

TECHNICAL BID (ANNEXURE -A) to BI 6300033884				
Tender: Procurement of 6 Numbers of CO2 Welding Set Inverter Type - 500 Amps required for Deference Production				
SPECIFICATIONS FOR GMAW WELDING SET				
SI	Description	Range	Complied / Not Complied	Remarks (With Justification)
	Make	LINCOLN/MILLER/KEMPPI/ESAB only		
A	Power Source			
1	Welding set	IGBT Inverter based		
2	Welding current range	Min 25 Max 500 A		
3	Duty cycle	400 to 450 A @ 100%		
4	Type of cooling	Air cooled		
5	Input power supply	3 Phase, 50 Hz, AC, 415 V +/- 10 %		
6	Trolley	Suitable for mounting of power source and gas cylinder		
7	Input Power & Ground Cable (90 Sq mm)	Each 5 m long with clamp		
8	Display of current & voltage	Digital type		
B	Wire Feeder Unit : LINCOLN/MILLER/KEMPPI/ESAB Make only			
1	Drive Roller	4 Roll drive suitable for welding with wire sizes 0.8, 1.2, 1.6 & 2.4 dia. All rollers & gears in the wire drive unit shall be metallic type.		
2	Spool Max	20 kg/300 mm		
3	Centre connector	Euro end type (for connecting to welding torch)		
4	Welding cable / Positive cable	10 m long (connector between power source and wire feeder)		
5	Trolley	To mount wire feeder unit		
6	Display & Control	Digital type		
C	GMAW welding torch: Ador/ABICOR BINZEL, Kemp / Esab/ Bernad Make only			
1	Torch length	5 meter		
2	Torch end connector	Euro end type		
3	Torch cooling	Air cooled type		
4	Duty Cycle	380 to 450 A @ 100%		
5	One additional Torch required with each machine			
D	Following items shall be supplied additionally along with each welding equipment			
1	Input Power Cable & Ground cable (90sq mm) of 5 m length each with clamps			
2	02 sets of metal wire feed rollers for wire sizes 1.2 and 1.6mm dia			
3	Standard tool kit and accessories shall be supplied			
4	Two stage CO ₂ regulator, Pre heater and Flow meter			
5	CO ₂ gas hose from flow meter to wire feeder unit for the length of 10 m			
6	Detailed drawings of electrical circuits, list of spare parts and maintenance manual			
7	Inter connecting cables should have protective shielding & Electronic components should have safety features against any fluctuations in electric supply			
8	50 nos contact tips of 1.2 mm and 1.6 mm diameter (Total 50x2x2 = 200 nos)			
9	5 nos spirals of dia 1.2 mm & 1.6 mm diameter (Total 5x2x2 = 20 nos)			
10	20 nos each of Gas Nozzles and Contact Tip Holders (Total 20x2= 40 nos)			
11	Suitable Arc Welding Holder with 10 m length 70 sq mm Cable and Gouging Torch.			

E	Qualifying Criteria		
1	Only OEMs or Authorised Dealers of OEMs to submit the offers with valid Authorisation Letter		
2	Make: Lincoln/Miller/Kemppi/Esab only		
3	Warranty: Min 3 years from the date of commissioning		
F	<u>General Terms & Conditions</u>		
1	Firms should provide full technical details with catalogues & spare part catalogue with part number details.		
2	All the welding equipments shall be installed & commissioned at BEML, KGF.		
3	Firms to indicate confirmation (Yes/No) to all the above points.		

Signature of the Bidder with Company Seal