

**NEYVELI LIGNITE CORPORATION LIMITED
2x500 MW NEYVELI NEW THERMAL POWER PROJECT
(NNTPP)**

NEYVELI, TAMIL NADU, INDIA

VOLUME – IIB

**TECHNICAL SPECIFICATION
FOR
GALVANISED
CABLE TRAY SUPPORT SYSTEM
*(WELDED TYPE)***

**SPECIFICATION NO : *PE-TS-400/402-507-E012*
REVISION : 0**



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



DOCUMENT TITLE

TECHNICAL SPECIFICATION FOR
GALVANISED
CABLE TRAY SUPPORT SYSTEM
(WELDED TYPE)

SPECIFICATION NO. PE-TS- 400/402-507-E012

VOLUME II B

SECTION ---

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DATE: 20.05.2014

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

BIDDER'S STAMP & SIGNATURE



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INSTRUCTIONS TO BIDDERS FOR PREPARING TECHNICAL OFFERS

1. Two signed and stamped copies of the following shall be furnished by all bidders as technical offer :
 - a. Unpriced Price Schedule (Annexure-I: BOQ, 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").
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 elsewhere/ covering letter of technical offer 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-I 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



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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.

2.0 The requirements mentioned in Section-C / Data Sheets-A of section-D shall prevail and govern in case of conflict between the same and the corresponding requirements mentioned in the descriptive portion in Section-D.



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SECTION – 'A' SCOPE OF ENQUIRY



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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 **CABLE TRAY SUPPORT SYSTEM (WELDED TYPE)** as mentioned in different sections of this specification for 2x500 MW NEYVELI NEW THERMAL POWER PROJECT at Neyveli, Tamil Nadu, India
- 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 Deviations if any should be brought out very clearly on deviation sheet. Otherwise it will be presumed that the bidder's offer is in line with what has been stated/ asked for in this specification.
- 6.0 The documents shall be in English Language and MKS system of units.



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SECTION – 'B' PROJECT INFORMATION



SALIENT FEATURES OF THE SITE & GENERAL PROJECT INFORMATION

1.1 Introduction

The project site at Neyveli has distinct location advantages, being at pit-head distance from the source of lignite supply from Mines, making it convenient for transportation of lignite by belt conveyor. Water source is readily available from the nearby mines lake. Besides, other infrastructure such as access road, railway connection etc, already exist.

1.2 Power Plant Site

The power plant site is located at Neyveli, opposite to the now defunct Fertilizer and Briquetting & Carbonization Plant, near TPS-I Expansion and TPS-II.

1.3 Project & Site Information


- | | | |
|------------------------------------|---|--|
| (i). Owner / Purchaser | : | Neyveli Lignite Corporation Limited (NLC Ltd), Neyveli, Cuddalore District, Tamil Nadu State, India |
| (ii). Consultant | : | Lahmeyer International (India) Pvt. Ltd (LII), Gurgaon, NCR, India. |
| (iii). Project Title | : | 2x500 MW Neyveli New Thermal Power Project (NNTPP) |
| (iv). Location | : | 200 kms south of Chennai and 50 kms south-west of Cuddalore |
| (v). Latitude | : | 11° 34' 00" N to 11° 35' 00" N |
| (vi). Longitude | : | 79° 26' 00" E to 79° 27' 00" E |
| (vii). Elevation above MSL | : | (+) 67 m |
| (viii). Nearest Railway Station | : | Neyveli, |
| (ix). Nearest Sea Port | : | Chennai, at a distance of 200 km |
| (x). Nearest Airport | : | Chennai, at a distance of 200 km |
| (xi). Road Access/Approach to Site | : | Connected by Chennai-Thanjavur NH 45C road and state highway connecting Cuddalore - Virudhachalam via Neyveli. Both NH and state high way roads are well connected to NLC township roads. The approach road is approximately 15 kms from Chennai-Thanjavur NH - 45C road |
| (xii). Site Meteorological Data | : | |
| • Max ambient temperature | : | 42.8° C |
| • Min Ambient Temperature | : | 26.9° C |






- Wet bulb temp : 29° C
- Max. Relative Humidity : 92 % in the month of September
- Min. Relative Humidity : 23 % in the month of May
- Rainfall : About 1265.7 mm annually (average)
- Wind direction : South West to North East direction
- Wind Speed : 97.2 km/hr (maximum recorded)
4.3 km/hr (average wind speed)
- Seismicity : As per IS: 1893 (part 4) (Zone-II)
Importance factor: 1.75.



