

NEYVELI LIGNITE CORPORATION LTD.

2 X 500 MW NEW NEYVELI TPP

**TECHNICAL SPECIFICATION
FOR
METAL EXPANSION BELLOWS**

VOLUME – IIB

SPECIFICATION NO: PE-TS-402-100-M021 (REV-00)



**BHARAT HEAVY ELECTRICALS LIMITED, POWER SECTOR
PROJECT ENGINEERING MANAGEMENT,
PLOT NO. 25, SECTOR-16A, NOIDA, INDIA**

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|  | TITLE: PREAMBLE | SPECIFICATION NO. PE-SS-999-100-Q001 | |
| | | VOLUME | |
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1.0 The tender document contains three (3) volumes. The bidder shall meet the requirements of all the three 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, B and C.

Data Sheet - A Specifies data and other requirements pertaining to the Equipment.


Data Sheet - B Specifies data to be filled by the bidder (Data Sheet-B is contained in Volume-III).

Data Sheet - C Indicates data/documents to be furnished after the award of contract as per agreed schedule by the vendor (as applicable).

1.2.2 **Volume-III (TECHNICAL SCHEDULES)**

This volume contains technical schedules and Data Sheets-B, which are to be duly filled by the bidder and the same shall be furnished with the technical bid as per instructions given in Document No. PE-SS-999-100-Q-002 in Volume-III.

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. This specification covers the Design, Manufacture, Inspection & Testing at vendor's and/or his sub-vendor's works, proper packing and delivery to site of the METAL EXPANSION BELLOWS as per the requirements mentioned in different sections of the specification for **2X500 MW NEW NEYVELI TPP**.
2. The purpose of metallic expansion bellows is to reduce the reactions/forces & moment at the connected equipment terminals due to thermal expansion/contraction and/or vibration of connected equipment and piping. The arrangement of the bellows in the piping, design conditions, size, bellow spring rates, lengths, tag nos. and services etc. are furnished in Data Sheet-A. The bellows shall be installed / located in the position as indicated in the data sheets.
3. It is not the intent to specify herein all the details of design and manufacture. However the equipment shall conform in all respects to high standards of design, engineering and workmanship and shall be capable of performing the required duties in a manner acceptable to purchaser, who will interpret the meaning of drawing and specification and shall be entitled to reject any work or material, which in his judgment is not in full accordance herewith.
4. The omission of specific reference to any component/ accessories necessary for the proper performance of Metal Expansion Bellows shall not relieve the bidder of the responsibility of providing such facilities to complete the supply of bellows at quoted prices.
5. Design/ drawings/ data sheets etc. shall be subject to approval of BHEL as per specification, in the event of order.
6. The equipment covered under this specification shall not be dispatched unless the same have been finally inspected, accepted and shipping release issued by BHEL.

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SECTION-B

PROJECT INFORMATION

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PROJECT INFORMATION


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 provided in this section will be for general guidance and shall not be contractually bidding on BHEL/OWNER. All relevant site data/information as may be necessary shall have to be obtained/ collected by the bidder.

| PROJECT INFORMATION | | |
|---------------------|--|---|
| Sl. No. | FEATURES | DETAILS |
| 1 | Owner | IDEAL ENERGY PROJECTS LIMITED |
| 2 | Site Location | 200 Kms south of Chennai and 50 Kms south-west of cuddalore. |
| 3 | Elevation above MSL | +67M |
| 4 | Nearest Railway Station | Neyveli |
| 5 | Nearest sea port | Chennai, at a distance of 200 Kms |
| 6 | Nearest air port | Chennai, at a distance of 200 Kms |
| 7 | 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. |
| 8 | Max. temperatures Deg. C | 42.8 |
| 9 | Minimum temperature Deg. C | 26.9 |
| 10 | Relative humidity (%) Maximum | 92% in the month of September |
| 11 | Average Annual rainfall during June to September | About 1265.7 mm annually (average) |
| 12 | Prevailing wind direction | South West to North East direction |
| 13 | Seismic condition | 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 GENERAL

- 1.1 The Metal expansion Bellows shall meet the technical requirements and conform to the standard technical specifications and Data sheet A of Section D. In addition, the requirements of this Section-C shall also be complied with. However, wherever the details given in the standard technical specification of Section-D and Data sheet-A are different, the requirements of Data sheet A shall prevail. Similarly in the event of contradictions between Section–C & Section–D/ Data sheet A, Section-C shall prevail.
- 1.2 The technical requirements for bellows shall, in general, be as per the attached standard Technical specification for bellows, and Data sheets A of Vol. II B Section D.
- 1.3 Based on BHEL's comments on design, EJMA calculations and constructional details, vendor may be required to make changes if needed so that the bellows meet the technical requirements of this specification. BHEL decision will be binding in case of any conflict and the vendor will have to comply with BHEL requirements.

2 SCOPE OF SUPPLY

- 2.1 The bellows to be supplied shall be as per Data sheet- A and Standard Technical Specification of Section D.
- 2.2 Special Tools and tackles, if any.
- 2.3 Drawings, datasheets, operation and maintenance manuals etc., as specified in Data Sheet-C.

3 QUALITY ASSURANCE AND TESTS


- 3.1 The Quality Plan enclosed with this specification specify minimum quality control requirement. During contract stage vendor shall furnish this Quality Plan duly signed & stamped for BHEL approval. The final quality plan may incorporate some changes based on customer comments (if any). Quality plans shall be approved by BHEL and customer (If necessary). All inspection and testing shall be carried out by BHEL/ BHEL representative and BHEL customer (if necessary). In case inspection is by both BHEL and their customer, then the inspection can be carried out jointly or separately, which will be informed later.
- 3.2 Type tests may be required to be done in line with clause 6.3 of Standard Technical specification of Vol. II B section D and quality plan. Final decision regarding conducting of type test will be conveyed by BHEL at a later date which will be binding on the vendor without commercial implication.

Note: There may be minor changes in quality plan depending on customer/consultant comments which will have to be accommodated by vendor at no extra cost.

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4 DOCUMENTS TO BE SUBMITTED ALONG WITH OFFER

- a) Compliance sheet as enclosed in Volume III.
- b) Drawings with following details (if asked for during clarifications):
 - i. Design data
 - ii. All necessary dimensions (with tolerance as per EJMA).
 - iii. Cross sectional arrangement.
 - iv. Arrangement of tie rods (limit rods) along with washers and nuts.
 - v. Arrangement of sleeves and cover.
 - vi. Bill of material and total weight.
 - vii. Welding standards and welding details.
 - viii. Flange details/butt welds end details.
 - ix. Design deflections and stiffness rates for each bellow.
 - x. Bellow element details.
 - xi. Painting details
 - xii. Testing requirements including test pressures.
- c) Design calculations as per EJMA for bellows & other components of bellow assembly such as tie rods, flanges washers etc. (if asked for during clarifications).
- d) Stress calculations for pressure carrying parts i.e. flanges, hinge plates, tie rods, gimbal rings etc. Finite element analysis for the same (if required by BHEL) may be required to be carried out on new and higher size bellows. In case FEA is to be done, then vendor will carry out the same at their own cost. No extra charges on this account will be admissible to vendors.
- e) Stress calculations for local stresses (if required by BHEL) where flanges are welded to pipe.
- f) Schedule of Deviations, duly filled, in format enclosed at Vol. III.
- g) Schedules of Price & Unit Price, duly filled, in format enclosed at Vol. III.
- h) Schedule of declaration, duly filled, in format enclosed at Vol. III.

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5 PAINING REQUIREMENT

| SERVICE | SURFACE CLEANING | PAINING DETAIL | COLOUR SHADE |
|-------------------------|--------------------------|---|------------------------------|
| Condensate suction line | SP3, Power tool cleaning | Bellows first shall be painted with two coats of Red oxide zinc chromate primer (alkyd base) with each coat of DFT equal to 25 microns conforming to IS:2074. Finish paint shall be three shop coats (DFT 35 microns each coat) of synthetic enamel paint (long oil alkyd) as per IS: 2932. Total DFT of primer and paint shall be 155 microns. | Sea green shade no. ISC -217 |
| Flash Tank Vents | SP3, Power tool cleaning | 2 coats (Total DFT 40 µm) of heat resistant aluminium paint to IS 13183 Gr.II. | Aluminium |
| TD BFP Exhaust | SP3, Power tool cleaning | 2 coats (Total DFT 40 µm) of heat resistant aluminium paint to IS 13183 Gr.II. | Aluminium |

6 TYPE TESTS

Type tests as per EJMA are required to be carried out for bellows. If type tests have been successfully done for earlier BHEL projects for the bellows of the same size (as required in the project) in a group (as per clause 6.3 of Standard technical specification of Vol. II B section D), then test certificates of same shall be reviewed and no type test need be carried out. Also, these test certificates shall not be older than 5 years from project bid opening date which is 4th January, 2014. In this case, type test clearance shall be taken from BHEL prior to offering to routine test.

In case no type test has been conducted for earlier projects or type reports are not valid for this project then the same shall be carried out as per clause 6.3 of Standard technical specification of Vol. II B section D and type test procedure approval shall be taken from BHEL prior to offering to routine test.

Final decision regarding conductance of type test will be conveyed by BHEL at a later date after award of contract, which will be binding on the bidder without commercial implication.


7 PACKING REQUIREMENT

Refer clause 8 of Section 'D' Standard Technical Specification for packing details. Vendor to provide soft copy of photos/snaps of duly packed ME Bellows. The soft copies to be provided by vendor after final inspection of ME Bellows. Clearance for dispatch of ME Bellows will be given only after verification of satisfactory packing conditions of ME Bellows from vendor's works.

8 CONSTRUCTION DETAILS

8.1 Bellows

- i. The bellows shall be manufactured by hydraulic forming, roll forming or any other method specified in latest edition of EJMA. They should be formed from perfect cylinders of single ply, 304 grade stainless steel.
- ii. The number of longitudinal weld seams shall be minimum and there shall be no circumferential weld seam.

