Single Phase Oil Immersed Distribution Transformers (Outdoor Type)

1 SCOPE:

1.1 This specification covers design, engineering, manufacture, assembly, stage testing, inspection and testing before supply and delivery at site of oil immersed naturally cooled 11 kV/240 V, 11/√3 kV/240 V single phase distribution transformers for outdoor use.

1.2 The equipment shall conform in all respects to high standards of engineering, design and workmanship and shall be capable of performing in continuous commercial operation in a manner acceptable to the purchaser, who will interpret the meanings of drawings and specification and shall have the power to reject any work or material which, in his judgment is not in accordance therewith. The offered equipment shall be complete with all components necessary for their effective and trouble free operation. Such components shall be deemed to be within the scope of bidder’s supply irrespective of whether those are specifically brought out in this specification and/or the commercial order or not.

1.3 The transformer and accessories shall be designed to facilitate operation, inspection, maintenance and repairs. The design shall incorporate every precaution and provision for the safety of equipment as well as staff engaged in the operation and maintenance of equipment.

1.4 All outdoor apparatus, including bushing insulators with their mountings, shall be designed so as to avoid any accumulation of water.

1.5 STANDARD RATINGS

1.5.1 Standard ratings of single phase transformers shall be 5, 10, 16 and 25 kVA.

2 STANDARDS:

2.1 The materials shall conform in all respects to the relevant Indian Standard, with latest amendments thereof unless otherwise specified herein; some of them are listed below.

2.2 Material conforming to other internationally accepted standards, which ensure equal or better quality than the standards mentioned above would also be acceptable. In case the bidder who wishes to offer material conforming to the other standards, salient points of difference between the standards adopted and the specific standards shall be clearly brought out in relevant schedule. Four copies of such standards with authentic English translations shall be furnished along with the offer.
3 SERVICE CONDITIONS:

<table>
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<th>Indian Standards</th>
<th>Title</th>
<th>International Standards</th>
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<tr>
<td>IS-2026</td>
<td>Specification for Power Transformers</td>
<td>IEC 76</td>
</tr>
<tr>
<td>IS 1180 (Part-I):</td>
<td>Outdoor Type Oil Immersed Distribution Transformers up to and including 2500kVA,</td>
<td></td>
</tr>
<tr>
<td>2014</td>
<td></td>
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<tr>
<td>IS 12444</td>
<td>Specification for Copper wire rod</td>
<td>ASTM B-49</td>
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<td>IS-335</td>
<td>Specification for Transformer/Mineral Oil</td>
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<td>Specification for high voltage porcelain bushing</td>
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<td>IS-7421</td>
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<td>IS-5484</td>
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<td>IS-9335</td>
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<td>IS-6600</td>
<td>Guide for loading of oil Immersed Transformers</td>
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<td>Method of test for power factor and dielectric constant of electrical insulating liquids</td>
<td></td>
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<td>IS-6792</td>
<td>Determination of electrical strength of insulating oil</td>
<td></td>
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<tr>
<td>IS-10028</td>
<td>Installation and maintenance of transformers.</td>
<td></td>
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</table>

3.1 The distribution transformers to be supplied against this specification shall be suitable for satisfactory continuous operation under the following climatic conditions as per IS 2026 (Part-I).

i) Location : At various locations in the country

ii) Max ambient air temperature ($^0C$) : 50

iii) Minimum ambient air temperature ($^0C$) : -5
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The climatic conditions specified above are indicative and can be changed by the user as per requirements.

1. The equipment shall generally be for use in moderately hot and humid tropical climate, conducive to rust and fungus growth unless otherwise specified.

4 PRINCIPAL PARAMETERS:

4.1 The Transformer shall be suitable for outdoor installation with single phase, 50 Hz, 11 kV systems in which the neutral is effectively earthed and they should be suitable for service under fluctuations in supply voltage up to plus 12.5% to minus 12.5%.

4.2 The transformer shall conform to the following specific parameters. Rated HV side value (11 kV or 11/√3 kV) shall be specified in the detailed bill of quantity by purchaser.

<table>
<thead>
<tr>
<th>Sl.No</th>
<th>ITEM</th>
<th>SPECIFICATION</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>System voltage(max)</td>
<td>7/ 12 kV</td>
</tr>
<tr>
<td>2.</td>
<td>Rated voltage HV</td>
<td>11/√3 or 11 kV</td>
</tr>
<tr>
<td></td>
<td>Rated voltage LV</td>
<td>240 V*</td>
</tr>
<tr>
<td>3.</td>
<td>Frequency</td>
<td>50 Hz +/- 5%</td>
</tr>
<tr>
<td>4.</td>
<td>No. of Phases</td>
<td>Single</td>
</tr>
<tr>
<td>5.</td>
<td>Type of cooling</td>
<td>ONAN</td>
</tr>
</tbody>
</table>

For HP, J&K, Uttrakhand, Sikkim, Assam, Meghalaya, Manipur, Nagaland, Tripura, Arunachal Pradesh and Mizoram

The climatic conditions specified above are indicative and can be changed by the user as per requirements.
4.3 **INSULATION LEVELS**

<table>
<thead>
<tr>
<th>Voltage (Volts)</th>
<th>Impulse Voltage (kV Peak)</th>
<th>Power Frequency (kV)</th>
</tr>
</thead>
<tbody>
<tr>
<td>433</td>
<td></td>
<td>3</td>
</tr>
<tr>
<td>11000</td>
<td>75</td>
<td>28</td>
</tr>
<tr>
<td>11000/√3</td>
<td>60</td>
<td>20</td>
</tr>
</tbody>
</table>

5 **TECHNICAL REQUIREMENTS:**

5.1 **CORE MATERIAL:**

5.1.1 Transformer core shall be wound core type construction using new and high quality cold rolled grain oriented (CRGO) steel with heat resistant insulating coating or Amorphous metal.

5.1.2 The bidder should offer the core for inspection and approval by the purchaser during manufacturing stage. CRGO steel for core shall be purchased only from the approved vendors, list of which is available at [http://apps.powergridindia.com/ims/ComponentList/Power-former%20upto%20420%20kV-CM%20List.pdf](http://apps.powergridindia.com/ims/ComponentList/Power-former%20upto%20420%20kV-CM%20List.pdf)

5.1.3 The transformer shall be suitable for over fluxing (due to combined effect of voltage and frequency) upto 12.5% without injurious heating. The operating flux density shall be such that there is a clear safe margin over the over fluxing limit of 12.5%.

5.1.4 No-load current shall not exceed 3% of full load current and will be measured by energizing the transformer at rated voltage and frequency. Increase of 12.5% of rated voltage shall not increase the no-load current by 6% of full load current.

5.1.5 Please refer to “Check-list for Inspection of Prime quality CRGO for Transformers” attached at Annexure-A. It is mandatory to follow the procedure given in this Annexure.

5.2 **WINDINGS MATERIALS:**

5.2.1 HV and LV windings shall be wound from Aluminum/Copper conductors covered with double paper/enamel. The inter layer insulation shall be of nomex/epoxy resin dotted kraft paper.

5.2.2 Proper bonding of inter layer insulation with the conductor shall be ensured. Test for bonding strength to be conducted.
5.2.3 The core coil assembly shall be dried in an oven. The type of winding shall be indicated in the tender. Whether LV windings are of conventional type or foil wound shall be indicated.

5.2.4 Dimensions of winding coils are very critical. Dimensional tolerances for winding coils shall be within limits as specified in guaranteed technical particulars (GTP).

5.2.5 The core coil assembly shall be securely held in position to avoid any movement under short circuit conditions.

5.2.6 Joints in the winding shall be avoided. However, if jointing is necessary the joints shall be properly brazed and the resistance of the joints shall be less than that of parent conductor. In case of foil windings, welding of leads to foil can be done within the winding.

5.3 **WINDING CONNECTION AND TERMINAL ARRANGEMENTS:**

5.3.1 For 11 kV transformers both ends of primary winding shall be brought out through HV bushings. For 11/√3 kV transformers, neutral end of the primary HV winding shall be brought out for connecting to 'Neutral' supply wire through 1 kV bushings. There shall be provision for connecting 'Neutral' terminal, to local 'Earth' by way of a tinned Copper strip of adequate size and dimension. The secondary winding shall be connected to two LV bushings.

5.4 **OIL:**

5.4.1 The insulating oil shall comply with the requirements of IS 335.Use of recycled oil is not acceptable. The specific resistance of the oil shall not be less than 2.5x10^{12} ohm-cm at 27 °C when tested as per IS 6103.

5.4.2 Oil shall be filtered and tested for break down voltage (BDV) and moisture content before filling.

5.4.3 The design and all materials and processes used in the manufacture of the transformer, shall be such as to reduce to a minimum the risk of the development of acidity in the oil.

6 **LOSSES:**

6.1 The bidder shall guarantee individually the no-load loss and load loss without any positive tolerance. The bidder shall also guarantee the total losses (no load + load losses at 75 °C) at the 50% of rated load and total losses at 100% of rated shall not exceed the maximum total loss values given in Table-9 of IS 1180(Part-1):2014.
6.2 The maximum allowable losses at rated voltage and rated frequency permitted at 75 °C for 11/0.433 kV transformers can be chosen by the utility as per Table-9 for ratings 5, 10, 16, 25kVA as per Energy Efficiency Level-2 specified in IS 1180 (Part-1): 2014 for single phase distribution transformers.

6.2 The above losses are maximum allowable and there would not be any positive tolerance. Bids with higher losses than the above specified values would be treated as non-responsive. However, the manufacturer can offer losses less than above stated values. The utility can evaluate offers with losses lower than the maximum allowable losses on total owning cost basis in accordance with methodology given in Annex-I.

7 PERCENTAGE IMPEDANCE:

7.1 The percentage impedance of single-phase transformers at 75 °C for different ratings up to 25 kVA shall be as per Table 9 of IS 1180(Part-1):2014.

8 TEMPERATURE RISE:

8.1 The permissible temperature rise shall be as per IS: 1180

8.2 Bids not conforming to the above limits of temperature rise will be treated as non-responsive.

9 PENALTY FOR NON PERFORMANCE

9.1 During testing at supplier’s works if it is found that the actual measured losses are more than the values quoted by the bidder, the purchaser shall reject the transformer and he shall also have the right to reject the complete lot.

9.2 Purchaser shall reject the entire lot during the test at supplier’s works, if the temperature rise exceeds the specified values.

9.3 Purchaser shall reject any transformer during the test at supplier’s works, if the impedance values differ from the guaranteed values including tolerance and if they do not meet the requirements of clause 7.1

10 BUSHINGS:

10.1 The bushings shall be either porcelain or epoxy type and shall conform to the relevant standards specified. Polymer insulator bushings conforming with relevant IEC can also be used.

10.2 For HV, 12 kV class bushings shall be used and for LV, 1 kV class bushings shall be used.
10.3 The terminal arrangement shall not require a separate oil chamber not connected to oil in the main tank.

10.4 The HV bushings shall be fixed to the top cover of the transformer and the LV bushings shall be fixed to transformer on sides and in the same plane.

10.5 The bushing rods and nuts shall be of brass/stainless steel.

10.6 Arcing horns will be provided on HV bushings shall not have arcing horns and 1 clamp for LA shall also be provided for each HT bushing. Supply of LA is not included in DT supplier’s scope.

10.7 Bushings shall be marked with manufacturer’s name, month and year of manufacture.

11 **BUSHING TERMINALS:**

11.1 HV terminal shall be designed to directly receive ACSR conductor upto 7/2.59 mm (without requiring the use of lug) and the LV terminals shall be suitable for directly receiving LT cables (aluminum) ranging from 10 Sq mm to 25 Sq mm both in vertical and horizontal position and the arrangements should be such as to avoid bimetallic corrosion. Terminal connectors must be type tested as per IS 5561.

12 **TANK:**

12.1 The oil volume inside the tank shall be such that even under the extreme operating conditions, the pressure generated inside the tank does not exceed 0.4 kg/sq. cm positive or negative. There must be sufficient space from the core to the top cover to take care of oil expansion.

12.2 The tank cover shall have plasticized surface at the top to guard against bird faults. Alternately, suitable insulating shrouds shall be provided on the bushing terminals.

12.3 The Transformer tank shall be of robust construction round/rectangular in shape and shall be built up of tested CRCA/Mild Steel Sheet.

12.4 The tank shall be capable of withstanding a pressure of 1 kg/cm² (g) and a vacuum of 760 mm of Hg for 30 minutes without any permanent deflection (Air pressure test shall be conducted as per IS -1180(Part-I):2014).

