

Bid invitation

Information

Description: MYS1/YPS/108/2020/BODYSTR/992BD0
2004
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Version: 1

Bid invitation rules

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ANNEXURE – 1

1.1#SCOPE OF WORK: WELDING, ASSEMBLY, ERECTION & COMMISSIONING OF DUMP BODY AT M/S. NCL, SINGRAULI PROJECTS

Eligibility :

- 1) Bids of firms who have experience in welding heavy duty structures / Assembly / Erection and Commissioning of similar type / Body Welding and Installation of Dump Truck Bodies of HEMM only will be considered for evaluation.
- 2) Firm should upload Documents supporting Experience in Body Welding and Installation of Dump Truck Bodies of HEMM.

A. WING STRUCTURE WELDING

1. Assemble both LH & RH Wing structure & centre support on to main frame as per the dimensions
2. Weld all the structures to main frame using CO2 welding / Arc welding.
3. Quality of weld: ref 1.2
4. Use dry electrodes AWS E7018/ Wire electrodes AWS A5018 class ER70S-6
5. DP test to be carried out on weld joints
6. Refer drawing and company standard for further information

B. MAJOR BODY SUB STRUCTURES ALIGNMENT & JOINING

1. BODY STR. LH
2. BODY STR. RH
3. CANOPY STR
4. BODY & HOIST CYLINDER SETUP AND INSTALLATION ON MAIN FRAME
5. EXHAUST BOX SET UP AND WELDING
6. BODY GUIDE AND BODY PAD, GREASE LINES SETUP & WELDING

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7. ROCK EJECTOR PAD & BODY LOCKING BRACKET SETUP & WELDING
8. BODY GUARD / PROTECTION WELDING ON SIDE SHEETS AND CANOPY
9. INSTALLATION OF REAR MUDFLOPS & ASSOCIATED BRACKETS
10. Body sub structures alignment & joining as per attached body welding drawing / sketch
11. Use dry electrodes AWS E7018/ Wire electrodes AWS A5018 class ER70S-6
12. General welding practice: ref 1.2
13. AWS D1.1IIW calibration blocks shall be used
14. Discontinuities shall be elevated to Fig.1 of QY1034-C
15. Weld identified with UT shall be used to verify penetration in addition of quality of weld.
16. Use suitable wooden blocks for position the body
17. Use alignment tool at the body pivot location for aligning the two halves of the body. Use the hardware to clamp the body halves and canopy.
18. Use the wedges to align the sub structures for proper joint fit up.
19. Complete the welding of floor, front and canopy joints as per the body weldment drawing and then weld the remaining items.
20. Apply paint on the un-painted areas.
21. Refer body weldment drawing 992-BD-02004-4 / 992BD01008 and field assembly manual for other details.

1.2 General Instruction:

i. Quality of weld:

- a. No excess penetration permitted. Excess penetration to be ground flush
 - b. No under cuts permitted-Additional weld should be added & ground flush to bring weld into compliance of the fine class standard for excess build up
 - c. No overlaps are permitted. Overlap shall be ground flush
 - d. All weld beads shall be stringer type. No weave beads permitted
 - e. Tack weld in the root of weld shall be cleaned prior to application of primary weld. Tack shall be completely consumed by overlying weld
 - f. Preheat the welding electrode to remove any moisture.
 - g. Preheat the weld joints to remove moisture if any.
- #### ii. General welding practice like Plate & Joint preparation should confirm to company standard PR1004C with the following inclusion / exceptions:
- a) Where finish requirements or edges brakes are noted on drawings
 - b) Root gouged joint shall be surface ground to clean and remove carbon deposits
- #### iii. Quality of weld joint should confirm to company standard STD.QY1027-C
- iv. 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.
 - v. The Firm has to remove all spatters, slag and grind the Weldment wherever it is required.
 - vi. All the Welding joints should be primer painted and final finish paint after welding.
 - vii. 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.
- a) 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.

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- b) Weld identified with UT shall be used to verify penetration in addition of quality of weld.
- c) All the above activities should be carried out at Customer site M/s. NCL, Singrauli, 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.
- d) The firm has to inform in advance whether CO2 welding / Arc welding will be taken up

1.3 Place of work:

- a) 4 equipments at Amlohri project and 4 equipment at Nigahi project
- b) The firm may have to carry out the body installation work simultaneously at 2 projects

1.4 Completion of job:

The firm has to start commencement of work immediately on intimation from Regional office, Singrauli and to complete the welding and installation within 21 days inclusive of Sundays & Holidays

1.5: FACILITIES TO BE PROVIDED BY THE FIRM : The firm has to arrange following infra structure to carry out welding and installation of body structure

