



इन्स्ट्रुमेन्टेशन लिमिटेड INSTRUMENTATION LIMITED

(भारी उद्योग मंत्रालय के अधीन भारत सरकार उपक्रम)
कंजिकोड पश्चिम - ६७८ ६२३, पालक्काड, केरल, भारत
TEL: (0491)2566127-130, 2567127, 2567596, 2566132
GST : 32AAACL4212G1Z6, CIN: U29299RJ1964GOI001174



(A Govt. of India Enterprise Under Ministry of Heavy Industries)
Kanjikode West - 678 623, Palakkad, Kerala, India
E-mail : commercial@ilpgt.com, contact@ilpgt.com
GeM Seller ID : E5FF200001308318, Web : www.ilpgt.com

ANCILLARY DEVELOPMENT DEPARTMENT E-TENDERING

| Tender Number | Tender Date |
|-------------------------------|-------------|
| ILP/ AD2/ADC031/24-25/TE-2644 | 22.03.2025 |

To

Dear Sir(s),

Bid are invited through online E-procurement mode for manufacturing and supply of Steel Castings in various grades of material on rate per Kg basis from the approved and developed vendors of ILP for following. New vendors are requested to contact undersigned for registration and new vendor development and approval.

| Item details :- | | | | | | |
|-----------------|--|--|-----------------------------|-----------------------------------|----------|---------|
| Sl. No | Description | Drawing No. | Weight/Piece (Approx) In Kg | Qty (nos) | Material | Remarks |
| 1 | 6" X 4" VST SEAT RING | 220204527-1660-NPC | 7 | 5 | CF8M | |
| 2 | 1" 150-600 BW BODY | 220104008-1330-NPC | 6 | 2 | WCB | RT |
| 3 | 2" 300 BW BODY | 220204023-1330-NPC | 17 | 3 | WCB | RT |
| 4 | 6" 600 BW BODY | 220204024-1330-NPC | 114 | 4 | WCB | RT |
| 5 | 3" 300 BW BODY | 220204353-1330-NPC | 30 | 1 | WCB | RT |
| 6 | 4" 300 BW BODY | 220204362-1330-NPC | 60 | 1 | WCB | RT |
| | Date of Publishing | 22.03.2025 | | | | |
| | Date of start of sale / download of tender documents | 22.03.2025 Website - www.ilpgt.com and https://etenders.gov.in/eprocure/app | | | | |
| | Last date of sale / download of tender documents | 31.03.2025 | | | | |
| | Due date and time of Tender Submission | 31.03.2025 16.00HRS. | | | | |
| | Date & time of priced bid opening | 01.04.2025 16.00HRS. | | Date & time of priced bid opening | | |



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CRITICAL DATE SHEET

Bid Submission:

| | |
|---|----------------------------|
| Published Date | 22.03.2025 (11.00AM) |
| Bid Document Download / Sale Start Date | 22.03.2025 (11.05 AM) |
| Clarification Start Date | --/--/---- (00.00AM) or NA |
| Clarification End Date | --/--/---- (00.00AM) or NA |
| Pre bid meeting | --/--/---- (00.00AM) or NA |
| Bid Submission Start Date | 22.03.2025 (11.10AM) |
| Bid Submission End Date | 31.03.2025 (16.00PM) |
| Bid Opening Date | 01.04.2025 (16.00PM) |

Bidders are advised to visit this website regularly to keep themselves updated as any change/ modification in the tender will be intimated through this website only.

Bids shall be submitted online only at <https://etenders.gov.in/eprocure/app>.

Tenderer/Contractor are advised to follow the instructions “Instructions To Bidder for Online Bid Submission” provided in the Annexure “IV” for online submission of bids.

Bid documents may be scanned with 100 dpi with black and white option which helps in reducing size of the scanned document.

The Hard Copy of original instruments in respect of cost of tender document, earnest money must be delivered to the _____ on or before bid opening date/time as mentioned in critical date sheet. Tenderer shall likely to be liable for legal action for non-submission of original payment instrument like DD, etc., against the submitted bid. The Demand Draft attached/submitted for tender fee shall be non refundable.

Bids will be opened as per date/time in the tender **Critical Date Sheet**.



