

## Bid invitation

### Information

Description: MYS1/YPS/197/2019/BODY WELDING & INSTALL

Bid invitation number: 6300032241

Version: 1

### Bid invitation rules

Bid invitation currency: INR

**Timezone:** UTC+53

**Submission period:** 28.05.2020 15:00:00

**Opening date:** 28.05.2020 15:15:00

**Created On:** 11.05.2020 11:11:59

### Bid invitation text:

ANNEXURE – 1

BH150E BODY TO P/No.991BD02006 ASSEMBLY & INSTALLATION SCOPE OF WORK AT FIELD:

For Assembly of Body at M/s. SECL, Gevra Opencast Project of Coal India Limited located at Korba District of Chattisgarh.

#### Note:

- 1) Bids of firms who have experience in Body Welding and Installation of Dump Truck Bodies of 150T and above only will be considered for evaluation.
- 2) Firm should upload Documents supporting Experience in Body Welding and Installation of Dump Truck Bodies of 150 Ton and above.
- 3) BEML has the right to split the order in the 60:40 ratio among L-1 & L-2 OR place 100% order on L-1, if required

The dismantled Sub-structures and other sub-items required for BH150E Body joining and Body installation activities will be supplied and positioned at the Customer site at M/s. SECL, Gevra Opencast Project of Coal India Limited located at Korba District of Chattisgarh, by M/s. BEML, Mysuru.

Firm has to follow the following steps as per attached sketches and Body Installation as per drawing 991BD01001 and 991MD00017.

#### A. BODY WELDING AT FIELD

1. Identify and check for the body sl.no. on the Body str LH, Body str RH, & Canopy structure.

# Bid invitation

## Information

Description: MYS1/YPS/197/2019/BODY WELDING & INSTALL

Bid invitation number: 6300032241

Version: 1

2. First place the Canopy main str in upright down position as shown in section FF and place Body str LH and Body str RH as shown in section AA & section DD.
3. Weld along split line as specified in section AA, section DD & section FF by ARC welding and Electrode AWS E7018 (Día 3.5, Día 4 & Día 6) to be used. Suitable support to be provided for proper welding.
4. Weld between canopy side sheet & body side sheet as shown.
5. Setup & weld Sq. tubes (6 nos) between front sheet & canopy as shown.
6. Weld closing plates & drain tube as shown.
7. Weld closing channel between two front sheet structure as shown.
8. Weld spill guard on both side of body as shown
9. Set up Pivot str parallel to the centre line with dimension Z being equal within  $\pm 3\text{mm}$  & C equal within  $\pm 3\text{mm}$  using hardware on to the early welded tapped pads (12 places)
10. Measure dimensions 'A' 3163 mm from the Front edge of the bore in the outside pivot plate to the front sill as shown. Mark each side.
11. Measure diagonal from the front edge of the bore in the outside pivot plate (as shown) to the 3163 mm. Mark on the opposite sill for dimensions B.
12. Full weld the pivot structure to floor structure as shown below. suitable support to be Provided for proper welding.
13. Weld 6 channels between Side Str, Floor Str, & Pivot Str as shown.
14. Weld 4 channels between Floor Str & Pivot Str as shown.
15. Weld exhaust box str. to body floor as shown.

## B. BUMPER EXTENSION AND FENDER LH/RH WELDING ON MAIN FRAME

1. Assemble both the bumper extensions on to main frame to the dimensions shown using hardware items
2. Weld both the extensions to bumper
3. Assemble both the Fender Str. on to bumper to the dimensions shown
4. Full weld the Fenders to Bumper

## C. LH & RH FLOOR SUPPORT WELDING ON HORSE COLLAR

1. Assemble both LH & RH floor Support Str. on to horse collar to the dimensions shown
2. Full weld the same as shown.

## D. EXHAUST BOX INSTALLATION AND WELDING

### General Instructions:

1. The Firm has to follow necessary pre heating and post heating to be done where ever it is necessary while carrying out the full Welding of the Body.
2. The Firm has to remove all spatters, slag and grind the Weldment wherever it is required.
3. All the Welding joints should be primer painted and final finish paint after welding. Primer paint & Finish paint will be supplied by M/s. BEML Limited, Mysuru.

# Bid invitation

## Information

Description: MYS1/YPS/197/2019/BODY WELDING & INSTALL

Bid invitation number: 6300032241

Version: 1

4. The activities involved during Welding and installation to be supervised by your Firm's representative. The Firm has to ensure Welding to be of high quality, total defect free and meet the drawing specifications and should satisfy the periodic tests conducted by BEML representatives.

5. BEML Quality representative will inspect the welding and installation activities after the completion of work. Any corrections and feed backs given by BEML Quality representatives should be immediately corrected at the customer site.