12.5 The L - seam joint, C - seam joint and all fittings and accessories shall be oil tight and no deflection / bulging should occur during service.
12.6 Manufacturer should carry out the all the welding operations as per the relevant ASME standards and submit a copy of the welding procedure and welder performance qualification certificates to the Purchaser.

12.7 The circular bottom plate edges of the tank should be folded upward, for at least 25 mm, to have sufficient overlap with vertical sidewall of the transformer.

12.8 The Transformer tank and the top cover shall be designed in such a manner as to leave no external pockets in which water can lodge.

12.9 Tank shall have permanent lugs for lifting the transformer bodily and there shall be facilities for lifting the core coil assembly separately.

12.10 The transformer shall be provided with two mounting lugs suitable for fixing the transformer to a single pole by means of 2 bolts of 20 mm diameter as per ANSI C 57.12.20-1988.

12.11 Both mounting lugs are made with steel of minimum 5 mm thickness.

12.12 Jump proof lips shall be provided for upper mounting lug.

12.13 Mounting lug faces shall be in one plane.

12.14 Minimum Oil level mark shall be embossed inside the tank (at 25°C).

12.15 The top cover shall be fixed to the tank through clamping only.

12.16 HV bushing pocket shall be embossed to top side of the top cover so as to eliminate ingress of moisture and water.

12.17 The edges of the top cover shall be formed, so as to cover the top end of the tank and gasket.

12.18 Nitrile/ polyurethane /neoprene rubber gaskets’ conforming to latest IS 4253 part-II shall be provided between tank and top cover.

12.19 The gaskets shall be continuous i.e. without any joint.

13 **TANK SEALING:**

13.1 The space on the top of the oil shall be filled with dry air or nitrogen. The nitrogen plus oil
volume inside the tank shall be such that even under extreme operating conditions, the pressure generated inside the tank does not exceed 0.4 kg/sq. cm positive or negative. The nitrogen shall conform to commercial grade of the relevant standards.

14 SURFACE PREPARATION AND PAINTING:

14.1 GENERAL

14.1.1 All paints, when applied in a normal full coat, shall be free from runs, sags, wrinkles, patchiness, brush marks or other defects.

14.1.2 All primers shall be well marked into the surface, particularly in areas where painting is evident, and the first priming coat shall be applied as soon as possible after cleaning. The paint shall be applied by airless spray according to manufacturer’s recommendations.

14.2 CLEANING AND SURFACE PREPARATION:

14.2.1 After all machining, forming and welding has been completed, all steel work surfaces shall be thoroughly cleaned of rust, scale, welding slag or spatter and other contamination prior to any painting. Steel surfaces shall be prepared by Shot blast cleaning (IS 9954) to grade Sa. 2.5 of ISO 8501-1 or chemical cleaning including phosphating (IS 3618).

14.2.2 The pressure and volume of the compressed air supply for blast cleaning shall meet the work requirements and shall be sufficiently free from all water contamination to ensure that the cleaning process is not impaired.

14.2.3 Chipping, scraping and steel wire brushing using manual or power driven tools cannot remove firmly adherent mill-scale and shall only be used where shot blast cleaning is impractical. Manufacturer shall indicate such location, for purchaser’s information, in his offer.

14.3 PROTECTIVE COATING:

As soon as all items have been cleaned and within four hours of the subsequent drying, they shall be given suitable anti-corrosion protection.

14.4 PAINT MATERIAL:

Following are the types of paint that may be suitably used for the items to be painted at shop and supply of matching paint to site:
14.4.1 The painting shall be as per Annexure-Paint which is attached herewith.

14.4.2 For external surfaces one coat of Thermo Setting paint or 1 coat of epoxy primer followed by 2 coats of polyurethane base paint. These paints can be either air-drying or stoving.

14.4.3 In case of highly polluted area, chemical atmosphere or at a place very near the sea coast, paint as above with one intermediate coat of high build MIO (Micaceous iron oxide) as an intermediate coat may be used to give a total dry film thickness of 150 to 180 microns.

14.5 PAINTING PROCEDURE:

14.5.1 All prepared steel surfaces should be primed before visible re-rusting occurs or within 4 hours, whichever is sooner. Chemical treated steel surfaces shall be primed as soon as the surface is dry and while the surface is still warm.

14.5.2 Where the quality of film is impaired by excess film thickness (wrinkling, mud cracking or general softness) the supplier shall remove the unsatisfactory paint coating and apply another. In all instances where two or more coats of the same paint are specified, such coatings may or may not be of contrasting colours.

14.5.3 DAMAGED PAINTWORK:

14.5.4 Any damage occurring to any part of a painting scheme shall be made good to the same standard of corrosion protection and appearance as that was originally employed.

14.5.5 Any damaged paint work shall be made good as follows:

14.5.6 The damaged area, together with an area extending 25 mm around its boundary, shall be cleaned down to bare metal.

14.5.7 A priming coat shall be immediately applied, followed by a full paint finish equal to that originally applied and extending 50 mm around the perimeter of the original damage.

14.5.8 The repainted surface shall present a smooth surface. This shall be obtained by carefully chamfering the paint edges before and after priming.
14.6 **DRY FILM THICKNESS:**

14.6.1 To the maximum extent practicable the coats shall be applied as a continuous film of uniform thickness and free of pores. Over spray, skips, runs, sags and drips should be avoided. The different coats may or may not be of the same colour.

14.6.2 Each coat of paint shall be allowed to harden before the next is applied as per manufacturer’s recommendation.

14.6.3 Particular attention must be paid to full film thickness at edges.

14.7 **TESTS:**

- The painted surface shall be tested for paint thickness.
- The painted surface shall pass the cross hatch adhesion test and impact test as routine test, Salt spray and Hardness test as type test as per the relevant ASTM standards.

14.8 The paint shade shall be as per Annexure-Paint which is attached herewith.

Note: Supplier shall guarantee the painting performance requirement for a period of not less than 5 years.

15 **RATING AND TERMINAL PLATES:**

15.1 Each transformer shall be provided with rating plate made of anodized aluminum/stainless steel material securely fixed on the outer body, easily accessible, showing the information given in Fig.2 of IS 1180(Part-1):2014 for single phase transformers. The entries on the rating plates shall be indelibly marked by engraving.

15.2 Each transformer shall be provided with a terminal marking plate in accordance with Fig.5 of IS 1180(Part-1):2014. The rating and terminal marking plates may be combined into one plate at the option of manufacturer.

15.3 The distribution transformer be marked with the Standard Mark and the use of Standard Mark is governed by the provisions of Bureau of Indian Standards Act, 1986 and the Rules and regulations made thereunder. As per Quality Control Order for Electrical Transformers- 2015, issued by Dept. of Heavy Industries, the Standard / ISI marking on Distribution Transformers is mandatory and the product should be manufactured in compliance with IS 1180 Part-1: (2014).
16 PRESSURE AND VACCUM REQUIREMENTS:

16.1 Single phase transformers up to 25kVA, the transformer tank shall be of robust construction, round in shape shall be capable of withstanding a pressure of 100kPa and a vacuum of 760 mm of mercury.

17 FITTINGS:

17.1 The following standard fittings shall be provided:

17.1.1 Two earthing terminals with earthing symbol.

17.1.2 Lifting lugs for the complete transformer as well as for core and winding assembly.

17.1.3 HV side neutral grounding strip (where one of the bushing terminal is connected to earth).

17.1.4 Rating and terminal marking plates. (Non detachable type)

17.1.5 Pressure relief device or self-ventilating cover

17.1.6 HV bushings.

17.1.7 LV bushings.

17.1.8 HV and LV terminal connectors.

17.1.9 Top cover fixing clamps.

17.1.10 Mounting lugs - 2 Nos.

17.1.11 Bird guard.

17.1.12 LV earthing arrangement.

17.1.13 Any other fitting required as per IS: 1180 (Part 1)

18 FASTENERS:

18.1 All bolts, studs, screw threads, pipe threads, bolt heads and nuts shall comply with the appropriate Indian Standards for metric threads, or the technical equivalent.
18.2 Bolts or studs shall not be less than 6 mm in diameter except when used for small wiring terminals.

18.3 All nuts and pins shall be adequately locked.

18.4 Wherever possible bolts shall be fitted in such a manner that in the event of failure of locking resulting in the nuts working loose and falling off, the bolt will remain in position.

18.5 All bolts/nuts/washers exposed to atmosphere should be as follows.

   a) Size 12 mm or below – Stainless steel
   b) Above 12 mm- steel with suitable finish like electro galvanized with passivation or hot dip galvanized.

18.6 Each bolt or stud shall project at least one thread but not more than three threads through the nut, except when otherwise approved for terminal board studs or relay stems. If bolts and nuts are placed so that they are inaccessible by means of ordinary spanners, special spanners shall be provided.

18.7 The length of the screwed portion of the bolts shall be such that no screw thread may form part of a shear plane between members.

18.8 Taper washers shall be provided where necessary. Protective washers of suitable material shall be provided front and back or the securing screws.

19 OVER LOAD CAPACITY:

19.1 The transformer shall be suitable for loading as per latest IS 6600.

20 TESTS:

All the equipment offered shall be fully type tested by the bidder as per the relevant standards including the additional type tests mentioned at clause 23. The type test must have been conducted on a transformer of same design during the last five years at the time of bidding. The bidder shall furnish four sets of type test reports along with the offer. In case, the offered transformer is not type tested, the bidder will conduct the type test as per the relevant standards including the additional type tests at his own cost in CPRI/ NABL.
accredited laboratory in the presence of employers representative(s) without any financial liability to employer in the event of order placed on him.

20.1 Special tests other than type and routine tests, as agreed between purchaser and bidder shall also be carried out as per the relevant standards.

20.2 The test certificates for all routine and type tests for the transformers and also for the bushings and transformer oil shall be submitted with the bid. However, if the same are not available at the time of bidding, the same may be submitted after order but before commencement of supply.

20.3 The procedure for testing shall be in accordance with IS 1180(Part-1): 2014/2026 as the case may be except for temperature rise.

20.4 Before dispatch each of the completely assembled transformer shall be subjected to the routine tests at the manufacturers works.

21 **ROUTINE TESTS:**

21.1 Ratio, polarity tests.

21.2 No load current and losses at service voltage and normal frequency.

21.3 Load losses at rated current and normal frequency.

21.4 Impedance Voltage test.

21.5 Resistance of windings cold (at or near the test bed temperature).

21.6 Insulation resistance.

21.7 Induced over voltage withstand test.

21.8 Separate source voltage withstand test. This test will not be applicable for single phase DTs with 11/√3 kV as primary voltage.

21.9 Oil sample test (one sample per lot) to comply with IS 1866.

21.10 Air pressure test on empty tank as per IS 1180.
TYPE TESTS TO BE CONDUCTED ON ONE UNIT:

In addition to the tests mentioned above following tests shall be conducted:

22.1 Temperature rise test for determining the maximum temperature rise after continuous full load run. The ambient temperature and time of test should be stated in the test certificate.

22.2 Impulse voltage withstand test: As per IS 2026 part-III. Basic insulation level (BIL) for 11 kV shall be 75 kV peak while for 11/√3 kV, it will be 60KVp

22.3 Air pressure test: As per IS 1180 (Part-1):2014.

22.4 Short circuit withstand test: Thermal and dynamic ability.

22.5 Oil samples (Post short circuit and temperature rise test) - Only DGA & BDV test shall be conducted.

22.6 Noise level measurement.

22.7 Permissible flux density and over fluxing withstand test.

22.8 Type test certificates for the tests carried out on prototype of same specifications shall be Submitted along with the bid.

22.9 The purchaser may select the transformer for type tests randomly.

23.10 Short Circuit Test and Impulse Voltage Withstand Test: The purchaser intends to procure transformers designed and successfully tested for short circuit and impulse test. In case the transformers proposed for supply against the order are not exactly as per the tested design, the supplier shall be required to carry out the short circuit test and impulse voltage withstand test at their own cost in the presence of the representative of the purchaser.

23.11 The supply shall be accepted only after such test is done successfully, as it confirms on successful withstand of short circuit and healthiness of the active parts thereafter on un-tankning after a short circuit test.

23.12 Apart from dynamic ability test, the transformers shall also be required to withstand thermal ability test or thermal withstand ability will have to be established by way of calculations.

23.13 It may also be noted that the purchaser reserved the right to conduct short circuit test and impulse voltage test in accordance with the IS, afresh on each ordered rating at purchaser’s cost, even if the transformers of the same rating and similar design are already tested. This test shall be carried out on a transformer to be selected by the purchaser either at their works
when they are offered in a lot for supply or randomly from the supplies already made to purchaser’s Stores. The findings and conclusions of these tests shall be binding on the supplier.