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| | |
|--------------|---|
| EMD | Applicable / Not applicable If applicable Amount Rs DD only in favour of Instrumentation Limited, payable at Palakkad. Bidders who are registered with the Central Purchase Organization, SSI Units registered under single point registration scheme of National Small Industries Corporation (NSIC) are exempted from EMD. |
| Tender cost | Applicable / Not applicable If applicable Amount Rs including GST (Rs including GST for collection by post) By DD in favour of Instrumentation Limited, payable at Palakkad Bidders who are registered with the Central Purchase Organization, SSI Units registered under single point registration scheme of National Small Industries Corporation (NSIC) are exempted from Tender Fee. |
| Eligibility | As per tender documents. |
| Bid Validity | 120 days |
| Type of Bid | Single part bid |

Note: *Quote your most competitive rate per Kg

*Terms of delivery: Free Delivery.

- * **Eligibility criteria:** a) The bidder should be an approved vendor of ILP for supply of steel casting. Vendor code is to be mentioned in the price bid format Annexure-1.
b) New vendors are requested to contact undersigned for registration and apart new vendors development and approved for subsequent requirements.

***MPI & RT required.**

* **The above castings are required for NPCIL project. NPCIL approved foundry can quote.**

* **For technical terms and condition please refer Annexure VI.**

General instructions:

1. Kindly quote for supply of the above items in full quantity as "RATE PER KG" as per price bid format enclosed.
2. Above castings are to be manufactured and supplied as per ASTM/AISI standards. Kindly follow Technical conditions.
3. Order is likely to be cancelled at the cost & risk of supplier, in case the delivery schedules are not maintained as per the purchase order.
4. The above Item are manufactured and supplied only as per drawings enclosed herewith.
5. Delivery schedule.
 - 6-8 weeks for proven items from the date of receipt of order schedules
 - 8-12 weeks for samples from the date of receipt of patterns. After sample approval by our QC another 6-8 weeks for Bulk supply.
6. Our payment term is 60 days of credit after receipt and acceptance of items.
7. LD will be 0.5% per week subject to maximum 5% of order value. However, for delayed deliveries, beyond contracted delivery period, the material is to be supplied after our clearance only.
8. Advance payment against execution of order is not agreed.
9. Those who are having coupling load and expertise in supplying this material grade only can quote.



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10. Patterns for the new sample item will be supplied by ILP.
11. Public Procurement Division of Department of Expenditure of Ministry of Finance, vide letter no No.F.5/4/2018-PPD dated 28.02.2018, has made the declaration of Udhhyog Aadhar Memorandum(UAM) number by the MSE vendors from 01.04.2018. The bidders who fail to submit UAM number shall not be able to avail the benefits available to MSEs as contained in public Procurement Policy for MSEs Order, 2012 issued by MSME for tenders invited electronically through CPPP.
12. SC/ST owned MSE's are requested to specifically mention that the bidder is MSE owned by SC/ST.
13. MSME registration owned by SC/ST entrepreneur to provide proof.
14. Rates should be quoted as per the price bid format **Annexure-I**
15. Bidders to follow the
 - Technical Terms and conditions as per **Annexure-II**
 - General terms and condition as per **Annexure-III**
16. Test rates will be applicable as per **Annexure-V**

Submission of Tender

The tender shall be submitted online in Single part bid ie price bid.

All the pages of bid being submitted must be signed and sequentially numbered by the bidder irrespective of nature of content of the documents before uploading as token of acceptance of all terms and conditions.

The offers submitted by Telegram/Fax/email/hardcopy shall not be considered . No correspondence will be entertained in this matter.

PRICE BID

- (a) Schedule of price bid in the form of BOQ_XXXX .xls

1 Address for Communication

: The AGM (Proc)
Ancillary Development Department
Instrumentation LTD.,
Kanjikode West,
Palakkad - 678 623, Kerala State.
Ph-0491-2569166/2569590

2. E-mail: adcasting@ilpgt.com , manikkam@ilpgt.com
3. Prices should be mentioned in Price Bid format (BOQ_XXXX.xls) provided on the portal .
4. The tender is being issued with no financial commitment and purchaser reserves the right to change or vary any part thereof at any stage. Purchaser also reserves the right to withdraw the tender should it be so necessary at any stage.
5. Please mention GST number in your quotation.
6. All provisions of the General Terms and conditions (Annexure -2) will be applicable, except those mentioned specifically in the tender.
7. ILP reserves it's right to go for reverse auction bidding with all bidders and for this separate notification will be sent to the bidders who participate in the tender and bid found valid.
8. All the approved vendors of IL Palakkad are required to participate in the bid. Non participation in 5 consecutive tenders can lead to cancellation of approved vendor status.

Engineer (Proc.)