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- iii. Cold-formed stainless steel bellows shall not be heat-treated.
- iv. All bellow elements shall be pickled after forming,
- v. Equalizing rings, where required, shall be either from high quality castings or from fabricated metal.
- vi. Flanged expansion joints shall be provided with adequate pipe stubs.
- vii. Butt welded expansion joints shall have adequate length of pipe so that site welding does not impair or reduce the joints efficiency.
- viii. Bellows will be Single Ply Design only.

8.2 Sleeves

- i. Expansion joints will be furnished with internal sleeves of the same material as the bellows and installed with sufficient clearance to allow full rated deflection. The sleeves shall be welded on the flow inlet end of the joint only.
- ii. Bellow shall have external sleeves with an arrow indicating the direction of flow on the outside. The external steel covers provided to protect bellows from physical damages, shall be suitable for supporting insulation where necessary and shall be detachable.

8.3 Tie Bars

- i. Joints shall be shipped at neutral length. They shall be provided with suitable erection and knock-off type temporary tie bars to prevent damage and misalignment during transit and also with permanent tie bars along with necessary nuts, bolts etc.
- ii. The rods on pressure balanced type expansion joints shall be adequately sized to prevent buckling in vacuum services or services with other external loads.

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SECTION-D
STANDARD TECHNICAL SPECIFICATION
FOR
METAL EXPANSION BELLOWS

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1 GENERAL

This specification covers the design, materials, construction features, manufacture and testing of Metal expansion bellows at Vendor's or/ and sub-Vendor's works inclusive of painting and packing requirements.

2 CODES & STANDARDS

- 2.1 The design, manufacture, performance and testing of the expansion bellows shall conform to the latest editions of the relevant codes and standards inclusive of the stipulations in the latest editions of Expansion Joint Manufacturers Association Standards (EJMA) as well as ASME Section III, ASME Section VIII, ASTM E-165 and ASME- B31.1.
- 2.2 In case of any conflict between the above Codes/Standards and this specification, the latter shall prevail and in case any further conflict in this matter, the interpretation of the specification by the Engineer shall be final & binding.

3 DESIGN REQUIREMENTS

- 3.1 The design calculations of bellows shall be as per EJMA.
- 3.2 Dimensional tolerance for the expansion bellows should be as per EJMA.
- 3.3 The expansion bellows shall be capable of withstanding design pressure and full vacuum also wherever applicable.
- 3.4 The expansion bellows shall be designed for the deflections /angulations indicated in data sheets- A. They should in addition be able to take an extra +5mm /1 Degree deflection in all directions to take care of any mismatch during erection. The spring rates of the bellows expansion joints shall be within the values specified.
- 3.5 The cyclic life of the expansion bellow shall be minimum of 10,000 cycles.
- 3.6 Stress relieving or annealing after forming of bellows is not recommended.
- 3.7 No pre-tension of bellows is permitted.

4 MATERIAL

- 4.1 The material of construction of main parts of bellows shall be as specified in Data Sheet - 'A' of Vol. IIB Section D.
- 4.2 The materials of construction of the remaining parts shall be to suit service conditions. These materials shall be subject to approval of the purchaser.
- 4.3 Materials used in manufacture of valves shall be of tested quality.


5 CONSTRUCTIONAL FEATURES

- 5.1 The type of the expansion joints shall be as indicated in the Data sheet- A.
- 5.2 All untied expansion joints shall have a minimum of two limit rods across the bellows to prevent the bellows from closing/opening under vacuum / pressure beyond limit.
- 5.3 Tied lateral angular expansion joints shall be provided with two tie rods to take vacuum/pressure thrust and these tie rods shall have spherical washers with sufficient

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clearances in flange holes to accommodate lateral deflections of bellows. These bellows shall be capable of taking care of angulation in one plane.

- 5.4 Spherical washers/hinges should have a low coefficient of friction preferably with P.T.F.E. lining.
- 5.5 Hinged bellow shall be provided with hinge plates and hinge pin permitting the bellows for angulating about one plane while taking the pressure thrust.
- 5.6 Gimbal bellows shall have a gimbal ring, which shall be square with hinge plates and pins allowing the bellows to angulate in both planes while taking the pressure thrust.
- 5.7 The number of longitudinal weld seam shall be minimum & Circumferential welding of elements to make bellows is not permitted. The welding procedure and welder qualification shall be as per ASME Section IX.
- 5.8 Each expansion bellow shall be enclosed in a protective cover to protect the bellows from damage during shipping, installation and while in operation. The arrangement of such cover will enable the thermal insulation to be provided leaving the tie rods uncovered. The cover shall not restrict the free deflection of bellows.
- 5.9 Bidder to ensure that thinning due to forming shall be less than 15%.
- 5.10 Bellows shall be provided with complete round flanges housing the tie rods/limit rods.
- 5.11 The bellows shall be manufactured by hydraulic forming, roll forming or any other method specified in latest edition of EJMA. They should be formed from perfect cylinders of single ply.
- 5.12 All bellow elements shall be pickled after forming,
- 5.13 Equalising rings, where required, shall be either from high quality castings or from fabricated metal.
- 5.14 Butt welded expansion joints shall have adequate length of pipe so that site welding does not impair or reduce the joints efficiency.
- 5.15 Expansion joints will be furnished with internal sleeves of the same material as the bellows and installed with sufficient clearance to allow full rated deflection. The sleeves shall be welded on the flow inlet end of the joint only. The sleeve shall also be provided with a drain hole wherever necessary to avoid condensate accumulation.
- 5.16 The tie rods and limit rods shall be adequately sized to absorb pressure thrust and prevent buckling in vacuum service.

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6 TESTING AND INSPECTION

6.1 The items covered under this contract shall be subjected to inspection, testing and quality surveillance. The Inspection Agency shall, at all reasonable times have access to Vendor's works, Quality Control records and all facilities as reasonably required for carrying out the inspection and testing efficiently, and these shall be provided by the vendor free of cost

6.2 The minimum NDT/testing and inspection requirements for bellows shall be as per the attached Quality Plan. However, in case of order, final inspection and testing shall be carried out as per the final approved quality plan without any price implications.

6.3 TYPE TESTS (CYCLE LIFE, SQUIRM AND YIELD RUPTURE TESTS):

Type tests as per EJMA are required to be carried out for bellows. These shall be done as per classification given below:

6.3.1 CLASSIFICATION OF BELLOWS FOR THE PURPOSE OF TYPE TEST

The bellows shall be classified as per parameters below. The bellows conforming to same combination of categories of these parameters shall constitute one group.

6.3.1.1 Material of Bellows: Three categories are envisaged - Carbon steel, stainless steel (e.g. SS-304, 321, 316 etc.) and High alloy steels (e.g. Inconel)

6.3.1.2 Profile of Convolutions: Each profile shall be considered as separate category (e.g. 'U' profile, 'V' profile, Lyra profile etc.).

6.3.1.3 Diameter of Bellows - The categories are as follows:

- a) Nominal dia upto 800mm NB.
- b) Nominal dia greater than 800mm NB upto 1600 NB.
- c) Each size above 1600mm NB shall be a separate category.

6.3.1.4 Design Pressure : Two categories are envisaged. First is for design pressure from full vacuum up to 5 Kg/cm² (g) second category is for pressure above 5 Kg/cm² (g) up to 10 Kg/cm² (g).

6.3.2 Criteria of test:

From each group of bellows, as per clause 6.3.1 above, Type tests shall be carried out on two nos. of bellows which has maximum total stress as per EJMA among the bellows of the same group. One bellow shall be used for life cycle test and the other for Squirm & Yield rupture test. Other bellows of this group shall be qualified on the basis of this test.

6.3.3 No. of Cycles

For the life cycle test, the number of test cycles shall be minimum 10,000 cycles. The squirm and yield pressure shall be as per approved pressure and calculations.

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7 PAINING

All parts which are not made of stainless steel or other corrosion resisting materials shall be cleaned, flushed and coated with anti-corrosive paints of approved make and quality before shipment. Before painting, the surfaces shall be thoroughly cleaned of grease, dirt etc.


8 CLEANING, PROTECTION FOR DESPATCH AND PACKING

All parts shall be properly boxed, crated or otherwise protected for transportation. Exposed finished surface shall be thoroughly greased before transportation. Joints shall be shipped at neutral length. They shall be provided with suitable erection and knock-off type temporary tie bars to prevent damage and misalignment during transit. These rods shall be tagged with instruction that they are to be left in place during erection but shall be removed before the system is placed in operation.

