

**TELANGANA STATE POWER GENERATION
CORPORATION LIMITED
1X800MW KOTHAGUDEM, TPS, STAGE-VII, UNIT#12**

VOLUME – IIB

**TECHNICAL SPECIFICATION
FOR
*OIL FILLED SERVICE TRANSFORMER***

SPECIFICATION NO: *PE-TS-410-302-E001, R0*



**BHARAT HEAVY ELECTRICALS LIMITED
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
NOIDA, UP (INDIA) – 201301**



TECHNICAL SPECIFICATION FOR
OIL FILLED SERVICE TRANSFORMER

SPECIFICATION NO. PE-TS- 410-302-E001

VOLUME II B

SECTION ---

REVISION 0

DATE: 13.07.2015

SHEET 1 OF 1

CONTENTS

<u>S. NO.</u>	<u>CONTENTS</u>	<u>NO. OF SHEETS</u>
01	INSTRUCTIONS TO BIDDERS	01
02	PREAMBLE	01
03	SECTION – 'A' SCOPE OF ENQUIRY	02
04	SECTION – 'B' PROJECT INFORMATION	03
05	SECTION – 'C' TECHNICAL SPEC FOR OIL FILLED SERVICE TRANSFORMERS SPECIFIC TO THIS CONTRACT	13
	ANNEXURE-A SCHEDULE OF PRICES- TRANSFORMERS	01
	ANNEXURE-B ACCESSORIES AND FITTING OF TRANSFORMER	
	ANNEXURE C SCHEDULE OF PRICES- MANDATORY SPARES	01
	ANNEXURE D SCHEDULE OF PRICES- TYPE TEST (CONDUCTION)	01
	ANNEXURE E LIST OF TYPE/SPECIAL TEST-PRICE INCLUSIVE	01
	ANNEXURE F LIST TYPE TESTS/SPECIAL TEST (REPORTS)	01
	DEFINITION OF SIMILAR TRANSFORMER	01
06	SECTION – 'D' SPECIFICATION NO: PE-TS-999-302-E001	51
	DATA SHEET-A OIL FILLED SERVICE TRANSFORMER	
	QUALITY PLAN OIL FILLED SERVICE TRANSFORMER	
	DATASHEET-B OIL FILLED SERVICE TRANSFORMER	
	DATASHEET-C OIL FILLED SERVICE TRANSFORMER	

TOTAL NO. OF SHEETS = 79 (INCLUDING COVER/ SEPARATOR SHEETS)

IT IS CONFIRMED THAT OUR TECHNICAL OFFER COMPLIES WITH THE SPECIFICATION IN TOTO, &
THAT THERE ARE NO TECHNICAL DEVIATIONS.

BIDDER'S STAMP & SIGNATURE
(REFER INSTRUCTION NO. 1 OF INSTRUCTION TO BIDDERS)



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SHEET 1 OF 1

PREAMBLE

1.0 The tender document contains two (2) volumes. The bidder shall meet the requirements of all the two volumes.

1.1 Volume-I (CONDITIONS OF CONTRACT)

This consists of four parts as below:-

- Volume-IA : This part contains instructions to bidders for making bids to BHEL.
Volume-IB : This part contains general commercial conditions of the tender & includes provision that vendor is responsible for the quality of item supplied by their sub-vendors.
Volume-IC : This part contains special conditions of contract.
Volume-ID : This part contains commercial conditions for erection & commissioning site work, as applicable.

1.2 Volume-II (TECHNICAL SPECIFICATIONS)

Technical requirements are stipulated in Volume-II which comprises of:-

- Volume-IIA : General Technical Conditions
Volume-IIB : Technical Specification including Drawings, if any.

1.2.1 Volume-IIB

This volume is sub-divided into following sections:-

- Section-A : This section outlines the scope of enquiry.
Section-B : This section provides "Project Information".
Section-C : This section indicates technical requirements specific to the contract, not covered in Section-D.
Section-D : This section comprises of technical specifications of equipments complete with data sheet A.

Data Sheet – A: - specifies data and other requirements pertaining to the Equipment.

Data sheet – C: - Indicates data / documents to be furnished after the award of Contract as per agreed schedule by the vendor (as applicable)

2.0 **This requirements mentioned in Section – C / Data Sheet – A shall prevail and govern in case of conflict between the same and the corresponding requirements mentioned in the descriptive portion in Section – D(General Technical Requirements).**



TECHNICAL SPECIFICATION FOR
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SPECIFICATION NO. PE-TS-410-302-E001

VOLUME II B

SECTION A

REVISION 0

DATE: 13.07.2015

SHEET 1 OF 2

SECTION – A

SCOPE OF ENQUIRY



**TECHNICAL SPECIFICATION FOR
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SPECIFICATION NO. PE-TS-410-302-E001

VOLUME II B

SECTION A

REVISION 0

DATE: 13.07.2015

SHEET 2 OF 2

SCOPE OF ENQUIRY

- 1.0 This specification covers the Design, Manufacture, Inspection and Testing at Manufacturer's works, proper packing and delivery to site of Oil Filled Service Transformer as mentioned in different sections of this specification for 1x800 MW KOTHAGUDEM TPS, STAGE-VII, UNIT#12
- 2.0 It is not the intent to specify herein all the details of design & manufacture. However, the equipment shall conform in all respects to high standards of design engineering and workmanship and shall be capable of performing in continuous commercial operation at site conditions.
- 3.0 The general terms and conditions, instructions to bidders and other attachment referred to elsewhere are hereby made part of the tender specification.
- 4.0 The bidder shall be responsible for and governed by all requirements stipulated hereinafter.
- 5.0 Bidder shall confirm total compliance to the specification without any deviations from technical/quality assurance requirements stipulated.
- 6.0 Deviations, if any should be brought at very clearly on deviation sheet enclosed with specification only, Otherwise it will be presumed that the bidder's offer is in line with what has been stated/ asked for in this specification.
- 7.0 The documents shall be in English Language and MKS system of units.



TECHNICAL SPECIFICATION FOR
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SPECIFICATION NO. PE-TS-410-302-E001

VOLUME II B

SECTION ---

REVISION 0

DATE:13.07.2015

SHEET 1

OF 1

INSTRUCTIONS TO BIDDERS FOR PREPARING TECHNICAL OFFER

1. Two signed and stamped copies of the following shall be furnished by all bidders as technical offer :
 - a. Unpriced Price Schedule with "QUOTED" words against each item (Annexure-A: BOQ-Cum-Price Schedule, as enclosed with the specification)
 - b. A copy of this sheet ("Instructions to Bidders for Preparing Technical Offer").
 - c. A copy of previous sheet ("Contents").
 - d. Datasheet-B duly filled, with bidder's signature and company stamp
 - e. ("Deviation Schedule"), with "NO DEVIATION" and bidder's signature and company stamp
2. No other technical submittal such as copies of type test certificates, data sheets, write-up, drawing, technical literature, etc. is required during tender stage. Any such submission, even if made, shall not be considered as part of offer.
3. No comments/ additions/ deletions shall be made by the bidder on the signed & stamped copy of the specification. Any such changes made by the bidder shall not be considered.
4. Confirmations/ comments (if any) regarding delivery schedules shall be furnished as part of the commercial offer. Any reference in the technical offer / covering letter shall not be considered by BHEL.
5. Any comments/ clarifications on technical/ inspection requirements furnished as part of bidder's covering letter shall not be considered by BHEL, and bidder's offer shall be construed to be in conformance with the specification.
6. Any changes made by the bidder in the price schedule with respect to the item description/ quantities, notes etc. from those given in Annexure-A of specification [Bill Of Quantities] shall not be considered (i.e., technical description, quantities, notes etc. as per specification shall prevail).

BIDDER'S STAMP & SIGNATURE



TECHNICAL SPECIFICATION FOR
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SPECIFICATION NO. PE-TS-410-302-E001

VOLUME NO. : II-B

SECTION : B

REV NO. : 0 DATE : 13.07.2015

SHEET : 1 OF 3

SECTION - B
PROJECT INFORMATION

VOLUME : IIA

SECTION-II

PROJECT SYNOPSIS AND GENERAL INFORMATION

1.00.00 INTRODUCTION

The proposed 1x800 MW Kothagudem Thermal Power Station (KTPS), Stage-VII, Unit-12 would be set up by Telangana State Power Corporation Ltd. (TSGENCO) at Kothagudem, Telangana. The proposed Power Plant will be installed adjacent to the existing D colony of Kothagudem Thermal Power Station, at Kothagudem.

The Bidder shall acquaint himself by a visit to the site, if felt necessary, with the conditions prevailing at site before submission of the bid. The information given here in under is for general guidance and shall not be contractually binding on the Owner. All relevant site data /information as may be necessary shall have to be obtained /collected by the Bidder.

2.00.00 APPROACH TO SITE

Site is located in the existing D Colony of Kothagudem Thermal Power Station, which is at a distance 30 km from temple town of Bhadrachalam and 300 km from Hyderabad by road. The Nearest railway station is Bhadrachalam Road (Known as Kothagudem) at a distance of 12 km. Kothagudem- Bhadrachalam National Highway branches off to the power station site near village Paloncha.

3.00.00 LAND

Land is primarily required for the main plant & auxiliaries (BTG) and balance of plant (BOP) like ash handling, coal storage, cooling tower, switchyard etc., which is available within the existing plant boundary.

The existing colony is to be dismantled, and the land of about 137 acres will be used for the main plant building, water facilities, switchyard, coal handling etc. The raw water reservoir will be located adjacent to the existing raw water reservoirs.

230 acres of land required for Ash Dyke will be procured. Land is available for staff colony, which is to be constructed by the EPC contractor.

4.00.00 SOURCE OF COAL

100% Imported and Blended coal (50% imported + 50% indigenous) will be used. Indigenous coal shall be sourced from Suliyari coal mines, Madhya Pradesh.

5.00.00 **SOURCE OF WATER**

Source of water (total quantity of water is 2192 m³/hr) is Godavari River near Burgampahad & water will be pumped through existing GRP pipe line (of length approx. 26 km).

6.00.00 **ASH DISPOSAL AREA**

Ash shall be dumped in the ash dump area which will be about 9 km from plant. The ash dyke area of 230 acres is adequate for 1x800 MW unit as per MOEF norms.

7.00.00 **SALIENT DESIGN DATA**

7.01.00 Meteorological data of site is given below:-

Elevation above MSL	:	89 m
Monthly highest temperature	:	44.9 °C
Monthly lowest temperature.	:	12.9 °C
Rainfall		
	Average.:	1031 mm
	Max. :	100 mm/ hr
Mean Wind speed	:	5.8 kmph
Relative Humidity		
	Max :	82%
	Min :	35%
Seismic Zone	:	Zone-III as per IS- 1893 (Part-IV)

[Climatological data of Khammam is attached for reference].

SEC-C
PROJECT SPECIFIC TECHNICAL REQUIREMENTS

**TECHNICAL SPECIFICATION
FOR
AUXILIARY POWER TRANSFORMER**

1.00.00 **SCOPE OF SUPPLY**

1.01.00 The requirement of major 11/3.6KV Auxiliary Power transformers are indicated in ~~BOQ-CUM-PRICE SCHEDULE. Additional transformers, if required, shall be decided by Bidder based on system design and power supply arrangement.~~

~~1.02.00 Transformer offered by the bidder shall be sized according to the maximum demand at most stringent condition plus minimum 10 % margin.~~

1.03.00 Each transformer shall be furnished complete with :-

- a) Fittings and accessories ~~-As per Ann-B of Sec-C. Items mentioned in Sec-D, cl. 7.0 also to be referred for~~ balance (but not duplicating with Sec-C) for total fitting and accessories required for
- ~~b) Auxiliary equipment~~ each transformer.
- c) First filling of oil including 10% extra ~~-As per BOQ-Cum-Price Schedule.~~

1.04.00 One set of special tools and tackles ~~-As per BOQ-Cum-Price Schedule.~~

1.05.00 Mandatory Spare parts ~~-As per BOQ-Cum-Price Schedule.~~

1.06.00 All relevant drawings, data and instruction manuals.

2.00.00 **CODES AND STANDARDS**

2.01.00 All equipment and materials shall be designed, manufactured and tested in accordance with the latest applicable Indian Standards (IS) and IEC except where modified and/or supplemented by this specification.

2.02.00 Equipment and material conforming to any other standard which ensures equal or better quality, may be accepted. In such case, copies of the English version of the standard adopted shall be submitted along with the bid.

2.03.00 The electrical installation shall meet the requirements of Indian Electricity Rules as amended upto date and relevant IS Code of Practice. In addition, other rules and regulations applicable to the work shall be followed.

3.00.00 **DESIGN CRITERIA**

3.01.00 The transformer will be used to supply power for Units & Station auxiliaries. The high voltage winding will be connected to the HV switchgear. The low voltage winding feeds the 3.3KV switchgear.

3.02.00 The transformer will be installed in hot, humid and tropical atmosphere. All equipment, accessories and wiring shall be provided with tropical finish to prevent fungus growth.

- 3.03.00 The transformer shall be capable of continuous operation at rated output under the following condition :
- a) Voltage variation : $\pm 10\%$
 - b) Frequency variation : +3% to -5%
 - c) Combined voltage and frequency variation (absolute sum) : 10%
- 3.04.00 The transformer shall be so designed that it is capable of operation at 125% rated voltage for a period of one minute and 140% rated voltage for a period of five seconds due to sudden load throw off.
- 3.05.00 The transformer shall be capable of withstanding the short circuit stresses due to a terminal fault on one winding with full voltage maintained on the other winding for minimum period of two (2) seconds.
- 3.06.00 The transformer shall be free from annoying hum or vibration. The design shall be such as not to cause any undesirable interference with radio or communication circuits.
- 3.07.00 The noise level shall be limited to the value specified by NEMA Standard Publication No. TR-1-1993 when measured in accordance with conditions outlines in ANSI/IEEE C57.12.90-1999/IS13964/CBIP publication.
- 4.00.00 **SPECIFIC REQUIREMENTS**
- 4.01.00 **Tanks**
- 4.01.01 The tank shall be fabricated from good commercial grade low carbon steel of adequate thickness.
- 4.01.02 The tank wall shall be reinforced by stiffener to ensure rigidity so that it can withstand without any deformation (a) mechanical shock during transportation, (b) full vacuum of 760mm, (c) Short circuit forces and (d) continuous internal pressure of 35 kN/m² over normal hydrostatic pressure of oil.
- 4.01.03 All removable covers shall be provided with weatherproof, hot oil resistant, resilient gaskets. The design shall be such as to prevent any ingress of water into or oil from the tank.
- 4.01.04 The tank shall be provided with one set of bi-directional flanged wheels for rolling the transformer parallel to either canter line over 1676 mm rail gauge. In case more than two rails are required to be provided the rail gauge of 1676 mm shall be maintained between two adjacent rails.
- 4.01.05 Jacking pads, lifting eyes and pulling lugs shall be provided to facilitate movement of the transformer. All heavy removal parts shall be provided with eye bolt for ease of handling.