(Handwritten signature)
375



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PROCUREMENT DEPARTMENT

Annexure - I

Price Bid

Name of Party :
ILP Vendor Code :
GST No :
Tender No :
-Item : Supply of castings in WCB & CF8M Grade material

| SI No | Description | Drawing no: | Weight/Piece (Approx) In Kg | Qty (nos) | Material | Rate per Kg |
|-------|-----------------------|--------------------|-----------------------------|-----------|----------|-------------|
| 1 | 6" X 4" VST SEAT RING | 220204527-1660-NPC | 7 | 5 | CF8M | |
| 2 | 1" 150-600 BW BODY | 220104008-1330-NPC | 6 | 2 | WCB | |
| 3 | 2" 300 BW BODY | 220204023-1330-NPC | 17 | 3 | WCB | |
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| 5 | 3" 300 BW BODY | 220204353-1330-NPC | 30 | 1 | WCB | |
| 6 | 4" 300 BW BODY | 220204362-1330-NPC | 60 | 1 | WCB | |

Technical other commercial terms and conditions as per tender. The above mentioned Financial Proposal/Commercial bid format is provided as BoQ_XXXX.xls along with this tender document at <https://etenders.gov.in/eprocure/app>. Bidders are advised to download this BoQ_XXXX.xls as it is and quote their offer/rates in the permitted column and upload the same in the commercial bid. **Bidder shall not tamper/modify downloaded price bid template in any manner.** In case if the same is found to be tempered/modified in any manner, tender will be completely rejected and EMD would be forfeited and tenderer is liable to be banned from doing business with Instrumentation Limited, Palakkad.



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ANNEXURE-II

TECHNICAL TERMS

- a)** Technical requirement of castings supplied by you shall be as per our drawings; material specification as per ASTM, ASME and AISI Standards (Please refer point Sl. No. 12 to 16 and Annexure I). Copy of which is already available with you. However, the same can be sent to you, if need be.
- Patterns will be supplied by us for sample items. Pattern layout drawings shall be submitted to ILP for our approval
- All supplies shall be accompanied by material test certificates in triplicate (free of cost), containing the chemical and physical property values besides hardness, impact test values, if called for.
- The supplier shall fulfill the following requirements.
 - Stainless Steel Castings are to be acid pickled and passivated.
 - Carbon Steel and low alloy steel castings are to be shot blasted and then rust preventive oil to be applied.
 - MPI test to be carried out for all low alloy steel castings and test reports should be issued when the castings are offered for IL inspection.
 - Bend test is to be carried out on all castings coming under ASTM A216 and ASTM A217 Grade as per testing standard ASTM A370.
- The test certificate shall also contain the HT/Stress relieving details, if any.
In case of well-known foundries, the test certificates shall contain relevant IBR Code No. and details. Foundries not approved by IBR shall have to furnish copies of test certificate containing the witness pouring details, chemical and mechanical properties etc. duly attested by local IBR authorities immediately after supply of the castings, followed with IBR approved TCs from CIB.
- NDT reports, X-rays films, etc. shall have to be sent along with consignments, directly to HOD (AD/Materials).
- Foundries may please ensure that the transport copy of invoice shall be delivered to ILP stores along with consignments.
- The material codification details given below shall be embossed on all castings as per our Plant standard ILPS 0015.

| | | | | | | | |
|-----|-----|-----|-----|------|------|---------|------|
| WCC | WCB | WC6 | WC9 | CF8M | CF3M | 17-4 PH | 440C |
| 310 | 330 | 430 | 440 | 660 | 670 | 680 | 630 |
- There shall be separate DC/Invoice for each lot of despatch covering supplies of various purchase order schedules mentioning the P.O. Schedule No. and description of the item in seriatim.
- All despatch documents like DC, Invoice etc shall bear the material code details. Our codification system is as follows: -
For eg. 22502676-1330
22 is computer code of castings
502676 is the drawing number of the component.
1-item code (wherever is applicable)
- 2-330-ILP material code for WCB



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DCs and Invoices shall contain as follows:-

"Pre-inspected castings" as per inspection No.....Dated.....