9 Bellows Tag Nos. shall be incorporated in all the dispatch documents.


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| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | | |
|------|---|--|--|--|-----------------------------|
| 1 | GENERAL | TAG NO. | - | E4,E5,E13,E14 | E6,E15 |
| 2 | | LOCATION | - | BFPT-A & B EXHAUST TO CONDENSER | |
| 3 | | INSTALLATION | - | VERTICAL | HORIZONTAL |
| 4 | | QUANTITIES REQD. PER UNIT | NOS | ONE EACH | ONE EACH |
| 5 | | TOTAL QUANTITY REQUIRED (2 UNITS) | NOS | EIGHT | FOUR |
| 6 | | FLUID | - | STEAM | |
| 7 | DESIGN & OPERATING PARTICULARS | TYPE | - | GIMBAL | HINGED ANGULAR |
| 8 | | SIZE | NB | 1600 | 1600 |
| 9 | | MATCHING PIPE (OD X THK) | MM | 1626x12 | 1626x12 |
| 10 | | OPERATING PRESSURE | KG/CM ² (A) | 0.106 | 0.106 |
| 11 | | OPERATING TEMPERATURE | °C | 100 | 100 |
| 12 | | DESIGN PRESSURE | KG/CM ² (G) | 2 & FULL VACUUM | 2 & FULL VACUUM |
| 13 | | DESIGN TEMPERATURE | °C | 100 | 100 |
| 14 | | DESIGN FLOW VELOCITY | M/S | 100 | 100 |
| 15 | | CYCLIC DESIGN LIFE | CYCLE | 10,000 | 10,000 |
| 16 | | AXIAL COMPRESSION (DESIGN) | MM | N.A. | N.A. |
| 17 | | AXIAL ELONGATION (DESIGN) | MM | N.A. | N.A. |
| 18 | | LATERAL DEFLECTION (DESIGN) | MM | N.A. | N.A. |
| 19 | | ANGULAR ROTATION (DESIGN) | DEGREE | 1.0 ⁰ | 0.5 ⁰ |
| 20 | | I. OVERALL LENGTH II. BELLOWS CENTRE DISTANCE | MM MM | 1100 N.A. | 900 N.A. |
| 21 | | MAX THEORETICAL INITIAL ELASTIC SPRING RATE: I) AXIAL II) LATERAL III) ANGULAR A) FOR FULL ASSEMBLY B) FOR EACH BELLOWS (IN CASE OF DOUBLE BELLOWS) | KG/MM KG/MM Kg-m/deg kg-m/deg | N.A. N.A. 550 N.A. | N.A. N.A. 550 N.A. |
| 22 | | MIN. FLANGE THICKNESS | MM | 70 | 70 |
| 23 | | MIN. TIE ROD DIAMETER | MM | - | - |
| 24 | | MIN. SLEEVE THICKNESS | MM | 8 | 8 |
| 25 | MIN GIMBAL RING THICKNESS (TxW) | MM | 70x325 | - | |
| 26 | MIN. HINGE MAIN PLATE THICKNESS | MM | - | 70 | |
| 27 | MIN. HINGE SUPPORT PLATE THICKNESS | MM | 36 | 36 | |
| 28 | MIN. HINGE/ GIMBAL PIN DIAMETER | MM | 80 | 80 | |


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|---|---|---------------------------------------|------------------|
|  | TITLE: TECHNICAL DATA SHEET DATA SHEET- A 2X500 MW NEW NEYVELI TPP | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | | VOLUME : IIB | |
| | | SECTION: D | |
| | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 2 OF 10 | |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | |
|------|---|--------------------|----------------------------------|----------------------------------|
| 29 | MIN. GUSSET THICKNESS | MM | 36 | 36 |
| 30 | THICKNESS OF END PIPE LOCAL TO FLANGE | MM | 25 (SEE NOTE BELOW) | 25 (SEE NOTE BELOW) |
| 31 | BELLOWS STABILITY FACTOR DEPENDING ON END CONN. FOR EVALUATING COL. SQUIRM | - | 0.5 PSC | 0.5 PSC |
| 32 | MIN. VALUE OF LIMITING INTERNAL DESIGN PRESSURE BASED ON COLUMN INSTABILITY (P_{sc}) | KG/CM ² | 4.5 | 4.5 |
| 34 | MIN. VALUE OF LIMITING DESIGN PRESSURE BASED ON INPLANE INSTABILITY AND LOCAL PLASTICITY (P_{sl}) | KG/CM ² | 4.5 | 4.5 |
| 35 | BELLOWS | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 36 | SPOOL PIPES | - | SA 672 GR.B70 | SA 672 GR.B70 |
| 37 | TIE ROD/LIMIT ROD WITH NUTS | - | - | - |
| 38 | HINGE PLATE | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 39 | GIMBAL RING | - | IS 2062 GR.B/ SA515/516 GR.70 | N.A. |
| 40 | SPHERICAL WASHERS a) MATERIAL b) CASE HARDENED c) SURFACE FINISH | - HRC MICRON | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 41 | HINGE PIN | - | CARBON STEEL CL.8.8 | CARBON STEEL CL.8.8 |
| 42 | INTERNAL SLEEVE | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 43 | COVER | - | CARBON STEEL | CARBON STEEL |
| 44 | FLANGE (HOUSING TIE RODS/ HINGE PLATE) | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 45 | FLANGE a) MATERIAL b) RATING c) DRILLING | - - - | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 46 | BUTTWELD DETAILS (TO SUIT MATCHING PIPE) | - | AS PER ASME B 16.25 | AS PER ASME B 16.25 |
| 47 | CODES/STANDARDS APPLICABLE | - | EJMA | EJMA |
| 48 | OTHER REQUIREMENTS | - | - | - |

NOTE: - THICKNESS OF END PIPE LOCAL TO FLANGE TO BE AS SPECIFIED. IT IS TO BE STEP MACHINED TO 12 MM NEAR THE BELLOWS CONVOLUTION AND EDGE PREPARED TO SUIT MATCHING PIPE AT OTHER END.


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|---|---------------------------------|---------------------------------------|------------------|
|  | TITLE: | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | TECHNICAL DATA SHEET | VOLUME : IIB | |
| | DATA SHEET- A | SECTION: D | |
| | 2X500 MW NEW NEYVELI TPP | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 3 | OF 10 |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | | |
|------|---|--|--|--|-----------------------------|
| 1 | GENERAL | TAG NO. | - | E7,E8 | E9 |
| 2 | | LOCATION | - | HP DRAIN FLASH TANK VENT TO CONDENSER | |
| 3 | | INSTALLATION | - | HORIZONTAL | VERTICAL |
| 4 | | QUANTITIES REQD. PER UNIT | NOS | ONE EACH | ONE |
| 5 | | TOTAL QUANTITY REQUIRED (2 UNITS) | NOS | FOUR | TWO |
| 6 | | FLUID | - | STEAM | |
| 7 | DESIGN & OPERATING PARTICULARS | TYPE | - | HINGED ANGULAR | HINGED ANGULAR |
| 8 | | SIZE | NB | 1200 | 1200 |
| 9 | | MATCHING PIPE (OD X THK) | MM | 1219X10 | 1219X10 |
| 10 | | OPERATING PRESSURE | KG/CM ² (A) | 0.11 | 0.11 |
| 11 | | OPERATING TEMPERATURE | °C | 100 | 100 |
| 12 | | DESIGN PRESSURE | KG/CM ² (G) | 2 & FULL VACUUM | 2 & FULL VACUUM |
| 13 | | DESIGN TEMPERATURE | °C | 210 | 210 |
| 14 | | FLOW VELOCITY AT OPERATING CONDITION | M/S | 100 | 100 |
| 15 | | CYCLIC DESIGN LIFE | CYCLE | 10,000 | 10,000 |
| 16 | | AXIAL COMPRESSION (DESIGN) | MM | N.A. | N.A. |
| 17 | | AXIAL ELONGATION (DESIGN) | MM | N.A. | N.A. |
| 18 | | LATERAL DEFLECTION (DESIGN) | MM | N.A. | N.A. |
| 19 | | ANGULAR ROTATION (DESIGN) | DEGREE | E7-2.25 ⁰ , E8-3.5 ⁰ | 1.5 ⁰ |
| 20 | | I. OVERALL LENGTH II. BELLOWS CENTRE DISTANCE | MM MM | 900 N.A. | 900 N.A. |
| 21 | | MAX THEORITICAL INITIAL ELASTIC SPRING RATE: I) AXIAL II) LATERAL III) ANGULAR A) FOR FULL ASSEMBLY B) FOR EACH BELLOWS (IN CASE OF DOUBLE BELLOWS) | KG/MM KG/MM Kg-m/deg kg-m/deg | N.A. N.A. 450 N.A. | N.A. N.A. 450 N.A. |
| 22 | | MIN. FLANGE THICKNESS | MM | 50 | 50 |
| 23 | | MIN. TIE ROD DIAMETER | MM | - | - |
| 24 | | MIN. HINGE PIN DIAMETER | MM | 60 | 60 |
| 25 | MIN. HINGE MAIN PLATE THICKNESS | MM | 40 | 40 | |
| 26 | MIN. HINGE SUPPORT PLATE THICKNESS | MM | 20 | 20 | |
| 27 | MIN. SLEEVE THICKNESS | MM | 6 | 6 | |
| 28 | MIN. GUSSET THICKNESS | MM | 20 | 20 | |


| | | | | |
|---|---------------------------------|--|---------------------------------------|------------------|
|  | TITLE: | | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | TECHNICAL DATA SHEET | | VOLUME : IIB | |
| | DATA SHEET- A | | SECTION: D | |
| | 2X500 MW NEW NEYVELI TPP | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | | SHEET 4 OF 10 | |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | |
|------|---|--------------------|----------------------------------|----------------------------------|
| 29 | THICKNESS OF END PIPE LOCAL TO FLANGE | MM | 20 (SEE NOTE BELOW) | 20 (SEE NOTE BELOW) |
| 30 | BELLOW STABILITY FACTOR DEPENDING ON END CONN. FOR EVALUATING COL. SQUIRM | - | 0.5 PSC | 0.5 PSC |
| 31 | MIN. VALUE OF LIMITING INTERNAL DESIGN PRESSURE BASED ON COLUMN INSTABILITY (P_{sc}) | KG/CM ² | 4.5 | 4.5 |
| 32 | MIN. VALUE OF LIMITING DESIGN PRESSURE BASED ON INPLANE INSTABILITY AND LOCAL PLASTICITY (P_{si}) | KG/CM ² | 4.5 | 4.5 |
| 33 | BELLOWS | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 34 | SPOOL PIPES | - | SA 672 GR.B70 | SA 672 GR.B70 |
| 35 | TIE ROD/LIMIT ROD WITH NUTS | - | N.A. | N.A. |
| 36 | HINGE PLATE | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 37 | GIMBAL RING | - | N.A. | N.A. |
| 38 | SPHERICAL WASHERS a) MATERIAL b) CASE HARDENED c) SURFACE FINISH | - HRC MICRON | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 39 | HINGE PIN | - | CARBON STEEL CL.8.8 | CARBON STEEL CL.8.8 |
| 40 | INTERNAL SLEEVE | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 41 | COVER | - | CARBON STEEL | CARBON STEEL |
| 42 | FLANGE (HOUSING TIE RODS/ HINGE PLATE) | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 43 | FLANGE a) MATERIAL b) RATING c) DRILLING | - - - | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 44 | BUTTWELD DETAILS (TO SUIT MATCHING PIPE) | - | AS PER ASME B 16.25 | AS PER ASME B 16.25 |
| 45 | CODES/STANDARDS APPLICABLE | - | EJMA | EJMA |
| 46 | OTHER REQUIREMENTS | - | - | - |

