



NO:BHEL:IVP:MM:EOI:13-14

Date: 27.04.2013

**NOTICE INVITING APPLICATIONS FOR REGISTRATION OF VENDORS**

BHARAT HEAVY ELECTRICALS LIMITED [BHEL] IVP is manufacturing Industrial Valves and other Boiler accessories at its Industrial Valves Plant, Goindwal Sahib Unit. The range of valves includes Carbon Steel, Alloy Steel and Stainless Steel- Gate, Globe and Non-return Valves (Flap Valves) of Pressure classes upto C600 of sizes 2" to 24" at present. The plant is heading towards increasing its volume as well as range of items. For an annual turnover to the tune of 500 Cr. BHEL IVP has to procure various forms of raw materials, bought out items and sub-assemblies

Expression of interest and applications for registration are invited from reputed Indian manufacturers/agents of foreign manufacturers [if the manufacturer is not doing business in India directly].

Vendors are required for the below mentioned item:

|                 |   |
|-----------------|---|
| <b>SAW FLUX</b> | SAW flux is used for SS Overlays. Approximately annual requirement is 18000 kgs valued approx. Rs 15 lakhs. For technical s p e c s , <b>pl.</b> refer WCPI 407 Rev 02 attached |
|-----------------|---|

MSE's shall be given preferences as described in "Public Procurement Policy for Micro and Small Enterprises (MSEs) Order, 2012" subject to the submission of proper documentary evidence (i.e. District Industries Centers or Khadi and Village Industries Commission or Khadi and Village Industries Board or Coir Board or National Small Industries Corporation or Directorate of Handicrafts and Handloom or any other body specified by Ministry of Micro, Small and Medium Enterprises) with quotation. "Public Procurement Policy for Micro and Small Enterprises (MSEs) Order, 2012" document can be downloaded from link <http://dcmsme.gov.in/FinaiPressorder.pdf> and can also be collected from the office of Manager/MM IVP Goindwal. Salient feature of this order are as below:

- 20% Procurement of the tender value shall be made from MSE (Micro, Small Enterprises) firms. 4% from the above mentioned 20% procurement quantity shall be procured from MSE's owned by SC /ST's. Failure to participate by any MSE owned by SC/ST's this 4% quantity shall be procured from other MSEs. EMD shall be exempted for MSEs. All these benefits are subject to production of all statutory documents. In tender, participating Micro and Small Enterprises quoting price within price band of L1+15 per cent shall also be allowed to supply a portion of requirement by bringing down their price to L1 price in a situation where L1 price is from someone other than a Micro and Small Enterprise and such Micro and Small Enterprise shall be allowed to supply up to 20 per cent of total tendered value. In case of more than one such Micro and Small Enterprise, the supply shall be shared proportionately (to tendered quantity).

BHEL IVP shall evaluate the vendors as per its established vendor selection, evaluation and registration procedure. Supplier registration form can also be downloaded from our website [www.bhel.com](http://www.bhel.com) available as a downloadable link at [http://www.bhel.com/images/pdf/vendor/Guidelines\\_Indian\\_Suppliers\\_SEARP20\\_10Amdt.02.pdf](http://www.bhel.com/images/pdf/vendor/Guidelines_Indian_Suppliers_SEARP20_10Amdt.02.pdf) BHEL IVP invites such vendors to visit its plant located in Goindwal Sahib Punjab Dist Tarn Taran on any working day from Monday to Saturday between 0900 Hrs to 1600 Hrs and contact

Undersigned for any clarification-

| Area about which information is required | Items details and requirement                      | Vendor registration form/procedure                   |  |
|--|--|--|--|
| Phone No.                                | 01859-224615                                       | 01859-224618   |  |
| Email                                    | <a href="mailto:gss@bhelivp.in">gss@bhelivp.in</a> | <a href="mailto:amit@bhelivp.in">amit@bhelivp.in</a> |  |



BHARATH HEAVY ELECTRICALS LIMITED  
TIRUCHIRAPALLI-620 014  
WELDING TECHNOLOGY CENTRE

Doc. Number:

Revision:

WCPI - 407

02

Date: 18/12/1992

Welding Consumable Purchase Instruction

Page 01 of 02

## PURCHASE INSTRUCTION FOR ARC WELDING FLUX FOR STAINLESS STEEL OVERLAYS.

### 1.0 SCOPE:

1.1 The flux supplied shall meet the following requirements. The quantities shall be supplied as specified in the PURCHASE ORDER.

### 2.0 CHEMICAL COMPOSITIONS:

2.1 Specified chemical composition of the flux shall be as follows:

SiO<sub>2</sub> : 6.00-10.00  
MnO : 35.00 Max  
CaO : 10.00-15.00  
Al<sub>2</sub>O<sub>3</sub> : 45.00 Max.  
CaF<sub>2</sub> : 25.00 Max.

### 3.0 USABILITY:

3.1 The flux is used for overlays on Valve seats in combination with ASW ER 410 and ER 430 wires.

3.2 The Basicity Index of the flux shall be 0.8 - 1.2.

3.3 The flux shall conform to the following mesh size 12 x 65 after Tyler.

3.4 The flux shall have very good slag detachability even in the rd hot condition.

3.5 The flux shall have very quick freezing characteristic to enable continuous welding of 8 passes in two layers.

3.6 The flux shall be dry and have very low sensitivity to moisture and contamination.

PREPARED:

(R. GOPALAKRISHNA PILLAI)  
EXECUTIVE FOREMAN / WTC

APPROVED:

(M. SUBRAMANI)  
SR. MANAGER/WTC



**4.0 PACKING AND STORAGE:**

- 4.1 The flux shall be packed in humidity resisting manifold with plastic lining and airtight sealing. The packing shall be suitable to with stand transportation, handling and storage under normal condition.
- 4.2 The flux in the originals unopened package shall withstand storage under normal conditions for at least 12 month without affecting its welding characteristics or the weld properties.
- 4.3 Every bag shall contain the maximum quantity of 50 kgs.
- 4.4 The entire lot of each dispatch shall be made from one batch of flux.

**5.0 MARKING:**

- 5.1 The following information shall be legibly printed on the out side of each bag.
  - a) Brand Name
  - b) Mesh size
  - c) batch No & date of manufacture
  - d) Net weight
- 5.2 A tag/label in the above information shall also be placed inside each bag.

**6.0 TEST CERTIFICATE:**

- 6.1 Individual test certificates shall be issued for every batch of flux. A batch is defined as the quantity produced from the same combination of raw materials under one production schedule.
- 6.2 The Test certificate shall contain chemical analysis. Basicity Index and mesh size for every batch of flux.
- 6.3 Three copies of test certificate shall be mailed for each batch of flux.
- 6.4 Prior approval shall be obtained from BHEL for any deviation of this PURCHASE INSTRUCTUION.

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