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SECTION -C

SPECIFIC TECHNICAL REQUIREMENTS

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1.0 **SCOPE OF ENQUIRY**

- 1.1 This enquiry covers the supply of **Cable tray support system (Welded type)** conforming to this specification.
- 1.2 General technical requirements of Cable tray support system (Welded type) Materials are indicated in Section-D. Project specific technical/ quality requirements / changes are listed in Section-C & Data Sheet-A.
- 1.3 The stipulations of Section-C, followed by those of Data Sheet – A shall prevail in case of any conflict between the stipulations of Section-C, Data sheet – A & Section-D.

2.0 **BILL OF QUANTITIES:**

- 2.1 Quantity requirements shall be as per **Annexure-I (Bill of Quantities (BOQ))** enclosed.

3.0 **SPECIFIC REQUIREMENTS:**

3.1 Technical:

<i>S. No.</i>	<i>Reference clause No. of Section D (if any)</i>	<i>Specific Requirement/ Change</i>
1	Clause no. 4.1	Quality plan number shall be read as PE-QP-999-507-E006 instead of PED-507-00-Q-007/02

3.2 Quality/ Inspection:

<i>S. No.</i>	<i>Reference clause No. of Section D (if any)</i>	<i>Specific Requirement/ Change</i>



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TECHNICAL SPECIFICATION FOR
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ANNEXURE-I (SG PACKAGE)**BOQ CUM PRICE SCHEDULE**

Item No.	Item Code	Item Description	Standard Length	Unit	Order Quantity	Lot-I Quantity	Unit Price (Ex-Works) Rs.	Total Price (Ex-Works) Rs.
1.0		CABLE TRAY SUPPORT (HOT DIP GALVANISED STRUCTURAL STEEL)						
1.1	507-33003-A	ISA 50X50X6	5.5 to 6.5 Metres	MT	103	70		
1.2	507-33005-A	ISMC - 100	5.5 to 6.5 Metres	MT	70	50		
1.3	507-33006-A	ISMC - 150	5.5 to 6.5 Metres	MT	115	80		

Notes:

- 1 The quantities will be released for manufacture in more than one lot. Lot-I quantities, which are indicated above, shall be released for manufacture along with LOI.
- 2 Manufacturing of Lot-I quantities shall be done after the approval of technical and quality documentation, and supply of same shall be completed within four months of date of approval of documents.
- 3 Subsequent lots shall be cleared for manufacture based on progress of engineering and site requirements. A lead-time of three months shall be given for completion of supply of each lot from the date of clearance of the quantities.
- 4 The total quantity variation shall be limited to -30 TO +30 % of the total contract value derived on the basis of the Order Quantities.
- 5 Raw materials: - Steel shall be procured from SAIL/TISCO/RINL/BHUSAN/JINDAL STEEL/JINDAL/ISPAT/ESSAR/LLOYD/ IISCO/ authorised SAIL Re Rollers.



DOCUMENT TITLE

TECHNICAL SPECIFICATION FOR
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(WELDED) TG-PACKAGE

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ANNEXURE-I (TG PACKAGE)**BOQ CUM PRICE SCHEDULE**

Item No.	Item Code	Item Description	Standard Length	Unit	Order Quantity	Lot-I Quantity	Unit Price (Ex-Works) Rs.	Total Price (Ex-Works) Rs.
1.0		CABLE TRAY SUPPORT (HOT DIP GALVANISED STRUCTURAL STEEL)						
1.1	507-33003-A	ISA 50X50X6	5.5 to 6.5 Metres	MT	102	70		
1.2	507-33005-A	ISMC - 100	5.5 to 6.5 Metres	MT	70	50		
1.3	507-33006-A	ISMC - 150	5.5 to 6.5 Metres	MT	115	80		

Notes:

- 1 The quantities will be released for manufacture in more than one lot. Lot-I quantities, which are indicated above, shall be released for manufacture along with LOI.
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- 3 Subsequent lots shall be cleared for manufacture based on progress of engineering and site requirements. A lead-time of three months shall be given for completion of supply of each lot from the date of clearance of the quantities.
- 4 The total quantity variation shall be limited to -30 TO +30 % of the total contract value derived on the basis of the Order Quantities.
- 5 Raw materials: - Steel shall be procured from SAIL/TISCO/RINL/BHUSAN/JINDAL STEEL/JINDAL/ISPAT/ESSAR/LLOYD/ IISCO/ authorised SAIL Re Rollers.