24 TESTS AT SITE:

24.1 The purchaser reserves the right to conduct all tests on transformer after arrival at site and the manufacturer shall guarantee test certificate figures under actual service conditions.

25 ACCEPTANCE TESTS:

25.1 The transformers shall be subjected to the following routine/acceptance test in the presence of purchaser’s representative at the place of manufacture before despatch without any extra charges. The testing shall be carried out in accordance with IS 1180, Part-1 (2014) and IS 2026. Checking of mass, dimensions, fitting and accessories, tank sheet thickness, oil quality, material, finish and workmanship as per GTP/QA plan and contract drawings.

25.2 Physical verification of core coil assembly and measurement of flux density of one unit of each rating, in every inspection with reference to short circuit test report.

25.3 All tests as specified in clause 22.

26 INSPECTION:

26.1 In respect of raw material such as core stampings, winding conductors, insulating paper and oil, supplier shall use materials manufactured/supplied by standard manufacturers and furnish the manufacturers’ test certificate as well as the proof of purchase from the manufacturers (excise gate pass) for information of the purchaser. The bidder shall furnish following documents along with their offer in respect to the raw materials:

26.1.1 Invoice of supplier.

26.1.2 Mill’s certificate.

26.1.3 Packing List.

26.1.4 Bill of landing.
26.1.5 Bill of entry certificate by custom.

Please refer to “Check-list for Inspection of Prime quality CRGO for Transformers” attached at Annexure-A. It is mandatory to follow the procedure given in this Annexure.

26.2 To ensure about the quality of transformers, the inspection shall be carried out by the purchaser’s representative at following stages:

26.2.1 Online anytime during receipt of raw material and manufacture/assembly whenever the purchaser desires.

26.2.2 When the raw material is received, and the assembly is in process in the shop floor.

26.2.3 At finished stage i.e. transformers are fully assembled and are ready for despatch.

26.3 After the main raw-materials i.e. core and coil materials and tanks are arranged and transformers are taken for production on shop floor and a few assembly have been completed, the firm shall intimate the purchaser in this regard, so that an officer for carrying out such inspection could be deputed, as far as possible within seven days from the date of intimation. During the stage inspection a few assembled core shall be dismantled (only in case of CRGO material) to ensure that the CRGO laminations used are of good quality. Further, as and when the transformers are ready for despatch, an offer intimating about the readiness of transformers, for final inspection for carrying out tests as per relevant IS and as in clauses above, shall be sent by the firm along with routine test certificates. The inspection shall normally be arranged by the purchaser at the earliest after receipt of offer for pre-delivery inspection.

26.4 In case of any defect/defective workmanship observed at any stage by the purchaser's inspecting officer; the same shall be pointed out to the firm in writing for taking remedial measures. Further processing should only be done after clearance from the Inspecting officer/purchaser.

26.5 All tests and inspection shall be carried out at the place of manufacture unless otherwise specifically agreed upon by the manufacturer and purchaser at the time of purchase. The manufacturer shall offer the inspector representing the purchaser all reasonable facilities, without charges, to satisfy him that the material is being supplied in accordance with this specification. This will include stage inspection during manufacturing stage as well as active part inspection during acceptance tests.
26.6 The manufacturer shall provide all services to establish and maintain quality of workmanship in his works and that of his sub-contractors to ensure the mechanical/electrical performance of components, compliance with drawings, identification and acceptability of all materials, parts and equipment as per latest quality standards of ISO 9000.

26.7 Along with the bid the manufacturer shall prepare Quality Assurance Plan (QAP) identifying the various stages of manufacture, quality checks performed at each stage and the customer hold points. The document shall also furnish details of method of checking, inspection and acceptance standards/values and get the approval of purchaser or his representative before proceeding with manufacturing. However, purchaser or his representative shall have the right to review the inspection reports, quality checks and results of manufacturer’s in house inspection department which are not customer hold points and the manufacturer shall comply with the remarks made by purchaser or his representative on such reviews with regards to further testing, rectification or rejection etc. Manufacturer should submit the list of equipment for testing along with latest calibration certificates to the purchaser.

26.8 Purchaser shall have every right to appoint a third party inspection to carry out the inspection process. The purchaser has the right to have the test carried out at his own cost by an independent agency wherever there is a dispute regarding the quality of supply. Purchaser has right to test 1% of the supply selected either from the stores or field to check the quality of the product. In case of any deviation purchaser has every right to reject the entire lot or penalise the manufacturer, which may lead to blacklisting among other things.

27 QUALITY ASSURANCE PLAN:

27.1 The bidder shall invariably furnish following information along with his bid, failing which his bid shall be liable for rejection. Information shall be separately given for individual type of material offered.

27.2 Statement giving list of important raw materials, names of sub-suppliers for the raw materials, list of standards according to which the raw materials are tested, list of test normally carried out on raw materials in presence of bidder’s representative and copies of test certificates.

27.3 Information and copies of test certificates as above in respect of bought out accessories.

27.4 List of manufacturing facilities available.

27.5 Level of automation achieved and list of areas where manual processing exists.
27.6 List of areas in manufacturing process, where stage inspections are normally carried out for quality control and details of such tests and inspections.

27.7 List of testing equipment available with the bidder for final testing of equipment along with valid calibration reports shall be furnished with the bid. Manufacturer shall possess 0.1 accuracy class instruments for measurement of losses.

27.8 Quality assurance plan with hold points for purchaser’s inspection.

27.9 The successful bidder shall within 30 days of placement of order, submit following information to the purchaser.

27.9.1 List of raw materials as well as bought out accessories and the names of sub-suppliers selected from those furnished along with offer.

27.9.2 Type test certificates of the raw materials and bought out accessories.

27.10 The successful bidder shall submit the routine test certificates of bought out accessories and central excise passes for raw material at the time of routine testing.

27.11 ISI marking on the transformer is mandatory. As per Quality Control Order for Electrical Transformers-2015, issued by Dept. of Heavy Industries, the Standard / ISI marking on Distribution Transformers is mandatory and the product should be manufactured in compliance with IS 1180 Part-1:(2014).

28 DOCUMENTATION:

28.1 Completely dimensioned drawings indicating general arrangement and details of fittings, clearances and winding details shall accompany the tender.

28.2 Drawings of internal constructional details and fixing details of coils should also be indicated. Tank dimensions, position of fittings, clearances between leads within the transformer, core grade of laminations, distance of core centers, area of conductor bare and with insulation. No. of coils, No. of turns per coil material of bushing metal parts etc., shall also be furnished with tender.
29  **PACKING and FORWARDING:**

29.1 The packing shall be done as per the manufacturer’s standard practice. However, he should ensure the packing is such that, the material should not get damaged during transit by rail/road.

29.2 The marking on each package shall be as per the relevant IS.

30  **GUARANTEE:**

31.1 The manufacturers of the transformer shall provide a guarantee of 60 months from the date of receipt of transformer at the stores of the Utility. In case the transformer fails within the guarantee period, the supplier will depute his representative within 15 days from date of intimation by utility for joint inspection. In case, the failure is due to the reasons attributed to supplier, the transformer will be replaced/repaired by the supplier within 2 months from date of joint inspection.

31.2 The outage period i.e. period from the date of failure till unit is repaired/replaced shall not be counted for arriving at the guarantee period.

31.3 In the event of the supplier’s inability to adhere to the aforesaid provisions, suitable penal action will be taken against the supplier, which may inter alia include blacklisting of the firm for future business with the purchaser for a certain period.

**Methodology for computing total owning cost**  

**Annex-I**

<table>
<thead>
<tr>
<th>TOC = IC + (A xWi) + (B xWc) ; Losses in KW</th>
</tr>
</thead>
<tbody>
<tr>
<td>Where,</td>
</tr>
<tr>
<td>TOC  =  Total Owning Cost</td>
</tr>
<tr>
<td>IC   =  Initial cost including taxes of transformer as quoted by the manufacturer</td>
</tr>
<tr>
<td>A factor = Cost of no load losses in Rs/KW  (A = 288239)</td>
</tr>
<tr>
<td>B factor = Cost of load losses in Rs/KW    (B = 93678)</td>
</tr>
<tr>
<td>Wi   =  No load losses quoted by the manufacturer in KW</td>
</tr>
<tr>
<td>Wc   =  Load losses quoted by the manufacturer in KW</td>
</tr>
</tbody>
</table>

Note:
No (+)ve tolerance shall be allowed at any point of time on the quoted losses after the award. In case, the losses during type testing, routine testing etc. are found above the quoted losses, the award shall stand cancelled. In such a case, the CPG money shall also be forfeited.
## Annexure-Paint

**Painting-Transformer Main tank, pipes, Conservator Tank, Radiator etc.-**

<table>
<thead>
<tr>
<th></th>
<th>Surface Preparation</th>
<th>primer coat</th>
<th>intermediate under coat</th>
<th>finish coat</th>
<th>total DFT</th>
<th>Colour shade</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Main tank, pipes, conservator tank, etc. (External surfaces)</strong></td>
<td>Blast cleaning Sa2½</td>
<td>Epoxy base Zinc primer 30-40 micron</td>
<td>Epoxy base Zinc primer 30-40 micron</td>
<td>Aliphatic Polyurethane (PU Paint) (min 50 micron)</td>
<td>Min 110 micron</td>
<td>541 shade of IS:5</td>
</tr>
<tr>
<td><strong>Main tank, pipes (above 80 NB), conservator tank, etc (Internal surfaces)</strong></td>
<td>Blast cleaning Sa2½</td>
<td>Hot oil resistant, non-corrosive varnish or paint</td>
<td>--</td>
<td>--</td>
<td>Min 30 micron</td>
<td>Glossy white for paint</td>
</tr>
<tr>
<td><strong>Radiator (External surfaces)</strong></td>
<td>Chemical / blast cleaning (Sa2½)</td>
<td>Epoxy base zinc primer 30-40 micron</td>
<td>Epoxy base Zinc primer Min 30-40 micron</td>
<td>Aliphatic Polyurethane (PU Paint) (min)50 micron</td>
<td>Min 110 micron</td>
<td>541 shade of IS:5</td>
</tr>
<tr>
<td><strong>Radiator and pipes up to 80 NB (Internal surfaces)</strong></td>
<td>Chemical cleaning if required</td>
<td>Hot oil proof low viscosity varnish or hot oil resistant non corrosive paint</td>
<td>--</td>
<td>--</td>
<td>--</td>
<td>Glossy white for paint</td>
</tr>
</tbody>
</table>
**GUARANTEED TECHNICAL PARTICULARS FOR COMPLETELY SELF PROTECTED DISTRIBUTION TRANSFORMERS**

<table>
<thead>
<tr>
<th>Sl.No.</th>
<th>Description</th>
<th>6.3 kVA</th>
<th>10 kVA</th>
<th>16 kVA</th>
<th>25 kVA</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Name of the manufacturer and place of manufacture</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>Continuous maximum rating as per this specification.</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>Normal ratio of transformer</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4.</td>
<td>Method of connection HV/LV</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5.</td>
<td>Maximum current density in Windings:</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>1. HV (A/sq mm)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>2. LV (A/sq mm)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>6.</td>
<td>Maximum hot spot temperature $^0C$. (Ambient air temperature on which above is based) $^0C$.</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>7.</td>
<td>Maximum temperature: $^0C$</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(a) Maximum observable oil temperature (ambient air temperature on which above is based)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>b) Maximum winding temperature at an ambient temperature of</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>8.</td>
<td>No-load losses at rated voltage (watt)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>9.</td>
<td>Full load losses at 75 $^0C$ (watt)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>10.</td>
<td>Total losses at 100% load (watt)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>11.</td>
<td>Total losses at 50% load (watt)</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>12.</td>
<td>Efficiency at normal voltage:</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(i) Unity Power Factor</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(a) At 50% load</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(b) At 75% load</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(c) At full load</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(ii) 0.8 Power Factor</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(a) At 50% load</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(b) At 75% load</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>(c) At full load</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>13.</td>
<td>Regulation as percentage of normal</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
voltage:

(a) At unity power factor
(b) At 0.8 power factor lagging

14. Percentage impedance voltage at normal ratio between HV and LV windings
15. Type of transformers, CRGO/ amorphous type
16. Type of Insulation used in
   HV Windings
   LV Windings
17. Type of insulation used in
   Core bolts
   Core bolt washers
   End plates
   Core lamination
18. Impulse withstand test voltage level (kV)
   HV Windings LV Windings
19. Characteristics of transformer oil
20. Total content of oil in litres
21. Whether transformer will be transported with oil?
22. Type of transformer tank
23. Approximate overall dimensions
   a) Height mm
   b) Length mm
   c) Width mm
   Tank dimensions
   a) Diameter mm
   b) Height mm
24. Mass of insulated conductor
   HV (minimum) kg
   LV (minimum) kg
25. Mass of core (minimum) kg (CRGO or amorphous metal)
26. Mass of complete transformer arranged for transport (kg)
### ADDITIONAL DETAILS

<table>
<thead>
<tr>
<th>Sl. No.</th>
<th>Description</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Core grade</td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>Core dimensions</td>
<td>mm</td>
</tr>
<tr>
<td>3.</td>
<td>Gross core area</td>
<td>cm²</td>
</tr>
<tr>
<td>4.</td>
<td>Net Core area</td>
<td>cm²</td>
</tr>
<tr>
<td>5.</td>
<td>Flux density</td>
<td>Tesla</td>
</tr>
<tr>
<td>6.</td>
<td>Mass of Core</td>
<td>kg</td>
</tr>
<tr>
<td>7.</td>
<td>Loss per kg of core at the specified flux density</td>
<td>watt</td>
</tr>
<tr>
<td>8.</td>
<td>Core window height</td>
<td>mm</td>
</tr>
<tr>
<td>9.</td>
<td>Center to center distance of the core</td>
<td>mm</td>
</tr>
<tr>
<td>10.</td>
<td>No. of LV Turns</td>
<td></td>
</tr>
<tr>
<td>11.</td>
<td>No. of HV Turns</td>
<td></td>
</tr>
<tr>
<td>12.</td>
<td>Size of LV Conductor bare/ covered (dia)</td>
<td>mm</td>
</tr>
<tr>
<td>13.</td>
<td>Size of HV conductor bare/ covered (dia)</td>
<td>mm</td>
</tr>
<tr>
<td>14.</td>
<td>No. of parallels</td>
<td></td>
</tr>
<tr>
<td>15.</td>
<td>Current density of LV winding</td>
<td>A/sq mm</td>
</tr>
<tr>
<td>16.</td>
<td>Current density of HV winding</td>
<td>A/sq mm</td>
</tr>
<tr>
<td>17.</td>
<td>Mass of the LV winding for Transformer</td>
<td>kg</td>
</tr>
<tr>
<td>18.</td>
<td>Mass of the HV winding for Transformer</td>
<td>kg</td>
</tr>
<tr>
<td>19.</td>
<td>No. of LV Coils/phase</td>
<td></td>
</tr>
<tr>
<td>20.</td>
<td>No. of HV coils . phase</td>
<td></td>
</tr>
<tr>
<td>21.</td>
<td>Height of LV Windings</td>
<td>mm</td>
</tr>
<tr>
<td>22.</td>
<td>Height of HV winding</td>
<td>mm</td>
</tr>
<tr>
<td>23.</td>
<td>ID/OD of LV winding HV</td>
<td>mm</td>
</tr>
<tr>
<td>24.</td>
<td>ID/OD of LV winding</td>
<td>mm</td>
</tr>
<tr>
<td>25.</td>
<td>Size of the duct in LV winding</td>
<td>mm</td>
</tr>
<tr>
<td>26.</td>
<td>Size of the duct in HV winding</td>
<td>mm</td>
</tr>
<tr>
<td>27.</td>
<td>Size of the duct between HV and LV</td>
<td>mm</td>
</tr>
<tr>
<td>28.</td>
<td>HV winding to LV clearance</td>
<td>mm</td>
</tr>
<tr>
<td>29.</td>
<td>HV winding to tank clearance</td>
<td>mm</td>
</tr>
<tr>
<td>30.</td>
<td>Calculated impedance</td>
<td>%</td>
</tr>
<tr>
<td>31.</td>
<td>HV to earth creepage distance</td>
<td>mm</td>
</tr>
<tr>
<td>32.</td>
<td>LV to earth creepage distance</td>
<td>mm</td>
</tr>
</tbody>
</table>
## Schedule II

**SOURCE OF MATERIALS/PLACES OF MANUFACTURE, TESTING AND INSPECTION**

<table>
<thead>
<tr>
<th>Sl. No.</th>
<th>Item</th>
<th>Source of Material</th>
<th>Place of Manufacture</th>
<th>Place of testing and inspection</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Laminations</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>Aluminium/Copper</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>Insulated winding wires</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4.</td>
<td>Oil</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5.</td>
<td>Press boards</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>6.</td>
<td>Kraft paper</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>7.</td>
<td>MS plates/Angles/Channels</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>8.</td>
<td>Gaskets</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>9.</td>
<td>Bushing HV/LV</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>10.</td>
<td>Paints</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Annexure - A

Check-list for Inspection of Prime quality CRGO for Transformers

During inspection of PRIME CRGO, the following points needs to be checked by the Transformer manufacturer. Utility's inspector shall verify all these points during inspection:-

i) In case PRIME CRGO cutting is at works of Transformer Manufacturer:

Review of documents:

- Purchase Order (unpriced) to PRIME CRGO supplier/Authorised Agency
- Manufacturer’s test certificate
- Invoice of the Supplier
- Packing List
- Bill of Lading
- Bill of Entry Certificate by Customs Deptt.
- Reconciliation Statement as per format below
- Certificate of Origin
- BIS Certification

Format for Reconciliation/Traceability records

<table>
<thead>
<tr>
<th>Serial No.</th>
<th>Details of Package/Job</th>
<th>Drawing reference</th>
<th>Quantity Involved</th>
<th>Commulative Quantity Consumed</th>
<th>Balance Stock</th>
</tr>
</thead>
</table>

(1.1 Inspection of PRIME CRGO Coils:

PRIME CRGO-Manufacturer’s Identification Slip on PRIME CRGO Coils

Visual Inspection of PRIME CRGO Coils offered as per packing list (for verification of coil details as per Test certificate & healthiness of packaging).

Unique numbering inside of each sample of PRIME CRGO coil and verification of records to be maintained in the register for consumption of CRGO coil.
ISI logo sticker on packed mother coil and ISI logo in Material TC.

2.2. During inspection of PRIME CRGO, surveillance testing of sample shall be carried out for Stacking Factor, Permeability, Specific watt loss at 1.5 Tesla and/or 1.7 Tesla depending on the grade of PRIME CRGO and aging test etc. applicable as per relevant IS/ IEC standard, Tech. Spec., MQP and Transformer manufacturer plant standard.

**Inspection Clearance Report would be issued after this inspection**

3  Inspection of PRIME CRGO laminations: Transformer manufacturer will maintain records for traceability of laminations to prime CRGO coils and burr/bow on laminations shall be measured. Utility can review these records on surveillance basis.

4.  Inspection at the time of core building:

Visual Inspection of PRIME CRGO laminations. In case of suspected mix-up/ rusting/decoloration, samples may be taken for testing on surveillance basis for tests mentioned in A.2.2 above.

Above tests shall be witnessed by Utility. In case testing facilities are not available at Manufacturer’s work, the sample(s) sealed by Utility to be sent to approved labs for testing.

**Inspection Clearance Report would be issued after this inspection**

(i) In case PRIME CRGO cutting is at Sub-vendor of Transformer Manufacturer:

Review of documents:

- Purchase Order (unpriced) to PRIME CRGO supplier/ Authorised Agency
- Purchase Order (unpriced) to Core Cutter
- Manufacturer test certificate
- Invoice of the Supplier
- Packing List
- Bill of Lading
- Bill of Entry Certificate by Customs Deptt.
- Reconciliation Statement as per format below
- Certificate of origin
- BIS Certification
**New Initiative on Material Mobilisation**

**Report of Committee A**

**Format for Traceability records as below:-**

Packing List No./date /Quantity of PRIME CRGO received

<table>
<thead>
<tr>
<th>Serial No.</th>
<th>Name of consumer</th>
<th>Details of Package/Job</th>
<th>Drawing reference</th>
<th>Quantity Involved</th>
<th>Commulative Quantity Consumed</th>
<th>Balance Stock</th>
<th>Dispatch</th>
</tr>
</thead>
</table>

(ii) .1 Inspection of PRIME CRGO Coils:

- PRIME CRGO-Manufacturer’s Identification Slip on PRIME CRGO Coils
- **Visual Inspection of PRIME CRGO Coils offered as per packing list (for verification of coil details as per Test certificate & healthiness of packaging).**
- Unique numbering inside of each sample of PRIME CRGO coil and verification of records to be maintained in the register for consumption of CRGO coil.
- **ISI logo sticker on packed mother coil and ISI logo in Material TC.**

2.2. During inspection of PRIME CRGO, surveillance testing of sample shall be carried out for Stacking Factor, Permeability, Specific watt loss at 1.5 Tesla and/or 1.7 Tesla, thickness depending on the grade of PRIME CRGO and aging test etc. applicable as per relevant IS/IEC standard, Tech. Spec., MQP and Transformer manufacturer plant standard.

**Inspection Clearance Report would be issued after this inspection**

3 **Inspection of PRIME CRGO laminations:**

Transformer manufacturer representative will inspect laminations and issue their internal Inspection Clearance Report. Inspection will comprise of review of traceability to prime CRGO coils, visual Inspection of PRIME CRGO laminations and record of burr/bow. After clearance given by transformer manufacturer, Utility will issue an Inspection Clearance Report after record review. If so desired by Utility, their representative may also join transformer manufacturer representative during this inspection.

**Inspection Clearance Report would be issued after this inspection**

vi) **Inspection at the time of core building:**

Visual Inspection of PRIME CRGO laminations. In case of suspected mix-up/rusting/decoloration, samples may be taken for testing on surveillance basis for tests mentioned in B.2.2.

**Inspection Clearance Report would be issued after this inspection**

**NOTE :-**

a) Transformer Manufacturer to ensure that PRIME CRGO is procured from POWERGRID approved vendors and CRGO manufacturer should have valid BIS Certificate for respective offered Grade.

14.1 Transformer Manufacturer should also involve themselves for ensuring the quality of CRGO laminations at their Core Cutter’s works. They should visit the works of their Core cutter and carry out necessary checks.
a) General

If a surveillance sample is drawn and sent to TPL (if testing facility not available with the manufacturer), the Transformer manufacturer can continue manufacturing at their own risk and cost pending TPL test report on PRIME CRGO sample drawn. Decision for acceptance of PRIME CRGO shall be based upon report of the sample drawn.

These checks shall be read in-conjunction with approved Quality Plan, specification as a whole and conditions of contract.

**Sampling Plan (PRIME CRGO)**

33 / 11 kV

- 1st transformer and subsequently at random 10% of Transformers (min. 1) offered for inspection.

DTs and other ratings

- 1st transformer and subsequently at random 2% of Transformers (min. 1) offered for inspection.

**NOTE:** One sample for each lot of CRGO shall be drawn on surveillance basis.

CRGO has to be procured only from POWERGRID approved vendors. List of such vendors is available at the following website. Since the list is dynamic in nature, the site may be checked from time to time to see the list of approved vendors.

http://apps.powergridindia.com/ims/ComponentList/Power-former%20upto%20420%20kV-CM%20List.pdf
3-Phase Distribution Transformers 11 or 33 kV/433-250V (Outdoor Type)

1. **SCOPE:**
   i) This specification covers design, engineering, manufacture, assembly, stage testing, inspection and testing before supply and delivery at site of oil immersed, naturally cooled 3-phase 11 kV/433 - 250 V and 33 kV/433-250 V distribution transformers for outdoor use.

   ii) The equipment shall conform in all respects to high standards of engineering, design and workmanship and shall be capable of performing in continuous commercial operation, in a manner acceptable to the purchaser, who will interpret the meanings of drawings and specification and shall have the power to reject any work or material which, in his judgment is not in accordance therewith. The offered equipment shall be complete with all components necessary for their effective and trouble free operation. Such components shall be deemed to be within the scope of bidder’s supply irrespective of whether those are specifically brought out in this specification and / or the commercial order or not.

   iii) The transformer and accessories shall be designed to facilitate operation, inspection, maintenance and repairs. The design shall incorporate every precaution and provision for the safety of equipment as well as staff engaged in operation and maintenance of equipment.

   iv) All outdoor apparatus, including bushing insulators with their mountings, shall be designed so as to avoid any accumulation of water.