NOTE: THICKNESS OF END PIPE LOCAL TO FLANGE TO BE AS SPECIFIED. IT IS TO BE STEP MACHINED TO 10 MM NEAR THE BELLOWS CONVOLUTION AND EDGE PREPARED TO SUIT MATCHING PIPE AT OTHER END.


| | | | |
|---|---------------------------------|---------------------------------------|------------------|
|  | TITLE: | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | TECHNICAL DATA SHEET | VOLUME : IIB | |
| | DATA SHEET- A | SECTION: D | |
| | 2X500 MW NEW NEYVELI TPP | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 5 OF 10 | |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | | |
|------|--|--|---------------------------------|--|------------------|
| 1 | GENERAL | TAG NO. | - | E10,E11 | E12 |
| 2 | | LOCATION | - | LP DRAIN FLASH TANK VENT TO CONDENSER | |
| 3 | | INSTALLATION | - | HORIZONTAL | VERTICAL |
| 4 | | QUANTITIES REQD. PER UNIT | NOS | ONE EACH | ONE |
| 5 | | TOTAL QUANTITY REQUIRED (2 UNITS) | NOS | FOUR | TWO |
| 6 | | FLUID | - | STEAM | |
| 7 | DESIGN & OPERATING PARTICULARS | TYPE | - | HINGED ANGULAR | HINGED ANGULAR |
| 8 | | SIZE | NB | 900 | 900 |
| 9 | | MATCHING PIPE (OD X THK) | MM | 914X10 | 914X10 |
| 10 | | OPERATING PRESSURE | KG/CM ² (A) | 0.11 | 0.11 |
| 11 | | OPERATING TEMPERATURE | °C | 100 | 100 |
| 12 | | DESIGN PRESSURE | KG/CM ² (G) | 2 & FULL VACUUM | 2 & FULL VACUUM |
| 13 | | DESIGN TEMPERATURE | °C | 150 | 150 |
| 14 | | FLOW VELOCITY AT OPERATING CONDITION | M/S | 100 | 100 |
| 15 | | CYCLIC DESIGN LIFE | CYCLE | 10,000 | 10,000 |
| 16 | | AXIAL COMPRESSION (DESIGN) | MM | N.A. | N.A. |
| 17 | | AXIAL ELONGATION (DESIGN) | MM | N.A. | N.A. |
| 18 | | LATERAL DEFLECTION (DESIGN) | MM | N.A. | N.A. |
| 19 | | ANGULAR ROTATION (DESIGN) | DEGREE | E10-1.5 ⁰ , E11-1.8 ⁰ | 0.5 ⁰ |
| 20 | | I. OVERALL LENGTH II. BELLOWS CENTRE DISTANCE | MM MM | 900 N.A. | 900 N.A. |
| 21 | MAX THEORETICAL INITIAL ELASTIC SPRING RATE: I) AXIAL II) LATERAL III) ANGULAR A) FOR FULL ASSEMBLY B) FOR EACH BELLOWS (IN CASE OF DOUBLE BELLOWS) | KG/MM KG/MM Kg- m/deg kg-m/deg | N.A. N.A. 150 N.A. | N.A. N.A. 150 N.A. | |
| 22 | MIN. FLANGE THICKNESS | MM | 45 | 45 | |
| 23 | MIN. TIE ROD DIAMETER | MM | - | - | |
| 24 | MIN. HINGE PIN DIAMETER | MM | 50 | 50 | |
| 25 | MIN. HINGE MAIN PLATE THICKNESS | MM | 40 | 40 | |


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|---|---|---------------------------------------|------------------|
|  | TITLE: TECHNICAL DATA SHEET DATA SHEET- A 2X500 MW NEW NEYVELI TPP | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | | VOLUME : IIB | |
| | | SECTION: D | |
| | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 6 OF 10 | |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | |
|------|---|--------------------|----------------------------------|----------------------------------|
| 26 | MIN. HINGE SUPPORT PLATE THICKNESS | MM | 20 | 20 |
| 27 | MIN. SLEEVE THICKNESS | MM | 6 | 6 |
| 28 | MIN. GUSSET THICKNESS | MM | 20 | 20 |
| 29 | THICKNESS OF END PIPE LOCAL TO FLANGE | MM | 20 (SEE NOTE BELOW) | 20 (SEE NOTE BELOW) |
| 30 | BELLOW STABILITY FACTOR DEPENDING ON END CONN. FOR EVALUATING COL. SQUIRM | - | 0.5 PSC | 0.5 PSC |
| 31 | MIN. VALUE OF LIMITING INTERNAL DESIGN PRESSURE BASED ON COLUMN INSTABILITY (P_{sc}) | KG/CM ² | 4.5 | 4.5 |
| 32 | MIN. VALUE OF LIMITING DESIGN PRESSURE BASED ON INPLANE INSTABILITY AND LOCAL PLASTICITY (P_{si}) | KG/CM ² | 4.5 | 4.5 |
| 33 | BELLOWS | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 34 | SPOOL PIPES | - | SA 672 GR.B70 | SA 672 GR.B70 |
| 35 | TIE ROD/LIMIT ROD WITH NUTS | - | N.A. | N.A. |
| 36 | HINGE PLATE | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 37 | GIMBAL RING | - | N.A. | N.A. |
| 38 | SPHERICAL WASHERS a) MATERIAL b) CASE HARDENED c) SURFACE FINISH | - HRC MICRON | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 39 | HINGE PIN | - | CARBON STEEL CL.8.8 | CARBON STEEL CL.8.8 |
| 40 | INTERNAL SLEEVE | - | ASTM A240 TP 304 | ASTM A240 TP 304 |
| 41 | COVER | - | CARBON STEEL | CARBON STEEL |
| 42 | FLANGE (HOUSING TIE RODS/ HINGE PLATE) | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 43 | FLANGE a) MATERIAL b) RATING c) DRILLING | - - - | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 44 | BUTTWELD DETAILS (TO SUIT MATCHING PIPE) | - | AS PER ASME B 16.25 | ASPER ASME B 16.25 |
| 45 | CODES/STANDARDS APPLICABLE | - | EJMA | EJMA |
| 46 | OTHER REQUIREMENTS | - | - | - |


NOTE: THICKNESS OF END PIPE LOCAL TO FLANGE TO BE AS SPECIFIED. IT IS TO BE STEP MACHINED TO 10 MM NEAR THE BELLOWS CONVOLUTION AND EDGE PREPARED TO SUIT MATCHING PIPE AT OTHER END.

| | | | |
|---|---------------------------------|---------------------------------------|------------------|
|  | TITLE: | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | TECHNICAL DATA SHEET | VOLUME : IIB | |
| | DATA SHEET- A | SECTION: D | |
| | 2X500 MW NEW NEYVELI TPP | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 7 OF 10 | |


| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | | |
|------|---|---|--|---|--------------------------------|
| 1 | GENERAL | TAG NO. | - | E1,E2 | E3 |
| 2 | | LOCATION | - | SD FLASH TANK VENT TO CONDENSER | |
| 3 | | INSTALLATION | - | VERTICAL | HORIZONTAL |
| 4 | | QUANTITIES REQD. PER UNIT | NOS | ONE EACH | ONE |
| 5 | | TOTAL QUANTITY REQUIRED (2 UNITS) | NOS | FOUR | TWO |
| 6 | | FLUID | - | STEAM | |
| 7 | DESIGN & OPERATING PARTICULARS | TYPE | - | HINGED ANGULAR | HINGED ANGULAR |
| 8 | | SIZE | NB | 600 | 600 |
| 9 | | MATCHING PIPE (OD X THK) | MM | 610X10 | 610X10 |
| 10 | | OPERATING PRESSURE | KG/CM ² (A) | 0.11 | 0.11 |
| 11 | | OPERATING TEMPERATURE | °C | 100 | 100 |
| 12 | | DESIGN PRESSURE | KG/CM ² (G) | 2 & FULL VACUUM | 2 & FULL VACUUM |
| 13 | | DESIGN TEMPERATURE | °C | 210 | 210 |
| 14 | | FLOW VELOCITY AT OPERATING CONDITION | M/S | 150 | 150 |
| 15 | | CYCLIC DESIGN LIFE | CYCLE | 10,000 | 10,000 |
| 16 | | AXIAL COMPRESSION (DESIGN) | MM | N.A. | N.A. |
| 17 | | AXIAL ELONGATION (DESIGN) | MM | N.A. | N.A. |
| 18 | | LATERAL DEFLECTION (DESIGN) | MM | N.A. | N.A. |
| 19 | | ANGULAR ROTATION (DESIGN) | DEGREE | E1-1 ⁰ , E2-1.5 ⁰ | 0.5 ⁰ |
| 20 | | I. OVERALL LENGTH II. BELLOWS CENTRE DISTANCE | MM MM | 700 N.A. | 700 N.A. |
| 21 | | MAX THEORITICAL INITIAL ELASTIC SPRING RATE: I) AXIAL II) LATERAL III) ANGULAR A) FOR FULL ASSEMBLY FOR EACH BELLOWS (IN CASE OF DOUBLE BELLOWS) | kg/mm KG/MM Kg-m/deg kg-m/deg | N.A. N.A. 40 N.A. | N.A. N.A. 40 N.A. |
| 22 | | MIN. FLANGE THICKNESS | MM | 40 | 40 |
| 23 | | MIN. TIE ROD DIAMETER | MM | - | - |
| 24 | | MIN. HINGE PIN DIAMETER | MM | 40 | 40 |
| 25 | | MIN. HINGE MAIN PLATE THICKNESS | MM | 40 | 40 |
| 26 | MIN. HINGE SUPPORT PLATE THICKNESS | MM | 20 | 20 | |
| 27 | MIN. SLEEVE THICKNESS | MM | 6 | 6 | |