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ANNEXURE – II

**LIST OF DRAWINGS / DOCUMENTS
(REQUIRED TO BE FURNISHED BY SUCCESSFUL BIDDER AFTER AWARD OF CONTRACT)**

Sl. No.	Drawings/Document Description	Drawings / Document Number	Submission Schedule
1.	Quality Plan for cable tray support material (Welded Type)	PE-V0-400/402-507-E907	Within one week of award of contract

Note:-

It may please be noted that successful bidder is not to make any fresh submittals at contract stage w.r.t. above mentioned drawings/documents. Standard Quality Plan as enclosed in the technical specification is to be appended with cover sheet bearing drawing/document number & description as stated above. The signed & stamped copy for the same shall be submitted by successful bidder to BHEL within one week of award of contract without making any changes in the contents of the drawing/document.

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ANNEXURE - III

(VENDOR DRAWING/DOCUMENT SCHEDULE)

S. NO.	DESCRIPTION	THROUGH DMS	HARD PRINTS	CD-ROMs
1	Docs. /drgs. for approval (First submission)	YES	-	-
2	Docs. / drgs. for approval (Second & subsequent submission till approval)	YES	-	-
3	Final approved docs. / drgs. for Distribution	YES	As per project specific requirement	As per project specific requirement



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SECTION – ‘D’

STANDARD SPECIFICATION



DOCUMENT TITLE

**TECHNICAL SPECIFICATION FOR
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1.0 GENERAL

This specification covers the design, manufacture, inspection & testing at vendor's works, packing and delivery to site of galvanised mild steel structural members to be used for cable tray support system (welded).

2.0 CODES AND STANDARDS

- 2.1 The material shall comply with all currently applicable safety codes and statutory regulations of India as well as of the locality where the material is to be installed.
- 2.2 The design, material, construction, manufacture, inspection, testing and performance of cable tray support system (welded) shall conform to the latest revision of relevant standards and codes of practices as per Annexure-III.
- 2.3 In case of conflict between the applicable reference standard and this specification, this specification shall govern.

3.0 DESIGN REQUIREMENTS AND CONSTRUCTIONAL FEATURES

- 3.1 All items listed in the Bill of Quantities (Annexure-I of the specification) shall be manufactured as per Datasheet-A.
- 3.2 Straight lengths of hot dip galvanised MS channels and angles of sizes indicated in Datasheet – A shall be supplied.
- 3.3 All finished galvanised MS structural members for cable tray supports shall be free from sharp edges, corners, burs & unevenness.

4.0 QUALITY/ INSPECTION:

- 4.1 BHEL's Standard QP (QP NO. PED-507-00-Q-007/02) is enclosed as per Annexure-II 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.
- 4.2 All materials shall be procured, manufactured, inspected and tested by vendor/ subvendor as per approved quality plan.
- 4.3 The supplier shall perform all tests necessary to ensure that the material and workmanship conform to the relevant standards and comply with the requirements of the specification. Charges for all these tests for all the equipments & components shall be deemed to be included in the bid price.

5.0 PACKING


The material shall be packed to ensure protection against damage during transit, storage for prolonged periods and handling.

6.0 DELIVERY

The delivery shall be as per NIT (Notice Inviting Tender).

7.0 DOCUMENTATION

- 7.1 Documents to be submitted by the bidder along with the bid.
- A copy of sheet "Contents" with bidder's signature & company stamp
 - A copy of sheet "Instructions to bidders for preparing Technical offer" with bidder's signature & company stamp.
 - Unpriced copy of "Annexure-I (Bill of Quantities)" with bidder's signature & company stamp.

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No other documentation is required to be submitted as technical offer. Any information contained in other parts of the offer (e.g. covering letter, annexures, etc.) which is deviating from specification requirements in any way shall not be considered by BHEL as part of offer.

- 7.2 Documents to be submitted by successful bidder after award of contract shall be as per Annexure-II.
- 7.3 Vendor drawing/ document schedule for the project shall be as per Annexure-III.