2. **STANDARD RATINGS:**

   The standard ratings shall be 16, 25, 63, 100,160, 200, 250, 315, 400, 500, 630, 1000, 1250, 1600, 2000 and 2500 kVA for 11 kV distribution transformers and 100, 160, 200, 315, 400, 500, 630, 1000, 1250, 1600,2000, 2500 kVA for 33 kV distribution transformers.

3. **STANDARDS:**

   3.1 The major materials used in the transformer shall conform in all respects to the relevant/specified Indian Standards and international Standards with latest amendments thereof as on bid opening date, unless otherwise specified herein. Some of the applicable Indian Standards are listed as hereunder:
3.2

<table>
<thead>
<tr>
<th>Indian Standard</th>
<th>Title</th>
<th>International</th>
</tr>
</thead>
<tbody>
<tr>
<td>IS -2026</td>
<td>Specification for Power Transformers</td>
<td>IEC 76</td>
</tr>
<tr>
<td>IS 1180 (Part-I): 2014</td>
<td>Outdoor Type Oil Immersed Distribution Transformers up to and including 2500 kVA - 33 kV Specification</td>
<td></td>
</tr>
<tr>
<td>IS 12444</td>
<td>Specification for Copper wire rod</td>
<td>ASTM B-49</td>
</tr>
<tr>
<td>IS-335</td>
<td>Specification for Transformer/Mineral Oil</td>
<td>IEC Pub 296</td>
</tr>
<tr>
<td>IS-5</td>
<td>Specification for colors for ready mixed paints</td>
<td></td>
</tr>
<tr>
<td>IS-104</td>
<td>Ready mixed paint, brushing zinc chromate, priming</td>
<td></td>
</tr>
<tr>
<td>IS-2099</td>
<td>Specification for high voltage porcelain bushing</td>
<td></td>
</tr>
<tr>
<td>IS-649</td>
<td>Testing for steel sheets and strips and magnetic circuits</td>
<td></td>
</tr>
<tr>
<td>IS-3024</td>
<td>Cold rolled grain oriented electrical sheets and strips</td>
<td></td>
</tr>
<tr>
<td>IS -4257</td>
<td>Dimensions for clamping arrangements for bushings</td>
<td></td>
</tr>
<tr>
<td>IS -7421</td>
<td>Specification for Low Voltage bushings</td>
<td></td>
</tr>
<tr>
<td>IS -3347</td>
<td>Specification for Outdoor Bushings</td>
<td>DIN 42531 to 33</td>
</tr>
<tr>
<td>IS - 5484</td>
<td>Specification for Al Wire rods</td>
<td>ASTM B - 233</td>
</tr>
<tr>
<td>IS -9335</td>
<td>Specification for Insulating Kraft Paper</td>
<td>IEC 554</td>
</tr>
<tr>
<td>IS - 1576</td>
<td>Specification for Insulating Press Board</td>
<td>IEC 641</td>
</tr>
<tr>
<td>IS - 6600</td>
<td>Guide for loading of oil Immersed Transformers</td>
<td></td>
</tr>
<tr>
<td>IS - 2362</td>
<td>Determination of water content in oil for porcelain bushing of transformers</td>
<td></td>
</tr>
<tr>
<td>IS - 6162</td>
<td>Paper covered Aluminium conductor</td>
<td></td>
</tr>
<tr>
<td>IS - 6160</td>
<td>Rectangular Electrical conductor for electrical machines</td>
<td></td>
</tr>
<tr>
<td>IS - 5561</td>
<td>Electrical power connector</td>
<td></td>
</tr>
<tr>
<td>IS - 6103</td>
<td>Testing of specific resistance of electrical insulating liquids</td>
<td></td>
</tr>
<tr>
<td>IS - 6262</td>
<td>Method of test for power factor and dielectric constant of electrical insulating liquids</td>
<td></td>
</tr>
<tr>
<td>IS - 6792</td>
<td>Determination of electrical strength of insulating oil</td>
<td></td>
</tr>
<tr>
<td>IS - 10028</td>
<td>Installation and maintenance of transformers.</td>
<td></td>
</tr>
</tbody>
</table>

4

SERVICE CONDITIONS:

4.1 The Distribution Transformers to be supplied against this Specification shall be suitable for satisfactory continuous operation under the following climatic conditions as per IS 2026 (Part - I).

i) Location : At various locations in the country

ii) Maximum ambient air temperature (°C) : 50

iii) Minimum ambient air temperature (°C) : -5

iv) Maximum average daily ambient air temperature (°C): 40

v) Maximum yearly weighted average ambient temperature(°C) : 32

vi) Maximum altitude above Altitude of 5000 meters mean sea level (meters) : for HP, J&K, Uttrakhand, Sikkim, Assam, Meghalaya, Manipur, Nagaland, Tripura, Arunachal Pradesh and Mizoram
Note:
1. The climatic conditions specified above are indicative and can be changed by the user as per requirements.
2. The equipment shall generally be for use in moderately hot and humid tropical climate, conducive to rust and fungus growth unless otherwise specified.

5 PRINCIPAL PARAMETERS:

5.1 The transformers shall be suitable for outdoor installation with three phase, 50 Hz, 11 kV or 33 kV system in which the neutral is effectively earthed and they should be suitable for service with fluctuations in supply voltage upto plus 12.5% to minus 12.5%.

(i) The transformers shall conform to the following specific parameters:

<table>
<thead>
<tr>
<th>Sl.No.</th>
<th>Item</th>
<th>11 kV Distribution Transformers</th>
<th>33 kV Distribution Transformers</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>System voltage (Max.)</td>
<td>12 kV</td>
<td>36 kV</td>
</tr>
<tr>
<td>2</td>
<td>Rated Voltage (HV)</td>
<td>11 kV</td>
<td>33 kV</td>
</tr>
<tr>
<td>3</td>
<td>Rated Voltage (LV)</td>
<td>433 - 250 V*</td>
<td>433 - 250 V*</td>
</tr>
<tr>
<td>4</td>
<td>Frequency</td>
<td>50 Hz +/- 5%*</td>
<td>50 Hz +/- 5%*</td>
</tr>
<tr>
<td>5</td>
<td>No. of Phases</td>
<td>Three</td>
<td>Three</td>
</tr>
<tr>
<td>6</td>
<td>Connection HV</td>
<td>Delta</td>
<td>Delta</td>
</tr>
<tr>
<td>7</td>
<td>Connection LV</td>
<td>Star (Neutral brought out)</td>
<td>Star (Neutral brought out)</td>
</tr>
<tr>
<td>8</td>
<td>Vector group</td>
<td>Dyn-11</td>
<td>Dyn-11</td>
</tr>
<tr>
<td>9</td>
<td>Type of cooling</td>
<td>ONAN</td>
<td>ONAN</td>
</tr>
</tbody>
</table>

Audible sound levels (decibels) at rated voltage and frequency for liquid immersed distribution transformers shall be as below (NEMA Standards):
<table>
<thead>
<tr>
<th>kVA rating</th>
<th>Audible sound levels (decibels)</th>
</tr>
</thead>
<tbody>
<tr>
<td>0-50</td>
<td>48</td>
</tr>
<tr>
<td>51-100</td>
<td>51</td>
</tr>
<tr>
<td>101-300</td>
<td>55</td>
</tr>
<tr>
<td>301-500</td>
<td>56</td>
</tr>
<tr>
<td>750</td>
<td>57</td>
</tr>
<tr>
<td>1000</td>
<td>58</td>
</tr>
<tr>
<td>1500</td>
<td>60</td>
</tr>
<tr>
<td>2000</td>
<td>61</td>
</tr>
<tr>
<td>2500</td>
<td>62</td>
</tr>
</tbody>
</table>

**TECHNICAL REQUIREMENTS:**

**6.1.1 CORE MATERIAL**

6.1.2.1 The core shall be stack / wound type of high grade Cold Rolled Grain Oriented or Amorphous Core annealed steel lamination having low loss and good grain properties, coated with hot oil proof insulation, bolted together and to the frames firmly to prevent vibration or noise. The core shall be stress relieved by annealing under inert atmosphere if required. The complete design of core must ensure permanency of the core loss with continuous working of the transformers. The value of the maximum flux density allowed in the design and grade of lamination used shall be clearly stated in the offer.

6.1.2.2 The bidder should offer the core for inspection and approval by the purchaser during manufacturing stage. CRGO steel for core shall be purchased only from the approved vendors, list of which is available at [http://apps.powergridindia.com/ims/ComponentList/Powerformer%20upto%20420%20kV-CM%20List.pdf](http://apps.powergridindia.com/ims/ComponentList/Powerformer%20upto%20420%20kV-CM%20List.pdf)

6.1.2.3 The transformers core shall be suitable for over fluxing (due to combined effect of voltage and frequency) up to 12.5% without injurious heating at full load conditions and shall not get saturated. The bidder shall furnish necessary design data in support of this situation.

6.1.2.4 No-load current up to 200kVA shall not exceed 3% of full load current and will be measured by energising the transformer at rated voltage and frequency. Increase of 12.5% of rated voltage shall not increase the no-load current by 6% of full load current.
No-load current above 200kVA and up to 2500kVA shall not exceed 2% of full load current and will be measured by energising the transformer at rated voltage and frequency. Increase of 12.5% of rated voltage shall not increase the no-load current by 5% of full load current.

6.1.2.5 Please refer to “Check-list for Inspection of Prime quality CRGO for Transformers” attached at Annexure-A. It is mandatory to follow the procedure given in this Annexure.

7 WINDINGS:

(i) Material:
7.1.1 HV and LV windings shall be wound from Super Enamel covered /Double Paper covered Aluminum / Electrolytic Copper conductor.
7.1.2 LV winding shall be such that neutral formation will be at top.
7.1.3 The winding construction of single HV coil wound over LV coil is preferable.
7.1.4 Inter layer insulation shall be Nomex /Epoxy dotted Kraft Paper.
7.1.5 Proper bonding of inter layer insulation with the conductor shall be ensured. Test for bonding strength shall be conducted.
7.1.6 Dimensions of winding coils are very critical. Dimensional tolerances for winding coils shall be within limits as specified in Guaranteed Technical Particulars (GTP Schedule I).
7.1.7 The core/coil assembly shall be securely held in position to avoid any movement under short circuit conditions.
7.1.8 Joints in the winding shall be avoided. However, if jointing is necessary the joints shall be properly brazed and the resistance of the joints shall be less than that of parent conductor. In case of foil windings, welding of leads to foil can be done within the winding.

8 TAPPING RANGES AND METHODS:

8.1.1 No tapping shall be provided for distribution transformers up to 100 kVA rating.
8.1.2 The tapping shall be as per provisions of IS: 1180 Part-I (2014).
8.1.3 Tap changing shall be carried out by means of an externally operated self-position switch and when the transformer is in de-energised condition. Switch position No.1 shall correspond to the
maximum plus tapping. Each tap change shall result in variation of 2.5% in voltage. Arrangement for pad locking shall be provided. Suitable aluminum anodized plate shall be fixed for tap changing switch to know the position number of tap.

9 **OIL:**

9.1 The insulating oil shall comply with the requirements of IS 335. Use of recycled oil is not acceptable. The specific resistance of the oil shall be as per IS 335.

9.2 Oil shall be filtered and tested for break down voltage (BDV) and moisture content before filling.

9.3 The oil shall be filled under vacuum.

9.4 The design and all materials and processes used in the manufacture of the transformer, shall be such as to reduce to a minimum the risk of the development of acidity in the oil.

10 **INSULATION LEVELS:**

<table>
<thead>
<tr>
<th>Sl. No.</th>
<th>Voltage (kV)</th>
<th>Impulse Voltage (kV)</th>
<th>Power Frequency</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>0.433</td>
<td>-</td>
<td>3</td>
</tr>
<tr>
<td>2</td>
<td>11</td>
<td>75</td>
<td>28</td>
</tr>
<tr>
<td>3</td>
<td>33</td>
<td>170</td>
<td>70</td>
</tr>
</tbody>
</table>

11 **LOSSES:**

11.1 The transformer of HV voltage up to 11kV, the total losses (no-load + load losses at 75 °C) at 50% of rated load and total losses at 100% of rated load shall not exceed the maximum total loss values given in Table-3 upto 200kVA & Table-6 for ratings above 200kVA of IS 1180(Part-1):2014.

11.2 The maximum allowable losses at rated voltage and rated frequency permitted at 75 °C for 11/0.433 kV transformers can be chosen by the utility as per Table-3 upto 200kVA and Table-6 for ratings above 200kVA as per Energy Efficiency Level-2 specified in IS 1180 (Part-1):2014 for all kVA ratings of distribution transformers.