- 4.01.06 Manholes/hand-holes of sufficient size shall be provided for access to leads, windings, bottom terminals of bushings and taps.
- 4.01.07 Suitable guide shall be provided in the tank for positioning the core and coil assembly.
- 4.02.00 **Core & Coils**
- 4.02.01 The core shall be built up with high grade, non-aging, low loss, high permeability, grain oriented, cold-rolled silicon steel laminations especially suitable for core material.
- 4.02.02 The coils shall be manufactured from electrolytic copper conductor and fully insulated for rated voltage. Insulation shall be of Class A.
- 4.02.03 Insulating material shall be of proven design. Coils shall be so insulated that impulse and power frequency voltage stresses are minimum.
- 4.02.04 Coil assembly shall be suitably supported between adjacent sections by insulating spacers and barriers. Bracing and other insulation used in assembly of the winding shall be arranged to ensure a free circulation of the oil and to reduce the hot spot of the winding.
- 4.02.05 All leads from the windings to the terminal board and bushings shall be rigidly supported to prevent injury from vibration or short circuit stresses. Guide tube shall be used where practicable.
- 4.02.06 The core and coil assembly shall be securely fixed in position so that no shifting or deformation occurs during movement of transformer or under short circuit stresses.
- 4.03.00 **Tapping**
- 4.03.01 Off-circuit tap change (OCTC) as specified in the annexure shall be provided on the high voltage winding.
- 4.03.02 The transformer shall be capable of operation at its rated KVA on any tap provided the voltage does not vary by more than $\pm 10\%$ of the rated voltage corresponding to the tap.
- 4.03.03 The winding including the tapping arrangement shall be designed to maintain electromagnetic balance between HV and LV windings at all voltage ratios.
- 4.04.00 **Off-Circuit Tap Changer (OCTC)**
- 4.04.01 The off-circuit tap changing will be affected by a gang operated switch for three-phase unit. Arrangement shall such that switch can be operated at standing height from ground level.
- 4.04.02 The operating handle can be padlocked at any tap position. The design shall be such that the lock cannot be inserted unless the contacts are correctly engaged.
- 4.04.03 The mechanism shall be provided with a mechanical tap position indicator and an operation counter.

- 4.04.04 All contacts shall be silver plated and held in position under strong contact pressure to ensure low contact drop and avoid pitting.
- 4.05.00 **Insulating oil**
- 4.05.01 The transformer shall be filled with mineral insulating oil suitably inhibited to prevent sludging.
- 4.05.02 First filling of oil along with 10% excess shall be furnished for each transformer. Oil shall be supplied in non-returnable containers suitable for outdoor storage.
- 4.05.03 Oil preservation shall be by means of bellows/ diaphragm sealed conservator tank with silica gel breather to avoid direct connection between atmosphere and transformer oil. It shall be complete with level gauges, pipes, drain valve, buchholz relay with shut-off valves at both sides etc. The level gauges shall be so placed that same can be readable standing from ground. Necessary device shall be kept to provide annunciation in the event of rupturing of bellow.
- 4.06.00 **Bushing**
- 4.06.01 Bushing rated below 52KV voltage class shall be solid porcelain or oil communicating type.
- 4.06.02 Bushings shall be provided with terminal connectors of approved type and size.
- 4.06.03 Bushing location shall provide adequate phase and ground clearances.
- 4.07.00 **Terminal Arrangements**
- 4.07.01 The physical position of the terminals and the markings shall be as per relevant IS/IEC unless otherwise required to suit the layout.
- 4.07.02 High voltage terminals shall be brought out thru' top cover mounted bushings with matching flanges around each bushing for connection to XLPE cables. The contractor shall furnish all necessary details in this connection for co-ordination with the bus duct/Cable and shall guarantee the matching dimensions within close tolerance.
- 4.07.03 Low voltage terminals shall be brought out thru' side wall mounted bushings. For bus duct connection, bushings shall have matching flange around. For cable connection, a detachable type cable end-box with disconnect links shall be furnished.
- 4.07.04 Low voltage winding neutral shall be brought out thru' side wall mounted bushing to a detachable cable end-box with disconnect link.
- 4.07.05 The cable end-box shall be self-supporting, weather-proof, air filled type, complete with all hardware such as gland plate, brass glands, tinned copper lugs, armour clamps etc.

4.07.06 In general, the arrangement shall be such as to permit removal of transformer and core/coil assembly without dismantling the bus duct/cable connection

4.08.00 **Cooling System**

4.08.01 The transformer cooling system (ONAN/~~ONAF~~) and number of cooling banks and capacity of each bank shall be as specified in the annex-B . The cooling system shall comprise number of cooling units each complete with its radiator banks, ~~pumps, fans~~ and other accessories

4.08.02 Transformer fitted with multiple cooling units but without having stand-by cooling units, it shall be able to deliver its rated output not exceeding specified temperature rise and calculated hot-spot temperature of 150 degree centigrade under following conditions:

~~a) for 20 minutes after failure of the blowers of one unit~~

b) for 10 minutes in the event of failure of the cooler units

4.08.03 The radiators shall be detachable type with top and bottom isolation valves to permit the removal of the same without drainage of oil from the tank.

~~4.08.04 All fans shall have safety guard. Pumps shall be provided with flow indicators for visual indication of oil flow.~~

~~4.08.05 Convenient means shall be provided to remove or replace any pump or fan with the transformer in service.~~

~~4.08.06 Complete control for fans inclusive of all switches, fuses, starters, relays and wiring shall be furnished. Each motor circuit shall have over load and short circuit protection.~~

~~4.08.07 Fan motor controls will be actuated automatically from winding temperature indicator contacts. Provision shall however be kept for manual operation from local cooler control panel and remote from central control room by serial link communication with the plant DCS.~~

4.09.00 **Cooler Control panel** (NOT APPLICABLE FOR ONAN TRANSFORMER)

4.09.01 The transformer cooler control panel shall be used for control, interlocking, metering and indication of cooler control system of transformer and shall be installed outdoor near the transformer coolers.

4.09.02 Control panels shall be of CRCA sheet steel construction with protection class of IP-52 for indoor and IP-55 for outdoor installation.

4.09.04 The frames and load bearing panels shall be fabricated of not less than 2 mm thick sheet steel. The doors and covers shall not be less than 1.6mm thick. All access doors shall be provided with channel rubber/ neoprene gaskets all round.

4.09.05 The operating height shall be limited from 750mm to 1800mm. The total height of the panel and its depth shall be matched with adjacent panel.

- 4.09.06 The operating handle shall have locking arrangement. The panels shall be complete with floor channel sills, vibration damping pads and stainless steel kick plates.
- 4.09.07 All instrument, relays, switches, etc. mounted on the front face of the panel shall be flush or semi flush type. Switch contacts shall be silver faced and rated at least 10 Amp at operating voltage. Push buttons shall have required number of contacts.
- 4.09.08 Panel shall be provided with internal illumination lamp with door switch, space heater with thermostat one 5A, 5 pin receptacles with plug.
- 4.09.09 The annunciation system shall be solid-state type with optical isolation for input signals. It shall be complete with its own power supply, audible alarms, acknowledge, reset, and test buttons and other necessary accessories.
- 4.09.10 The control panels shall be fully wired up at factory. All spare contacts of relays and switches shall be wires upto the terminal blocks.
- 4.09.11 The panel shall have provision of cable entry from bottom. Bottom gland plate shall be 3mm thick.
- 4.09.12 50 x 6 mm GI ground bus shall be provided on the panel extending along the entire length of the assembly. The ground bus shall have two-bolt drilling with GI bolts and nuts at each end to receive ground connection of 75x10 mm G.I. flat.
- 4.09.13 Wiring shall be done with flexible, 1100V grade PVC fire resistance wires in GI conduit or FRLS type PVC armored (round GI Wire) cable within transformer and also from transformer to Cooler Control Cabinet. Minimum wire size shall be 2.5 mm² stranded copper. Not more than two wires shall be connected to a terminal. 10% spare terminals shall be provided.
- 4.10.00 **Marshalling Box**
- 4.10.01 A sheet steel, weatherproof, IPW55, marshalling box shall be provided for the transformer. The box shall contain all auxiliary devices except those which must be located directly on the transformer.
- 4.10.02 All terminal blocks for cable connection shall be located in this box.
- 4.10.03 The marshalling box shall be provided with cubicle lamp with door switch, space heater with thermostat and removable cable gland plate.
- 4.11.00 **Wiring**
- 4.11.01 All control, alarm and indication devices provided with the transformer shall be wired upto the terminal blocks.
- 4.11.02 Wiring shall be done with flexible, 1100V grade fire resistance PVC wires in conduit or FRLS type PVC armored cable. Minimum wire size shall be 2.5 mm² stranded copper. Not more than two wires shall be connected to a terminal. 10% spare terminals shall be provided.

- 4.11.03 Multi-way terminal block complete with mounting channel, binding screws and washers for wire connections and marking strip for circuit identification shall be provided for terminating the panel wiring. Terminals shall be stud type, suitable for terminating 2 nos. 2.5 mm² stranded copper conductor and provided with acrylic insulating cover. Terminals for C.T. secondary leads shall have provision for shorting and grounding.
- 4.11.04 All devices and terminal blocks shall be identified by symbols corresponding to those used in applicable schematic or wiring diagram. Each wire shall be identified, at both ends, with interlocking type permanent markers bearing wire numbers as per Contractor's Wiring Diagrams. AC / DC wiring shall have separate color-coding.
- 4.11.05 Wire termination shall be made with crimping type connectors with insulating sleeves. Wires shall not be spliced between terminals.
- 4.12.00 **Grounding**
- 4.12.01 The grounding pads, located on the opposite sides of the tank, cooling units, marshalling cabinet shall be provided for connection to station ground mat.
- 4.12.02 Grounding pad shall have clean buffed surface with two tapped holes, M10 G.I. bolts and spring washers for connection to 75x10 mm G.I. flat.
- 4.12.03 Ground terminals shall be also provided on marshalling box to ensure its effective earthing.
- 4.12.04 For continuity of earth connection, all gasketed joints shall be provided with braided copper wire jumpers.
- 4.13.00 **Auxiliary Supply**
- 4.13.01 415V A.C. supply will be made available to each transformer by two separate feeders one normal and the other standby.
- 4.13.02 MCCB shall be provided for each of the incoming supply along with automatic changeover scheme to switch on to the standby source in case of failure of the normal supply.
- 4.14.00 **Auxiliary Equipment**
- 4.14.01 Neutral bushing current transformers shall be furnished when specified in the **DATA SHEET-A**
- 4.14.02 The arrangement shall be such that the C.T. can be removed from the transformer without removing the tank cover.
- 4.14.03 CT secondary leads shall be wired upto the terminal blocks. The terminals for CT secondary leads shall be provision fro shorting.
- 4.15.00 **Painting**
- 4.15.01 All steel surfaces shall be thoroughly cleaned by sand blasting or chemical agents as required, to produce a smooth surface free of scales, grease and rust.

4.15.02 The internal surfaces in contact with insulating oil shall be painted with heat resistant insulating varnish which shall not react with and be soluble in the insulating liquid used.

4.15.03 The external surfaces, after cleaning, shall be given a coat of high quality red oxide or yellow chromate primer followed by filler coats.

4.15.04 *Paint Finish coat shall be Epoxy based with suitable additives. The thickness of finish coat shall be minimum 80 microns (minimum total DFT shall be 100 microns). However in case electrostatic process of painting is offered for any electrical equipment, minimum paint thickness of 80 microns shall be acceptable for finish coat. Paint shade shall be semi glossy finish of shade Light Grey.*

4.15.05 The paints shall be carefully selected to withstand tropical heat, rain etc. The paint shall not scale off or crinkle or be removed by abrasion due to normal handling.

4.15.06 Sufficient quantity of touch up paint shall be furnished for application after installation at site.

4.15.07 If it is considered necessary, the transformer may be given a further coating at site by the Owner/Purchaser. The Bidder shall therefore indicate the type and quality of the paint with full specification for this purpose.

4.15.08 All supporting structures and hardware shall be hot dip galvanized.

4.16.00 **Transportation**

4.16.01 Transformer tank shall be dispatched filled with oil or pure dry inert Nitrogen gas depending upon the transport weight limitations. A positive pressure of 2 to 2.5 Psi at temperature of 36°C approximate shall be kept. In case the tank is filled with oil, sufficient space is left above the oil to take care of the expansion of the oil. The space is filled with pure dry air or inert gas under atmospheric pressure.

The temperature and pressure at the time of gas filling shall be marked on a tag. A graph showing pressure vs. temperature shall be attached for reading pressures at different temperatures. Necessary valves, two stage pressure regulators, filled up Nitrogen cylinder etc. along with other accessories required shall be provided with the tank for intermittent replenishment during transportation.

4.16.02 **Impact Recorder**

Impact recorder/indicator shall be provided to monitor the impact experienced by the transformer during transport.

5.00.00 **TESTS**

5.01.00 **Routine Tests**

During manufacture and on completion, all transformers shall be subjected to the routine tests in accordance with latest IEC 60076 and its different parts.

In addition, the following tests shall be performed on each transformer :

- 5.01.01 Transformer tank with coolers shall be tested for leaks with normal head of oil plus 35 KN/m² for a period of 8 hours. If any leak occurs, the test shall be conducted again after all leaks have been repaired.
- 5.01.02 During fabrication stage, the tank shall be pressure tested with air at a pressure corresponding to twice the normal head of oil or normal pressure plus 35KN/m² whichever is lower for a period of one hour. Also the tank designed for full vacuum shall be tested for maximum internal pressure of 3.33KN/m² for one hour. The permanent deflection of flat plates shall not exceed CBIP specified figures on release of excess pressure of pressure test and on release of vacuum.
- 5.01.03 After assembly, each core shall be pressure tested for one minute at 2KV (r.m.s.) A.C. between all bolts, side plates, structural steel works and the core.
- 5.01.04 The wiring for auxiliary power and control circuitry shall be subjected to withstand one minute power frequency test with 2.0KV (r.m.s.) to earth.
- 5.01.05 Dielectric special tests as per IEC60076-3.
- 5.01.06 Determination of capacitances windings-to-earth and between windings.
- 5.01.07 Frequency Response Analysis test (This test shall also be undertaken by the manufacturer at site after transformer is installed.).
- 5.01.08 Measurement of acoustic sound level.
- ~~5.01.09 Measurement of power consumption of fans.~~
- 5.01.10 Measurement of zero sequence impedance(s) on three-phase unit.
- 5.01.11 Measurement of dissipation factor (tan delta) of insulation system capacitances.
- 5.01.11 All test on transformer oil as per IS 335 shall be conducted.

Note: Routine tests mentioned above are part of QAP and its Annexure.

5.02.00 **Type Tests ****

Following type tests shall be performed on one ^{*} transformer in accordance with relevant standard:

- a) Dielectric type test (IEC60076-3) d) Other Type tests as per Quality Plan and Ann-1 to QAP
- b) Temperature rise test.
- c) Short circuit test

* Note:- . Type test mentioned at a) , b) c) & d) to be performed on one transformer of each rating. For Short Circuit test, charges for carrying out the test on one Transformer of each rating shall be payable based on actual invoice from designated laboratories(CPRI Bhopal/ CPRI Bangalore/ ERDA, Vadodara)

5.03.00 **Miscellaneous**

All component parts and auxiliary equipment such as oil, bushings, C.Ts etc. shall be routine tested as per relevant Indian Standards.