| | | | | |
|---|---------------------------------|--|---------------------------------------|------------------|
|  | TITLE: | | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | TECHNICAL DATA SHEET | | VOLUME : IIB | |
| | DATA SHEET- A | | SECTION: D | |
| | 2X500 MW NEW NEYVELI TPP | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | | SHEET 8 OF 10 | |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | |
|------|---|--------------------|----------------------------------|----------------------------------|
| 28 | MIN. GUSSET THICKNESS | MM | N.A. | N.A. |
| 29 | BELLOW STABILITY FACTOR DEPENDING ON END CONN. FOR EVALUATING COL. SQUIRM | - | 0.5 PSC | 0.5 PSC |
| 30 | MIN. VALUE OF LIMITING INTERNAL DESIGN PRESSURE BASED ON COLUMN INSTABILITY (P_{sc}) | KG/CM ² | 4.5 | 4.5 |
| 31 | MIN. VALUE OF LIMITING DESIGN PRESSURE BASED ON INPLANE INSTABILITY AND LOCAL PLASTICITY (P_{si}) | KG/CM ² | 4.5 | 4.5 |
| 32 | BELLOWS | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 33 | SPOOL PIPES | - | SA 672 GR.B70 | SA 672 GR.B70 |
| 34 | TIE ROD/LIMIT ROD WITH NUTS | - | N.A. | N.A. |
| 35 | HINGE PLATE | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 36 | GIMBAL RING | - | N.A. | N.A. |
| 37 | SPHERICAL WASHERS a) MATERIAL b) CASE HARDENED c) SURFACE FINISH | - HRC MICRON | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 38 | HINGE PIN | - | CARBON STEEL CL.8.8 | CARBON STEEL CL.8.8 |
| 39 | INTERNAL SLEEVE | - | ASTM A240 TP 304 | ASTM A240 TP 304 |
| 40 | COVER | - | CARBON STEEL | CARBON STEEL |
| 41 | FLANGE (HOUSING TIE RODS/ HINGE PLATE) | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 42 | FLANGE a) MATERIAL b) RATING c) DRILLING | - - - | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 43 | BUTTWELD DETAILS (TO SUIT MATCHING PIPE) | - | AS PER ASME B 16.25 | AS PER ASME B 16.25 |
| 44 | CODES/STANDARDS APPLICABLE | - | EJMA | EJMA |
| 45 | OTHER REQUIREMENTS | - | - | - |

| | | |
|---|---------------------------------|---------------------------------------|
|  | TITLE: | SPECIFICATION NO. PE-TS-402-100-M 021 |
| | TECHNICAL DATA SHEET | VOLUME : IIB |
| | DATA SHEET- A | SECTION: D |
| | 2X500 MW NEW NEYVELI TPP | REV. NO.: 00 DATE: 10/07/2014 |
| | | SHEET 9 OF 10 |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | |
|------|--|--|--------------------------------|------------------------------|
| 1 | TAG NO. | - | E16,E17,E18 | E19,E20 |
| 2 | LOCATION | - | MAIN CONDENSATE SUCTION | |
| 3 | INSTALLATION | - | HORIZONTAL | VERTICAL |
| 4 | QUANTITIES REQD. PER UNIT | NOS | ONE EACH | ONE EACH |
| 5 | TOTAL QUANTITY REQUIRED (2 UNITS) | NOS | EIGHT | FOUR |
| 6 | FLUID | - | CONDENSATE | |
| 7 | TYPE | - | UNTIED | UNTIED |
| 8 | SIZE | NB | 500 NB | 500 NB |
| 9 | MATCHING PIPE (OD X THK) | MM | 508X12.7 | 508X12.7 |
| 10 | OPERATING PRESSURE | KG/CM ² (A) | 0.105 | 0.105 |
| 11 | OPERATING TEMPERATURE | °C | 46.4 | 46.4 |
| 12 | DESIGN PRESSURE | KG/CM ² (G) | 2 & FULL VACUUM | 2 & FULL VACUUM |
| 13 | DESIGN TEMPERATURE | °C | 55 | 55 |
| 14 | FLOW VELOCITY AT OPERATING CONDITION | M/S | 0.95 | 0.95 |
| 15 | EXTREMELY TURBULENT FLOW (AS PER CLAUSE C-3.2.5 OF EJMA) | YES/NO | NO | NO |
| 16 | CYCLIC DESIGN LIFE | CYCLE | 10,000 | 10,000 |
| 17 | AXIAL COMPRESSION (DESIGN) | MM | 17 | 17 |
| 18 | AXIAL ELONGATION (DESIGN) | MM | N.A. | N.A. |
| 19 | LATERAL DEFLECTION (DESIGN) | MM | 10 | 10 |
| 20 | ANGULAR ROTATION (DESIGN) | DEGREE | N.A. | N.A. |
| 21 | I. OVERALL LENGTH II. BELLOWS CENTRE DISTANCE | MM MM | 912 N.A. | 912 N.A. |
| 22 | MAX THEORITICAL INITIAL ELASTIC SPRING RATE: I) AXIAL II) LATERAL III) ANGULAR A) FOR FULL ASSEMBLY B) FOR EACH BELLOWS (IN CASE OF DOUBLE BELLOWS) | KG/MM KG/MM Kg- m/deg kg-m/deg | 40 25 N.A. N.A. | 40 25 N.A. N.A. |
| 23 | NO OF TIE RODS | NOS | 2 | 2 |
| 24 | MIN. FLANGE THICKNESS | MM | 30 | 30 |
| 25 | MIN. TIE ROD DIAMETER | MM | 30 | 30 |
| 26 | MIN. SLEEVE THICKNESS | MM | 1.5 | 1.5 |

| | | | | |
|---|---------------------------------|--|---------------------------------------|------------------|
|  | TITLE: | | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | TECHNICAL DATA SHEET | | VOLUME : IIB | |
| | DATA SHEET- A | | SECTION: D | |
| | 2X500 MW NEW NEYVELI TPP | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | | SHEET 10 OF 10 | |

| S.NO | DESCRIPTION | UNITS | DATA/PARTICULARS | |
|------|---|--------------------|----------------------------------|----------------------------------|
| 27 | MIN. GUSSET THICKNESS | MM | N.A. | N.A. |
| 28 | BELLOW STABILITY FACTOR DEPENDING ON END CONN. FOR EVALUATING COL. SQUIRM | - | 0.5 PSC | 0.5 PSC |
| 29 | MIN. VALUE OF LIMITING INTERNAL DESIGN PRESSURE BASED ON COLUMN INSTABILITY (P_{sc}) | KG/CM ² | 4.5 | 4.5 |
| 30 | MIN. VALUE OF LIMITING DESIGN PRESSURE BASED ON INPLANE INSTABILITY AND LOCAL PLASTICITY (P_{sl}) | KG/CM ² | 4.5 | 4.5 |
| 31 | BELLOWS | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 32 | SPOOL PIPES | - | SA 106 GR.B | SA 106 GR.B |
| 33 | TIE ROD/LIMIT ROD WITH NUTS | - | CARBON STEEL (CL. 6.8 & 6.0) | CARBON STEEL (CL. 6.8 & 6.0) |
| 34 | HINGE PLATE | - | N.A. | N.A. |
| 35 | GIMBAL RING | - | N.A. | N.A. |
| 36 | SPHERICAL WASHERS a) MATERIAL b) CASE HARDENED c) SURFACE FINISH | - HRC MICRON | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 37 | HINGE PIN | - | N.A. | N.A. |
| 38 | INTERNAL SLEEVE | - | ASTM 240 TP 304 | ASTM 240 TP 304 |
| 39 | COVER | - | CARBON STEEL | CARBON STEEL |
| 40 | FLANGE (HOUSING TIE RODS/ HINGE PLATE) | - | IS 2062 GR.B/ SA515/516 GR.70 | IS 2062 GR.B/ SA515/516 GR.70 |
| 41 | FLANGE a) MATERIAL b) RATING c) DRILLING | - - - | N.A. N.A. N.A. | N.A. N.A. N.A. |
| 42 | BUTTWELD DETAILS (TO SUIT MATCHING PIPE) | - | AS PER ASME B 16.25 | AS PER ASME B 16.25 |
| 43 | CODES/STANDARDS APPLICABLE | - | EJMA | EJMA |
| 44 | OTHER REQUIREMENTS | - | - | - |

| | | | | | | | | | | | |
|----------------|------------------------------------|--|--|--|--|--|---------------------------------------|--|--|--|--|
| MFGR'S LOGO | MANUFACTURER'S NAME AND ADDRESS | MANUFACTURING QUALITY PLAN | | | | | PROJECT : 2X500 MW NEW NEYVELI TPP | | | | |
| | | ITEM : ME BELLOWS (500, 600, 900, 1200, 1600 NB) SUB-SYSTEM: POWER CYCLE PIPING | | | QP NO. : PE-QP-402-100-M021 REV.NO.:00 DATE: 10/07/2014 PAGE: 1.... OF...5. | | CUSTOMER : NEYVELI LIGNITE CORP. LTD. | | | | |
| | | | | | | | JOB NO. : 402 | | | | |
| | | | | | | | MAIN-SUPPLIER : BHEL (PEM), NOIDA | | | | |