11.3 The above losses are maximum allowable and there would not be any positive tolerance. Bids with higher losses than the above specified values would be treated as non-responsive. However, the manufacturer can offer losses less than above stated values. The utility can evaluate offers with losses lower than the maximum allowable losses on total owning cost basis in accordance with methodology given in Annex-I.
12 **TOLERANCES:**

12.1 No positive tolerance shall be allowed on the maximum losses displayed on the label for both 50% and 100% loading values.

13 **PERCENTAGE IMPEDANCE:**

The percentage impedance of transformers at 75°C for different ratings upto 200 kVA shall be as per Table 3 and for ratings beyond 200 kVA shall be as per Table 6 of IS 1180(Part-1):2014.

14 **Temperature rise:** The temperature rise over ambient shall not exceed the limits given below:

14.1 The permissible temperature rise shall be as per IS: 1180 (Part-1):2014.

14.2 The transformer shall be capable of giving continuous rated output without exceeding the specified temperature rise. Bidder shall submit the calculation sheet in this regard.

15 **PENALTY FOR NON PERFORMANCE:**

15.1 During testing at supplier’s works if it is found that the actual measured losses are more than the values quoted by the bidder, the purchaser shall reject the transformer and he shall also have the right to reject the complete lot.

15.2 Purchaser shall reject the entire lot during the test at supplier’s works, if the temperature rise exceeds the specified values.

15.3 Purchaser shall reject any transformer during the test at supplier’s works, if the impedance values differ from the guaranteed values including tolerance.

16 **INSULATION MATERIAL:**

16.1 Electrical grade insulation epoxy dotted Kraft Paper/Nomex and pressboard of standard make or any other superior material subject to approval of the purchaser shall be used.

16.2 All spacers, axial wedges / runners used in windings shall be made of pre-compressed Pressboard-solid, conforming to type B 3.1 of IEC 641-3-2. In case of cross-over coil winding of HV all spacers shall be properly sheared and dovetail punched to ensure proper locking. All axial wedges / runners shall be properly milled to dovetail shape so that they pass through the
designed spacers freely. Insulation shearing, cutting, milling and punching operations shall be carried out in such a way, that there should not be any burr and dimensional variations.

17.1 TANK:

- Transformer tank construction shall conform in all respect to clause 15 of IS 1180(Part-1):2014.
- The internal clearance of tank shall be such, that it shall facilitate easy lifting of core with coils from the tank without dismantling LV bushings.
- All joints of tank and fittings shall be oil tight and no bulging should occur during service.
- Inside of tank shall be painted with varnish/hot oil resistant paint.
- The top cover of the tank shall be slightly sloping to drain rain water.
- The tank plate and the lifting lugs shall be of such strength that the complete transformer filled with oil may be lifted by means of lifting shackle/Hook Type.
- Manufacturer should carry out all welding operations as per the relevant ASME standards and submit a copy of the welding procedure and welder performance qualification certificates to the customer.

i) PLAIN TANK:

17.2.1 The transformer tank shall be of robust construction rectangular/octagonal/round/ elliptical in shape and shall be built up of electrically tested welded mild steel plates of thickness of 3.15 mm for the bottom and top and not less than 2.5 mm for the sides for distribution transformers upto and including 25 kVA, 5.0 mm and 3.15 mm respectively for transformers of more than 25 kVA and up to and including 100 kVA and 6 mm and 4 mm respectively above 100 kVA. Tolerances as per IS1852 shall be applicable.

17.2.2 In case of rectangular tanks above 100 kVA the corners shall be fully welded at the corners from inside and outside of the tank to withstand a pressure of 0.8 kg/cm² for 30 minutes. In case of transformers of 100 kVA and below, there shall be no joints at corners and there shall not be more than 2 joints in total.

17.2.3 Under operating conditions the pressure generated inside the tank should not exceed 0.4 kg/ sq. cm positive or negative. There must be sufficient space from the core to the top cover to take care of oil expansion. The space above oil level in the tank shall be filled with dry air or nitrogen...
conforming to commercial grade of IS 1747 for DT up to 63 KVA. For DT of 63 KVA and above rating, conservator shall be provided.

(i) The tank shall be reinforced by welded flats on all the outside walls on the edge of the tank.

(ii) Permanent deflection: The permanent deflection, when the tank without oil is subjected to a vacuum of 525 mm of mercury for rectangular tank and 760 mm of mercury for round tank, shall not be more than the values as given below:

<table>
<thead>
<tr>
<th>Horizontal length of flat plate</th>
<th>Permanent deflection</th>
</tr>
</thead>
<tbody>
<tr>
<td>Up to and including 750</td>
<td>5.0</td>
</tr>
<tr>
<td>751 to 1250</td>
<td>6.5</td>
</tr>
<tr>
<td>1251 to 1750</td>
<td>8.0</td>
</tr>
<tr>
<td>1751 to 2000</td>
<td>9.0</td>
</tr>
</tbody>
</table>

(All figures are in mm)

17.2.4 The tank shall further be capable of withstanding a pressure of 0.8kg/sq.cm and a vacuum of 0.7 kg/sq.cm (g) without any deformation.

17.2.5 The radiators can be tube type or fin type or pressed steel type to achieve the desired cooling to limit the specified temperature rise.

17.3 **CORRUGATED TANK:**

17.3.1 The bidder may offer corrugated tanks for transformers of all ratings.

17.3.2 The transformer tank shall be of robust construction corrugated in shape and shall be built up of tested sheets.

17.3.3 Corrugation panel shall be used for cooling. The transformer shall be capable of giving continuous rated output without exceeding the specified temperature rise. Bidder shall submit the calculation sheet in this regard.

17.3.4 Tanks with corrugations shall be tested for leakage test at a pressure of 0.25kg/ sq cm measured at the top of the tank.

17.3.5 The transformers with corrugation should be provided with a pallet for transportation, the
dimensions of which should be more than the length and width of the transformer tank with corrugations.

18 **CONSERVATOR:**

(i) Transformers of rating 63 kVA and above with plain tank construction, the provision of conservator is mandatory. For corrugated tank and sealed type transformers with or without inert gas cushion, conservator is not required.

(ii) When a conservator is provided, oil gauge and the plain or dehydrating breathing device shall be fitted to the conservator which shall also be provided with a drain plug and a filling hole [32 mm (1 ¼") normal size thread with cover. In addition, the cover of the main tank shall be provided with an air release plug.

(iii) The dehydrating agent shall be silica gel. The moisture absorption shall be indicated by a change in the colour of the silica gel crystals which should be easily visible from a distance. Volume of breather shall be suitable for 500g of silica gel conforming to IS 3401 for transformers upto 200 kVA and 1 kg for transformers above 200 kVA.

(iv) The capacity of a conservator tank shall be designed keeping in view the total quantity of oil and its contraction and expansion due to temperature variations. The total volume of conservator shall be such as to contain 10% quantity of the oil. Normally 3% quantity the oil shall be contained in the conservator.

(v) The cover of main tank shall be provided with an air release plug to enable air trapped within to be released, unless the conservator is so located as to eliminate the possibility of air being trapped within the main tank.

(vi) The inside diameter of the pipe connecting the conservator to the main tank should be within 20 to 50 mm and it should be projected into the conservator so that its end is approximately 20 mm above the bottom of the conservator so as to create a sump for collection of impurities. The minimum oil level (corresponding to -5 °C) should be above the sump level.
19 SURFACE PREPARATION AND PAINTING:

(i) GENERAL

19.1.1 All paints, when applied in a normal full coat, shall be free from runs, sags, wrinkles, patchiness, brush marks or other defects.

19.1.2 All primers shall be well marked into the surface, particularly in areas where painting is evident and the first priming coat shall be applied as soon as possible after cleaning. The paint shall be applied by airless spray according to manufacturer’s recommendations. However, wherever airless spray is not possible, conventional spray be used with prior approval of purchaser.

19.2 CLEANING AND SURFACE PREPARATION:

a) After all machining, forming and welding has been completed, all steel work surfaces shall be thoroughly cleaned of rust, scale, welding slag or spatter and other contamination prior to any painting.

b) Steel surfaces shall be prepared by shot blast cleaning (IS9954) to grade Sq. 2.5 of ISO 8501-1 or chemical cleaning including phosphating of the appropriate quality (IS 3618).

c) Chipping, scraping and steel wire brushing using manual or power driven tools cannot remove firmly adherent mill-scale. These methods shall only be used where blast cleaning is impractical. Manufacturer to clearly explain such areas in his technical offer.

19.3 PROTECTIVE COATING:

19.3.1 As soon as all items have been cleaned and within four hours of the subsequent drying, they shall be given suitable anti-corrosion protection.

19.4 PAINT MATERIAL:

i) Following are the types of paint which may be suitably used for the items to be painted at shop and supply of matching paint to site: Heat resistant paint (Hot oil proof) for inside surface

ii) For external surfaces one coat of thermo setting powder paint or one coat of epoxy primer followed by two coats of synthetic enamel/polyurethene base paint. These paints can be either air drying or stoving.

iii) For highly polluted areas, chemical atmosphere or for places very near to the sea coast, paint as above with one coat of high build Micaceous iron oxide (MIO) as an intermediate coat may be used.
19.5 **PAINTING PROCEDURE:**

i) All prepared steel surfaces should be primed before visible re-rusting occurs or within 4 hours, whichever is sooner. Chemical treated steel surfaces shall be primed as soon as the surface is dry and while the surface is still warm.

ii) Where the quality of film is impaired by excess film thickness (wrinkling, mud cracking or general softness) the supplier shall remove the unsatisfactory paint coating and apply another coating. As a general rule, dry film thickness should not exceed the specified minimum dry film thickens by more than 25%.

19.6 **DAMAGED PAINTWORK:**

(i) Any damage occurring to any part of a painting scheme shall be made good to the same standard of corrosion protection and appearance as that was originally applied.

(ii) Any damaged paint work shall be made good as follows:

19.6.2.1 The damaged area, together with an area extending 25 mm around its boundary, shall be cleaned down to bare metal.

19.6.2.2 A priming coat shall be immediately applied, followed by a full paint finish equal to that originally applied and extending 50 mm around the perimeter of the original damage.

19.6.2.3 The repainted surface shall present a smooth surface. This shall be obtained by carefully chamfering the paint edges before and after priming.

19.6.2.4 The paint shade shall be as per Annexure-Paint which is attached herewith.

19.7 **DRY FILM THICKNESS:**

19.7.1 To the maximum extent practicable the coats shall be applied as a continuous film of uniform thickness and free of pores. Overspray, skips, runs, sags and drips should be avoided. The different coats may or may not be of the same colour.

19.7.2 Each coat of paint shall be allowed to harden before the next is applied as per manufacturer’s recommendation.

19.7.3 Particular attention must be paid to full film thickness at the edges.
19.7.4 The requirements for the dry film thickness (DFT) of paint and the materials to be used shall be as given below:

<table>
<thead>
<tr>
<th>Sl. No.</th>
<th>Paint type</th>
<th>Area to be painted</th>
<th>No. of coats</th>
<th>Total dry film thickness (min.) (microns)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Thermo setting powder paint</td>
<td>inside</td>
<td>01</td>
<td>30</td>
</tr>
<tr>
<td></td>
<td></td>
<td>outside</td>
<td>01</td>
<td>60</td>
</tr>
<tr>
<td>2.</td>
<td><strong>Liquid paint</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a)</td>
<td>Epoxy (primer)</td>
<td>outside</td>
<td>01</td>
<td>30</td>
</tr>
<tr>
<td>b)</td>
<td>P.U. Paint (Finish coat)</td>
<td>inside</td>
<td>02</td>
<td>25 each</td>
</tr>
</tbody>
</table>

**19.8 TESTS FOR PAINTED SURFACE:**

19.8.1 The painted surface shall be tested for paint thickness.

19.8.2 The painted surface shall pass the cross hatch adhesion test and impact test as acceptance tests and Salt spray test and Hardness test as type test as per the relevant ASTM standards.

Note: Supplier shall guarantee the painting performance requirement for a period of not less than 5 years.

**20 BUSHINGS:**

20.1 The bushings arrangement shall be decided by utility during detailed engineering.

20.2 For 33 kV-36 kV class bushings shall be used for transformers of ratings 500 kVA and above. And for transformers below 500 kVA, 33 kV class bushings, for 11 kV-12 kV class bushings and for 0.433 kV-1 kV class bushings shall be used.

20.3 Bushing can be of porcelain/epoxy material. Polymer insulator bushings conforming with relevant IEC can also be used.

