

Technical Specification for Automatic Oscillation Welding System

NOTE:-

1. The "Offered" Column and where applicable, the "Deviations" & "Remarks" Column of this format shall be filled in by the Vendor and submitted along with the offer. Inadequate / incomplete, ambiguous, or unsustainable information against any of the clauses of the specifications/requirements shall be treated as non-compliance.

2. The offer and all documents enclosed with offer should be in English language only.

ADDRESS OF THE SUPPLIER :

ADDRESS OF THE INDIAN DEALER:

TELEPHONE NOS.:

TELEPHONE NOS.:

FAX NOS.:

FAX NOS.:

E-MAIL ADDRESS :

E-MAIL ADDRESS :

SCOPE: SUPPLY, ERECTION & COMMISSIONING OF Automatic Oscillation Welding System AS BELOW :

SL.NO.	DESCRIPTION FOR REQUIREMENT	FOR VENDOR		
		OFFERED	DEVIATIONS	REMARKS
1.0 PURPOSE				
1.1	Automatic oscillation Welding System will be used for welding on Linear as well as Circular track(360°) at all position.	Vendor to note & accept		
2.0 SPECIFICATION:				
2.1	Linear Oscillation System for flexible Track suitable for all welding position. It shall run on flexible track which attaches to work surface via magnets or vacuum system in any position.	Vendor to specify		
2.1.1	Motorized weld center line adjustment With independent, electronically controlled dwells (0-5 sec.) at each end of the stroke and at the centre of the stroke path. Speed range 8 to 188 cycles per minute(16 to 376 passes per minute).	Vendor to specify		
2.1.2	It has suitable adjustment to support MIG gun and cable support assembly to prevent cable drag from MIG gun.	Vendor to specify		

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SL.NO	DESCRIPTION FOR REQUIREMENT		FOR VENDOR		
			OFFERED	DEVIATION	REMARK
2.1.3	It has automatic wire feed start ,adjustable carriage delay start,dwell on/off switch,auto start switch, toggle switch to change oscillator mode from standard angular oscillation pattern to step square wave oscillation pattern. (radial).	Vendor to specify			
2.1.4	Oscillation speed is electronically controlled by a speed potentiometer 140 inches(3556mm) per minutes linear 45° per second radial	Vendor to specify			
2.1.5	Motorized easy, precise stroke width	Vendor to offer			
2.1.6	Digital travel speed indicator	Vendor to offer			
2.1.7	Vertical lifting power (Vendor to specify)	Vendor to offer			
2.1.8	Precision drive motor prevents unit from moving when power is off	Vendor to offer			
2.1.9	Storage of welding parameters after power is turned off	Vendor to offer			
2.2	Rack box riser bracket provides an adjustable mounting surface – 2"(50.8mm),4"(101.6mm)or 6" (152.4mm)above the normal carriage rack box mounting surface	Vendor to offer			
2.3	Flexible track idler carriage with self-aligning wheel assemblies providing flat surface for mounting equipment.	Vendor to offer			
2.4	Heavy duty flexible track with minimum dia approx. OD 1500 mm, complete with interlocking ends. Total length -9 to 10 meter.	Vendor to specify			
2.5	Aluminum flexible track stiffener with fixing screw.	Vendor to offer			
2.6	Track mounting device consisting of magnet with on/off switch suitable to above equipment & sufficient to track length.	Vendor to offer			
2.7	Pivoting track mounting assembly for lifting to standard track mounting devices.	Vendor to offer			
2.8	Power Supply	Vendor to specify			

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SL.NO.	DESCRIPTION FOR REQUIREMENT	FOR VENDOR		
		OFFERED	DEVIATIONS	REMARKS
3.0	DOCUMENTATION :			
3.1	Three sets of following documents (Hard copies) in English language shall be supplied along with the machine	Vendor to offer		
3.2	Operating manuals of Machine	Vendor to offer		
3.3	Catalogues, Operation & Maintenance Manuals of all items including drawings, wherever applicable.	Vendor to offer		
4.0	COMMISSIONING :			
4.1	Supplier to take full responsibility for carrying out start up, testing of machine, it's control & all types of other supplied equipment etc.	Vendor to confirm		
4.2	Successful proving of BHEL Jobs by the supplier shall be considered as part of commissioning.	Vendor to confirm		
4.3	Tools, Tackles, Test Mandrels, instruments and other necessary equipment required to carry out all erection & commissioning activities to be arranged and brought by the supplier. Out of the complete supply, all tools, tackles, mandrels etc. which may be required by BHEL to maintain the machine, after commissioning, shall not be taken back by vendor. Vendor to offer accordingly.	Vendor to offer		
4.4	Commissioning spares, required for commissioning of the machine within stipulated time, shall be brought by the supplier on returnable basis.	Vendor to offer		
4.5	Schedule of Commissioning shall be submitted with the offer.	Vendor to submit		
5.0	MACHINE ACCEPTANCE: (Tests/Activities to be Performed by Vendor)			
5.1	Demonstration of all features of the machine, control system & accessories.	Vendor to accept		
5.2	Training of BHEL's machine operators in operation of complete machine & accessories etc for minimum of 6 working days. by the supplier's experts during their stay at BHEL works for commissioning of the machine. Training area given below (a) Operation for the machine (b) Electrical & Electronic maintenance for machine & other supplied equipment. (c) Maintenance of the machine & other supplied equipment.	Vendor to accept		

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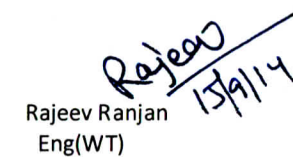
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SL.NO.	DESCRIPTION FOR REQUIREMENT	FOR VENDOR		
		OFFERED	DEVIATIONS	REMARKS
7.0	PACKING :			
7.1	All Transport worthy & rigid packing for all items of complete machine	Vendor to accept & offer		
8.0	GUARANTEE/WARANTEE :			
8.1	Guarantee / Warrantee for complete machine for 24 months from the date of acceptance of the machine.	Vendor to offer/ confirm		
9.0	GENERAL :			
9.1	Machine Model No.	Vendor to inform		
9.2	Total connected load (KVA)	Vendor to inform		
9.3	Total weight of the machine	Vendor to inform		
9.4	Weight of heaviest part of machine	Vendor to inform		
9.5	Weight of the heaviest assembly / sub-assembly of the Machine	Vendor to inform		
9.6	Dimensions of largest part/ sub-assembly/ assembly of the machine	Vendor to inform		
9.7	Vendor to submit, along with offer, reference list of customers where similar machines have been supplied mentioning broad specifications of the supplied machine etc	Vendor to submit		


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