03 : (i) Para 4.0, 6.0 included.

(ii) Para 5.0 (b),(c),(h),(j), 8.0 and 9.0 (17) are revised.

Revision 04 : (i) New material specification SA 182 F92 added.

(ii) Para 1.0, 3.0, 4.2, 5 (f), (g) & 8.2 are revised.

(iii) Para 5 (a) to (h) are modified for better clarity.

Revision 05 : (i) Para 10.0 added.

(ii) Para 2 (c), 3.0, 8.2, 8.3.2 & 9.0 are revised.

(iii) Para 5 (c), 5 (d) & 5 (i) are modified for better clarity.

Revision 06 : (i) Para 2 (b), 3 (e),(g) & 9.0 are revised.

(ii) Para 4.1, 4.2, 5(h), 6.0, 8.1, 8.2, 8.3 & 8.4 are modified for better clarity.

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TERMS & CONDITIONS FOR PROCUREMENT OF FORGED F91 FITTINGS -- FOREIGN & INDIGENOUS

SL NO	BHEL REQUIREMENT	AGREE	DISAGREE
1	TYPE OF BID – Offers are invited to submit in single/ Two parts A.In case of Single Part Bid no deviation shall be taken and bids will be rejected if any deviation is taken. The order will be finalized based on price /negotiation/RA with all other conditions being accepted by the bidder.	NA	NA
	B.In case of Two part bid , the following procedure shall be followed. Part-I TECHNICAL - CUM – COMMERCIAL PART (Un priced) :- This part of the Bid shall contain following Technical and Commercial Points only (Except Price Portion) <ul style="list-style-type: none"> • Acceptance to our TDC104 rev 06 (Technical delivery condition) as given in the tender. Deviation if any shall be clearly indicated. UNDISCLOSED DEVIATIONS ARE NOT ACCEPTABLE. • Copy of price bid without price part to know the items for which you are quoting against this tender. • Confirmation to supply as per drawings if any sent along with enquiry. (Money values shall not be indicated i.e.unpriced bid).		
	PART II PRICE PART :		
	Foreign vendors- The unit price shall be quoted on CFR Chennai port		
	Indigenous vendors- The unit price on FOR Trichy/Site basis . (Including freight and insurance)		
	The price shall include all testing, inspection, packing & Forwarding charges. PLEASE DO NOT QUOTE ON EX –WORKS BASIS. This part of the Bid shall contain item-wise Price details against each Enquiry Sl.No. and the same shall be put in a sealed cover duly indicating Tender No, Tender Opening date, and “Price Bid” on the Sealed cover. Price quoted by the Supplier, itemwise including Taxes & Duties shall be furnished. Preconditions for price will not be accepted. Both the above referred parts(part I , part II) of the Bid each sealed in a separate cover shall be put in a sealed outer cover duly indicating Tender No.& Date, Tender Opening date and to be sent to		
	MANAGER / PURCHASE (FITTINGS) BHEL: PIPING CENTRE 80, G.N CHETTY STREET T.NAGAR, CHENNAI 600 017		
	TENDER SHALL BE PROCESSED BY OPENING THE SUBMITTED SEALED PRICE BID.		
HOWEVER BHEL RESERVES THE RIGHT TO FINALIZE THE PRICES THROUGH REVERSE AUCTION WHICH WILL BE INFORMED AFTER TECHNICAL EVALUATION.			
Price Comparison shall be made by considering the Exchange rates as on Technical bid opening date.			
2	If you are not interested / not in a position to participate in the tender, please send regret letter for not participating, before due date of the tender.		
3	You are requested to quote only for the sizes / spec for which are within your manufacturing range and approved by BHEL, Piping Centre.		