**Type test reports of a similar transformer (as per the guidance for identification of a similar transformer as defined in Annexure-B of IEC 60076-5) to be furnished after award of contract by successful bidder. The type test certificates shall not be more than 5 years old from the date of Technical Offer. However, conduction of type tests shall prevail as mentioned at *note above.

6.00.00 **SPECIAL TOOLS & TACKLES**

6.01.00 A set of special tools & tackle which are necessary or convenient for erection, commissioning, maintenance and overhauling of the equipment shall be supplied.

6.02.00 The tools shall be shipped in separate containers, clearly marked with the name of the equipment for which they are intended.

7.00.00 PROVENNESS CRITERIA

7.01.00. Bidder should have manufactured & supplied at least two numbers (one each at two different project sites) of at least highest offered rating oil filled transformers which must be in successful operation for a period of at least two (2) years as on 24 December,2014.

7.02.00. Bidder should have his own facilities for conducting all routine and type tests as per IS: 2026 (except short circuit test).

7.03.00. The transformer considered for the above (cl no. 7.01.00) should have been successfully short circuit tested.

Bidder shall submit relevant supporting document against provenness criteria.

ANNEXURE-B

FITTINGS AND ACCESSORIES

Transformer shall be equipped with fittings and accessories as listed below :-

1. Oil conservator with filler cap, drain plug, plain oil level gauge and alarm contacts for rupturing of bellows/diaphragm.
2. Oil preservation system complete with accessories.
3. Air release plugs.
4. Pressure release device with trip contacts. Explosion vent, if provided, should be double diaphragm type.
5. 150 mm dial magnetic oil level gauge with low level alarm contacts
6. 150 mm dial oil temperature indicator with maximum reading pointer and electrically separate contacts for trip and alarm and embedded temperature detectors (PT-100) with suitable output for remote indication (data logging).
7. 150 mm dial winding temperature indicator with maximum reading pointer and electrically separate sets of contacts for trip, alarm and cooler control and embedded temperature detectors (PT-100) with suitable output for remote indication (data logging).
8. Remote winding temperature indicator for mounting on Owner/Purchaser's panel with a separate detector element.
9. Thermometer pockets.
10. Double float Buchholz relay with gas release cock, shut-off valve on either sides with separate sets of contacts for trip and alarm.
11. Filter valve with threaded adopter (top and bottom).
12. Drain valve with threaded adopter.
13. Sampling valve.
14. Necessary valves for detachable cooler units.
15. Jacking pads, handling and lifting lugs.
16. Cover lifting eyes.
17. Bi-directional flanged wheels and skids.
18. Clamping device with bolts & nuts.
19. Hand-hole of sufficient size for access to interior of the tank.
20. Two-grounding pads.

21. Ladder with safety device for access to the top of transformer tank.
22. Weather proof marshalling box for housing control equipment and terminal connections.
23. H.V. and L.V. bushing terminal connectors.
24. Rating and terminal marking plates.
25. Cooler units complete with valves, ~~fans~~, supporting structure with fixing and foundation bolts etc as required ~~and Cooler Control panel~~.
26. Tap-changing gear complete with tap position indicator, operation counter etc. ~~For OLTC gear (where specified), oil surge relay (OSL) with shut-off valve, Local control cabinet and Remote (RTCC) panel~~

Note : All indication, alarm, trip contacts provided shall be rated for 2.0A at 220 V D.C. and 5A at 240 V A.C.

Note:- Fitting and Accessories mentioned in Sec-D, Cl. no. 7.0 also to be referred and any additional items to be included as accessories for each transformer which are not mentioned above.

1X800 MW KOTHAGUDEM TPS
SPECIFICATION NO.: PE-TS-410-302-E001

ANNEXURE-A
BOQ CUM PRICE SCHEDULE FOR OIL FILLED SERVICE TRANSFORMER (MAIN ITEMS)

Sr. No.	Item code	Item description	Unit	ORDERED QUANTIT Y	UNIT PRICE (EX-WORKS) Rs	TOTAL PRICE (EX-WORKS) Rs	REMARKS
1.0	302-11014-A	6300KVA, 11KV/3.6KV, 3 PHASE, 2 WINDING, OUTDOOR, ONAN, Z=7.0%, DYN11, OFF CIRCUIT TAPS. 5% IN STEPS OF 2.5% (WITH CABLE BOX TYPE HV AND WITH BUS-DUCT TYPE LV TERMINATION)	NOS.	2			
2.0	302-11012-A	3500KVA, 11KV/3.6KV, 3 PHASE, 2 WINDING, OUTDOOR, ONAN, Z=6.0%, DYN11, OFF CIRCUIT TAPS. 5% IN STEPS OF 2.5% (WITH CABLE BOX TYPE HV AND WITH BUS-DUCT TYPE LV TERMINATION)	NOS.	2			
3.0	302-11045-A	10 % EXTRA TRANSFORMER OIL IN SEALED NON RETURNABLE STANDARD DRUMS FOR 6300KVA, 11KV/3.6KV, 3 PHASE, 2 WINDING, OUTDOOR, ONAN, Z=7.0%, DYN11	NOS.	2			
4.0	302-11045-A	10 % EXTRA TRANSFORMER OIL IN SEALED NON RETURNABLE STANDARD DRUMS FOR 3500KVA, 11KV/3.6KV, 3 PHASE, 2 WINDING, OUTDOOR, ONAN, Z=6.0%, DYN11	NOS.	2			
5.0	302-11055-A	MISCELLANEOUS ITEMS					
5.0(a)		SPECIAL TOOLS AND TACKLES	LOT	1			BIDDER TO FURNISH THE LIST
5.0(b)		FREQUENCY RESPONSE ANALYSIS TEST AT SITE AFTER TRANSFORMER INSTALLATION					
5.0(b.1)		CHARGES PER VISIT	VISIT	2			REFER NOTE 4 & 5
5.0(b.2)		MANDAYS CHARGES	NOS.	4			REFER NOTE 4 & 5

Notes:

- 1 ABOVE QUANTITY OF TRANSFORMERS SHALL BE FOR ORDERING. VARIATION IN RATING AND QUANTITY MAY BE TO THE EXTENT OF ±30% OF THE TOTAL ORDER VALUE.
- 2 BIDDER SHALL SUPPLY 10% EXTRA OIL AS PER THE QUOTED PRICE. QUANTITY OF EXTRA OIL SHALL BE SUBJECT TO APPROVAL DURING DETAIL ENGINEERING.
- 3 BIDDER TO NOTE THAT THE COST OF TRANSFORMER SHALL INCLUDE THE COST OF FOLLOWING SPECIAL TESTS AS ROUTINE TESTS:
 - a) OIL LEAKAGE TEST FOR 8 HRS
 - b) JACKING TEST ON TRANSFORMERS LOAD BEARING MEMBER
 - c) TANK PRESSURE & TANK VACUUM TEST
 - d) DIELECTRIC SPECIAL TESTS AS PER IEC-60076-3
 - e) MEASUREMENT OF CAPACITANCE & TAN DELTA TO DETERMINE CAPACITANCE BETWEEN WINDING, BETWEEN WINDING TO EARTH AND INSULATION SYSTEM CAPACITANCE.
 - f) FREQUENCY RESPONSE ANALYSIS TEST
 - g) MEASUREMENT OF ACOUSTIC SOUND LEVEL
 - h) MEASUREMENT OF ZERO SEQ. IMPEDANCE(S) ON THREE PHASE UNIT
 - i) TEST ON TRANSFORMER OIL AS PER IS:335.
 THE ABOVE MENTIONED TEST SHALL BE CARRIED OUT ON ALL TRANSFORMERS WITHOUT ANY ADDITIONAL COST. BIDDER SHALL QUOTE ACCORDINGLY.
- 4 FOR EACH RATING(2NOS.) OF TRANSFORMER 1(ONE) VISIT AND 2(TWO) MANDAYS TO BE CONSIDERED. THE VISIT CHARGES SHALL BE INCLUSIVE OF CHARGES OF AIR FARE/TRAIN FARE , BOARDING/LODGING, MEDICAL , INSURANCE ETC. TOOLS & TACKLES INCLUDING FREQUENCY RESPONSE ANALYSER FOR TESTING AT SITE SHALL BE ARRANGED BY BIDDER.
- 5 AMOUNT PAYABLE PER VISIT = VISIT CHARGES AS PER SL. NO. 5.0(b.1) ABOVE (+) MANDAYS CHARGES AS PER SL. NO. 5.0(b.2) ABOVE (x) NO. OF DAYS AT SITE(TO BE CERTIFIED BY BHEL SITE)
- 6 BOQ-CUM-PRICES SCHEDULE (ANNEXURE-A & ANNEXURE-C) AND TYPE TEST CONDCTION SCHEDULE (ANNEXURE-D) WILL BE CONSIDERED FOR PRICE EVALUATION PURPOSE.

**1X800 MW KOTHAGUDEM TPS
SPECIFICATION NO.: PE-TS-410-302-E001**

**ANNEXURE-C
BOQ CUM PRICE SCHEDULE FOR OIL FILLED SERVICE TRANSFORMER (MANDATORY SPARES)**

Sr. No.	Item code	Item description	Unit	ORDERED QUANTITY	UNIT PRICE (EX-WORKS) Rs	TOTAL PRICE (EX-WORKS) Rs	REMARKS
	302-11000-B	MANDATORY SPARES FOR EACH TYPE AND RATING OF TRANSFORMER					
1.0		BUSHING					
1.0(a)		HV BUSHING	NO.	1			
1.0(b)		LV BUSHING	NO.	1			
1.0(d)		LV NEUTRAL BUSHING	NO.	1			
2.0		WINDING TEMPERATURE INDICATOR WITH ALL ACCESSORIES	NO.	1			
3.0		OIL TEMPERATURE INDICATOR	NO.	1			
4.0		PRESSURE RELIEF DEVICE OR DIAPHRAGM FOR EXPLOSION RELIEF VENT	NO.	1			
5.0		MAGNETIC OIL LEVEL GAUGE	NO.	1			
6.0		BUCHHOLZ RELAY	NO.	1			
7.0		SILICA GEL BREATHER	NO.	1			
8.0		OIL SURGE RELAY FOR OLTC	NO.	1			
9.0		COMPLETE CABLE CUM BUSDUCT LV TERMINALS	NO.	1			
10.0		VALVE OF EACH TYPE INSTALLED	NO.	1			

Notes:

- 1 BIDDER TO CONSIDERED ABOVE QUANTITY FOR EACH RATING OF TRANSFORMER AND QUOTE ACCORDINGLY.

**1X800 MW KOTHAGUDEM TPS
SPECIFICATION NO.: PE-TS-410-302-E001**

**ANNEXURE-D
(TYPE TESTS TO BE CONDUCTED)**

Sr. No.	Item code	Item description	UNIT PRICE (EX- WORKS) FOR 6300KVA Rs.	UNIT PRICE (EX- WORKS) FOR 3500KVA Rs.	REMARKS
	302-11051-A	TYPE TESTS ON ONE NUMBER OF EACH TYPE AND RATING OF TRANSFORMER			
1.0		TEMPERATURE RISE TEST			
2.0		DIELECTRIC TYPE TESTS			
3.0		SHORT CIRCUIT TEST**	** REFER NOTE- 2		

Notes:

- 1 BIDDER TO QUOTE UNIT PRICES FOR TYPE TESTS AT SL. NO. 1.0 & 2.0 ONLY. CONDUCTION OF SHORT CIRCUIT TEST WILL ALSO BE IN THE SCOPE OF BIDDER, BUT ACTUAL CHARGE FOR THE SAME WILL BE BORNE BY BHEL AS PER NOTE NO. 2 BELOW.
- 2 ** CHARGES FOR CARRYING OUT SHORT CIRCUIT TEST SHALL BE PAYABLE BASED ON ACTUAL INVOICE FROM DESIGNATED LABORATORIES (CPRI, BHOPAL/ CPRI, BANGLORE / ERDA, VADODARA) WITH AN ADDITIONAL LUMP SUM AMOUNT OF 5% OF EX-WORKS PRICE OF TRANSFORMER BEING TESTED TO COVER HANDLING COSTS (TRANSPORTATION, INSURANCE ETC.).
- 3 TYPE TEST REPORTS (CONDUCTED FOR THIS CONTRACT) SHALL BE SUBMITTED FOR APPROVAL DURING DETAILED ENGINEERING.

**1X800 MW KOTHAGUDEM TPS
SPECIFICATION NO.: PE-TS-410-302-E001**

**ANNEXURE-E
(LIST OF TYPE TEST /SPECIAL TESTS INCLUSIVE IN TRANSFORMER PRICES)**

Sr. No.	Item code	Item description	11/3.6KV, 6300KVA	11/3.6KV, 3500KVA	REMARKS
1.0		OIL LEAKAGE TEST FOR 8 HRS	INCLUSIVE	INCLUSIVE	
2.0		TANK PRESSURE TEST	INCLUSIVE	INCLUSIVE	
3.0		TANK VACUUM TEST	INCLUSIVE	INCLUSIVE	
4.0		MEASUREMENT OF ACOUSTIC NOISE LEVEL AS PER NEMA TR-1	INCLUSIVE	INCLUSIVE	
5.0		DGA TEST ON OIL BEFORE AND AFTER TEMPERATURE TEST	INCLUSIVE	INCLUSIVE	
6.0		JACKING TEST ON TRANSFORMERS LOAD BEARING MEMBER	INCLUSIVE	INCLUSIVE	
7.0		MEASUREMENT OF WINDING RESISTANCE	INCLUSIVE	INCLUSIVE	
8.0		MEASUREMENT OF VOLTAGE RATIO AND CHECK OF VOLTAGE VECTOR RELATIONSHIP	INCLUSIVE	INCLUSIVE	
9.0		MEASUREMENT OF IMPEDANCE VOLTAGE /SHORT CIRCUIT IMPEDANCE (PRINCIPAL TAPPING) AND LOAD LOSS	INCLUSIVE	INCLUSIVE	
10.0		MEASUREMENT OF NO-LOAD LOSS AND CURRENT	INCLUSIVE	INCLUSIVE	

Notes:

- 1 TYPE TESTS ON TRANSFORMERS AS LISTED ABOVE (SL NO. 1.0 TO 10.0) AND LISTED IN QUALITY PLAN SHALL BE DEEMED TO BE INCLUDED IN TRANSFORMER PRICES. BIDDER TO NOTE THAT NO SEPARATE TYPE TEST CHARGES SHALL BE PAYABLE EXCEPT CHARGES FOR SHORT CIRCUIT AS OUT LINED IN ANNEXURE-D.
- 2 TESTS (SL NO. 1.0 TO 10.0) SHALL BE CONDUCTED AT THIRD PARTY LAB OR IN PRESENCE OF CLIENT/ EMPLOYER'S REPRESENTATIVE AND VENDOR TO SUBMIT THE REPORTS FOR APPROVAL.