6. All the above activities should be carried out at Customer site M/s. SECL, Gevra Opencast Project, Bilaspur with the Firm's Workmen and the Firm should possess their own ESI and PF codes for their workmen. The Firm should provide the details of ESI and PF codes registered in the name of Firm.

## ANNEXURE - 2

### TERMS AND CONDITIONS :

#### 01.FACILITIES TO BE PROVIDED BY BEML LIMITED, MYSORE:

- a) Sufficient Welding Electrodes/Coils & Gouging Electrodes of different sizes for Welding & Gouging.
- b) The material required to carry out DP test.
- c) Alignment Bars for Body aligning which should be returned to M/s. BEML, Mysuru after completion of the job.
- d) Body resting stand Structures & Wedges (Metallic) for Body alignment.
- e) Crane facility as and when required for shifting the Dumper Body position/alignment during body Welding and mounting of the body onto the Equipment.
- f) Lifting Slings, 'D' shackles & Crane facility for alignment of Dump Body.
- g) Required Quantity of Thinner, Primer paint & Finish paint to carry out painting on Welded joints.
- h) 50 Nos. of Wooden Planks.

#### 02.MAN POWER & FACILITIES TO BE ORGANISED BY THE FIRM:

The following resources will have to be organised by the Firm at their Cost to the customer site M/s SECL, Bilaspur.

- a) Welding Generators/Transformers of required capacity to carry out the welding activity.
- b) Oxygen and Acetylene Gas cylinders along with Gas cutting Torch, Nozzles & suitable length of both the Hoses.
- c) Necessary tools like Buckles, Screw jacks, hydraulic jacks, supports & clamps etc., for set up the Body for full Welding
- d) Required number of skilled and trained Welders having good experience in full Welding of heavy-duty structures and necessary manpower to the extent to handle fitment and installation of Body on the Frame.
- e) Accommodation required for work men.
- f) Transport for work men.
- g) Grinding Machine and required Grinding Wheels.
- h) Safety devices viz., Helmet, Welding Shield, Hand Gloves, Gas cutting Goggles etc,
- i) Painting to be carried at all the welded areas and necessary painting Spray Gun to be arranged by the Firm.
- j) Sludge Hammer and required Spanners to align the Body.
- k) Electrical Pre-heater / Oven for pre-heating the Welding Electrodes.

# Bid invitation

## Information

Description: MYS1/YPS/197/2019/BODY WELDING & INSTALL

Bid invitation number: 6300032241

Version: 1

### 03. PRICES:

The prices indicated by the Firm are inclusive of all statutory levies and taxes.

### 04. PAYMENT:

30 days after successful completion of body Full Welding and Certification of acceptance of work at the customer site and after certification by M/s. BEML Limited, Mysuru, Quality representatives.

### 05. DELIVERY SCHEDULE:

Complete Body Welding of Body and installation should be completed as per the M/s. BEML, Mysuru, delivery schedules as mentioned in the PO terms.

### 06. GUARANTEE:

The job carried out by the Firm has to be guaranteed for proper workmanship of Welding activity for a minimum period of 2 years from the date of completion of job or 6000 HMR of operation whichever occurs earlier. In case it is found defective during the guarantee period, the Firm should rectify the defect at free of cost at our customer site.

### 07. INCOME TAX:

Since this is a Labour work, as per rules Income taxes will be deducted at source from your bills and same shall be remitted to the concerned income tax authorities.

### 08. DRAWINGS:

The Drawings and Welding procedure given to you are the property of M/s. BEML Limited, Mysuru, and shall be treated as "CONFIDENTIAL DOCUMENTS". The contents of the Drawings shall not be parted to any outside Firms either in part or in full. In case, these Drawings are used for any other purposes other than for which intended, the Firm is liable for punitive action as per BEML Rules. The Drawings sent along with PO should be returned after the completion of all works against the Purchase order.

### 09. INSPECTION:

The Dump Bodies after the completion of welding are subject to approval of our inspection and their findings are final. The necessary corrections are to carry out immediately at the customer site by the Firm.

### 10. STATUTORY REQUIREMENTS:

All the Statutory payments like Workmen Compensation, Insurance, ESI and PF etc if any payable in respect of the contractor's workmen shall be on the account of Firm only. In all cases of exigencies like the worker falling sick, encounters an accident during the course work the Firm should bear all the expenses on their own account and M/s. BEML Limited, Mysuru, shall have no liability in that behalf.

# Bid invitation

## Information

Description: MYS1/YPS/197/2019/BODY WELDING & INSTALL

Bid invitation number: 6300032241

Version: 1

## Bid invitation details

Item	Product Price Condition	Description	Vendor product number	Delivery date/ performance period	Quantity
1		BH150E FULL WELDNG & INSTLN OF DUMP BODY			7 NO
	Freight Cost		%		
	Basic Price		INR		
	CGST - Central GST		%		
	IGST -Integrated GST		%		
	SGST - State GST		%		