20.4 Dimensions of the bushings of the voltage class shall conform to the Standards specified and dimension of clamping arrangement shall be as per IS 4257.
20.5 Minimum external phase to phase and phase to earth clearances of bushing terminals shall be as follows:

<table>
<thead>
<tr>
<th>Voltage</th>
<th>Clearance</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Phase to phase</td>
</tr>
<tr>
<td>33 kV</td>
<td>350mm</td>
</tr>
<tr>
<td>11 kV</td>
<td>255mm</td>
</tr>
<tr>
<td>LV</td>
<td>75mm</td>
</tr>
</tbody>
</table>

For DTs of 200 kVA and above, the clearances of cable box shall be as below:

<table>
<thead>
<tr>
<th>Voltage</th>
<th>Clearance</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Phase to phase</td>
</tr>
<tr>
<td>33 kV</td>
<td>350mm</td>
</tr>
<tr>
<td>11 kV</td>
<td>130mm</td>
</tr>
<tr>
<td>LV</td>
<td>25mm</td>
</tr>
</tbody>
</table>

20.6 Arcing horns shall be provided on HV bushings.

20.7 Brazing of all inter connections, jumpers from winding to bushing shall have cross section larger than the winding conductor. All the Brazes shall be qualified as per ASME, section – IX.

20.8 The bushings shall be of reputed make supplied by those manufacturers who are having manufacturing and testing facilities for insulators.

20.9 The terminal arrangement shall not require a separate oil chamber not connected to oil in the main tank.

21 **TERMINAL CONNECTORS:**

21.1 The LV and HV bushing stems shall be provided with suitable terminal connectors as per IS 5082 so as to connect the jumper without disturbing the bushing stem. Connectors shall be with eye bolts so as to receive conductor for HV. Terminal connectors shall be type tested as per IS 5561.

22 **LIGHTNING ARRESTORS:**

22.1 9 kV, 5 kA metal oxide lightning arrestors of reputed make conforming to IS 3070 Part-III, one number per phase shall be provided.( To be mounted on pole or to be fitted under the HV bushing with GI earth strip 25x4 mm connected to the body of the transformer with necessary clamping arrangement as per requirement of purchaser.) Lightening arrestors with polymer insulators in conformance with relevant IEC can also be used. 1 clamp for LA shall also be provided for each HT bushing. Supply of LA is not included in DT supplier’s scope.
23 **CABLE BOXES:**

No cable box shall be provided in transformer below 200 kVA. Above 200kVA, Cable Boxes shall be provided on both HV & LV side.

23.1 In case HV/LV terminations are to be made through cables the transformer shall be fitted with suitable cable box on 11 kV side to terminate one 11kV/ 3 core aluminium conductor cable up to 240 sq. mm. (Size as per requirement).

The bidder shall ensure the arrangement of HT Cable box so as to prevent the ingress of moisture into the box due to rain water directly falling on the box. The cable box on HT side shall be of the split type with faces plain and machined and fitted with Neo-k-Tex or similar quality gasket and complete with brass wiping gland to be mounted on separate split type gland plate with nut-bolt arrangement and MS earthing clamp. The bushings of the cable box shall be fitted with nuts and stem to take the cable cores without bending them. The stem shall be of copper with copper nuts. The cross section of the connecting rods shall be stated and shall be adequate for carrying the rated currents. On the HV side the terminal rod shall have a diameter of not less than 12 mm. The material of connecting rod shall be copper. HT Cable support clamp should be provided to avoid tension due to cable weight.

23.2 The transformer shall be fitted with suitable LV cable box having non-magnetic material gland plate with appropriate sized single compression brass glands on LV side to terminate 1.1 kV/single core XLPE armoured cable (Size as per requirement).

24 **TERMINAL MARKINGS:**

High voltage phase windings shall be marked both in the terminal boards inside the tank and on the outside with capital letter 1U, 1V, 1W and low voltage winding for the same phase marked by corresponding small letter 2U, 2V, 2W. The neutral point terminal shall be indicated by the letter 2N. Neutral terminal is to be brought out and connected to local grounding terminal by an earthing strip.

26.1 The following standard fittings shall be provided:

i. Rating and terminal marking plates, non-detachable.

ii. Earthing terminals with lugs - 2 Nos.

iii. Lifting lugs for main tank and top cover

iv. Terminal connectors on the HV/LV bushings (For bare terminations only).

v. Thermometer pocket with cap - 1 No.

vi. Air release device (for non-sealed transformer)

vii. HV bushings - 3 Nos.
viii. LV bushings - 4 Nos.

ix. Pulling lugs

x. Stiffener

xi. Radiators - No. and length may be mentioned (as per heat dissipation calculations)/
corrugations.

xii. Arcing horns on HT side - 3 No. Only clamps for lightning arrester shall be provided.

xiii. Prismatic oil level gauge.

xiv. Drain cum sampling valve.

xv. One filter valve on upper side of the transformer (For transformers above 200 kVA)

xvi. Oil filling hole having p. 1- ¼ thread with plug and drain plug on the conservator.

xvii. Silica gel breather (for non-sealed type transformer)

xviii. Base channel 75x40 mm for up to 100 kVA and 100 mmx50 mm above 100 kVA, 460 mm long with holes to make them suitable for fixing on a platform or plinth.

xix. 4 No. rollers for transformers of 200 kVA and above.

xx. Pressure relief device or explosion vent (above 200 kVA)

xxi. Oil level gauge

A. -5 °C and 90°C marking for non-sealed type
    Transformers

B. - 30°C marking for sealed type transformers

xxii. Nitrogen / air filling device/ pipe with welded cover
    Capable of reuse (for sealed type transformers)

xxiii. Inspection hole for transformers above 200 kVA

xxiv. Pressure gauge for sealed type transformers above 200 kVA.

xxv. Buchholz relay for transformers above 1000 kVA.

27 FASTENERS:

27.1 All bolts, studs, screw threads, pipe threads, bolt heads and nuts shall comply with the
    appropriate Indian Standards for metric threads, or the technical equivalent.

27.2 Bolts or studs shall not be less than 6 mm in diameter except when used for small wiring
    terminals.
27.3 All nuts and pins shall be adequately locked.

27.4 Wherever possible bolts shall be fitted in such a manner that in the event of failure of locking resulting in the nuts working loose and falling off, the bolt will remain in position.

27.5 All bolts/nuts/washers exposed to atmosphere should be as follows.
   a) Size 12 mm or below – Stainless steel
   b) Above 12 mm- steel with suitable finish like electro galvanized with passivation or hot dip galvanized.

27.6 Each bolt or stud shall project at least one thread but not more than three threads through the nut, except when otherwise approved for terminal board studs or relay stems. If bolts and nuts are placed so that they are inaccessible by means of ordinary spanners, special spanners shall be provided.

27.7 The length of the screwed portion of the bolts shall be such that no screw thread may form part of a shear plane between members.

27.8 Taper washers shall be provided where necessary.

27.9 Protective washers of suitable material shall be provided front and back of the securing screws.

28 OVERLOAD CAPACITY:

28.1 The transformers shall be suitable for loading as per IS 6600.

29 TESTS:

29.1 All the equipment offered shall be fully type tested by the bidder or his collaborator as per the relevant standards including the additional type tests. The type test must have been conducted on a transformer of same design during the last five years at the time of bidding. The bidder shall furnish four sets of type test reports along with the offer. In case, the offered transformer is not type tested, the bidder will conduct the type test as per the relevant standards including the additional type tests at his own cost in CPRI/ NABL accredited laboratory in the presence of employers representative(s) without any financial liability to employer in the event of order placed on him.

29.2 Special tests other than type and routine tests, as agreed between purchaser and bidder shall also be carried out as per the relevant standards.
29.3 The requirements of site tests are also given in this clause.

29.4 The test certificates for all routine and type tests for the transformers and also for the bushings and transformer oil shall be submitted with the bid.

29.5 The procedure for testing shall be in accordance with IS1180 (Part-1) :2014/2026 as the case may be except for temperature rise test.

29.6 Before dispatch each of the completely assembled transformers shall be subjected to the routine tests at the manufacturer’s works.

30 **ROUTINE TESTS:**

30.1 Ratio, polarity, phase sequence and vector group.

30.2 No Load current and losses at service voltage and normal frequency.

30.3 Load losses at rated current and normal frequency.

30.4 The test certificates for all routine and type tests for the transformers and also for the bushings and transformer oil shall be submitted after the receipt of order.

30.5 Impedance voltage test.

30.6 Resistance of windings at each tap, cold (at or near the test bed temperature).

30.7 Insulation resistance.

30.8 Induced over voltage withstand test.

30.9 Separate source voltage withstand test.

30.10 Neutral current measurement-The value of zero sequence current in the neutral of the star winding shall not be more than 2% of the full load current.

30.11 Oil samples (one sample per lot) to comply with IS 1866.

30.12 Measurement of no load losses and magnetizing current at rated frequency and 90%, 100% and 110% rated voltage.
30.13 Pressure and vacuum test for checking the deflection on one transformer of each type in every inspection.

31 **TYPE TESTS TO BE CONDUCTED ON ONE UNIT:**

In addition to the tests mentioned in clause 30 and 31 following tests shall be conducted:

31.1 Temperature rise test for determining the maximum temperature rise after continuous full load run. The ambient temperature and time of test should be stated in the test certificate.

31.2 Impulse voltage test: with chopped wave of IS 2026 part-III. BIL for 11 kV shall be 75 kV peak.

31.3 Short circuit withstand test: Thermal and dynamic ability.

31.4 Air Pressure Test: As per IS – 1180 (Part-1):2014.

31.5 Magnetic Balance Test.

31.6 Un-balanced current test: The value of unbalanced current indicated by the ammeter shall not be more than 2% of the full load current.

31.7 Noise-level measurement.

31.8 Measurement of zero-phase sequence impedance.

31.9 Measurement of Harmonics of no-load current.

31.10 Transformer tank shall be subjected to specified vacuum. The tank designed for vacuum shall be tested at an internal pressure of 0.35 kg per sq cm absolute (250 mm of Hg) for one hour. The permanent deflection of flat plates after the vacuum has been released shall not exceed the values specified below:

<table>
<thead>
<tr>
<th>Horizontal length of flat plate (in mm)</th>
<th>Permanent deflection (in mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Upto and including 750</td>
<td>5.0</td>
</tr>
<tr>
<td>751 to 1250</td>
<td>6.5</td>
</tr>
<tr>
<td>1251 to 1750</td>
<td>8.0</td>
</tr>
<tr>
<td>1751 to 2000</td>
<td>9.0</td>
</tr>
</tbody>
</table>
31.11 Transformer tank together with its radiator and other fittings shall be subjected to pressure corresponding to twice the normal pressure or 0.35 kg / sq.cm whichever is lower, measured at the base of the tank and maintained for an hour. The permanent deflection of the flat plates after the excess pressure has been released, shall not exceed the figures for vacuum test.

31.12 Pressure relief device test: The pressure relief device shall be subject to increasing fluid pressure. It shall operate before reaching the test pressure as specified in the above class. The operating pressure shall be recorded. The device shall seal-off after the excess pressure has been released.

31.13 **Short Circuit Test and Impulse Voltage Withstand Tests**: The purchaser intends to procure transformers designed and successfully tested for short circuit and impulse test. In case the transformers proposed for supply against the order are not exactly as per the tested design, the supplier shall be required to carry out the short circuit test and impulse voltage withstand test at their own cost in the presence of the representative of the purchaser.

31.13.1 The supply shall be accepted only after such test is done successfully, as it confirms on successful withstand of short circuit and healthiness of the active parts thereafter on un-tanking after a short circuit test.

31.13.2 Apart from dynamic ability test, the transformers shall also be required to withstand thermal ability test or thermal withstand ability will have to be established by way of calculations.

31.13.3 It may also be noted that the purchaser reserves the right to conduct short circuit test and impulse voltage withstand test in accordance with the IS, afresh on each ordered rating at purchaser cost, even if the transformers of the same rating and similar design are already tested. This test shall be carried out on a transformer to be selected by the purchaser either at the manufacturer’s works when they are offered in a lot for supply or randomly from the supplies already made to purchaser’s stores. The findings and conclusions of these tests shall be binding on the supplier.

32 **ACCEPTANCE TESTS:**

32.1 **At least 10% transformers of the offered lot (minimum of one)** shall be subjected to the following routine/acceptance test in presence of purchaser’s representative at the place of manufacture before dispatch without any extra charges. The testing shall be carried out in accordance with IS:1180 (Part-1): 2014 and IS:2026.