1X800 MW KOTHAGUDEM TPS
SPECIFICATION NO.: PE-TS-410-302-E001

ANNEXURE-F
LIST OF TYPE TESTS/SPECIAL TESTS (VALID REPORTS TO BE SUBMITTED)

Sr. No.	Item code	Item description	11/3.6KV, 6300KVA	11/3.6KV, 3500KVA	REMARKS
1.0		DEGREE OF PROTECTION (IP 55) TESTS ON MARSHALLING BOX	APPLICABLE	APPLICABLE	
2.0		DEGREE OF PROTECTION (IP 55) TESTS ON CABLE BOX	APPLICABLE	APPLICABLE	
3.0		PRD OPERATION TEST(APPLICABLE FOR 2000KVA & ABOVE RATING TRANSFORMER)	APPLICABLE	APPLICABLE	
4.0		MEASUREMENT OF HARMONICS CURRENT IN NO LOAD CURRENT	APPLICABLE	APPLICABLE	

Notes:

- 1 TYPE TEST REPORTS OF A SIMILAR TRANSFORMER (AS PER THE GUIDANCE FOR IDENTIFICATION OF A SIMILAR TRANSFORMER AS DEFINED IN ANNEXURE-B OF IEC 60076-5) TO BE FURNISHED AFTER AWARD OF CONTRACT.
- 2 THE TYPE TEST REPORTS SHALL NOT BE MORE THAN 5 YEARS OLD FROM THE DATE OF TECHNICAL OFFER AND TEST(S) SHOULD HAVE BEEN EITHER CONDUCTED AT AN INDEPENDENT LABORATORY OR SHOULD HAVE BEEN WITNESSED BY A CLIENT.
- 3 IF VALID TYPE TEST REPORTS ARE NOT AVAILABLE OR REPORTS ARE NOT ACCEPTABLE OR REPORTS ARE NOT MEETING THE CONTRACT SPECIFICATION REQUIREMENT DURING DETAILED ENGINEERING THEN ALL TYPE TESTS LISTED ABOVE SHALL BE CONDUCTED FREE OF COST ON ONE TRANSFORMER OF EACH TYPE AND RATING .

Annex B (informative)

Definition of similar transformer

A transformer is considered similar to another transformer taken as a reference if it has the following characteristics in common with the latter:

- same type of operation, for example generator step-up unit, distribution, interconnection transformer;
 - same conceptual design, for example dry type, oil-immersed type, core type with concentric windings, sandwich type, shell type, circular coils, non-circular coils;
 - same arrangement and geometrical sequence of the main windings;
 - same type of winding conductors, for example aluminium, aluminium alloy, annealed or work-hardened copper, metal foil, wire, flat conductor, continuously transposed conductors and epoxy bonding, if used;
 - same type of main windings, for example helical-, disc-, layer-type, pancake coils;
 - absorbed power at short circuit (rated power/per unit short-circuit impedance) between 30 % and 130 % of that relating to the reference transformer;
 - axial forces and winding stresses occurring at short circuit not exceeding 120 % of those relating to the reference transformer;
 - same manufacturing processes;
 - same clamping and winding support arrangement.
-


TECHNICAL SPECIFICATION
FOR
OIL FILLED SERVICE TRANSFORMERS

SPECIFICATION NO.: PE - TS - 999 - 302 - E001

REV. NO. 00




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

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 2 of 50	


CONTENTS

S. NO	DESCRIPTION	NO. OF SHEETS
1	SECTION 'A'	
	SCOPE OF ENQUIRY	01
2.	SECTION 'D'	
	SPECIFIC TECHNICAL REQUIREMENTS	13
	ANNEXURE - I (LIST OF O & M SPARES)	01
	ANNEXURE - II (TYPE TESTS FOR OIL FILLED SERVICE TRANSFORMERS)	01
	ANNEXURE - III (TRANSFORMER LOSSES)	01
	ANNEXURE - IV (DOCUMENTS / DRAWINGS SCHEDULE)	01
	ANNEXURE - V (STANDARD QUALITY PLAN)	06
	ANNEXURE- VI (SPECIAL TOOLS & TACKLES)	01
	ANNEXURE- VII (COMMISSIONING SPARES)	01
	ANNEXURE- VIII (APPLICABLE STANDARDS & CODES FOR TRANSFORMERS)	01
	DATA SHEET -A FOR OIL FILLED SERVICE TRANSFORMERS	06
	DATA SHEET -B FOR OIL FILLED SERVICE TRANSFORMERS	02
	DATA SHEET -C FOR OIL FILLED SERVICE TRANSFORMERS	05
3	PRICE SCHEDULES	
	SCHEDULE OF PRICES- TRANSFORMERS	06
	SCHEDULE OF PRICES- O & M SPARES	01
	SCHEDULE OF PRICES- TYPE TESTS	01

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 3 of 50	


SECTION 'A'

SCOPE OF ENQUIRY


	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 4 of 50	

SCOPE OF ENQUIRY

- 1.0 This specification covers the design, manufacture, inspection and testing at manufacturer's works, proper packing and delivery to site of **OIL FILLED SERVICE TRANSFORMERS**.
- 2.0 It is not the intent to specify herein all the details of design & manufacture. However, the equipment shall conform in all respect to high standards of design engineering and workmanship and shall be capable of performing in continuous commercial operation.
- 3.0 The general terms and conditions, instructions to bidders and other attachment referred to elsewhere are hereby made part of the tender specification.
- 4.0 The bidders shall be responsible for and governed by all requirements stipulated hereinafter.
- 5.0 Bidders shall confirm total compliance to the specification without any deviation from the technical/ quality assurance requirements stipulated

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 5 of 50	

GENERAL TECHNICAL REQUIREMENTS

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 6 of 50	

1.00 INTENT OF SPECIFICATION


- 1.01 This specification covers the design, manufacture, inspection & testing, packing at manufacturer's works and delivery to site of mineral oil filled service Transformers complete with all fittings & accessories for satisfactory operation at site.
- 1.02 The intent of specification is not to specify all details of design & construction of equipment. The equipment shall, however, conform in all aspects to high standard of design, engineering and workmanship and be capable of performing in continuous operation upto & after bidder's guarantee period in manner acceptable to purchaser who will interpret the drawings & specification and shall have power to reject any work or material which in his judgement is not in full accordance with this specification.

2.00 CODES AND STANDARDS

- 2.01 The equipment shall comply with all currently applicable safety codes and statutory regulations of India as well as of the locality where the equipment is to be installed including Indian Electricity Act, Indian Electricity Rules and Bureau of Indian Standards.
- 2.02 The design, material, construction, manufacture, inspection, testing and performance of LT Service Transformers shall conform to the currently applicable standards and codes of practices as per Annexure-VIII. General design, electrical & constructional features and various fittings & accessories shall be as per CBIP manual on Transformers Publication No. 275 (latest edition).
- 2.03 In case of conflict between the applicable reference standard and this specification, this specification shall govern.

3.00 SCOPE OF ENQUIRY

- 3.01 Bidder shall quote for mineral oil filled LT Service Transformers including 10% spare oil in accordance with various sections of this specification. The transformer shall be provided with all fittings & accessories (including foundation hardware) & shall be complete in all aspects, for satisfactory operation, in accordance with this specification & technical particulars. Design ambient temperature shall be 50 deg. C. Project information shall be given separately for the specific project.
- 3.02. Bidder shall quote for following equipment & services:
1. Transformers (Rating & quantity of transformers shall be as per specific project requirement-Sec-C).

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 7 of 50	

2. Special Tools & Tackles required for erection, commissioning and proper maintenance of equipment. One Lot
(Bidder to furnish list along with offer)
3. Commissioning spares for each transformer. One Lot
(Bidder to furnish list along with offer)
4. O & M spares As specified in Annexure-I
5. Type Tests As specified in Annexure-II

Note:

Extra 10% of total oil quantity shall be supplied along with the first lot of transformers in sealed non-returnable drums.

4.00 SERVICES & EQUIPMENT TO BE EXCLUDED


- 4.01 Civil work such as transformer foundation, cable trenches etc.
- 4.02 Erection, testing, commissioning of transformer at site.
- 4.03 External power connection for HV & LV side of transformer by means of busduct/ cables, as applicable.
- 4.04 HV termination kits.
- 4.05 Connection to Station Earth.

5.00 TERMINAL POINTS


- I. HV bushings with terminal connector for bus duct/ cable glands & lugs in case of cable connection.
- II. LV bushings with terminal connector (3 Phase + 1 Neutral) for bus duct/ cable glands & lugs in case of cable connection.
- III. For HV Earthing : (Applicable in case of star connection of HV) - neutral earth busbar brought near the base of transformer/ Cable glands & lugs in case of cable connection
- IV. For LV Earthing : - neutral earth busbar brought near the base of transformer/ Cable glands & lugs in case of cable connection
- V. Transformer earthing pads.
- VI. Terminals of marshalling box for external connection to equipment supplied by the purchaser.

6.00 TECHNICAL REQUIREMENTS

- 6.01 Technical particulars of transformers are specified in Data Sheet –A

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 8 of 50	

- 6.02 Equipment shall give continuous service under specified site conditions.
- 6.03 All windings shall be fully insulated. Material of the windings shall be electrolytic grade copper, free from scales and burrs. Winding shall be uniformly insulated.
- 6.04 The core shall be constructed from high grade, non-ageing, cold rolled, grain oriented silicon steel laminations.
- 6.05 Internal design of transformer shall ensure that air is not trapped in any location.
- 6.06 Under base of tank shall be fixed type.
- 6.07 Nuts, bolts and pins used inside the transformer shall be provided with lock washers & locknuts
- 6.08 Specific technical requirements are as follows:
- 6.08.01 **Tank:** - Fabricated from tested quality steel and designed to withstand continuous internal pressure of 35 kN per sq. m. over normal pressure as well as short circuit forces. The main tank body including tap-changer compartment, radiators and coolers shall be capable of withstanding full vacuum. All steel surfaces in contact with insulating oil shall be painted with two coats of heat resistant oil in soluble insulating varnish. Tank shields, if provided, shall not resonate at natural frequency of equipment.
- 6.08.02 **Tank mounting** Transformer tank shall be mounted on bi-directional rollers. Suitable locking arrangement shall be provided to prevent accidental movement of transformer. Tank shall also be provided with lifting lugs and minimum four jacking pads. Rollers shall be provided with holding clamp plates (04 nos), required hardware and foundation bolts etc. for each transformer.
- 6.08.03 **Tank openings** At least two adequately sized inspection openings, one at each end of the tank for easy access to bushings and earth connections.
- 6.08.04 **Oil preservation** Conservator tank of adequate capacity for expansion of oil from minimum ambient to 100 deg. C shall be provided. The transformers rated 6.3MVA and above shall be provided with air bag breathing through silica gel breather. For lower rating transformers with conventional conservator with dry air filling of the space above oil and connected to silica gel breather shall be provided.
- 6.08.05 **Radiators** Tank mounted with shut off valves.


	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 9 of 50	

6.08.06 **Insulating Oil** As per IS: 335. No external inhibitors are permitted.

6.08.07 All transformers shall be suitable for cable/ Busduct termination as indicated in data sheet-A.

6.08.09 Bushings/ Insulators

- a) The bushings shall conform to the requirements of IS: 2099 and IS: 3347 and shall be of porcelain and above 3150A for the LV bushing Epoxy bushing can be acceptable.
- b) For 3.3kV, 6.6kV and 11 kV windings, 17.5kV bushing shall be provided. For 415V windings, 1.1kV bushings shall be provided.
- c) The porcelain shall not engage directly with hard metal and, wherever necessary, gaskets shall be interposed between the porcelain and the fitting.
- d) Clamps and fittings of steel or malleable cast iron shall be galvanised.
- e) Where bushing current transformer is provided, the bushing shall be mounted so that it can be removed and replaced without disturbing the current transformers. CTs shall be cast resin type & suitable for operation at ambient temperature existing at its location on the transformer.
- f) Creepage distance shall be as per data sheet-A.
- g) Minimum rated current for bushings shall be as under. However, same shall comply with IS-2099 and HV/LV system fault current mentioned in Clause No. 20.00 of Datasheet A:
 - 1) H V Bushing for 11kV & 6.6kV
 - 10.0MVA= 1000A
 - 8.0MVA = 1000A
 - 6.3MVA = 800A
 - 5.0MVA = 630A
 - 3.5MVA = 250A
 - 2.5 MVA = 250A
 - 2.0 MVA = 250A
 - 1.6 MVA = 250A
 - 1.0 MVA = 100A
 - 630 kVA = 100A
 - 2) H V Bushing for 3.3kV
 - 2.5 MVA = 630A
 - 2.0 MVA = 500A
 - 1.6 MVA = 400A

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 10 of 50	


1.0 MVA = 250A
630 kVA = 250A

- 3) L V Bushing for 11kV, 6.6kV & 3.3kV
10.0MVA= 2500A
8.0MVA = 2000A
6.3MVA = 1600A
5.0MVA = 1250A
3.5MVA= 1250A

- 4) L V Bushing for 433V/420V
2.5 MVA = 4000A
2.0 MVA = 4000A
1.6 MVA = 3150A
1.0 MVA = 2000A
630 kVA = 1000A

6.08.10 Cable Box

- a) A dust tight air insulated type cable box with D.O.P. of IP: 55 shall be provided for terminating the cables directly of size and type specified in Data sheet-A. The cable box shall also be provided with a suitable canopy. Suitable cable glands (double compression type) and lugs shall be provided for cable termination.
- b) Dimensions of cable box shall be subject to purchaser's approval.
- c) Inspection cover for fixed portion of cable box shall be provided. Handles for lifting cable box shall be provided.
- d) Creepage distance and clearances in air shall be as per CBIP manual.
- e) Provision shall be made for earthing the body of each cable box. Separate earthing pads shall be provided for this purpose, suitable for bolted connection to galvanised mild steel flat of size to be specified during contract engineering stage.
- f) Gland plate for single core cable termination shall be of Aluminium.
- g) Cable box (es) shall be provided with suitable air-insulated disconnecting chamber so that if required, transformer can be removed from its position without disconnecting the cables in the cable box (es). Independent supporting arrangement shall be provided for cable box (es) for this purpose. Supporting arrangement shall be supplied along with required hardware & foundation bolts etc.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 11 of 50	

6.08.11 Busduct Termination

If LV terminals are specified to be connected by means of a busduct, a flanged throat or equivalent connection shall be provided to suit purchaser's busducts. The winding termination shall be on outdoor type of bushing. Necessary flexibles shall be provided by purchaser to connect the bushing terminals to the busbars of the busduct. Details of busduct shall be furnished during detail engineering stage. Degree of protection of LV busduct flange enclosure shall be IP: 55.

6.08.12 Neutral Terminals


Two (2) nos. neutral terminals shall be provided on LV side. One neutral terminal shall be part of phase connection arrangement busduct throat/ LV cable-box (as applicable). Other neutral terminal shall be in a separate box and brought to tank bottom by means of earthing bar of 50x6 mm of copper, supported on porcelain insulators mounted on transformer tank. The neutral earthing bar brought to the tank bottom for connection to station earth shall be provided with holes and suitable connecting hardware. This earthing bar shall have fork type arrangement at the end.