SL NO	BHEL REQUIREMENT	AGREE	DISAGREE
4	<p>Test certificates as called for in the TDC shall be sent to Purchase / Piping centre BHEL Chennai immediately after the shipment / dispatch of items and not through Bank.</p> <p>Inspection documents shall be furnished for each batch of dispatch / consignment. If entire P O quantity is manufactured in one lot but dispatched in phased manner, original IBR should be sent along with the first consignment and the attested Xerox copy of IBR shall be sent for subsequent consignments.</p> <p>Soft copy of the all the test certificates shall also be submitted through email.</p>		
5	Year of Code for Viz. the standards ASME B16.9, ASME B 28 & ASME B.16.11 etc. shall be latest and the specific year is to be mentioned in the Manufacturer's test certificates, as well as in IBR Form III-C. Also the relevant Year Code for material standard and the NDT standard (ie U.T/LPI/MPI) has to be mentioned.		
6	VALIDITY OF THE OFFER :- The quotation shall be valid at least for a period of 90 days from the date of technical bid opening / 60 days from the date of final reverse auction. Offer with lesser validity may not be considered		
7	DELIVERY SCHEDULE :- 4 MONTHS from LOI / PO date DELIVERY IS THE ESSENCE OF THE CONTRACT. As delivery will affect our project requirements, kindly quote for the above delivery period only.		
8	<p>TERMS OF DELIVERY :- Indigenous vendors FOR Trichy/Site basis</p> <p>Foreign vendors CFR-Chennai port, VENDORS QUOTING ON CFR BASIS SHALL ARRANGE FOR FREE CONTAINER RETENTION PERIOD OF 21 DAYS FOR CLEARANCE OF CARGO .</p>		
9	TAXES & DUTIES :- Please indicate clearly the percentages of applicable taxes, duties like CST, Excise Duty or any other taxes / duties.		
10	<p>TRANSPORT :</p> <p>For Indigenous suppliers: Wherever DTS advice is given , fittings shall be directly sent to respective project sites . The remaining items shall be sent to Trichy Stores.</p> <p>For Foreign suppliers: All Items are to be shipped to Chennai Port India.</p>		
11	PRESERVATION & IDENTIFICATION:- As per Technical Delivery Condition		
12	<p>INSPECTION :-</p> <p>Indigenous suppliers. a) IBR & BHEL/Third Party inspection agency for CS & AS materials. b) Only BHEL/Third Party inspection agency for SS Materials . No IBR inspection for SS materials.</p> <p>Foreign suppliers SGS / BV /LLOYDS/TUV or IBR approved inspection agency.</p>		
13	<p>Inspection Charges:-</p> <p>For Indigenous vendors : Inspection shall be by BHEL / BHEL approved third party inspection agency . No inspection charges are applicable to the vendor. Inspection charges shall be borne by BHEL . However testing charges shall be included in vendors scope.</p> <p>For Foreign vendors: Inspection shall be by reputed agencies like Lloyds , BV , SGS , TUV etc (Vendor shall indicate the name of the agency in the technical bid). Inspection charges shall be included in the quoted price .</p>		
14	GUARANTEE : Vendors shall guarantee the supplies for a period of 24 months from the date of dispatch of materials or 18 months from the date of their commissioning whichever is earlier.		
15	<p>LD CLAUSE :- If the supplier fails to deliver the fittings within the period specified in the contract the purchaser shall deduct Liquidated Damages, a sum equivalent to 0.5% of the price for each week of delay up to a maximum of 15% of the price of delayed/undelivered portion.</p> <p>For the purpose of LD , the delivery date will be reckoned as follows:</p> <p>a) For foreign/Imported vendors: Date of Bill of Lading will be taken as delivery date.</p> <p>b) For Indigenous sources: LR date will be taken as the delivery date.</p>		

SL NO	BHEL REQUIREMENT	AGREE	DISAGREE
16	TERMS OF PAYMENT: No advance payment shall be made by BHEL.		
	For indigenous vendors: 100% payment within 45 days after receipt of site acknowledged LR. : Payment shall be made against presentation of following documents to our Finance Department . However a copy of Invoice and LR shall be sent to Purchase department immediately after the dispatch is effected. A. Invoice in Triplicate B. Delivery Challan in duplicate. C. Guarantee certificate in duplicate. D. Lorry Way Bill Copy 1) Site acknowledged LR in case of DTS desptch 2) Proof of receipt of material at Trichy stores E. Inspection report copy F. IBR Form III-C copy G. ED gate pass original or copy with a confirmation that the original is sent with the goods.		
	For Foreign Vendors: 100% through CAD with PBG for 10% of PO Value. (OR) 100 % LC at sight with PBG for 10% of PO. It may be noted that loading for LC charges will be made @ 1.5% of quoted rates.		
17	No raw material / component /other services for items of ENQ SL NO 32 shall be sourced from China either directly or indirectly for manufacturing or supply.		
18	GENERAL :- <ul style="list-style-type: none"> • The PO copy with all details will be given to successful bidders in soft mode also. • Order will be placed on individual L1 vendor only and not as a total package. • Acknowledgement for receipt of PO shall be sent within one week from the date of receipt. • During the Contract period, any of our sister units of BHEL Piping Centre will be entitled to place order for this item on the same terms and conditions • BHEL reserves the right to cancel this tender without assigning any reasons what so ever. • Deviation taken after placement of order will not be accepted (Both technical & on delivery) • Suppliers to analyze in detail, at the time of submission of offer with reference to our “delivery” requirement of fittings and confirm Compliance or otherwise. • Lowest prices received against BHEL tenders does not mean order will be placed on that Supplier. BHEL reserves the right not to consider the same. • BHEL reserves the right to negotiate or re-float the tender opened if L1 price /or other details are not acceptable to them • BHEL reserves the right to order on more than one vendor at the lowest acceptable price to BHEL • Risk purchase clause: In case vendor fails to meet delivery date as per Purchase order, BHEL has the right to cancel the order and order the same item on other vendor and recover the additional cost that may incur. • Unsolicited offers will not be considered for this enquiry .New Vendors may download Vendor registration forms from BHEL Web site www.bhel.com. and submit all relevant data for registration purpose. 		

Note : Please confirm your acceptance/other wise to all the points indicated above positively and submit this format duly filled, signed & stamped along with the technical bid.

VENDORS SIGNATURE & SEAL