12. Sufficient casting envelope should be provided for machining the castings if the drawings are for fully machined component.
13. Radiography on castings wherever required is to be carried out on casting as per procedure
 - i. ILPS 0012
 - ii. ASME Sec 5 article 2
 - iii. ASME 94 & ASTM E142 and acceptance standard ASME B 16.34 appendix I.
14. Ultrasonic test (UT) on castings wherever required is to be carried out as per procedure
 - i. ASTM A609
 - ii. ILPS 0113
 - iii. ASME Sec V article 5 and acceptance standard ASME B 16.34 appendix IV.
15. MPI (Magnetic Particle Test) test on casting wherever required is to be carried out as per procedure
 - i. ASTM E709
 - ii. ILPS 114
 - iii. ASME Sec V article 7 and acceptance standard ASME B16.34 appendix II.
16. LPI / DP (Liquid penetrant / Dye penetrant) test is to be carried on casting wherever required as per procedure.
 - i. ASTM E 165
 - ii. ILPS 0112
 - iii. ASME E Sec V article 6 and acceptance standard ASME B 16.34 appendix III.
17. **Inspection**

All castings will be pre-inspected by ILP-QC at your works prior to dispatch and only accepted castings shall be dispatched. Material Test Certificate, MPI, UT, DP, RT films and reports copy shall be handed over to ILP-QC at the time of inspection. Weight certification of sample castings shall be carried out in the presence of ILP-QC and mutually accepted weight only shall be invoiced.
18. Drawing numbers with material code, Heat No., MPI No., UT No., DP No., RT No., etc shall be punched visibly on the castings as per P.O.
19. The items should be guaranteed for a period of 18 months from the date of acceptance, against material/manufacturing defects. Any rejection found during the usage of the item due to above defects, within the period the items should be replaced or reworked.

Engineer (Proc.)
IL, Palakkad



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ANNEXURE-III

GENERAL TERMS AND CONDITIONS

1. SPECIFIED GOODS

The goods supplied should be strictly according to the specifications as given in the schedule of material failing which they are liable to be returned at your risk and cost.

2. DESPATCH INSTRUCTIONS

The materials should be despatched to Instrumentation Limited, Palakkad (Kerala) along with original invoice, duplicate for transporter copy of invoice and extra copy of invoice. All invoices should bear Purchase Order No. & date.

3. FREIGHT & INSURANCE

F.O.R Destination i.e., M/s. Instrumentation Ltd Palakkad. Inclusive of freight, packing & forwarding and insurance.

4. REJECTION OF MATERIAL

If, on inspection, the Company finds that the stores or part of stores supplied are not of the contract quality or of defective condition or otherwise are not in satisfactory condition owing to any reason of which the Company shall be the sole judge, the Company will be entitled to reject the material, cancel the purchase order and purchase its requirement from other sources at the risk and cost of the supplier and recover the loss if any from the supplier. Rejected goods will be despatched periodically back to the supplier at freight to pay basis. The L.R. with packing note will be sent to the supplier immediately after despatch. It is the sole responsibility of the supplier to collect the material from the transporter. ILP will not entertain any claim either from the supplier or from the transporter for goods not collected in a reasonable period. In case of blow holes formed during machining and subsequent rejection of castings the machining charges will be deducted from the vendor.

5. WARRANTY & GUARANTEE

18 months from date of supplies.

6. REPLACEMENT OF THE REJECTED MATERIALS

If you fail to replace any stores rejected by us or fail to execute orders or any part thereof as stipulated, either by non-delivery, part delivery or defective supplies, within such time as stipulated, we shall be entitled to purchase without notice to you such stores from any source and if such price exceeds the rate sent out in the schedule of acceptance of tender you shall be responsible to pay the difference between the rest of which such stores have been purchased and also the incidental charges so incurred.

7. FULL SUPPLY

As far as possible, full quantity against individual item mentioned in the purchase order schedules may be supplied one time.



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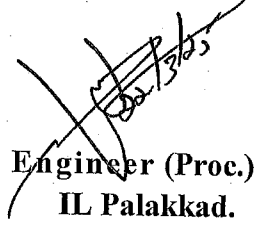
8. VALIDITY OF OFFER

120 days from date of opening of tender.

9. Please indicate your PAN / TIN No/MSME registration No, if applicable along with documentary evidence.

10. Price shall be firm till full execution of order.

- CONSIGNEE** - **INSTRUMENTATION LIMITED, KANJIKODE WEST POST PALAKKAD-678 623, KERALA.**
- BANKERS** - **THE STATE BANK OF INDIA, PUDUSSERY BRANCH, KANJIKODE WEST, PALAKKAD-678 623**
- NOTE** - **ALL DISPUTES ARE SUBJECT TO PALAKKAD JURISDICTION ONLY.**
- APPROVED TRANSPORTERS** - **PATEL ROADWAYS/KTC/ARC/JB TRANSPORT**


Engineer (Proc.)
IL Palakkad.