6.09 Neutral CT

Bidder to provide neutral bushing CT as per details given in data sheet - A for restricted earth fault protection or standby earth fault protection. In case neutral CT is tank mounted, CT box shall be weather proof having D.O.P. IP: 55. The Neutral CT box shall also be provided with a suitable canopy. CTs shall be cast resin type. CT mounted inside the tank shall not be acceptable.

6.10 Voltage control (off circuit type)

- Off circuit tap-changing switch shall be three phase, hand operated, for simultaneous switching of similar taps on all the three phases by operating an external handle/ hand wheel.
- Operating mechanism of tap changer shall be suitably labelled to show the direction of operation for raising secondary voltage & vice versa. Position markings shall be provided.
- Arrangement shall be made for securing and padlocking the tap-changing switch at any working position. It shall not be possible to set and padlock in any intermediate position.
- The position of off-circuit tap switch handle/hand wheel provided outside the transformer tank should be such as to enable an operator standing on ground to operate the same with ease. A caution plate indicating that switch shall be operated only when the transformer is de-energised shall be fitted near tap switch.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 12 of 50	

- e) Tap position indicator and mechanical stops to prevent over-cranking of the mechanism shall be provided.

6.11 Marshalling box

- a) Tank mounted vermin and dust proof marshalling box shall be provided.
- b) The marshalling box shall be fabricated using sheet steel of at least 2.5mm thickness. The marshalling box shall have domed or sloping roof.
- c) Marshalling box shall be complete with all internal wiring and identification ferrules, cables, conduits required for wiring between marshalling box and instruments on transformer. Wiring shall be by 1100 V grade, copper cable of size 2.5mm².
- d) The terminal blocks shall be complete with insulating barriers and clip-on type terminals suitable for 2.5mm² stranded copper wire. At least 20% spare terminals shall be provided.
- e) The marshalling box shall be provided with thermostatically controlled space heaters and shall have IP: 55 degree of protection. The marshalling box shall also be provided with a suitable canopy.
- f) CT terminals shall be with shorting and disconnecting facility.

6.12 Flux density

Flux density in any part of the core & yoke on any tap position with $\pm 10\%$ voltage variation from voltage corresponding to the tap shall not exceed 1.9 Wb/m².

Transformer shall also withstand following conditions due to combined voltage and frequency variations:


- Continuous operation for 110% flux density
- At least 1 minute operation for 125% flux density
- At least 5 sec. operation for 140% flux density

6.13 Winding

For 11KV & 3.5KV winding, type of winding shall be continuous disc & for 433V winding, type of winding shall be spiral type.

6.14 Noise & Vibration

The design and manufacture of transformer, fittings and accessories shall be such as to reduce noise & vibration. Noise level shall not be more than as specified in NEMA Standard

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 13 of 50	

Publication TR-1, when measured with transformer energised at normal voltage and frequency.

6.15 All transformers and their accessories shall be capable of withstanding without damage any external short circuit at the terminals for duration of two seconds. Calculation shall be furnished by the bidder during contract engineering stage to substantiate the adequacy of support system to withstand short circuit forces.

6.16 Maximum Transformer losses including tolerances shall be as per annexure – III.


6.17 LOADING CAPABILITY

Transformer shall be suitable for continuous operation at rated kVA on any tap with voltage variation of $\pm 10\%$ corresponding to voltage of the tap. Short duration overloading shall be in accordance with IEC 354/IS: 6600.

7.0 Fittings & accessories

7.01 Transformer shall be provided with, but not restricted to following minimum fittings and accessories for satisfactory operation:

- a) Conventional type conservator with drain valve and oil filling hole.
- b) Magnetic oil level gauge with low-level alarm contact.
- c) Prismatic & toughened glass oil level gauge.
- d) Gaskets
- e) Gasket protection covers.
- f) Silica gel breather with oil seal.
- g) Double float type Buchholz relay with alarm and trip contacts with suitable gas collecting device with two shut-off valve on both side.
- h) Diaphragm type explosion vent for transformers of rating less than 2MVA
- i) Pocket on tank cover for thermometer.
- j) Protected type mercury in glass thermometer.
- k) Dial type (150 mm) Oil temperature indicator (OTI) with two sets of electrical potential-free contact rated for 2A, 220V DC, for alarm and trip purpose. The OTI shall be provided with anti-vibration mounting. OTI shall have maximum reading pointer along with resetting device. For remote oil temperature metering, an independent dual output 4-20 mA should be made available.
- l) Dial type (150 mm) Winding temperature indicator (WTI) with two sets of electrical potential-free contact rated for 2A, 220V DC, for alarm and trip purpose. The WTI shall be provided with anti-vibration mounting. WTI shall have maximum reading position along with resetting devices. For remote winding temperature metering, an independent dual output 4-20 mA should be made available.
- m) Drain Valves.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 14 of 50	

- n) Sampling devices.
- o) Filter valves.
- p) Earthing terminals – 2 Nos.
- q) Rating & Diagram plates.
- s) Valve schedule plate.
- t) Two sets of lifting lugs (one for transformer with oil and other for tank cover).
- u) Jacking pads.
- v) Skids and pulling eyes on both sides.
- w) Air release devices.
- x) Inspection cover.
- y) Oil filling hole and cap.
- z) Tank mounted marshalling box.
 - aa) Detachable, flat, bidirectional rollers with 90 deg. swivel mechanism.
 - bb) Clamping arrangement for rollers.
 - cc) Ground support for cable box.
 - dd) Neutral CT secondary box.
 - ee) Haulage facilities.
 - ff) Two nos. spring operated pressure relief devices with extension pipe to bring oil to plinth level along with electrically insulated contact for alarm and tripping for transformer rating 2 MVA and above.
 - gg) Gas collection device along with all accessories.

7.02 Breather shall be fitted at a height not exceeding 1.5 M.

7.03 Rating and diagram plate shall be fitted at a height of about 1.75 M above the ground level.


7.04 The WTI and OTI shall have accuracy class of ± 2 deg. C or better.

7.05 Rating/ Name/ Valve schedule plates shall be of white non-hygroscopic material with engraved black lettering. Such plates shall be bi- lingual with Hindi inscription first, followed by English. Alternatively, two separate plates with Hindi & English inscription shall be provided.

8.00 PAINTING

Paint shade shall be informed to successful bidder during detail engineering as applicable for specific project.

Successful bidder shall furnish painting specification/ procedure to be used for BHEL/ CUSTOMER approval during detailed engineering. Adequate quantity of touch up paint shall also be supplied. There shall be no commercial or delivery implication to BHEL on account of paint shade, paint specification/ procedure.


	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 15 of 50	

9.00 COMMISSIONING, O & M SPARES AND SPECIAL TOOLS & TACKLES

- 9.01 Commissioning spares are those, which may be required during commissioning of the equipment. Bidder to furnish list of commissioning spares along with technical offer
- 9.02 O & M spares are those which are required for satisfactory & trouble free operation of equipment. List of O & M spares is enclosed as per Annexure-I.
- 9.03 The bidder shall supply with the equipment, one unused complete set of all special tools & tackles required for the erection, assembly, disassembly and proper maintenance of the equipment. A list of such tools & tackles (price deemed to be included in the total bid price) shall be submitted by the bidder along with the offer.

10.00 QUALITY ASSURANCE, TESTING & INSPECTION


- 10.01 BHEL's Standard QP (PED-302-00-Q-001 Rev. 03) is enclosed as per Annexure-V for reference. However, at contract stage, the successful bidder shall submit the QP for BHEL/ultimate customer's approval. In case bidder has reference QP agreed with ultimate customer, same can be submitted for specific project after award of contract for BHEL/ultimate customer's approval. There shall be no commercial implication to BHEL on account of QP approval.
- 10.02 All materials, components and accessories of the transformers shall be procured, manufactured, inspected and tested by vendor/ sub-vendor as per approved quality plan.
- 10.03 Tests shall be performed in presence of Purchaser's representative. The bidder shall give at least fifteen (15) days advance notice of date when the tests are to be carried out.
- 10.04 All routine and acceptance tests as per relevant standards and specification shall be carried out by the vendor/ sub-vendor on all transformers. Charges for all these routine and acceptance tests for all the equipments & components shall be deemed to be included in the bid price.
- 10.05 Additionally, the bidder shall include in his equipment price the cost of carrying out the following special tests as routine tests on all the transformers:
- 1) Oil Leakage test for 24 hours
 - 2) Jacking test on transformer's load bearing members.
 - 3) Repeat no load loss tests after electrical tests.
 - 4) Measurement of capacitance & tan delta to determine capacitance between winding & earth.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 16 of 50	

- 10.06 Type tests & special tests shall be conducted on one transformer of each rating and type as per Annexure-II. The charges for each of the type test & special test shall be quoted in “Schedule of Prices –Type/special Tests on Transformers”. These charges shall also be applicable in case of waiver of any type test/special test by the purchaser at a later date.
- 10.07 Successful bidder shall furnish List of sub-vendors/ makes of items for BHEL/ customer approval at contract stage. This shall not have any commercial implication to BHEL.
- 10.08 Charges for all type tests and special test as per Annexure-II except Short circuit test shall be considered for price comparisons purpose.
- 10.09 Charges for carrying out Short circuit test shall be payable based on actual invoice from the designated laboratories (CPRI, Bhopal / CPRI, Bangalore / ERDA, Vadodara) with an additional lump sum amount of 5% of ex-works price of transformer being tested to cover handling costs (transportation, insurance etc.).
- 10.10 In case any of the type and special tests are required to be repeated the same shall be carried out by the vendor without any commercial / delivery implication to BHEL.
- 10.11 For acceptance of short circuit reports for tests carried out earlier on similar transformers, successful bidder shall furnish the following documents for BHEL/ BHEL’s customer acceptance without any commercial/ delivery implication to BHEL
- Calculations and design considerations to prove ability to withstand the dynamic effects of short circuit.
 - Short circuit test report of previously tested similar transformer for validation by comparison. Criteria for similarity of transformer for acceptance of Short circuit test report shall be as given in the Annexure-B of IEC-60076-5.

11.00 DRAWINGS, DATA & DOCUMENTS TO BE SUBMITTED

- 11.01 Following shall be submitted along with the offer:
- The enclosed Data Sheet-B filled up completely for each rating/ type of transformers.
 - Clause – wise deviation, if any.
- 11.02 Following documents shall be submitted after placement of order for BHEL & customer’s approval:
- The enclosed Data Sheet – C duly filled up.
 - Vendor drawing submission schedule.
 - Design calculations for short circuit withstand capability (refer cl.6.15 & cl 10.11)

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 17 of 50	

- d) Overall General Arrangement Drawing clearly showing all fittings, accessories, termination details, foundation details with roller locking arrangement.
- e) General Arrangement of Marshalling Box.
- f) Rating & Diagram Plate Drawing.
- g) Valve Schedule Plate Drawing.
- h) Cable Box Arrangement Drawing.
- i) Bushing/ Insulator Drawings.
- j) Busduct Trunking Drawings.
- k) Quality Plan.
- l) Type test procedure
- m) Wiring Diagrams.
- n) Type/ Special Test certificates for tests already carried out on similar transformers.
- n) Painting procedure of vendor for approval of customer.
- o) Recommended Field Quality Plan
- q) Routine test reports
- r) O & M Manuals

The documents listed at sl. no. a),b) & c) shall be submitted by successful bidder within 2 weeks from L.O.I while documents sl. no. d) through o) shall be submitted by successful bidder within 4 weeks from L.O.I.


No. of documents/ drawings required shall be as per “Documents/ Drawings Distribution Schedule” enclosed as per Annexure-IV.

12.00 O & M MANUALS

12.01 O & M manuals for the installation, operation and maintenance of transformers shall be furnished at least three months before despatch of equipment.


12.02 Draft manual should first be submitted for purchaser’s approval. The manual should contain minimum following details:

- a) General description of equipment.
- b) Approved Technical Data Sheet
- c) Salient constructional features.
- d) Technical leaflets of fittings/ important parts.
- e) All drawings.
- f) Type and routine test certificates.
- g) Instructions to be followed on receipt of equipment at site & for storage.
- h) Instructions for foundation arrangement.
- i) Erection procedures and checks.
- j) Pre-commissioning checks.
- k) Commissioning procedures.
- l) Withdrawal arrangement/ material handling instructions.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 18 of 50	

- m) Operation instructions.
- n) Maintenance instructions.
- o) Trouble-shooting.
- p) Safety instructions.

13.00 All drawings/ documents indicated at clause no. 11 & 12 above shall be computer generated. Drgs. / documents shall be required in soft form (PDF format) also. All drawings shall be prepared in AUTOCAD latest version. Drawings & documents shall be submitted in CD also. The number of copies of various drawings/ documents shall be as per Annexure -IV.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 19 of 50	

ANNEXURE-I


NOT TO BE QUOTED

LIST OF O & M SPARES

S. NO.	DESCRIPTION	QTY
1	HV bushing with metal parts & gaskets	1 no. for each rating
2	LV bushing with metal parts & gaskets	1 no. for each rating
3	WTI with alarm & trip contacts	1 no.
4	OTI with alarm & trip contacts	1 no.
5	Magnetic oil level gauge	1 no.
6	Diaphragm of explosion vent	1 no.
7	Buchholz relay	1 no.
8	Silica gel charge	Three charge
9	Floats with contacts for Buchholz relay	1 set
10	Set of gaskets	2 sets
11	Set of valves (1 no. of each size & Type)	1 set
12	Set of windings for one limb in a suitable oil container (container shall be completely filled with transformer oil)	1 no. of each rating & type of transformer.
13	Contact for tap changer	1 set
14	Pressure relief device for 2MVA & above transformers	1 no.
15	Hydraulic/screw Jacks	4 no.
16	Any other item considered essential by the bidder	

Note:


- 1) Wherever set is indicated above, it means the total parts/ accessories required to replace the particular item for a given equipment
- 2) O & M spares shall be supplied along with transformers and packed separately with proper inscription.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 20 of 50	

ANNEXURE-II

TYPE/SPECIAL TESTS FOR OIL FILLED SERVICE TRANSFORMERS

- a) Tank Pressure test
- b) Tank Vacuum test
- c) Capacitance & tan delta of windings
- d) Noise level
- e) Measurement of harmonic current in no load current
- f) PRD operation test (applicable for 2000kVA & 2500kVA transformer)
- g) Short circuit test
- h) Degree of protection (IP55) test on marshalling box.
- i) Degree of protection (IP55) test on cable box.
- j) Degree of protection (IP55) test on LV busduct flange enclosure.
- k) Zero sequence impedance.
- l) Temp rise test.
- m) Dielectric type test (including chopped wave impulse test)
- n) DGA test on oil before and after temperature test.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 21 of 50	