| SL No | COMPONENT & OPERATIONS | CHARACTERISTICS | CLASS | TYPE OF CHECK | QUANTUM OF CHECK | | REFERENCE DOCUMENT # | ACCEPTANCE NORMS | FORMAT OF RECORD | | AGENCY | | | REMARKS | | | |
|---------------------|--|--------------------------|----------|------------------------------------|-----------------------|-----------------------|---|-----------------------|---------------------------------|-----------------------|-----------------------|-----------------------|---|--|-----------------|-----|---|
| | | | | | M | C/N | | | | * | D | M | C | | - | | |
| 1 | 2 | 3 | 4 | 5 | 6 | | 7 | 8 | 9 | * | ** | | | | | | |
| 1.0 MATERIAL | | | | | | | | | | | | | | | | | |
| | MATERIAL FOR BELLOWS / PIPE ENDS / PLATES FOR PIPES / FLANGES / LUGS / HINGE PLATES / GIMBLE RING / SLEEVE / PIN / TIE ROD | CHEMICAL COMPOSITION | MAJOR | CHEMICAL ANALYSIS | ONE PER HEAT | | BHEL DRAWING / APPROVED DRAWING / TECH SPEC | | MTC (or) CHECK TEST CERTIFICATE | √ | P | V | - | CO RELATED TC TO BE REVIEWED BY BHEL QC. | | | |
| | | MECHANICAL PROPERTIES | | UTS, YS & PERCENTAGE OF ELONGATION | ONE PER HEAT | | | | | √ | P | V | - | REFER NOTE NO:3 | | | |
| | | DIMENSIONAL CHECK | | MEASUREMENT | 100 % | 100 % | | | | - | P | V | - | | | | |
| | | SURFACE EXAMINATION | MINOR | VISUAL | 100 % | 100 % | | | | - | P | V | - | | | | |
| 2.0 WELDING | | | | | | | | | | | | | | | | | |
| 2.1 | 1) WELDING PROCEDURE | CORRECTNESS OF PROCEDURE | CRITICAL | VERIFICATION OF WPS | 100 % | | IS 7307 / ASME SEC IX | IS 7307 / ASME SEC IX | IS 7307 / ASME SEC IX | IS 7307 / ASME SEC IX | √ | P | V | - | REFER NOTE NO:4 | | |
| | 2) PROCEDURE QUALIFICATION | WELD SOUNDNESS | | DESTRUCTIVE TESTS | IS 7307 / ASME SEC IX | IS 7307 / ASME SEC IX | | | | | IS 7307 / ASME SEC IX | IS 7307 / ASME SEC IX | √ | P | | V | - |
| | 3) WELDER PERFORMANCE QUALIFICATION | WELDERS' PERFORMANCE | | DESTRUCTIVE TESTS / NDE | IS 7310 / ASME SEC IX | IS 7310 / ASME SEC IX | | | | | IS 7310 / ASME SEC IX | IS 7310 / ASME SEC IX | √ | P | | W/V | - |

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|-------------------------------|---------------|---|-------------|--|-------------------|--|---------------|
| | | LEGEND: * RECORDS, INDENTIFIED WITH "TICK" (√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER/SUB-SUPPLIER C: MAIN SUPPLIER(BHEL) P: PERFORM W: WITNESS & V: VERIFICATION. AS APPROPRIATE | DOC. NO.: | | REV..... CAT..... | | |
| MANUFACTURER/ SUB-SUPPLIER | MAIN-SUPPLIER | | REVIEWED BY | | APPROVED BY | | APPROVAL SEAL |
| SIGNATURE | | | | | | | |

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|----------------|------------------------------------|--|--|--|--|--|---------------------------------------|--|--|--|--|
| MFGR'S LOGO | MANUFACTURER'S NAME AND ADDRESS | MANUFACTURING QUALITY PLAN | | | | | PROJECT : 2X500 MW NEW NEYVELI TPP | | | | |
| | | ITEM : ME BELLOWS (500, 600, 900, 1200, 1600 NB) SUB-SYSTEM: POWER CYCLE PIPING | | | QP NO. : PE-QP-402-100-M021 REV.NO.:00 DATE: 10/07/2014 PAGE: 2.... OF...5. | | CUSTOMER : NEYVELI LIGNITE CORP. LTD. | | | | |
| | | | | | | | JOB NO. : 402 | | | | |
| | | | | | | | MAIN-SUPPLIER : BHEL (PEM), NOIDA | | | | |

| SL No | COMPONENT & OPERATIONS | CHARACTERISTICS | CLASS | TYPE OF CHECK | QUANTUM OF CHECK | | REFERENCE DOCUMENT # | ACCEPTANCE NORMS | FORMAT OF RECORD | | AGENCY | | | REMARKS |
|-------|---|-------------------------------|----------|---|------------------|-------|---------------------------------------|---|-----------------------------|----|--------|---|---|------------------------|
| | | | | | M | C/N | | | | D* | M | C | - | |
| 1 | 2 | 3 | 4 | 5 | 6 | | 7 | 8 | 9 | | ** | | | |
| | | | | | M | C/N | | | | D* | M | C | - | |
| 2.2 | BUTT / GROOVE WELDS | | | | | | | | | | | | | |
| | 1) BELLOWS AND PLATE FORMED PIPES | FITUP, SIZE OF WELD | MAJOR | VISUAL AND MEASUREMENT | 100 % | - | APPD DRG / ASME SEC VIII – DIVISION 1 | ASME SEC VIII – DIVISION 1 | INTERNAL INSPECTION REPORTS | - | P | - | - | |
| | | SOUNDNESS OF WELD | CRITICAL | PT FOR BELLOW LONG SEAM BEFORE FORMING RT FOR BELLOW LONG SEAM BEFORE FORMING RT FOR PIPE LONG SEAM | 100 % | | ASME SEC V / APPD. DRG | ASME SEC VIII – DIVISION 1 | INTERNAL INSPECTION REPORTS | - | P | V | - | |
| | | | | | | | | | LAB REPORT | √ | P | V | - | REVIEW OF FILM BY BHEL |
| | | | | | | | | | LAB REPORT | √ | P | V | - | |
| | 2) SEGMENTAL FLANGES | SURFACE DEFECTS OF WELDMENTS | MAJOR | PT | 100 % | 100 % | ASTM E 165 | NO SURFACE DEFECT | INTERNAL INSPECTION REPORTS | √ | P | V | - | |
| | | INTERNAL DEFECTS OF WELDMENTS | MAJOR | RT UT | 100 % | | ASME SEC V ASTM A388&A435 | ASME SEC VIII – DIVISION 1 TECH SPEC | LAB REPORT | √ | P | V | - | REVIEW OF FILM BY BHEL |
| | i) FOR THICKNESS 40 MM & BELOW ii) FOR THICKNESS ABOVE 40 MM | LAB REPORT | | | | | | | √ | P | V | - | | |
| 2.3 | FILLET WELDS | SOUNDNESS OF WELDMENTS | MAJOR | PT | 100 % | | ASME SEC V / APPD. DRG | ASME SEC VIII – DIVISION 1 | INTERNAL INSPECTION REPORTS | √ | P | V | - | |

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| MANUFACTURER/ SUB-SUPPLIER | MAIN-SUPPLIER | | | | |
| SIGNATURE | | | REVIEWED BY | APPROVED BY | APPROVAL SEAL |

| | | | | | | | | | | | |
|---------------|---------------------------------|--|--|--|--|--|--------------------------------------|-----------------------------------|--|--|--|
| MFR'S LOGO | MANUFACTURER'S NAME AND ADDRESS | MANUFACTURING QUALITY PLAN | | | | | PROJECT : 2X500 MW NEW NEYVELI TPP | | | | |
| | | ITEM : ME BELLOWES (500, 600, 900, 1200, 1600 NB) SUB-SYSTEM:POWER CYCLE PIPING | | | QP NO. : PE-QP-402-100-M021 REV.NO.:00 DATE: 10/07/2014 PAGE: 3.... OF...5. | | CUSTOMER :NEYVELI LIGNITE CORP. LTD. | | | | |
| | | | | | | | | JOB NO. : 402 | | | |
| | | | | | | | | MAIN-SUPPLIER : BHEL (PEM), NOIDA | | | |

| SL No | COMPONENT & OPERATIONS | CHARACTERISTICS | CLASS | TYPE OF CHECK | QUANTUM OF CHECK | | REFERENCE DOCUMENT # | ACCEPTANCE NORMS | FORMAT OF RECORD | | AGENCY | | | REMARKS |
|-----------------------------------|--|--|----------|------------------------|------------------|-------------------------------|--|-----------------------------|------------------|----|--------|---|------------------|---------|
| | | | | | M | C/N | | | 9 | D* | M | C | - | |
| 3.0 INSPECTION & TESTS | | | | | | | | | | | | | | |
| 3.1 | BELLOWS CONVOLUTIONS | WORKMANSHIP | MAJOR | VISUAL | 100 % | APPD. DRG | | INTERNAL INSPECTION REPORTS | √ | P | W | - | | |
| | | DIMENSIONS | | MEASUREMENT | | | | | | | | | | |
| | | SURFACE DEFECTS (INSIDE & OUTSIDE OF LONG SEAM) | | PT | | ASME SEC V | NO SURFACE DEFECT | | √ | P | W | - | | |
| 3.2 | GIMBAL RING, HINGE PLATE, FLANGE, SHROUD,SLEEVE,PIN, TIE ROD,WASHER & NUTS | WORKMANSHIP & DIMENSIONS | MAJOR | VISUAL & MEASUREMENT | 100 % | APPD. DRG | | INTERNAL INSPECTION REPORTS | - | P | V | - | | |
| 3.3 | SEGMENTAL FLANGE | STRESS RELIEVEING | MAJOR | REVIEW OF HT CHART | 100 % | ASME SEC VIII | | SR CHART | √ | P | V | - | | |
| 3.4 | ROUTINE TESTS | 1) LEAK TIGHTNESS | CRITICAL | 1)HYDROSTATIC PR. TEST | 100 % | APPD. DRG / 1) 3 Kg /Sq.cm(g) | NO LEAKAGE OR PERMANENT DEFORMATION | TEST REPORTS | √ | P | W | - | | |
| | | | | 2) VACUUM TEST | | 2) 12 mm Hg (A) | | | √ | P | W | - | | |
| | | 2) DEFLECTION | CRITICAL | DEFLECTION TESTS | 100 % | EJMA / TECH. SPEC / APPD. DRG | EJMA / TECH. SPEC / APPD. DRG | TEST REPORTS | √ | P | W | - | | |
| | | 3) THINNING | MAJOR | MOCK UP PIECE (or) UT | ONE / TYPE | EJMA / TECH. SPEC | NOT TO EXCEED 15% OF ACTUAL RAW MATERIAL THICKNESS | INTERNAL INSPECTION REPORTS | √ | P | W | - | REFER NOTE NO: 6 | |

