



ISO 9001:2000  
&14001:2004  
NAVARATNA  
COMPANY

सामग्री प्रबन्धन (क्रय विभाग)  
**MATERIAL MANAGEMENT (PURCHASE)**  
सेन्ट्रल फाउन्ड्री फोर्ज प्लांट, भारत हेवी इलेक्ट्रिकल्स लिमिटेड  
**CENTRAL FOUNDRY FORGE PLANT, BHEL HARDWAR**  
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Ref: FF/PPX/EOI/17  
Dt. 01/06/2009

Sub: **EXPRESSION OF INTEREST FOR SUPPLY OF Heavy Duty Gouging  
Electrode holder for 1000 Amp.**

Dear Sir,

CFFP/BHEL has huge requirement for following item and thus desires Expression of Interest from interested vendors for supply of this item.

EOI NO.	Description	Due date
FF/PPX/EOI/17	Heavy Duty Gouging Electrode Holder for 1000 Amp.	18/07/2009

You are requested to please submit your interest along with Supplier Registration Form (which can be downloaded from our web site [www.bhel.com](http://www.bhel.com) ).

Kindly note that supplier registration form is mandatory requirement for processing your application against this Expression of Interest .

Thanking you.

(Rohit Varshney)  
Engineer (Pur)

	<b>संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)</b> <b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)	<b>FF77184 Rev 02</b> पृष्ठ का Page 1 of 4
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SUPERSEDES INVENTORY NO. \_\_\_\_\_  
 समीचीन सूची संख्या में परिवर्तन के लिए  
 SUPERSEDES INVENTORY NO. \_\_\_\_\_  
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 स्वसंपत्कित एवं गोपनीयता का दस्तावेज है। इस दस्तावेज में दी गई सूचना का उपयोग केवल केवल के लिए ही किया जा सकता है। इस दस्तावेज में दी गई सूचना का उपयोग अन्य किसी भी उद्देश्य के लिए नहीं किया जा सकता है।

**1. Scope :**  
 This purchase specification specifies the requirements and tests for gouging electrode holders (used for removal of material from steel castings with the help of gouging carbon electrodes), in order to optimize the safety of the welder and to ensure satisfactory condition of use during heavy duty manual electric air arc gouging on carbon steel and different alloy steel castings.

**2. Compliance with National & International Standard :**  
 The gouging electrode Holder shall be in general as per IS 2641:1993 suitable for current rating at 100% duty cycle use with the characteristics as stated under Technical specifications.

**3. Technical Specifications:**

3.1. Type of Gouging Holder and their current capacity:

Type of Gouging Holder	Suitable for Gouging Electrodes	Current Rating at 100% duty cycle	Length of heavy duty cable
Gouging Holder-1000 Amps	φ 9mm and φ12mm	1000 amps	2 meter long
Gouging Holder-1800 Amps	φ 18mm	1800 amps	3 meter long

3.2. The gouging Electrode Holder shall be suitable for use on circuits with OCV up-to and including 100 V (RMS).

3.3. The gouging holder shall be made of copper/copper alloy, free from blow holes, cracks and the defects which impair the electrical conductivity.

3.4. The gouging electrode holder shall be of open mouth-Jaw type and it shall be as light as possible.

3.5. The gouging electrode holder shall be fitted with unitized standard cable & hose, air cooled & swivel type terminating in rubber/ jacketed air-power connection and insulation boot. Provision shall be there for connection of pneumatic hose.

RMI	K B Subramanyam	अनुमोदक	TRANSLATED BY		
MPIC	Ranjan Kumar	द्वितीयक	WORKED BY	V.K.AGARWAL	
CHAIRMAN CPSC	B RAHA	अनुमोदक	CHECKED BY	A.K.GARG	
AGREED DEPTT	NAME	विवरण एवं हस्ताक्षर	DATE & SIGNATURE	SUPERVISED BY	A.K.GARG
समीचीन सूची संख्या में परिवर्तन के लिए INVENTORY NO. _____					
APPROVED : <b>प्लांट स्टैंडर्ड्स</b> <b>PLANT STANDARDS COMMITTEE</b>					
निर्देशिका		अनुपसक्त		कक्षा	दिनांक
टेक्नोलॉजी		ISSUED : WELDING TECHNOLOGY		25.05.07	



संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार)

FF 77184 Rev 02

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**PLANT PURCHASE SPECIFICATION**  
(CFFP - HARDWAR)

SUPERSEDES INVENTORY NO.  
 मूल्य सूची संख्या  
 को अधिकाधिक मूल्य  
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 स्वराशिकार एवं गोपनीयता  
 इस दस्तावेज में दी गई जानकारी का अधिकार सी.एफ.एफ.पी. के पास है। इस जानकारी को बिना अनुमति के किसी भी प्रकार प्रयोग नहीं किया जा सकता है।  
 अधिकार संकेत  
 SIGN & DATE  
 मूल्य सूची संख्या

- 3.6. The gouging holder shall have provision for 360° free revolving movement of the holder around air hose/ cable without twisting the air hose/cable for maximum maneuverability.
- 3.7. The Gouging electrode holder along with coaxial unitized standard cable and air hose assembly shall be able to work continuously at the maximum current (rated for 100% duty cycle) with 7kg/cm<sup>2</sup> air pressure without any air leakage through jaws and the air switch of the holder.
- 3.8. The Handle lever and handle covers shall be made in tough heat resistant and electrical insulating material and shall be so constructed that no dirt or foreign particles (likely to cause danger by electric shock) can lodge in joints, holes & other services and that the live ends of screws, pins etc can not be exposed in use.
- 3.9. Grip of Handle (OD) shall be such that operator can grip it easily & comfortably. The temperature of the grip of handle shall not exceed 30°C above ambient temperature when continuously used at rated current for 100% duty cycle for 30 minutes minimum.
- 3.10. Spring, if used, shall be insulated electrically so that they do not carry welding current unless designed to do so.

**4. Test Certificate:**

The party shall supply two sets of the test certificates along with dispatch documents at the time of delivery of gouging holder to confirm the suitability of the gouging electrode holder to meet all the technical requirements as per clause 3.1 to 3.10 given above and to pass all the four tests as given below and described under section 5.3 of IS 2641:1989.

- a) Insulation resistance test.
- b) High voltage test.
- c) Impact test.
- d) Test for flammability and resistance to heat.

**5. Marking :**

Each gouging electrode holder shall be marked with the following information:  
 (a) Name of manufacturer, Trade mark, if any.  
 (b) Current Rating at 100% duty cycle.

**6. Guarantee :**

The gouging electrode holder shall be guaranteed for 18 months from the date of receipt

**7. Packing :**

The packing should be suitable to avoid any damage/ loss of material during handling, transit and storage.

निर्माणकर्ता WORKED BY	V.K.Agarwal		14/7/07
जांचकर्ता CHECKED BY	AKGarg		14/7/07



संस्थान क्रय विनिर्देश ( सी.एफ.एफ.पी - हरिद्वार)  
**PLANT PURCHASE SPECIFICATION**  
 (CFFP - HARDWAR)

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संस्था की ओर से  
 अथवा अधिकारी द्वारा

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स्वामिकार एवं गोपनीयता: जोर में ही यह सूचना प्राप्त है।  
 यह सूचना सी.एफ.एफ.पी. द्वारा प्रसारित की जा सकती है।  
 यह सूचना सी.एफ.एफ.पी. द्वारा प्रसारित की जा सकती है।

अधिकारी का नाम  
 SIGN & DATE

संस्था की ओर से  
 अथवा अधिकारी द्वारा

**8. Special Requirements:**

- a) The party shall send with offer the gouging holder catalogue / leaflet giving details of the gouging electrode holder construction and arrangement of holding the gouging cable, in particular.
- b) The party shall send quote for all the spares of holder for two years trouble free operation.
- c) The party shall provide test certificates (for the test conducted as per Clause-4 above) with supply.
- d) Party shall submit two copies of the operation and maintenance manual along with detailed assembly drawing (in English language) at the time of delivery of gouging holder.
- e) Final acceptance of gouging electrode holder shall be based on satisfactory report/ performance on shop floor.
- f) If the material received in CFFP is found not suitable as per clause no 4 given above, it shall be replaced free of cost by the supplier.

निर्माणकर्ता WORKED BY	V.K. Agarwal		14/7/17
जांचकर्ता CHECKED BY	AKGarg		14/7/17