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ANNEXURE-IV

Instructions for Online Bid Submission:

The bidders are required to submit soft copies of their bids electronically on the CPP Portal, using valid Digital Signature Certificates. The instructions given below are meant to assist the bidders in registering on the CPP Portal, prepare their bids in accordance with the requirements and submitting their bids online on the CPP Portal.

More information useful for submitting online bids on the CPP Portal may be obtained at:
<https://etenders.gov.in/eprocure/app>

REGISTRATION

- 1) Bidders are required to enroll on the e-Procurement module of the Central Public Procurement Portal (URL: <https://etenders.gov.in/eprocure/app>) by clicking on the link “Online bidder Enrollment” on the CPP Portal which is free of charge.
- 2) As part of the enrolment process, the bidders will be required to choose a unique username and assign a password for their accounts.
- 3) Bidders are advised to register their valid email address and mobile numbers as part of the registration process. These would be used for any communication from the CPP Portal.
- 4) Upon enrolment, the bidders will be required to register their valid Digital Signature Certificate (Class III Certificates with signing key usage) issued by any Certifying Authority recognized by CCA India (e.g. Sify / nCode / eMudhra etc.), with their profile.
- 5) Only one valid DSC should be registered by a bidder. Please note that the bidders are responsible to ensure that they do not lend their DSC's to others which may lead to misuse.
- 6) Bidder then logs in to the site through the secured log-in by entering their user ID / password and the password of the DSC / e-Token.

SEARCHING FOR TENDER DOCUMENTS

- 1) There are various search options built in the CPP Portal, to facilitate bidders to search active tenders by several parameters. These parameters could include Tender ID, Organization Name, Location, Date, Value, etc. There is also an option of advanced search for tenders, wherein the bidders may combine a number of search parameters such as Organization Name, Form of Contract, Location, Date, Other keywords etc. to search for a tender published on the CPP Portal.
- 2) Once the bidders have selected the tenders they are interested in, they may download the required documents / tender schedules. These tenders can be moved to the respective 'My Tenders' folder. This would enable the CPP Portal to intimate the bidders through SMS / e-mail in case there is any corrigendum issued to the tender document.
- 3) The bidder should make a note of the unique Tender ID assigned to each tender, in case they want to obtain any clarification / help from the Helpdesk.



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PREPARATION OF BIDS

- 1) Bidder should take into account any corrigendum published on the tender document before submitting their bids.
- 2) Please go through the tender advertisement and the tender document carefully to understand the documents required to be submitted as part of the bid. Please note the number of covers in which the bid documents have to be submitted, the number of documents - including the names and content of each of the document that need to be submitted. Any deviations from these may lead to rejection of the bid.
- 3) Bidder, in advance, should get ready the bid documents to be submitted as indicated in the tender document / schedule and generally, they can be in PDF / XLS / RAR / DWF/JPG formats. Bid documents may be scanned with 100 dpi with black and white option which helps in reducing size of the scanned document.
- 4) To avoid the time and effort required in uploading the same set of standard documents which are required to be submitted as a part of every bid, a provision of uploading such standard documents (e.g. PAN card copy, annual reports, auditor certificates etc.) has been provided to the bidders. Bidders can use "My Space" or "Other Important Documents" area available to them to upload such documents. These documents may be directly submitted from the "My Space" area while submitting a bid, and need not be uploaded again and again. This will lead to a reduction in the time required for bid submission process.

SUBMISSION OF BIDS

- 1) Bidder should log into the site well in advance for bid submission so that they can upload the bid in time i.e. on or before the bid submission time. Bidder will be responsible for any delay due to other issues.
- 2) The bidder has to digitally sign and upload the required bid documents one by one as indicated in the tender document.
- 3) Bidder has to select the payment option as "offline" to pay the tender fee / EMD as applicable and enter details of the instrument.
- 4) Bidder should prepare the EMD as per the instructions specified in the tender document. The original should be posted/couriered/given in person to the concerned official, latest by the last date of bid submission or as specified in the tender documents. The details of the DD/any other accepted instrument, physically sent, should tally with the details available in the scanned copy and the data entered during bid submission time. Otherwise the uploaded bid will be rejected.
- 5) Bidders are requested to note that they should necessarily submit their financial bids in the format provided and no other format is acceptable. If the price bid has been given as a standard BoQ format with the tender document, then the same is to be downloaded and to be filled by all the bidders. Bidders are required to download the BoQ file, open it and complete the white coloured (unprotected) cells with their respective financial quotes and other details (such as name of the bidder). No other cells should be changed. Once the details have been completed, the bidder should save it and submit it online, without changing the filename. If the BoQ file is found to be modified by the bidder, the bid will be rejected.