ANNEXURE III

TRANSFORMER LOSSES


1. The No-Load and Load losses for transformers are given below:

11KV/433V, 6.6KV/433V & 3.3KV/433V TRANSFORMERS

Ratings	Maximum No-Load losses at rated frequency and 100% voltage	Maximum Load losses at normal ratio, rated current and 75 deg. C
<u>10.0 MVA</u>	9.0kW	72.0kW
<u>8.0MVA</u>	7.5 kW	57.0kW
<u>7.5 MVA</u>	7.2 kW	50.0kW
<u>6.3MVA</u>	6.5kW	45.0kW
<u>5.0MVA</u>	5.5kW	36.0kW
<u>3.5kVA</u>	4.5kW	32.0kW
<u>2.5 MVA</u>	2.8kW	30.0kW
<u>2.0MVA</u>	2.4 kW	24.0kW
<u>1.6MVA</u>	2.1kW	19.0kW
<u>1.25 MVA</u>	1.7kW	15.0kW
<u>1.0MVA</u>	1.5kW	12.0kW
<u>630 kVA</u>	1.0kW	7.5kW

- The above indicated maximum No-Load and Load losses are inclusive of permissible tolerance as per IS-2026. Further tolerance on maximum losses is not permissible.
- In case measured losses of transformers during testing exceeds the above mentioned values, BHEL may accept the transformer with penalty. The rate of penalty shall be Rs. 1.95 lacs per kW. The penalty shall be calculated for each transformer as given below:


$$\text{PENALTY} = \text{Penalty Rate} \times [\text{measured No-Load losses} - \text{maximum No-Load losses}] + (\text{measured Load losses} - \text{maximum Load losses})$$

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 22 of 50	

ANNEXURE- IV


DOCUMENTS/ DRAWINGS DISTRIBUTION SCHEDULE


S. NO.	DESCRIPTION	No. hard prints/Soft copies	No. of CD-ROMs	REMARKS
1.	Docs. /drgs. for approval (First submission)	1 Hard copies + Soft Copy	Nil	
2.	Drgs. / docs. for approval (Second & subsequent submission till approval)	Soft Copy	Nil	
3.	Final approval drgs. / docs. for Distribution	14 Hard Copies + Soft Copy	3 CD-ROMS	
4.	As Built Drg.	6 Hard copies + Soft Copy	3 CD-ROMS	
5.	Operation & Maintenance manual for approval	Soft Copy		
6.	Approved Operation & Maintenance Manual for distribution	6 Hard copies + Soft Copy	3 CD-ROMS	
7.	Erection/ Installation Manual	6 Hard copies	3 CD-ROMS	
8.	Type Test Certificates/ Reports	1 Hard copies + Soft Copy		


	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 23 of 50	


ANNEXURE - V


STANDARD QUALITY PLAN


		QUALITY PLAN			CUSTOMER : TSGENCO		PROJECT TITLE : 1X800MW KOTHAGUDEM		SPECIFICATION NO. : PE-TS-410-302-E001			
					BIDDER/ VENDOR :		STANDARD QP NO. : PE-QP-999-302-E001, REV. 0		SPECIFICATION TITLE:			
		SHEET 1 OF 10		SYSTEM			ITEM : OIL FILLED TRANSFORMER			DOC. NO. :		
SL. NO.	COMPONENT/OPERATION	CHARACTERISTIC CHECK	CAT.	TYPE/ METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY			REMARKS
									P	W	V	
1	2	3	4	5	6	7	8	9	10			11
1.0 RAW MATERIALS & BOUGHT OUT ITEMS												
1.1	Mild Steel plate, MS Pipe, Channels, MS Angles	a) Thickness b) Surface defects c) Chemical composition d) Mechanical Properties e) Hydraulic test of pipes	Major Major Major Major Major	MEASURE VISUAL TEST TEST TEST	10% 100% - - -	'MANUF. STD / IS:2062 / IS:1239	'MANUF. STD / IS:2062 / IS:1239	QC Record. QC Record. Supplier's TC Supplier's TC Supplier's TC	3/2 3/2 3/2 3/2 3/2		1 2 - 2 2	
1.2	CRGO Steel	a) Thickness Dimension & Finish b) Grade of CRGO c) Cutting & burr d) Scratches, surface finish e) Waviness & edge camber f) Specific core loss g) Surface resistivity h) Stacking factor i) Permeability j) Bend test/ Ductility	Major Major Major Major Major Major Major Major Major Major	MEASURE MEASURE MEASURE VISUAL MEASURE TEST TEST TEST TEST TEST MEASURE	10% - 10% 10% 10% - - - - - -	DRG/DATA SHEET/ 'MANUF. STD / IS:3024 / IS:649	DRG/DATA SHEET/ 'MANUF. STD / IS:3024 / IS:649	QC Record. TC QC Record. QC Record. QC Record. Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC	2 3/2 2 3/2 2 3/2 3/2 3/2 3/2 3/2		1 2 - - 1 2 2 2 2 2	
1.3	Paper Insulated Copper Conductor	a) Dimensions b) Resistivity/Conductivity c) Elongation d) Tensile Strength e) Proof stress if applicable f) Insulation test between strands for bunched conductors g) Cu purity of CC rod h) Chemical composition i) Surface Finish	Major Major Major Major Major Major Major Major Major	MEASURE TEST TEST TEST TEST TEST TEST TEST TEST VISUAL	100% 10% - - - - - - - 100%	'MANUF. STD / IS:13730-P-27/IEC 60554	'MANUF. STD / IS:13730-P-27/IEC 60554	QC Record. Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC QC Record.	2 3/2 3/2 3/2 3/2 3/2 3/2 3/2 3/2 2		1 1 2 2 2 2 2 2 2 2	
1.4	Insulating Paper	a) Dimensions b) Density & substance c) Tensile Strength d) Elongation e) Water absorption f) Moisture content g) pH value & conductivity aqueous extract h) Ash content i) Electrical strength j) Air permeability k) Tear index l) Heat stability	Major Major Major Major Major Major Major Major Major Major Major Major	MEASURE TEST TEST TEST TEST TEST TEST TEST TEST TEST TEST TEST TEST	10% - - - - - - - - - - - -	'MANUF. STD / IS:9335-P-2/IS:9335-P-III/IEC 60554	'MANUF. STD / IS:9335-P-2/IS:9335-P-III/IEC 60554	QC Record. Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC	2 3/2 3/2 3/2 3/2 3/2 3/2 3/2 3/2 3/2 3/2 3/2		1 2 2 2 2 2 2 2 2 2 2 2	
BHEL			PARTICULARS			BIDDER/VENDOR						
			NAME									
			SIGNATURE									
			DATE									
												BIDDER'S/VENDORS COMPANY SEAL
LEGEND : 1 - BHEL/ CUSTOMER 2 - VENDOR 3 - SUB- VENDOR P - PERFORM W - WITNESS V - VERIFICATION												


		QUALITY PLAN			CUSTOMER :			PROJECT TITLE :			SPECIFICATION NO. :		
SHEET 2 OF 10		BIDDER/ VENDOR :			STANDARD QP NO. : PE-QP-999-302-E001, REV. 0			SPECIFICATION TITLE:					
SYSTEM		ITEM : OIL FILLED TRANSFORMER			DOC. NO. :								
SL. NO.	COMPONENT/OPERATION	CHARACTERISTIC CHECK	CAT.	TYPE/ METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY			REMARKS	
									P	W	V		
1	2	3	4	5	6	7	8	9	10			11	
1.5	Insulation & Press-Board moulding (stock items)	a) Dimension	Major	Measure	10%	'MANUF. STD / IS:1576	'MANUF. STD / IS:1576	QC Record.	2		1		
		b) Compressibility	Major	Test	-			Supplier's TC	3/2		2		
		c) Density	Major	Test	-			Supplier's TC	3/2		2		
		d) Tensile strength	Major	Test	-			Supplier's TC	3/2		2		
		e) pH value/Conductivity of water extract	Major	Test	-			Supplier's TC	3/2		2		
		f) Electrical strength in air & oil	Major	Test	-			Supplier's TC	3/2		2		
		g) Shrinkage in air	Major	Test	-			Supplier's TC	3/2		2		
		h) Flexibility	Major	Test	-			Supplier's TC	3/2		2		
		i) Ash content	Major	Test	-			Supplier's TC	3/2		2		
		j) Moisture content	Major	Test	-			Supplier's TC	3/2		2		
		k) Cohesion between plies	Major	Test	-			Supplier's TC	3/2		2		
		l) Elongation	Major	Test	-			Supplier's TC	3/2		2		
		m) Oil absorption	Major	Test	-			Supplier's TC	3/2		2		
1.6	Densified wood	a) Dimension	Major	Measure	10%	'MANUF. STD / IS:3513	'MANUF. STD / IS:3513	QC Record.	2		1		
		b) Surface finish	Major	Visual	10%			QC Record.	2		-		
		c) Electrical strength in oil	Major	Test	-			Supplier's TC	3/2		1		
		d) Oil absorption	Major	Test	-			Supplier's TC	3/2		-		
		e) Moisture content	Major	Test	-			Supplier's TC	3/2		-		
		f) Compression strength	Major	Test	-			Supplier's TC	3/2		-		
		g) Crossbreaking strength	Major	Test	-			Supplier's TC	3/2		-		
		h) Tensile strength	Major	Test	-			Supplier's TC	3/2		-		
		i) Specific gravity/ Density	Major	Test	-			Supplier's TC	3/2		-		
		1.7	Gasket(Rubber Bonded Cork sheet (if applicable)	a) Dimension	Major			Measure	10%	'MANUF. STD / IS:4253	'MANUF. STD / IS:4253		QC Record.
b) Hardness	Major			Test	-	Supplier's TC	3/2		1				
c) Tensile strength	Major			Test	-	Supplier's TC	3/2		-				
d) Compressibility	Major			Test	-	Supplier's TC	3/2		1				
e) Recovery	Major			Test	-	Supplier's TC	3/2		-				
f) Compression set	Major			Test	-	Supplier's TC	3/2		-				
g) Flexibility	Major			Test	-	Supplier's TC	3/2		-				
h) Fluid resistance test	Major			Test	-	Supplier's TC	3/2		-				
i) Chloride/Sulphate content of water extract	Major			Test	-	Supplier's TC	3/2		-				
j) Density	Major			Test	-	Supplier's TC	3/2		-				
1.8	Nitrile Rubber Cord and "O" Ring (if applicable)			a) Dimension	Major	MEASURE	10%	'MANUF. STD / IS:4253	'MANUF. STD / IS:4253			Supplier's TC	2
		b) Shore Hardness	Major	Test	-	Supplier's TC	3/2				-		
		c) Tensile strength	Major	Test	-	Supplier's TC	3/2				-		
		d) Elongation at break	Major	Test	-	Supplier's TC	3/2				-		
		e) Compression set	Major	Test	-	Supplier's TC	3/2				-		
		f) Accelerated Ageing in oil	Major	Test	-	Supplier's TC	3/2				-		
BHEL			PARTICULARS			BIDDER/VENDOR							
			NAME										
			SIGNATURE										
			DATE										
LEGEND :			1 - BHEL/ CUSTOMER	2 - VENDOR	3 - SUB- VENDOR	P - PERFORM	W - WITNESS	V - VERIFICATION	BIDDER'S/VENDORS COMPANY SEAL				

		QUALITY PLAN			CUSTOMER :			PROJECT TITLE :			SPECIFICATION NO. :		
SHEET 4 OF 10		BIDDER/ VENDOR :			STANDARD QP NO. : PE-QP-999-302-E001, REV. 0			SPECIFICATION TITLE:					
SYSTEM		ITEM : OIL FILLED TRANSFORMER			DOC. NO. :								
SL. NO.	COMPONENT/OPERATION	CHARACTERISTIC CHECK	CAT.	TYPE/ METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY			REMARKS	
									P	W	V		
1	2	3	4	5	6	7	8	9	10			11	
2.3	Bucholz Relay	a) Type, size & make b) Continuity for alarm & trip (Performance) c) Porosity test d) High voltage & IR test e) Element test f) Gas volume test g) Loss of oil & surge test	Major Major Major Major Major Major Major	Visual Test Test Test Test Test Test	100% - - - - - -	MANFUF. STD./ IS:3637	MANFUF. STD./ IS:3637	QC records Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC	2 3/2 3/2 3/2 3/2 3/2 3/2		1 2 2 2 2,1 2,1		
2.4	Pressure Relief Device	a) Type, size & make b) Operation (Pressure & flag indication) c) HV Test d) Switch contact operation	Major Major Major Major	Visual Test Test Test	100% - - -	MANFUF. STD./ IS:3637	MANFUF. STD./ IS:3637	QC records Supplier's TC Supplier's TC Supplier's TC	2 3/2 3/2 3/2		1 2,1 2,1 2		
2.5	Magnetic Oil Level Gauge (MOG)	a) Type, size & make b) Dial marking c) Switch continuity d) HV test e) Operation test	Major Major Major Major Major	Visual Visual Test Test Test	100% - - - -	MANFUF. STD'	MANFUF. STD.'	QC records Supplier's TC Supplier's TC Supplier's TC Supplier's TC	2 3/2 3/2 3/2 3/2		1 2 2 2 2		
2.6	Off-Circuit Tap Changer/Switch (if applicable)	a) Dimensions b) Physical condition c) operation of switch d) Insulation resistance test e) Leak test of handle stuffing box f) Milli volt drop test	Major Major Major Major Major Major	Measure Visual Test Test Test Test	100% 100% - - - -	MANFUF. STD'	MANFUF. STD'	QC records QC records QC records Supplier's TC Supplier's TC Supplier's TC	2 2 2 3/2 3/2 3/2		- - - 2 2 2		
2.7	On load Tap Changer (if applicable)	a) Visual check b) Dimensional check c) Mechanical operation on Diverter & Selector switch, 4000 switching oper. (Min) d) HV test on Auxiliary circuit e) Sequence test f) Pressure test of diverter switch compartment with oil g) Mechanical test of Tap selector with motor drive 500 satisfactory opm(in all) from one extreme position to the other in air h) Opm test of complete tapchanger i) Aux. ckt. HV test at 2 KV for 1 min.	Major Major Major Major Major Major Major Major Major	Visual Measure Verify Test Test Test Test Test Test	100% 100% - - - - - - -	IS:8468/IEC 60214	IS:8468/IEC 60214	QC records Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC	2 2 3/2 3/2 3/2 3/2 3/2 3/2		- - 2 2,1 2,1 2,1 2,1 2,1		
			PARTICULARS			BIDDER/VENDOR							
BHEL			NAME										
			SIGNATURE										
			DATE										
			BIDDER'S/VENDORS COMPANY SEAL										
LEGEND : 1 - BHEL/ CUSTOMER 2 - VENDOR 3 - SUB- VENDOR P - PERFORM W - WITNESS V - VERIFICATION													