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| SIGNATURE | | | REVIEWED BY | APPROVED BY | APPROVAL SEAL | |

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|----------------|------------------------------------|--|--|-----------------------------|--|---------------------------------------|--|--|--|
| MFGR'S LOGO | MANUFACTURER'S NAME AND ADDRESS | MANUFACTURING QUALITY PLAN | | | | PROJECT : 2X500 MW NEW NEYVELI TPP | | | |
| | | ITEM : ME BELLOWES (500, 600, 900, 1200, 1600 NB) | | QP NO. : PE-QP-402-100-M021 | | CUSTOMER : NEYVELI LIGNITE CORP. LTD. | | | |
| | | SUB-SYSTEM: POWER CYCLE PIPING | | REV.NO.:00 | | JOB NO. : 402 | | | |
| | | | | DATE: 10/07/2014 | | MAIN-SUPPLIER : BHEL (PEM), NOIDA | | | |
| | | | | PAGE: 4.... OF...5. | | | | | |

| SL No | COMPONENT & OPERATIONS | CHARACTERISTICS | CLASS | TYPE OF CHECK | QUANTUM OF CHECK | | REFERENCE DOCUMENT # | ACCEPTANCE NORMS | FORMAT OF RECORD | | AGENCY | | | REMARKS |
|-------|------------------------|--|----------|--|------------------|-------|--|--|-----------------------------|---|--------|---|---|---|
| | | | | | M | C/N | | | D* | M | C | - | | |
| 1 | 2 | 3 | 4 | 5 | 6 | | 7 | 8 | 9 | | ** | | | |
| | ROUTINE TESTS | 4) SPRING RATE (ONLY AXIAL) | CRITICAL | STIFFNESS TEST | ONE / TYPE | | EJMA / TECH. SPEC | TECH. SPEC | SPRING RATE CURVES REPORT | √ | P | W | - | BELLOWS UNDER NORMAL CONDITION DEFLECTED TO THE VALUE AS SPECIFIED IN TECH SPEC./ APPD. DRAWINGS REFER NOTE NO: 6 |
| | | 5) CLEANLINESS | MAJOR | VISUAL | 100 % | 100 % | TECH. SPEC / APPD. DRG | TECH. SPEC / APPD. DRG | INTERNAL INSPECTION REPORTS | √ | P | V | - | |
| | | 6) PAINT THICKNESS | | VISUAL MEASUREMENT | | | | | | √ | P | V | - | |
| | | 7) WORKMANSHIP | | VISUAL | | | | | | √ | P | V | - | |
| | | 8) MARKING | | VISUAL | | | | | | √ | P | V | - | |
| 3.5 | TYPE TEST | 1) CYCLE LIFE (10000 CYCLES), SQUIRM TEST, YIELD & RUPTURE | CRITICAL | DESTRUCTIVE TEST | REFER NOTE NO:1 | | BHEL/CUSTOMER APPD. TEST PROCEDURES / DATA SHEETS / DRGS | BHEL/CUSTOMER APPD. TEST PROCEDURES / DATA SHEETS / DRGS | TEST REPORTS | √ | P | W | - | REFER NOTE NO: 1 & 5 |
| 3.6 | ASSEMBLY | WORKMANSHIP & DIMENSIONS | MAJOR | VISUAL & MEASUREMENT | 100 % | 100 % | APPD. DRGS | APPD. DRGS | INTERNAL INSPECTION REPORTS | √ | P | V | - | |
| 4.0 | DOCUMENTATION | COMPLETENESS OF RECORDS | | VERIFICATION OF RECORDS & CERTIFICATES | 100 % | 100 % | TECH. SPEC / APPD. DRG | TECH. SPEC / APPD. DRG | INTERNAL INSPECTION REPORTS | √ | P | V | - | |
| 5.0 | PACKING | SOUNDNESS OF PACKING | | VISUAL | 100 % | 100 % | TECH. SPEC / APPD. DRG | TECH. SPEC / APPD. DRG | INTERNAL INSPECTION REPORTS | √ | P | V | - | PHOTOGRAPHS OF BELLOWES AFTER PACKING TO BE VERIFIED BY BHEL BEFORE ISSUING MDCC |


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| SIGNATURE | | | | | | |

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|---------------|------------------------------------|---|---------------------------------|---------------------------------------|
| MFR'S LOGO | MANUFACTURER'S NAME AND ADDRESS | MANUFACTURING QUALITY PLAN | | PROJECT : 2X500 MW NEW NEYVELI TPP |
| | | ITEM : ME BELLOWS (500, 600, 900, 1200, 1600 NB) | QP NO. : PE-QP-402-100-M021 | CUSTOMER : NEYVELI LIGNITE CORP. LTD. |
| | | SUB-SYSTEM: POWER CYCLE PIPING | REV.NO.: 00 DATE: 10/07/2014 | JOB NO. : 402 |
| | | | PAGE: 5.... OF...5. | MAIN-SUPPLIER : BHEL (PEM), NOIDA |

NOTES:-

1. a) Life cycle test shall be carried out on one bellow of each group as mentioned in Section C of the specification.
b) Squirm & Yield – Rupture test shall also be carried out on one bellow (other than the bellow on which life cycle test has been carried out of each group as mentioned in Section C of the specification).
2. Test reports for final performance tests, material test certificates and stage inspection records as indicted in the quality plan shall be submitted to BHEL for their scrutiny and approval.
3. In case co related test certificates are not available, check testing shall be carried out by vendor at approved lab.
4. For qualified welders, WPS & PQR shall be reviewed by BHEL. In case welder is not qualified, witnessing will be done by main supplier i.e. BHEL.
5. If type tests as mentioned at 3.5 (1) above, have been successfully done for earlier BHEL projects for the bellows of the same size in a group, then only TCs of same shall be reviewed and no type test need to be carried out. Also TC's of same size of bellows in specified group shall not be older than 5 years from project bid opening date which is 4th January, 2014 and type test clearance shall be taken from BHEL prior to offering to routine test. In case the type test is to be done, type test procedure approval shall be taken from BHEL.
6. Bellows of the same type would mean those having the same diameter and convolutions.
7. All materials of construction shall be as per approved drawings / data sheet.

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| MANUFACTURER/ SUB-SUPPLIER | MAIN-SUPPLIER | | | | | |
| SIGNATURE | | | REVIEWED BY | APPROVED BY | APPROVAL SEAL | |

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|---|--|---------------------------------------|------------------|
|  | TITLE: DATA SHEET-C | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | | VOLUME : II B | |
| | | SECTION: D | |
| | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 1 OF 2 | |

DRAWINGS, DOCUMENTS & DATA TO BE FURNISHED BY VENDOR AFTER AWARD OF CONTRACT

1 The successful bidder shall submit the following drawings/documents for approval within two weeks after award of contract:

1.1 Relevant drawings of each bellow with full details inclusive of the following:

- a) All necessary dimensions (with tolerance as per EJMA).
- b) Cross sectional arrangement.
- c) Arrangement of tie rods (limit rods) along with washers and nuts.
- d) Arrangement of sleeves and cover.
- e) Bill of material and total weight.
- f) Welding standards and welding details.
- g) Flange details/butt weld end details.
- h) Design deflections and stiffness rates for each bellow.
- i) Bellow element details.

1.2 Quality plan.

1.3 Design calculations as per EJMA for bellows & other components of bellow assembly such as tie rods, flanges washers etc.

1.4 Stress calculations including Finite element analysis (if required by BHEL) for all pressure carrying parts i.e. flanges, hinge plates, tie rods, gimbal rings etc.

1.5 Stress calculations for local stresses (if required by BHEL) where flanges/lugs are welded to pipe.

1.6 Test procedures for type tests and spring rate test.

2 The following shall be submitted within the stipulated time period as per vendor's drawings/documents schedule, but not later than one month before first dispatch:


2.1 Instruction manual for erection, operation and maintenance.

2.2 Storage instructions.

3 Before dispatch of the equipment the vendor shall furnish the following:

3.1 Material Test certificates.

3.2 Shop test reports and certificates.

| | | | |
|---|--|---------------------------------------|------------------|
|  | TITLE: DATA SHEET-C | SPECIFICATION NO. PE-TS-402-100-M 021 | |
| | | VOLUME : II B | |
| | | SECTION: D | |
| | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 2 OF 2 | |

4 Distribution of drawings / documents for all projects

After award of the contract the successful bidder shall furnish drawings/ documents as per following distribution schedule.

| Sl. No. | Type of Document | No of Hard copies | No. of Soft copies |
|---------|---|-------------------|--------------------|
| 1 | Documents submitted for Approval | 2 Nos. | 1 Nos. |
| 2 | Final Distribution (Approved Documents) | 12 Nos. | 2 Nos.(CD) |
| 3 | Test Certificates/Test Reports | 4 Nos. | 1 Nos. |
| 4 | O&M Manuals | 12 Nos. | 2 Nos.(CD) |

NEYVELI LIGNITE CORPORATION LTD.

2 X 500 MW NEW NEYVELI TPP


**TECHNICAL SCHEDULES
FOR
METAL EXPANSION BELLOWS**

VOLUME – III

SPECIFICATION NO: PE-TS-402-100-M021 (REV-00)




**BHARAT HEAVY ELECTRICALS LIMITED, POWER SECTOR
PROJECT ENGINEERING MANAGEMENT,
PLOT NO. 25, SECTOR-16A, NOIDA, INDIA**

| | | | |
|---|--|--------------------------------------|------------------|
|  | TITLE: TECHNICAL SCHEDULES METAL EXPANSION BELLOWS 2X500 MW NEW NEYVELI TPP | SPECIFICATION NO. PE-TS-402-100-M021 | |
| | | VOLUME : III | |
| | | SECTION: | |
| | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 1 OF 1 | |

CONTENTS

| SL.NO | TITLE |
|-------|--|
| 1 | COMPLIANCE SHEET |
| 2 | SCHEDULE OF DEVIATIONS |
| 3 | SCHEDULE OF DECLARATIONS |
| 4 | SCHEDULE OF PRICES (As per enclosed format only) |

| | | | |
|---|---------------------------------|--------------------------------------|------------------|
|  | TITLE: | SPECIFICATION NO. PE-TS-402-100-M021 | |
| | TECHNICAL SCHEDULES | VOLUME : III | |
| | METAL EXPANSION BELLOWS | SECTION: | |
| | 2X500 MW NEW NEYVELI TPP | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 1 OF 1 | |

INSTRUCTIONS REGARDING SCHEDULES AND COMPLIANCE SHEET TO BE FILLED BY BIDDER

1.0 Volume III comprises of following:-

1.1 Compliance Sheet : Filled by bidder

1.2 Schedules:

PART - A : Schedule of deviation & schedule of declaration

PART - B : Price Schedules

The Schedules and Compliance Sheets enclosed/indexed shall be completely filled up by the bidder and furnished with the bid duly signed and stamped by the bidder. Purchaser reserves the right to ask the bidder to fill 'additional schedules' which are not listed in the contents.