- a) Welding Generators/Transformers (Minimum 06 Nos of Welding Machines shall be provided by contractor) of required Capacity to carry out the welding activity and to complete the project as per BEML schedule.
- b) Oxygen and Acetylene Gas cylinders along with Gas cutting Torch, Nozzles & suitable length of Hoses , sufficient stock of Oxygen & Acetylene gas cylinders shall be positioned at site .
- c) Grinding Machine and required Grinding Wheels.
- d) Necessary tools like Buckles, Screw jacks, hydraulic jacks, supports & clamps etc., for set up the Body for full Welding. Sludge Hammer and required Spanners to align the Body. Required wedges during set up & welding.
- e) Lifting Slings, 'D' shackles required for handling the structures.
- f) Safety devices viz., Helmet, Welding Shield, Hand Gloves, Gas cutting Goggles etc.,
- g) Required material for DP test and arrange for UT test wherever it is called for.
- h) Electrical Pre-heater / Oven for pre-heating the Welding Electrodes.
- i) Supervisors and required number of highly skilled and trained Welders having good experience in full Welding of heavy duty structures should work compulsory on Two - Shift basis (06 welders in each shift) and additional required man power to handle fitment and installation of Body on the Frame - Setup and welding work to be carried out under Firm's supervision.
- j) Accommodation & transportation of work men.
- k) Painting to be carried at all welded areas including complete body and necessary painting Spray Gun to be arranged by the Firm.
- l) Crane facility will be given by M/s. NCL. The firm has to organise the same as and when required for shifting the Dumper Body position/alignment during body Welding and mounting of the body onto the Equipment.
- m) The firm has to take almost care while body rotation and body setup.
- n) The list of manpower to be deployed have to be submitted to projects in advance at least 15 days in advance for VTC and gate pass. Any delay may affect commissioning.
- o) Necessary C -Clamps and wedges shall be provided by contractor

1.6 FACILITIES TO BE PROVIDED BY BEML LIMITED:

- a) The dismantled Sub-structures and other sub-items required for BH205E Body joining and Body installation activities will be supplied and positioned at the Customer site at M/s. NCL, Singrauli.

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- b) Sufficient Welding Electrodes/Coils & Gouging Electrodes of different sizes for Welding & Gouging.
- c) Alignment Bars for Body aligning which should be returned to M/s. BEML, RO Singrauli after completion of the job.
- d) Body resting stand Structures & Wedges (Metallic) for Body alignment.
- e) Required Quantity of Thinner, Primer paint & Finish paint to carry out painting on Welded joints including complete body.

1.7 PRICES: The prices indicated by the Firm should be inclusive of all statutory levies and taxes. If different Firms quote the same price, then L1 will be decided based on the Firm's previous year turnover (Firm with higher turnover will be considered as L1). 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.

1.8 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.

1.9 DELIVERY SCHEDULE: Complete Body Welding and installation should be completed as per the M/s. BEML delivery schedules as mentioned in the PO terms.

1.10 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 8000 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.

1.11 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.

1.12 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.

1.13 INSPECTION: The Dump Bodies after the completion of welding & Installation 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.

1.14 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, shall have no liability in that behalf.

1.15 LD clause: Body installation & commissioning within 21 days inclusive of Sundays & Holidays. For every week of delay on account of from Firm side, over and above the allowed time as in above, a penalty of 0.5% of the order value shall be levied, subject to a maximum of 5% of the value of the contract.

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1.16 CRANE: M/s. NCL shall arrange crane for commissioning activities

1.17 INDEMNITY: The firm shall indemnify BEML at all times against all claims made by the firm’s personnel and third parties in respect of any injury’s accidents or any other claim in the form of compensation.

1.18 FORCE MAJEURE: The firm shall not be responsible for any delay in execution of this contract if the delay is caused as a result of Force Majeure. “Force Majeure” means an event beyond the control of the Firm, such as Floods, wars or revolutions, epidemics, strikes (caused by other than firms own employees/ workmen), terrorist attack etc.

1.19 ARBITRATION CLAUSE: If BEML and the firm are not able to resolve any contract dispute amicably within a reasonable period of time, such disputes shall be referred to a sole Arbitrator to be appointed by BEML and the proceedings before the Arbitrator shall be governed by the provisions of Arbitrations and conciliation Act 1996, in which event the Arbitration proceedings shall be held at Bangalore and the Arbitrator shall be required to give a reasoned award. Courts in Bangalore alone shall have jurisdiction in the matter.

1.20 APPLICABLE LAW: The contract shall be interpreted in accordance with the laws prevailing in India.

1.21 JURISDICTION OF COURTS: The courts in Bangalore only will have jurisdiction.

Attachments:

- BH205E-FIELD WELDING
- BH205E BODY WELDING
- BH205E Body Installation-992BD01008
- 992-BD-02004-4 drawing
- BH205E-Body welding SCOPE OF WORK
- Digital Signature

Bid invitation details

Item	Product	Description	Vendor product number	Delivery date/ performance period	Quantity
1		BH205E FULL WELDNG & INSTLN OF DUMP BODY			8 NO
	Basic Price		INR		
	CGST - Central GST		%		
	IGST -Integrated GST		%		
	SGST - State GST		%		