		QUALITY PLAN			CUSTOMER :			PROJECT TITLE :			SPECIFICATION NO. :			
					BIDDER/ VENDOR :			STANDARD QP NO. : PE-QP-999-302-E001, REV. 0			SPECIFICATION TITLE:			
		SHEET 5 OF 10			SYSTEM			ITEM : OIL FILLED TRANSFORMER			DOC. NO. :			
SL. NO.	COMPONENT/OPERATION	CHARACTERISTIC CHECK	CAT.	TYPE/ METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY			REMARKS		
									P	W	V			
1	2	3	4	5	6	7	8	9	10			11		
2.8	Gun Metal / Cast Iron Valves Gate/globe/ Butterfly)	a) Dimensional check b) Type, size & make c) Leakage test(Hydraulic test for Body & Seat) d) Operational test (close & open)	Major Major Major Major	Measure Visual Test Test	100% 100% - -	Manf. Std./IS:778 Class 1	Manf. Std./IS:778 Class 1	QC Record QC Record Supplier's TC Supplier's TC	2 2 3/2 3/2	- - 2,1 2				
2.9	Bushing CT	a) Visual check/Dimensional check b) Routin test	Major Major	Measure/Visual test Test	100% -	Manf. Std./IS:2705 Manf. Std./IS:2705	Manf. Std./IS:2705 Manf. Std./IS:2705	Supplier's TC Supplier's TC	2 3/2	- 2,1				
2.10	Marshaling box/RTCC	a) Visual check for wiring b) Dimensional check c) Check for make of components d) 2 kV insulation test on auxiliary wiring e) Check for paint, shade & thickness f) Degree of Prot. By paper insertion	Major Major Major Major Major	Test Measure/Test Measure/Test Measure/Test Measure/Test	100% 100% 100% 100% 100%	Dr./Manf. Std./IS:5/IS:13947	Dr./Manf. Std./IS:5/IS:13947	Supplier's TC Supplier's TC Supplier's TC Supplier's TC Supplier's TC	3/2 3/2 3/2 3/2 3/2	2 2 2 2 2	- - - - -			
2.11	OTI&WTI	a) Type size & make b) HV test c) Temperature calibration d) Switch setting & switch deferential e) Calibration & operation of switch	Major Major Major Major Major	Visual Test Test Test Test	100% - - - -	Manf. Std.	Manf. Std.	QC records Supplier's TC Supplier's TC Supplier's TC Supplier's TC	2 3/2 3/2 3/2 3/2	1 2,1 2,1 2,1 2,1				
2.12	Radiator	a) Type, Model, Rating b) Dimensions & No. of elements c) Paint shade, Finish & film thickness d) Pressure test e) Adhesion test on paint f) Welding quality	Major Major Major Major Major Major	Visual Measure Measure/test Test Test Visual/ DPTest	100% 100% 100% 100% 100% 100%	Dr./Manf. Std./IS:101	Dr./Manf. Std./IS:101	QC records QC records QC records Supplier's TC Supplier's TC	3/2 3/2 3/2 3/2 3/2	2 2 2 2 2	1 - - 1 1			
2.13	Hardware	a) Dimensional check b) Tensile strength	Major Major	Measure Test	100% -	Manf. Std.	Manf. Std.	QC records Supplier's TC	2 3/2	- -				
			PARTICULARS			BIDDER/VENDOR								
BHEL			NAME											
			SIGNATURE											
			DATE											
LEGEND :			1 - BHEL/ CUSTOMER			2 - VENDOR			3 - SUB- VENDOR			P - PERFORM W - WITNESS V - VERIFICATION		
												BIDDER'S/VENDORS COMPANY SEAL		


		QUALITY PLAN			CUSTOMER :			PROJECT TITLE :			SPECIFICATION NO. :		
					BIDDER/ VENDOR :			STANDARD QP NO. : PE-QP-999-302-E001, REV. 0			SPECIFICATION TITLE:		
		SHEET 6 OF 10			SYSTEM			ITEM : OIL FILLED TRANSFORMER			DOC. NO. :		
SL. NO.	COMPONENT/OPERATION	CHARACTERISTIC CHECK	CAT.	TYPE/ METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY			REMARKS	
									P	W	V		
1	2	3	4	5	6	7	8	9	10			11	
2.14	Oil Pump Motor set (if applicable)	a) Type, Model, Rating b) Dimensional check c) Hv test at 2 kV for one minute d) Input power taken by pump e) Performance test (I/P,O/P,DISCH, NO LOAD, Locked Rotor te)	Major Major Major Major Major	Visual Measure Test Test Test	100% 100% - - -	Manf. Std.	Manf. Std.	QC records QC records Supplier's TC Supplier's TC Supplier's TC	2 2 3/2 3/2 3/2	- - 2,1 2,1 2,1			
2.15	Cooling Fan (if applicable)	a) Type, Model, Rating b) Dimensional check c) HV test at 2 KV for one minute d) IR test e) Power consumption & RPM	Major Major Major Major Major	Visual Measure Test Test Test	100% - - - -	Approved drgs/docs/spec./ IS:2312	Approved drgs/docs/spec./ IS:2312	QC records QC records Supplier's TC Supplier's TC Supplier's TC	2 2 3/2 3/2 3/2	- - 2,1 - 2,1			
2.16	Roller Assembly	a)Dimensions b) Mechanical & Chemical properties of Raw material used for Shaft & Roller	Major Major	Measure Measure	100% -	Manf. Drg./docs	Manf. Drg./docs	QC records Supplier's TC	2 3/2	- 2			
2.17	Terminal Connector (if applicable)	a) Dimensional check b) Surface finish c) Acceptance test	Major Major Major	Measure Visual Test	100% - -	Manf. Drg./docs/IS:5561	Manf. Drg./docs/IS:5561	QC records Supplier's TC Supplier's TC	2 3/2 3/2	- 2 2,1			
2.18	Air Cell for Conservator (if applicable)	a) Dimensional check b) Surface finish c) Acceptance test	Major Major Major	Measure Visual Test	100% 100% 100%	Manf. Drg./docs/PO	Manf. Drg./docs/PO	QC records Supplier's TC Supplier's TC	2 3/2 3/2	- 2 2,1			
2.19	Oil Flow Indicator (if applicable)	a) Type, Model, Rating b) Dimensional check c) Functional test	Major Major Major	Visual Measure Test	100% 100% -	Manf. Drg./docs/Spec.	Manf. Drg./docs/Spec.	QC records QC records Supplier's TC	2 2 3/2	- - 2,1			
2.20	Silicagel Breather	a) Type, Size, Model b) Pressure/ Leakage test c) Colour of silica gel	Major Major Major	Visual Test Visual	100% - -	Manf. Drg./docs/Spec.	Manf. Drg./docs/Spec.	QC records Supplier's TC Supplier's TC	2 3/2 3/2	- 2 2,1			
			PARTICULARS			BIDDER/VENDOR							
BHEL			NAME										
			SIGNATURE										
			DATE									BIDDER'S/VENDORS COMPANY SEAL	
LEGEND : 1 - BHEL/ CUSTOMER 2 - VENDOR 3 - SUB- VENDOR P - PERFORM W - WITNESS V - VERIFICATION													

		QUALITY PLAN			CUSTOMER :			PROJECT TITLE :			SPECIFICATION NO. :		
		SHEET 8 OF 10			BIDDER/ VENDOR SYSTEM			STANDARD QP NO. : PE-QP-999-302-E001, REV. 0			SPECIFICATION TITLE:		
SL. NO.	COMPONENT/OPERATION	CHARACTERISTIC CHECK	CAT.	TYPE/ METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY			REMARKS	
									P	W	V		
1	2	3	4	5	6	7	8	9	10			11	
3.4	Test on Core	a) Dimensional check	Major	Measure	100%	Manf. Drg./stand.	Manf. Drg./stand.	QC Records	2		-		
		b) Flux density measurement	Major	Measure	100%			QC Records	2		-		
		c) Isolation test between(core to core clamps)	Major	Test	100%			QC Records	2		-		
		d)Torque Tightness	Major	Measure	100%			QC Records	2		-		
		e) Core Insulation	Major	Electrical	100%			QC Records	2		-		
		f) Core Loss	Major	Electrical with dummy coil	100%			QC Records	2		1		
		g)Visual checks of core verticality	Major	Visual	100%			QC Records	2		-		
		h) Core pressure Test at 2kV AC for one minute between all bolts, side plates, structure steel works and core	Major	Electrical	100%			QC Records	2	1	-		
3.5	Winding	a) Brazing procedure & Brazer qualification	Major	Review	100%	Manf. Drg./Relevant stand.	Manf. Drg./Relevant stand.	QC Records	2		-		
		b) Conductor size.	Major	Measure	100%			QC Records	2		-		
		c) Radial depth of winding	Major	Measure	100%			QC Records	2		-		
		d) Anchoring & binding at start & finish	Major	Measure	100%			QC Records	2		-		
		e) No. of turns	Major	Measure	100%			QC Records	2		-		
		f) Transposition of cross-overs	Major	Measure	100%			QC Records	2		-		
		g) Dimensional check (OD,ID & axial length)	Major	Measure	100%			QC Records	2		-		
		h) Insulation arrangement & alignmt.	Major	Measure	100%			QC Records	2		-		
		i) Winding length	Major	Measure	100%			QC Records	2		-		
		j) Brazed joints	Major	Measure	100%			QC Records	2		-		
		k) Lead & coil identification and marking	Major	Measure	100%			QC Records	2		-		
		l) Free from damages	Major	Measure	100%			QC Records	2		-		
		m) Continuity test for leads	Major	Measure	100%			QC Records	2		-		
n) Turn to Turn Insulation	Major	Measure	100%	QC Records	2		1						
o) Measure. Of Resistance	Major	Measure	100%	QC Records	2		1						
3.6	Core coil assembly	a) Cleanliness of core	Major	Visual	100%	Manf. Drg./Relevant stand.	Manf. Drg./Relevant stand.	QC Records	2		-		
		b) Alignment of spacers/blocks	Major	Visual	100%			QC Records	2		-		
		c) Elect. Clearance & Insp. Of core & coil assly after completion of terminal gear	Major	Visual/measure	100%			QC Records	2		-		
		d) Check provision of core frame earthing	Major	Visual	100%			QC Records	2		-		
3.7	Connection and Tap switch assembly	a) Ratio test on all taps	Major	Test	100%	Manf. Drg./Relevant stand.	Manf. Drg./Relevant stand.	QC Records	2		1		
		b) Lead disposition.	Major	Visual	100%			QC Records	2		-		
		c) Brazing of joints	Major	Visual	100%			QC Records	2		-		
		d) Crimping of joints	Major	Visual	100%			QC Records	2		-		
		e) Insulation over joints	Major	Visual	100%			QC Records	2		-		
		f) Vector group	Major	Test	100%			QC Records	2		1		
3.8	Overning and Tanking	a) Cleanliness of tank	Major	Visual	100%	Manf. Drg./Relevant stand.	Manf. Drg./Relevant stand.	QC Records	2		-		
		b) Drawing	Major	Physical	100%			QC Records	2		1		
		c) Check tightness of clamped blocks and measurements of winding height	Major	Measure	100%			QC Records	2		1		
		d) Electrical clearances	Major	Measure	100%			QC Records	2		1		
		e) Oil filling and air release	Major	Physical	100%			QC Records	2		-		
		f) Dryness (Tan-delta & I.R)	Major	Measure	100%			QC Records	2		-		
			PARTICULARS		BIDDER/VENDOR								
BHEL			NAME										
			SIGNATURE										
			DATE										
BIDDER'S/VENDORS COMPANY SEAL													
LEGEND : 1 - BHEL/ CUSTOMER 2 - VENDOR 3 - SUB- VENDOR P - PERFORM W - WITNESS V - VERIFICATION													

		QUALITY PLAN		CUSTOMER :			PROJECT TITLE :			SPECIFICATION NO. :		
				BIDDER/ VENDOR :			STANDARD QP NO. : PE-QP-999-302-E001, REV. 0			SPECIFICATION TITLE:		
				SHEET 10 OF 10			SYSTEM			ITEM : OIL FILLED TRANSFORMER		
SL. NO.	COMPONENT/OPERATION	CHARACTERISTIC CHECK	CAT.	TYPE/METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORM	FORMAT OF RECORD	AGENCY			REMARKS
1	2	3	4	5	6	7	8	9	P	W	V	11
		p) Verification of oil leakage test with all fitting & accessories at normal head of oil plus 35KPA for 8 hours.	Major	Measure	100%	As per APPROVED DATA SHEET/IS:2026/ IEC-60076/ MANF. STD.	As per APPROVED DATA SHEET/IS:2026/ IEC-60076/ MANF. STD.	Manf. Test Records/QC Formats	2	1		This test shall also to be performed at site by bidder after transformer Installation
		q) Frequency Response Analysis Test	Major	Measure	100%				2	1		
		r) Jacking Test followed by D.P. Test	Major	Measure	100%				2	1		
		s) Paint shade & adhesion test	Major	Measure	100%				2	1		
		t) Protection on M. Box by paper insertion	Major	Measure	100%				2	1		
		u) 2 KV test on M.Box wiring & functional check for component of MB	Major	Measure	100%				2	1		
		v) Slope and alignment of Buchhoz relay	Major	visual	100%				2	1		
		w) DFT of paint	Major	Measure	100%				2	1		
		x) Test on Transformer Oil	Major	Measure	100%	2	1				As Per IS-335	
6	Pre Shipment check & Despatch	a) Transformer- verification of final transportation.							2			
		b) Dew points measurement of N2/Dry gas tightness/ Pr reading (Only applicable for transformers dispatched with Gas Filling)							2			
		c) Packing of loose items							2			
			PARTICULARS			BIDDER/VENDOR						
BHEL			NAME									
			SIGNATURE									
			DATE						BIDDER'S/VENDORS COMPANY SEAL			
LEGEND : 1 - BHEL/ CUSTOMER 2 - VENDOR 3 - SUB- VENDOR P - PERFORM W - WITNESS V - VERIFICATION												

ANNEXURE-1 TO QAP

TYPE TEST	APPLICABLE (YES/NO)	REMARKS
a) Measurement of winding resistance	YES	ON EACH RATING OF TRANSFORMER. PRICES TO BE INCLUDED IN MAIN TRANSFORMER PRICES
b) Measurement of voltage ratio and check of voltage vector relationship	YES	
c) Measurement of impedance voltage/short-circuit impedance (principal tapping) and load loss	YES	
d) Measurement of no-load loss and current	YES	
e) Measurement of insulation resistance	YES	
f) DGA Test on Oil before and after Temperature Test	YES	
g) Dielectric Type Tests (As per IEC-60076-3)- Full Wave Lightning impluse Test for the Line Terminals(LI)	YES	REFER ANNEXURE-C (TYPE TEST CONDUCTION SCHEDULE)
h) Temperature-rise	YES	
i) Tests on on-load tap-changers, where appropriate	NOT APPLICABLE	
j) Short-circuit test	YES**	**CHARGES FOR CARRYING OUT SHORT CIRCUIT TEST SHALL BE PAYABLE BASED ON ACTUAL INVOICE FROM DESIGNATED LABORATORIES (CPRI, BHOPAL/ CPRI, BANGLORE / ERDA, VADODARA) WITH AN ADDITIONAL LUMP SUM AMOUNT OF 5% OF EX-WORKS PRICE OF TRANSFORMER BEING TESTED TO COVER HANDLING COSTS (TRANSPORTATION, INSURANCE ETC.)
SPECIAL TEST		
a) Dielectric Special Test (As per IEC-60076-3) ##:- 1. Chopped Wave Lightning impulse Test for the Line Terminals(LIC) 2. Lightning impluse Test for the Neutral Terminals(LIN) 3. Induced Voltage Test with PD measurement(IVPD)	YES	## These Special Test shall be conducted as Routine Test on all transformer.
b) Measurement of zero-sequence impedance of three-phase transformers \$\$	YES	\$\$ These Special Test shall be conducted as Routine Test on all transformer.
d) Measurement of acoustic noise level \$\$	YES	
e) Measurement of the harmonics of the no-load current	N	
f) Measurement of the power taken by the fans and oil pumps	NOT APPLICABLE	
g) Degree of Protection on Cable Box	NO	
h) Degree of Protection on Marshalling Box	NO	
i) PRD operation test (if PRD is applicable)	NO	

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 34 of 50	


ANNEXURE - VI

SPECIAL TOOLS AND TACKLES REQUIRED FOR ERECTION, COMMISSIONING AND MAINTENANCE OF EQUIPMENT

S. NO.	DESCRIPTION	QTY.

Note

Bidder shall furnish the list of special tools & tackles and quantity along with the offer. Price shall be included in the total bid price.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 35 of 50	

ANNEXURE -VII


COMMISSIONING SPARES FOR EACH TRANSFORMER

S. NO.	DESCRIPTION	QTY.					REMARKS
		10.0MVA	8.0 MVA	6.3 MVA	5.0 MVA	3.5 MVA	

S. NO.	DESCRIPTION	QTY.					REMARKS
		2500kVA	2000 kVA	1600 kVA	1000 kVA	630 kVA	

Note


Bidder shall furnish the list of commissioning spares and quantity for each type of transformer along with the offer. Price shall be included in the transformer price.