2.0 Schedule of deviation, schedule of declaration and compliance sheet shall be filled up by the bidder as per the instructions given below:

- a) Duly filled Part - A schedules (Technical schedules) & compliance sheet shall be furnished with the technical bid, while Part - B Schedules (Price Schedules) shall be submitted with price bid in separate covers.
- b) Un-priced copy of Part – B schedules shall also be furnished along with Part-A schedules in the technical bid.

| | | | |
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|  | TITLE: COMPLIANCE SHEET METAL EXPANSION BELLOWS 2X500 MW NEW NEYVELI TPP | SPECIFICATION NO. PE-TS-402-100-M021 | |
| | | VOLUME : III | |
| | | SECTION: | |
| | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 1 OF 2 | |

The bidder shall sign and return a copy of this compliance sheet along with his offer, indicating his compliance to the points specified herein:

A) Technical Details: Bidder to tick (√) whichever is applicable.

| | | | |
|----|--|-----------------|---------------------|
| 1 | Specific Technical requirements of Vol. II B Section-C | Accepted | Not Accepted |
| 2 | Standard Technical Specification of Vol. II B Section-D | Accepted | Not Accepted |
| 3 | DATA SHEET-A of Vol. II B Section-D | Accepted | Not Accepted |
| 4 | Quality Plan | Accepted | Not Accepted |
| 5 | Documentation requirement as per Data sheet-C | Accepted | Not Accepted |
| 6 | As per technical specification if Type Tests are required to be carried out in line with technical specification/final approved QP/customer comments, vendors shall do so at their own cost. No extra charges on this account will be admissible to vendors. | Accepted | Not Accepted |
| 7 | Finite Element Analysis for bellows will be submitted in case of order (If applicable). If FEA is required to be done, vendors shall do so at their own cost. No extra charges on this account will be admissible to vendors. | Accepted | Not Accepted |
| 8 | All drawings and other documents will be modified in line with BHEL comments. | Accepted | Not Accepted |
| 9 | Bellows shall be provided with complete round flanges housing the tie rods/limit rods. | Accepted | Not Accepted |
| 10 | All bellows will be in single ply design. | Accepted | Not Accepted |

B) Deviations to the technical specification are not acceptable. However, if there are any deviations due to unavoidable reasons then the same to be clearly specified in the schedule of deviation. In case of no deviations, schedule of deviations to be filled as NIL by bidder.

C) The offered materials should be either equivalent or superior to those specified. Also for components where material is not specified it shall be suitable for intended duty.

| PARTICULARS OF BIDDER / AUTHORISED REPRESENTATIVE | | | | COMPANY SEAL |
|---|-------------|-----------|------|--------------|
| NAME | DESIGNATION | SIGNATURE | DATE | |

| | | | |
|---|---|--------------------------------------|------------------|
|  | TITLE: COMPLIANCE SHEET METAL EXPANSION BELLOWS 2X500 MW NEW NEYVELI TPP | SPECIFICATION NO. PE-TS-402-100-M021 | |
| | | VOLUME : III | |
| | | SECTION: | |
| | | REV. NO.: 00 | DATE: 10/07/2014 |
| | | SHEET 2 | OF 2 |

- D) QP/ test procedures shall be submitted in the event of order based on the guidelines given in the specification & QP enclosed therein. QP will be subject to BHEL/Customer approval in the event of order & customer hold points for inspection/ testing shall be marked in the QP at the contract stage. Inspection/ testing shall be witnessed as per same apart from review of various test certificates/ Inspection records etc. The charges for 3rd party inspection (Lloyds , TUV or equivalent) for foreign bidders shall be included in the base price of the equipment by the bidder. This 3rd party inspection agency shall be approved by BHEL and will be decided in contract stage.
- E) All drawings/data – sheets etc. to be submitted during contract shall be subject to BHEL/Customer review/ approval.
- F) GA drawings, as submitted with offer at tender stage are for reference purpose only and shall be subject to approval during contract stage.
- G) Bidder confirms that all drawings/documents in soft as well as hard copy shall be submitted within 2 weeks from placement of LOI's in the event of order. Within one (1) week of receipt of BHEL comments a technical representative of bidder shall come for meeting with BHEL along with revised documents to resolve all issues and incorporate all comments in the soft copy here for further submission to customer. Further on receipt of customer comments on the documents a technical representative from bidder shall come for meeting to resolve all issues and incorporate all comments in the soft copy at BHEL and resubmit the drawings/documents for approval and shall visit customer/customer's consultant if required for across the table approval of documents.
- H) Any special tools & tackles, if required, shall be in bidder's scope.
- I) Prices for recommended spares (if any) for three year operation shall be furnished separately and not to be included in the base price.
- J) Bidder confirms that offered model design is their proven model and they have designed, manufactured, supplied and tested the equipment of similar type and rating in at least two projects which are in satisfactory operation for last two years.

| PARTICULARS OF BIDDER / AUTHORISED REPRESENTATIVE | | | | |
|---|-------------|-----------|------|--------------|
| | | | | |
| NAME | DESIGNATION | SIGNATURE | DATE | COMPANY SEAL |



TITLE

*** SCHEDULE OF DEVIATIONS**

() From Technical Specifications (Volume –II B)

SPECIFICATION NO
PE-TS-402-100-M021

VOL III 'PART-A'

SHEET OF.....

We the undersigned hereby certify that the above mentioned are the only deviations.

PARTICULARS OF BIDDER / AUTHORISED REPRESENTATIVE

| PARTICULARS OF BIDDER / AUTHORISED REPRESENTATIVE | | | | |
|---|-------------|-----------|------|--------------|
| | | | | |
| NAME | DESIGNATION | SIGNATURE | DATE | COMPANY SEAL |



TITLE

***SCHEDULE OF DECLARATIONS**

SPECIFICATION NO
PE-TS-402-100-M021
VOL III PART 'A'
SHEET..... OF.....

* Bidder shall include this schedule both in technical and Price offers

DECLARATION

Icertify that all the technical data and information pertaining to this specification are correct and are true representation of the equipment/system covered by our format proposal number Dated and there is no deviation to the specification other than those listed in "Schedule of deviations" of this Vol III.

I hereby certify that I am duly authorized representative of the Bidder's company whose name appears above my signature.


Bidder's Company Name

Authorised representative's Signature

Name

Bidder's Name The bidder hereby agrees to fully comply with the requirements and intent of this specification for the price indicated

| PARTICULARS OF BIDDER / AUTHORISED REPRESENTATIVE | | | | |
|---|-------------|-----------|------|--------------|
| | | | | |
| NAME | DESIGNATION | SIGNATURE | DATE | COMPANY SEAL |

| | | | |
|---|---|---------------------------------------|------------------|
|  | TITLE: SCHEDULE OF UNIT PRICES (METAL EXPANSION BELLOWS) | SPECIFICATION NO : PE-TS-402-100-M021 | |
| | | REV.00 | DATE: 10/07/2014 |
| | | VOLUME III | PART B |
| | | SHEET 1 OF 1 | |

Bidder to mention the word "QUOTED" in all columns against each item for which bidder wants to quote:

A) SUPPLY OF BELLOWS (2X500 MW NEW NEYVELI TPP)

| SI. NO. | ITEM DESCRIPTION | | | QTY PER UNIT | TOTAL QTY | UNIT EX-WORKS PRICE DULY PACKED | TOTAL EX-WORKS PRICE DULY PACKED |
|---------|------------------|------------------------|-------------------------|--------------|-----------|---------------------------------|----------------------------------|
| | SIZE | TYPE | TAG NO. | | | | |
| 1. | 600 NB | HINGED ANGULAR BELLOWS | E1, E2, E3 | 3 | 6 | | |
| 2. | 1600 NB | GIMBAL BELLOWS | E4, E5, E13, E14 | 4 | 8 | | |
| 3. | 1600 NB | HINGED ANGULAR BELLOWS | E6, E15 | 2 | 4 | | |
| 4. | 1200 NB | HINGED ANGULAR BELLOWS | E7, E8, E9 | 3 | 6 | | |
| 5. | 900 NB | HINGED ANGULAR BELLOWS | E10, E11, E12 | 3 | 6 | | |
| 6. | 500 NB | UNTIED BELLOWS | E16, E17, E18, E19, E20 | 5 | 10 | | |
| | TOTAL | | | 20 | 40 | | |

Points for vendors to consider:

- 1-If Type Tests are required to be carried out in line with technical specification then the charges for the same shall deemed to be included in the unit quoted prices of main item. Bidder shall not indicate these charges as a separate head in the price bid.
- 2-If FEA are required to be done, Vendor will carry out the same at their own cost. No extra charges on this account will be admissible to vendors.

| | | | | |
|---|--------------------|------------------|-------------|---------------------|
| BIDDER SHALL FURNISH THIS PRICE SCHEDULE IN HIS PRICE OFFER ONLY | | | | |
| PARTICULARS OF BIDDER / AUTHORISED REPRESENTATIVE | | | | |
| | | | | |
| NAME | DESIGNATION | SIGNATURE | DATE | COMPANY SEAL |
| * Un priced schedule shall also be furnished along with with Part-A schedule in Technical Bid | | | | |