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- 6) The server time (which is displayed on the bidders' dashboard) will be considered as the standard time for referencing the deadlines for submission of the bids by the bidders, opening of bids etc. The bidders should follow this time during bid submission.
- 7) All the documents being submitted by the bidders would be encrypted using PKI encryption techniques to ensure the secrecy of the data. The data entered cannot be viewed by unauthorized persons until the time of bid opening. The confidentiality of the bids is maintained using the secured Socket Layer 128 bit encryption technology. Data storage encryption of sensitive fields is done. Any bid document that is uploaded to the server is subjected to symmetric encryption using a system generated symmetric key. Further this key is subjected to asymmetric encryption using buyers/bid openers public keys. Overall, the uploaded tender documents become readable only after the tender opening by the authorized bid openers.
- 7) The uploaded tender documents become readable only after the tender opening by the authorized bid openers.
- 8) Upon the successful and timely submission of bids (ie after Clicking "Freeze Bid Submission" in the portal), the portal will give a successful bid submission message & a bid summary will be displayed with the bid no. and the date & time of submission of the bid with all other relevant details.
- 9) The bid summary has to be printed and kept as an acknowledgement of the submission of the bid. This acknowledgement may be used as an entry pass for any bid opening meetings."

ASSISTANCE TO BIDDERS

- 1) Any queries relating to the tender document and the terms and conditions contained therein should be addressed to the Tender Inviting Authority for a tender or the relevant contact person indicated in the tender.
- 2) Any queries relating to the process of online bid submission or queries relating to CPP Portal in general may be directed to the 24x7 CPP Portal Helpdesk.



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ANNEXURE-V

Applicable Rates for Tests

| SI No | Test | Category | Unit | Rate (in Rs.) |
|-------|---|--------------------------------------|-------------|---------------|
| 1 | Radiography of exposed and accepted films | Ir.192 | Per Sq.inch | 8.00 |
| 2 | | Co.60 | Per Sq.inch | 14.00 |
| 3 | Ultrasonic Test (UT) | Up to 50Kg per piece | Per Piece | 100.00 |
| 4 | | Above 50Kg and up to 250Kg per piece | Per Piece | 200.00 |
| 5 | | Above 250Kg per piece | Per Piece | 300.00 |
| 6 | Magnetic Particle Test (MPI) | Up to 50Kg per piece | Per Piece | 100.00 |
| 7 | | Above 50Kg and up to 250Kg per piece | Per Piece | 200.00 |
| 8 | | Above 250Kg per piece | Per Piece | 300.00 |
| 9 | Impact Test | | Per Kg | 6.00 |
| 10 | Intra Granular Corrosion Test (IGC) | Practice-B&E | Per Heat | 5000.00 |
| 11 | Dye Penetrate Test (DP) | Up to 50Kg per piece | Per Piece | 125.00 |
| 12 | | Above 50Kg and up to 250Kg per piece | Per Piece | 200.00 |
| 13 | | Above 250Kg per piece | Per Piece | 250.00 |

ANNEXURE-VI

1. The above castings are required for NPCIL Project against OR No.4910996.
2. All the castings are to be manufactured in line with Quality plan QAP No. 44/STD/4910996 Rev.0 Dt: 27.02.2025 (enclosed) and material grade WCB & CF8M in **ASME standards.**
3. 3 sets of drawings for above items are enclosed herewith.
4. Witness pouring required by ILP QC.
5. Chemical and mechanical test are to be conducted on NABL approved laboratory.
6. Mechanical testing and chemical compositions are to be witnessed by ILP QC, and same may be verified by NPCIL QA & ILP QC
7. Heat treatment to be witnessed by ILP QC and relevant heat treatment charts are to be verified by NPCIL QA & ILP QC.
8. a) Radiography is to be carried out 100% area of coverage as per ASME B 16.34 procedure
b) Please submit Radiography shooting sketch for approval by ILP QC & NPCIL.
9. DP/MPI/LPI is to be carried out for required castings and same may be reviewed by NPCIL QA & ILP QC .
10. Dimensional Inspection reports are to be prepared in presence of ILP QC & NPCIL Personnel.
11. Drawing Number, Material Code, Heat Number, RT, MPI/LPI Number are to be punched in unmachined area of castings and same to be encircled in Blue Paint. RT locations are to be encircled with blue paint.
12. Heat Treatment chart to be submitted along with supplies.