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 36 of 50	


ANNEXURE - VIII

APPLICABLE STANDARDS & CODES FOR TRANSFORMERS

Specification for power transformers	IS: 2026 []	IEC: 76 []	BS: 171 []
	IS: 11171 []	IEC:354 []	
	IS:6600 []		
Fittings & accessories for power transformer	IS: 3639 []	IEC: []	BS: []
Specification for new insulation oil	IS: 335 []	IEC: 296 []	BS: 148 []
Bushing for alternative voltage above 1000 volts	IS: 2099 []	IEC: 137 []	BS: 223 []
Dimension for porcelain transformer bushings	IS: 3347 []		
Current transformers	IS: 2705 []	IEC: 185 []	BS: 3938 []
Gas operated relays	IS: 3637 []		
Classification of insulating material for electrical machinery & apparatus in relation to their thermal stability in service	IS:1271 []	IEC: 216 []	
Classification of degrees of protection provided by enclosures of electrical equipment	IS: 12063 []	IEC: 529 []	IS: 13947 []
Method of high voltage testing	IS: 2071 []	IEC: 60 []	
Colours for ready mixed paints & enamels	IS: 5 []		
Specifications for power & distribution transformers	CBIP Publication No275(1999 edition []		
Guide for loading of oil immersed transformers	IS: 6600 []	IEC: 354 []	BS: []
Noise level	NEMA, STANDARD-TR1		


	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 37 of 50	

SPECIFIC TECHNICAL REQUIREMENTS (DATA SHEET-A)

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 38 of 50	

11/3.6kV

<u>S. No.</u>	<u>Description</u>	<u>Unit</u>	<u>Particulars</u>
1.0	Quantity	Nos.	3.5 MVA 6.3 MVA
2.0	Service (Unit/Station)		Unit/Station
3.0	Installation		Out Door
4.0	Type of insulating oil		Mineral
5.0	No. of phase	No(s)	03
6.0	Frequency	Hz	50
7.0	Type of cooling		ONAN
8.0	Rated output under site conditions	kVA	As indicated
9.0	Rated Voltage		
	a) HV Winding	kV	11.0
	b) LV Winding	kV	3.6
10.0	No Load transformation ratio		11/3.6
11.0	Vector group		Dyn11
12.0	Impedance voltage at rated current and frequency for the principal tapping at 75 deg. C	%	3.5 MVA: 6% 6.3 MVA: 7%
13.0	Total range of tapplings and tapping steps		± 5% in steps of 2.5%
14.0	Type of tap changing equipment		Off-Circuit
15.0	Temperature rise		
	a) Top oil by thermometer	deg. C	50 deg. C above ambient of 50 deg.C
	b) Winding by resistance	deg. C	55 deg. C above ambient of 50 deg.C
16.0	System Highest Voltage		
	a) HV Winding	kV	12.0 kV
	b) LV Winding	kV	3.6 kV + 10%
17.0	Phase Connection		
	a) HV Winding		Delta
	b) LV Winding		Star

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 39 of 50	

18.0 Insulation Levels

18.1 One minute power frequency withstand voltage (rms)

- | | | |
|---------------|----|------------|
| a) HV Winding | kV | 28 (11kV) |
| b) LV Winding | kV | 10(3.6 kV) |

18.2 Impulse withstand voltage

- | | | |
|---------------|-----|-------------|
| a) HV Winding | kVp | 75 (11kV), |
| b) LV Winding | kVp | 40 (3.6 kV) |

19.0 Terminal details

- | | |
|---------------|--|
| a) HV Line | Cable box (XLPE cables) |
| b) HV Neutral | N.A. |
| c) LV Line | Flange for Segregated Phase Busduct |
| d) LV Neutral | One neutral as part of LV busduct throat and second neutral with copper earthing bar for system earthing brought near the base of the transformer. |

20.0 System Fault Level

- | | | |
|---------------|----|--------------------|
| a) HV Winding | kA | 50 kA RMS for 1Sec |
| b) LV Winding | kA | 40 kA RMS for 1Sec |

21.0 Method of System Earthing

- | | |
|--------------|--|
| a) HV System | Unearthed |
| b) LV System | Low resistance earthed to limit Earth fault current to 300A for 10 Sec |

22.0 Details of Cooling Equipment

Detachable tank mounted radiators


23.0 Provision/ accommodation of CTs
LV Neutral

1 Core PS CLASS and 1 Core 5P20.
CT particulars shall be given to successful bidder during detail engineering. There shall be no commercial implication to BHEL on this account.


24.0 Colour Shade:

- | | |
|--------------------------|-------------|
| a) Interior (For M. Box) | As required |
| b) Exterior | As required |


25.0 Space/ Layout Limitation if Any

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
SHEET : 40 of 50		

26.0	Cable details		
	a) HV side		
	i) Type		XLPE
	ii) Voltage Grade	12kV	Unearthed
	iii) Conductor material & size		Stranded Aluminium, after award of contract
	iv) No. of cores & runs		Three core/Single core, one run/Three run
27.0	Penalty for Losses		
	a) Rates for bid evaluation		N.A.
	b) 'A' (for no load loss)		Losses not to exceed max. Losses as per annex-III of the specification
	ii) 'B' (for load losses)		- Do-
	c) Rates for penalty		
	i) 'A' (for no load loss)		Rs. 1.95 lacs per kW
	ii) 'B' (for load loss)		Rs. 1.95 Lacs per kW
28.0	Transformer Bushing		
	a. Voltage Class	kV, rms	HV LV 17.5 7.2
	b. Material		Solid porcelain or oil communicating type
	c. Creepage distance	mm	31mm/kV
29.0	Max. Flux density in any part of core & Yoke at 110% rated voltage		1.9 Tesla
30.0	Max. Current density of conductor coil of HV and LV winding		2.5 A/ Sq. Cm

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 41 of 50	


DATA SHEET-B
**(TO BE SUBMITTED ALONG WITH
OFFER FOR EACH RATING)**

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 42 of 50	

DATA SHEET-B


FOR 11kV/3.6kV

S. No	Description	6.3MVA	3.5MVA
1.	Rating		
2.	No Load transformation ratio		
3.	Maximum No- load losses at rated frequency and 100% rated voltage		
4.	Maximum load losses at normal ratio, rated current and 75 deg. C		
5.	Overall Dimensions		
6.	Total weight		
7.	Total oil Quantity		


	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 43 of 50	

GUARANTEED TECHNICAL PARTICULARS (DATA SHEET-C)


Instructions to vendor : This data sheet shall be submitted by successful bidder after award of contract

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 44 of 50	


<u>S. No.</u>	<u>Description</u>	<u>Unit</u>	<u>Particulars</u>
1.0	Name of Manufacturer		
2.0	Reference Standards		
3.0	Installation		
4.0	Rated no load Voltage		
	a) HV Winding	kV	
	b) LV Winding	kV	
5.0	Type of cooling		
6.0	Rated kVA		
7.0	No. of phase	No(s)	
8.0	Rated Frequency	Hz	
9.0	Winding connections		
	a) HV Winding		
	b) LV Winding		
10.0	Vector group		
11.0	Impedance voltage at rated current and frequency for the principal tapping at 75 deg. C	%	
12.0	Off-Circuit tap changer		
	a) Total range of tappings (+/-)	%	
	b) Size of tapping step	%	
	c) For HV/LV variation		
13.0	Impulse voltage withstand level		
	a) HV Winding	kVp	
	b) LV Winding	kVp	
14.0	Power frequency withstand voltage for one minute		
	a) HV Winding	kV	
	b) LV Winding	kV	
15.0	Maximum No load losses at rated frequency and		
	a) 100% rated voltage	kW	
	b) 110% rated voltage	kW	

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 45 of 50	


- 16.0 Maximum Load losses at normal ratio, rated current and 75 deg. C
- 17.0 Tolerance on losses (+/-)
- 18.0 Guaranteed maximum Temperature rise of
- a) Top oil by thermometer deg. C
above ambient of 50 deg. C
- b) Winding by resistance deg. C
above ambient of 50 deg. C
- 19.0 Efficiency at 75 deg. C and unity power factor for
- a) 100% full load %
b) 75% full load %
c) 50% full load %
- 20.0 Voltage regulation at full load at 75 deg. C
- a) Unity power factor %
b) 0.8 Power factor (Lagging) %
- 21.0 External short circuit withstand capacity & duration MVA, sec
- 22.0 Max. short time (30 sec.) rating of transformer KVA
- 23.0 Type of magnetic circuit Core/ Shell
- 24.0 Type of core joints
- 25.0 Type of winding
- a) HV Winding
b) LV Winding
- 26.0 Type of insulation
- a) HV winding
b) LV winding
c) Between core & adjacent winding
d) Between windings
- 27.0 HV terminal arrangement
- a) Bushing with or without CTs
b) CT details (Ratio, ACC. Class, VA, Type)
c) Clearance between phases in air mm
d) Clearances to earth in air mm

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 46 of 50	


- 28.0 LV terminal arrangement
- Bushing with or without CTs
 - CT details (Ratio, ACC. Class, VA, Type)
 - Clearance between phases in air mm
 - Clearances to earth in air mm
- 29.0 Neutral terminal arrangement
- No. of neutral terminals
 - Neutral CT provided or not
 - NCT details (Ratio, ACC. Class, VA, Type)
- 30.0 HV Bushing
- Rated voltage class kV
 - Rated current A
- 31.0 LV Bushing
- Rated voltage class kV
 - Rated current A
- 32.0 LV Neutral Bushing
- Rated voltage class kV
 - Rated current A
- 33.0 Maximum flux density
- At rated voltage Wb/M²
 - At 110% rated voltage Wb/M²
- 34.0 Maximum current density for
- HV Winding Amp/mm²
 - LV Winding Amp/mm²
- 35.0 Magnetising current at rated voltage and frequency (% of full load current)
- 36.0 Rollers
- Type
 - Unidirectional/ Bidirectional
 - Quantity
 - Gauges
 - Longitudinal mm
 - Transverse mm
- 37.0 Pressure test withstand
- Tank Kg/M²
 - Radiator and other fittings Kg/M²

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 47 of 50	


- 38.0 Vacuum withstand
- a) Tank mm of Hg
- b) Radiator and other fittings mm of Hg
- 39.0 Approximate weight of
- a) Core Kg
- b) Windings Kg
- c) Tank, Fittings & Coolers etc. Kg
- d) Oil Kg
- e) Total weight with oil Kg
- f) Untanking weight (core & winding) Kg
- g) Shipping weight of the heaviest package Kg
- 40.0 Quantity of Insulating Oil
- a) Oil in tank Ltrs.
- b) Oil in cooling equipment Ltrs.
- c) Total oil Quantity Ltrs.
- 41.0 Dimensions
- 42.1 Tank dimensions
- a) Length mm
- b) Breath mm
- c) Height mm
- 42.2 Shipping dimensions of the largest package
- a) Length mm
- b) Breath mm
- c) Height mm
- 42.3 Overall Dimensions (LxBxH) (mmXmmXmm)
- 43.0 Details of tank and other material
- a) Thickness of tank side plate mm
- b) Thickness of tank bottom plate mm
- c) Thickness of tank cover plate mm
- d) Thickness of radiator sheets mm
- e) Minimum clearance height for lifting core and winding from tank mm
- 44.0 Positive sequence impedance at
- a) Maximum voltage tap %
- b) Minimum voltage tap %
- 45.0 Zero-sequence impedance at principal tap %

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 48 of 50	

46.0	Paint Shade	:	
47.0	Voltage Variation	:	CFVV
48.0	Noise Level	:	
49.0	Degree of Protection		
	a) Marshalling Box	:	IP55
	b) HV Cable Box	:	IP55
	c) LV Flange Enclosure	:	IP55
50.0	Creepage Distance		
	a) HV Bushing (mm/kV)	:	
	b) LV Bushing (mm/kV)	:	
	c) Neutral Bushing (mm/kV)	:	
51.0	Material of Winding		
	a) HV/LV	:	
52.0	Insulation level separate source power frequency voltage withstand		
	i) HV winding (kV RMS)	:	
	ii) LV winding (kV RMS)	:	
	iii) HV Bushing	:	
	iv) LV Bushing	:	
	v) Neutral Winding	:	
53.0	Temperature Class of Insulation	:	
54.0	Over Excitation withstand time (sec)		
	100%	:	
	110%	:	
	125%	:	
	140%	:	
55.0	Thermal Time constant	:	
56.0	Magnetizing Inrush Current	:	
57.0	Radiator Details		
	a) No. of Radiators	:	
	b) No. of Flutes	:	
	c) Overall Dimensions	:	
	d) Radiator sizing calculations furnished	:	(YES/NO)

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 49 of 50	

SCHEDULE OF DEVIATIONS

	TITLE :	SPECIFICATION NO.
	TECHNICAL SPECIFICATION FOR OIL FILLED SERVICE TRANSFORMERS	PE-TS-999-302-E001
		VOLUME NO. : II-B
		SECTION : D
		REV NO. : 00 DATE : 30/03/2015
	SHEET : 50 of 50	

Sl. No	Specification Clause Ref.	Technical Deviation	Reason for Deviation
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We the undersigned hereby certify that the above mentioned are the only Technical deviations

Particulars of bidder/Authorised representative				COMPANY SEAL
NAME	Designation	Signature	Date	