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DATASHEET A

(SPECIFIC TECHNICAL REQUIREMENTS)

1.0 APPLICABLE STANDARDS:

- a) IS: 2062 For Structural steel.
- b) IS: 2629 For hot dip galvanising of steel & surface pre treatment.
- c) IS: 2633 For testing of zinc coating.
- d) IS: 6745 For determining of mass of zinc coating.
- e) IS: 1852 For rolling & cutting tolerances of hot rolled steel products.
- f) IS: 4759 For hot-dip zinc coatings on structural steel & other allied products

2.0 GALVANISED CABLE TRAY SUPPORT SYSTEM (WELDED):

- a) Material: Hot Rolled Mild Steel
- b) Length: Standard length of 5.5m to 6.5m
- c) Sizes: As per Annexure-I (BOQ cum Price schedule) attached
- d) Type: Hot-dip galvanised

3.0 SURFACE TREATMENT:

Galvanizing:

- a) Pre-treatment: As per IS 2629 prior to galvanisation
- b) Type: Hot dip galvanization
- c) Applicable Standard: IS 2629
- d) Minimum thickness: 75 microns (minimum)
- e) Min. weight of:
Zinc deposit: 610 gms. per square meter
- f) Tests for galvanizing:
 - i) Weight of zinc coating as per IS : 6745
 - ii) Thickness of zinc coating as per IS : 4759
 - iii) Uniformity of zinc coating as per IS : 2633
 - iv) Adhesion as per IS: 2629



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STANDARD QUALITY PLAN

ANNEXURE-1

INSTRUCTIONS FOR QUALITY PLAN

The Quality Plan shall include all the Quality Control Measures and Checks adopted by the Vendor to ensure that the material/component/assembly/services supplied by him meet/will meet the requirements as per specifications and good practices. They shall include all stages of operation such as materials, processes, manufacture, assembly, packing and despatch. The following guide lines may be noted:

- Column 1- Serial Number
- Column 2- Component/Operation- The component and/or operation being checked shall be given here.
- Column 3- Characteristics check- The characteristics being checked shall be given here, e.g., chemical composition, mechanical properties, leak tightness, surface defects etc..
- Column 4- Category - 'CR' stands for critical characteristic - affecting safety of equipment and personnel
'MA' stands for major Characteristic - affecting safety of equipment and personnel
'MI' stands for minor characteristic - affecting appearance etc.
- Column 5- Type/Method of check e.g. chemical analysis tensile testing, hydraulic test, visual examination radiography etc.
- Column 6- Extent of check, such as, 100, 10, 1 percent etc.
- Column 7- Reference Documents - Documents, such as technical specification, drawings, standard specifications (IS, BS ETC.) procedure, etc. according to which check is done.
- Column 8- Acceptance Norms - Standards etc. according to which acceptability or otherwise of the characteristics being checked is decided.
- Column 9- Format of Record - Formats, log sheets, reports, etc. in which the observations are recorded. Standard log sheets, reports, formats etc. of the Vendors shall be numbered and such reference numbers shall be included here.
- Column 10- Agency - The agency which performs the test/instruction shall be written in sub-column 'W'
The agency which verifies test certificates/inspection records and carries out audit check of the components/operation shall be written in sub-column 'V'
- The agencies are codified as 1,2 & 3
- '1' stands for (BHEL)
- '1' * means the operation shall be cleared by BHEL before the start of the next operation.
- '2' Stands for Vendor
- '3' stands for sub-Vendor of the Vendor and so on.
- Example :
- Entry '3' in column 'P' means test./inspection to be performed by sub-Vendor's QC
- Entry '2' in column 'W' means test./inspection to be witnessed by Vendor's QC
- Entry '1' in column 'V' means verification shall be done by BHEL and next stage to be started only after the hold point is cleared by BHEL
- Column 11- Remarks - Any special remarks shall be given here.

NOTES :

1. In absence of correlation with the test certificate(s) (e.g. material identification) samples shall be drawn by BHEL and all tests as per relevant specifications shall be carried out in their presence or in recognized Government Laboratory.
2. When materials and components are initially identified and stamped by BHEL QS engineer, the identification marks shall be preserved till despatch. Wherever this is not possible, the identification mark shall be transferred to the components in the presence of BHEL QS Engineer unless otherwise agreed.
3. For castings and forgings integral test specimens shall be provided, When this is not possible for casting, they shall be poured in the presence of BHEL QS Engineer unless otherwise, if witnessing of test by BHEL is called for.
4. When welders qualified by reputed inspection agencies or statutory bodies are not available, qualification tests shall be conducted in the presence of BHEL QS Engineer.
5. This Quality Plan is liable to be modified as per the requirements of approved drawings and changes in technical specifications/drawings. If there are contradictions in respect of column 7 & 8 between this Quality Plan and the approved drawings specifications, the latter shall prevail.
6. Wherever inspection by BHELs Purchaser/Third Party/Statutory authorities are mandatory, this shall be complied with.
7. Inspection reports, log sheets, test reports/certificate. etc. shall be furnished to BHEL at the appropriate stages or at the time of final inspection, as required.
8. This Quality Plan is also applicable to spares, if any, under scope of supply of Vendor.
9. The quality plan shall be submitted in minimum 4 copies with a soft copy of the same or in line with contract requirements.

ANNEXURE -2 of Quality Plan

(LIST OF BHEL- PEM APPROVED GALVANIZERS)

SL. NO.	ITEM	VENDOR NAME	ADDRESS
1	GALVANISING	JENCO INDUSTRIAL CORPORATION	CHINCHOLI BUNDER KHKAR ROAD NEAR LINK ROAD DEVRUWADI MALAD (W) MUMBAI 400064
2	GALVANISING	NATIONAL GALVANISING COMPANY	66, BARRACKPORE KAMARHATT TRUNCK ROAD CALCUTTA-700058
3	GALVANISING	SIGMA GALVANISING PVT.LTD	PLOT NO.C-169, TTC, MIDC IND AREA NAVIN MUMBAI-400705
4	GALVANISING	B.P. PROJECTS PVT LTD	167A, VIVEKANANDA ROAD KOLKATA-700006
5	GALVANISING	STANDARD GALVANISERS	Makardah Road, Kabar Para, Bankra, Howarah - 711403
6	GALVANISING	STEEL PRODUCTS	National Highway No. 6, Chamrail, Kona, Howrah-711114
7	GALVANISING	UNITECH FABRICATORS & ENGINEERS PVT. LTD.	VILLAGE- AJAB NAGAR, P.O. -MOLLA SIMLLA, P.S. - SINGUR, DIST - HOOGLY, PIN-712223
8	GALVANISING	M/s Shivam Engineers & Fabricators	A0-282-284, Industrial area, South side of G.T. road, Ghaziabad, U.P.
9	GALVANISING	M/s B.G. Shirke Construction Technology Pvt. Ltd.	Office & factory : 72-76, Mundhawa, Pune - 401 036
10	GALVANISING	M/s Galbro Ispat Galvanizers Pvt. Ltd.	Gut 11 and 12, Opp. Kudus Steel Rolling mill, Wada, Thane , Mumbai

Note:- The above list doesn't include the list of BHEL - PEM approved galvanizing plants owned by BHEL - PEM registered vendor of cabling packages.



QUALITY PLAN

CUSTOMER :
NEYVELI LIGNITE CORPORATION LTD.
BIDDER/
VENDOR :

PROJECT TITLE :2x500 MW NEYVELI NEW THERMAL POW
PROJECT
STANDARD QP NO. : PE-QP-999-507-E006, REV. 0

SPECIFICATION NO. PE-TS-400/402-507-E012
SPECIFICATION TITLE: TECHNICAL SPECIFICATION FOR GALVANIS
CABLE TRAY SUPPORT SYSTEM(WELDED TYPE)

SHEET 1 OF2

SYSTEM CABLEING

ITEM : CABLE TRAY SUPPORT MATERIAL (WELDED TYPE)

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	11	
1.0	RAW MATERIAL											
1.1	MILD STEEL SECTIONS (CHANNEL & ANGLES) AS PER SPECIFICATION	1.CHEMICAL & PHY. PROPERTIES	MA	VERIFICATION OF TC'S	100%	IS -2062	IS -2062	MILL TC	3	-	1/2	Steel shall be procured from SAIL/TISCO/RINL/BHUSAN/JINDAL STEEL/JINDAL ISPAT/ESSAR/LLOYD/ IISCO/ authorised SAIL Re Rollers.
		2.DIMENSIONS	MA	MEASUREMENT	100%	IS - 808/ IS - 1852	IS - 808/ IS - 1852	QC RECORD	3/2	-	-	
		3.SURFACE FINISH	MA	VISUAL	100%	IS:2062	IS:2062	QC RECORD	3/2	-	-	
1.2	ZINC	CHEM.COMP.	MA	CHEM. TEST	EACH HEAT	IS-209	IS-209	QC RECORD	3/2	-	1/2	
2.0	IN-PROCESS											
2.1	CUTTING	1.DIMENSIONS	MA	MEASUREMENT	100%	APP. DATA SHEET	APP. DATA SHEET	QC RECORD	2	-	1	
		2. WELDING QUALITY (IF APPLICABLE)	MA	VISUAL	100%	GOOD WELDING PRACTICE	FREE FROM DEFECTS & SLAG	QC RECORD	2	-	1	
		3.SURFACE FINISH	MA	VISUAL	100%	FREE FROM DEFECTS & SLAG	FREE FROM DEFECTS & SLAG	QC RECORD	2	-	1	
2.2	SURFACE PREPARATION	1.CLEANING, PICKLING, RINSING & FLUXING	MA	VISUAL	PERIODIC IN EACH SHIFT	IS:2629	IS:2629	QC RECORD	2	-	-	
		2. SURFACE QUALITY	MA	VISUAL	100%	IS-2629	IS-2629	QC RECORD	2	-	-	
2.3	GALVANISING	1.TEMPERATURE OF BATH	MA	TEMPERATURE INDICATOR	CONTINUOUS	IS-2629	IS-2629	QC RECORD	3/2	-	-	If vendor doesn't have his own galvanizing plant duly approved by BHEL PEM; then galvanizing shall be carried out at BHEL-PEM approved other galvanizing plants as per Annexure-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 :
NEYVELI LIGNITE CORPORATION LTD.
BIDDER/
VENDOR

PROJECT TITLE :2x500 MW NEYVELI NEW THERMAL POW
PROJECT
STANDARD QP NO. : PE-QP-999-507-E006, REV. 0

SPECIFICATION NO. PE-TS-400/402-507-E012
SPECIFICATION TITLE: TECHNICAL SPECIFICATION FOR GALVANIZED
CABLE TRAY SUPPORT SYSTEM(WELDED TYPE)

SHEET 2 OF 2

SYSTEM CABLING

ITEM : CABLE TRAY SUPPORT MATERIAL (WELDED TYPE)

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
3.0	FINISHED ITEMS	2. DROSS	MA	VISUAL	PERIODIC	IS - 2629	IS - 2629	QC RECORD	3/2	-	-	
		3. RATE OF IMMERSION	MA	VISUAL MEASUREMENT	100%	IS - 2629 / MFR'S PRACTICE	IS - 2629 / MFR'S PRACTICE	QC RECORD	3/2	-	2	
		4. SURFACE QUALITY	MA	VISUAL	100%	IS - 2629	FREE FROM BURRS ROUGHNESS, SLAG, FLUX, STAIN, ETC.	QC RECORD	3/2	-	-	
		1.DIMENSIONS	MA	MEASUREMENT	IS 2500 (PART 1) LEVEL S-4	APP. DATA SHEET	APP. DATA SHEET	INSP. REPORT	2	1	-	
		2. SURFACE FINISH	MA	VISUAL	IS 2500 (PART 1) LEVEL S-4	FREE FROM BURRS, SLAG, ROUGHNESS, FLUX, STAIN, ETC.	FREE FROM BURRS, SLAG, ROUGHNESS, FLUX, STAIN, ETC.	INSP. REPORT	2	1	-	
		3.MASS OF ZINC COATING	MA	CHEM. TEST	IS - 4759	IS-6745 / APP. DATA SHEET	APP. DATA SHEET	INSP. REPORT	2	1	-	
		4.UNIFORMITY OF ZINC COATING	MA	CHEM. TEST	IS - 4759	IS-2633	IS-2633	INSP. REPORT	2	1	-	
		5.THICKNESS OF ZINC COATING	MA	ELCOMETER	IS - 4759	APP. DATA SHEET	APP. DATA SHEET	INSP. REPORT	2	1	-	
		6.ADHESION	MA	MECH.TEST	IS-4759	IS-2629	IS-2629	INSP. REPORT	2	1	-	
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