32.2 Checking of weights, dimensions, fitting and accessories, tank sheet thickness, oil quality, material, finish and workmanship as per GTP and contract drawings on one transformer of each type in every inspection.
32.3 Physical verification of core coil assembly and measurement of flux density of one unit of each rating, in every inspection with reference to short circuit test report.

32.4 Temperature rise test on one unit of the total ordered quantity.

33 **TESTS AT SITE:**

The purchaser will conduct the following test on receipt of transformers in their store. The utility shall arrange all equipment, tools & tackle and manpower for the testing. The bidder will depute his representative to witness the same. All such test shall be conducted by utility not later than 10 days from receipt of transformers.

i) Megger Test
ii) Ratio test

34 **INSPECTION:**

34.1 In respect of raw material such as core stampings, winding conductors, insulating paper and oil, supplier shall use materials manufactured/supplied by standard manufacturers and furnish the manufacturers’ test certificate as well as the proof of purchase from these manufacturers (excise gate pass) for information of the purchaser. The bidder shall furnish following documents along with their offer in respect of the raw materials:

i. Invoice of supplier.
ii. Mill’s certificate.
iii. Packing list.
iv. Bill of landing.

v. Bill of entry certificate by custom.

Please refer to "Check-list for Inspection of Prime quality CRGO for Transformers" attached at Annexure-A. It is mandatory to follow the procedure given in this Annexure.

35 **INSPECTION AND TESTING OF TRANSFORMER OIL:**

35.1 To ascertain the quality of the transformer oil, the original manufacturer’s tests report should be submitted at the time of inspection. Arrangements should also be made for testing of transformer oil as per IS: 335, after taking out the sample from the manufactured transformers and tested in the presence of purchaser’s representative.
35.2 To ensure about the quality of transformers, the inspection shall be carried out by the purchaser’s representative at following two stages:-

35.2.1 Anytime during receipt of raw material and manufacture/assembly whenever the purchaser desires.

35.2.2 At finished stage i.e. transformers are fully assembled and are ready for dispatch.

35.3 The stage inspection shall be carried out in accordance with Annexure-II.

35.4 After the main raw-material i.e. core and coil material and tanks are arranged and transformers are taken for production on shop floor and a few assembly have been completed, the firm shall intimate the purchaser in this regard, so that an officer for carrying out such inspection could be deputed, as far as possible within seven days from the date of intimation. During the stage inspection a few assembled core shall be dismantled to ensure that the laminations used are of good quality. Further, as and when the transformers are ready for despatch, an offer intimating about the readiness of transformers, for final inspection for carrying out tests as per relevant IS shall be sent by the firm along with Routine Test Certificates. The inspection shall normally be arranged by the purchaser at the earliest after receipt of offer for pre-delivery inspection. The proforma for pre delivery inspection of Distribution transformers is placed at Annex-III.

35.5 In case of any defect/defective workmanship observed at any stage by the purchaser’s Inspecting Officer, the same shall be pointed out to the firm in writing for taking remedial measures. Further processing should only be done after clearance from the Inspecting Officer/purchaser.

35.6 All tests and inspection shall be carried out at the place of manufacture unless otherwise specifically agreed upon by the manufacturer and purchaser at the time of purchase. The manufacturer shall offer the Inspector representing the Purchaser all reasonable facilities, without charges, to satisfy him that the material is being supplied in accordance with this specification. This will include Stage Inspection during manufacturing stage as well as Active Part Inspection during Acceptance Tests.

35.7 The manufacturer shall provide all services to establish and maintain quality of workmanship in his works and that of his sub-contractors to ensure the mechanical/electrical performance of components, compliance with drawings, identification and acceptability of all materials, parts and equipment as per latest quality standards of ISO 9000.

35.8 Purchaser shall have every right to appoint a third party inspection to carry out the inspection
process.

35.9 The purchaser has the right to have the test carried out at his own cost by an independent agency wherever there is a dispute regarding the quality supplied. Purchaser has right to test 1% of the supply selected either from the stores or field to check the quality of the product. In case of any deviation purchaser have every right to reject the entire lot or penalize the manufacturer, which may lead to blacklisting, among other things.

36 QUALITY ASSURANCE PLAN:

36.1 The bidder shall invariably furnish following information along with his bid, failing which his bid shall be liable for rejection. Information shall be separately given for individual type of equipment offered.

36.2 Statement giving list of important raw materials, names of sub-suppliers for the raw materials, list of standards according to which the raw materials are tested, list of tests normally carried out on raw materials in the presence of bidder’s representative, copies of test certificates.

36.3 Information and copies of test certificates as above in respect of bought out accessories.

36.4 List of manufacturing facilities available.

36.5 Level of automation achieved and list of areas where manual processing exists.

36.6 List of areas in manufacturing process, where stage inspections are normally carried out for quality control and details of such tests and inspection.

36.7 List of testing equipment available with the bidder for final testing of equipment along with valid calibration reports. These shall be furnished with the bid. Manufacturer shall posses 0.1 accuracy class instruments for measurement of losses.

36.8 Quality Assurance Plan (QAP) withhold points for purchaser’s inspection.

36.9 The successful bidder shall within 30 days of placement of order, submit following information to the purchaser:

36.9.1 List of raw materials as well as bought out accessories and the names of sub-suppliers selected from those furnished along with offer.
36.9.2 Type test certificates of the raw materials and bought out accessories.

36.9.3 The successful bidder shall submit the routine test certificates of bought out accessories and central excise passes for raw material at the time of routine testing.

36.9.4 ISI marking on the transformer is mandatory. As per Quality Control Order for Electrical Transformers- 2015, issued by Department of Heavy Industries, Government of India, the Standard / ISI marking on Distribution Transformers is mandatory and the product should be manufactured in compliance with IS 1180 Part-1: (2014).

37 DOCUMENTATION:

37.1 The bidder shall furnish along with the bid the dimensional drawings of the items offered indicating all the fittings.

37.2 Dimensional tolerances.

37.3 Weight of individual components and total weight.

37.4 An outline drawing front (both primary and secondary sides) and end-elevation and plan of the tank and terminal gear, wherein the principal dimensions shall be given.

37.5 Typical general arrangement drawings of the windings with the details of the insulation at each point and core construction of transformer.

37.6 Typical general arrangement drawing showing both primary and secondary sides and end-elevation and plan of the transformer.

38 PACKING AND FORWARDING:

38.1 The packing shall be done as per the manufacturer’s standard practice. However, it should be ensured that the packing is such that, the material would not get damaged during transit by Rail / Road / Sea.

38.2 The marking on each package shall be as per the relevant IS.
GUARANTEE

41.1 The manufacturers of the transformer shall provide a guarantee of 60 months from the date of receipt of transformer at the stores of the Utility. In case the transformer fails within the guarantee period, the supplier will depute his representative within 15 days from date of intimation by utility for joint inspection. In case, the failure is due to the reasons attributed to supplier, the transformer will be replaced/repaired by the supplier within 2 months from date of joint inspection.

41.2 The outage period i.e. period from the date of failure till unit is repaired/ replaced shall not be counted for arriving at the guarantee period.

41.3 In the event of the supplier’s inability to adhere to the aforesaid provisions, suitable penal action will be taken against the supplier which may inter alia include blacklisting of the firm for future business with the purchaser for a certain period.

SCHEDULES:

42.1 The bidder shall fill in the following schedule which will be part of the offer. If the schedule are not submitted duly filled in with the offer, the offer shall be liable for rejection.

Schedule-A : Guaranteed Technical Particulars

Schedule-B : Schedule of Deviations

DEVIATIONS :

43.1 The bidders are not allowed to deviate from the principal requirements of the Specifications. However, the bidder is required to submit with his bid in the relevant schedule a detailed list of all deviations without any ambiguity. In the absence of a deviation list in the deviation schedules, it is understood that such bid conforms to the bid specifications and no post-bid negotiations shall take place in this regard.

43.2 The discrepancies, if any, between the specification and the catalogues and / or literatures submitted as part of the offer by the bidders, shall not be considered and representations in this regard shall not be entertained.

43.3 If it is observed that there are deviations in the offer in guaranteed technical particulars other than those specified in the deviation schedules then such deviations shall be treated as deviations.

43.4 All the schedules shall be prepared by vendor and are to be enclosed with the bid.
## METHODOLOGY FOR COMPUTING TOTAL OWNING COST

<table>
<thead>
<tr>
<th>Equation</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>( TOC = IC + (A \times Wi) + (B \times Wc) ; ) Losses in KW</td>
<td></td>
</tr>
</tbody>
</table>

Where,

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>TOC</td>
<td>Total Owning Cost</td>
</tr>
<tr>
<td>IC</td>
<td>Initial cost including taxes of transformer as quoted by the manufacturer</td>
</tr>
<tr>
<td>A factor</td>
<td>Cost of no load losses in Rs/KW ((A = 288239))</td>
</tr>
<tr>
<td>B factor</td>
<td>Cost of load losses in Rs/KW ((B = 93678))</td>
</tr>
<tr>
<td>Wi</td>
<td>No load losses quoted by the manufacturer in KW</td>
</tr>
<tr>
<td>Wc</td>
<td>Load losses quoted by the manufacturer in KW</td>
</tr>
</tbody>
</table>

**Note:** No (+)ve tolerance shall be allowed at any point of time on the quoted losses after the award. In case, the losses during type testing, routine testing etc are found above the quoted losses, the award shall stand cancelled. In such a case, the CPG money shall also be forfeited.
<table>
<thead>
<tr>
<th>Surface Preparation</th>
<th>primer coat</th>
<th>intermediate under coat</th>
<th>finish coat</th>
<th>total DFT</th>
<th>Colour shade</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Main tank, pipes, conservator tank, etc. (External surfaces)</strong></td>
<td>Blast cleaning Sa2½</td>
<td>Epoxy base Zinc primer 30-40 micron</td>
<td>Epoxy base Zinc primer 30-40 micron</td>
<td>Aliphatic Polyurethane (PU Paint) (min 50 micron)</td>
<td>Min 110 micron</td>
</tr>
<tr>
<td><strong>Main tank, pipes (above 80 NB), conservator tank, etc (Internal surfaces)</strong></td>
<td>Blast cleaning Sa2½</td>
<td>Hot oil resistant, non-corrosive varnish or paint</td>
<td>--</td>
<td>--</td>
<td>Min 30 micron</td>
</tr>
<tr>
<td><strong>Radiator (External surfaces)</strong></td>
<td>Chemical / blast cleaning (Sa2½)</td>
<td>Epoxy base zinc primer 30-40 micron</td>
<td>Epoxy base Zinc primer Min 30-40 micron</td>
<td>Aliphatic Polyurethane (PU Paint) (min)50 micron</td>
<td>Min 110 micron</td>
</tr>
<tr>
<td><strong>Radiator and pipes up to 80 NB (Internal surfaces)</strong></td>
<td>Chemical cleaning if required</td>
<td>Hot oil proof low viscosity varnish or hot oil resistant non corrosive paint</td>
<td>--</td>
<td>--</td>
<td>--</td>
</tr>
</tbody>
</table>
PROFORMA FOR STAGE INSPECTION OF DISTRIBUTION TRANSFORMERS

(A) GENERAL INFORMATION:

1. Name of firm : M/s.
2. Order No. and Date :
3. Rating-wise quantity offered :
4. Details of offer
   a) Rating
   b) Quantity
   c) Serial Numbers
5. Details of last stage inspected lot:
   a) Total quantity inspected
   b) Serial Numbers
   c) Date of stage inspection
   d) Quantity offered for final inspection of
      (a) above with date

(B) Availability of material for offered quantity :

Details to be filled in

(C) Position of manufacturing stage of the offered quantity :

a) Complete tanked assembly
b) Core and coil assembly ready
c) Core assembled
d) Coils ready for assembly
   (i) HV Coils
   (ii) LV Coils

Note: (i) A quantity of less than 100 Nos. shall not be entertained for stage inspection. If the awarded quantity is less than 100 Nos., then whole lot shall be offered in single lot.
(ii) The stage inspection shall be carried out in case:-
   (a) At least 25% quantity offered has been tanked and
   (b) core coil assembly of further at least 30% of the quantity offered has
(iii) Quantity offered for stage inspection should be offered for final inspection within 15 days from the date of issuance of clearance for stage inspection, otherwise stage inspection already cleared shall be liable for cancellation.

<table>
<thead>
<tr>
<th>Sl. No</th>
<th>Particulars</th>
<th>As offered</th>
<th>As observed</th>
<th>Deviation and Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>(D)</td>
<td>Inspection of Core:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(I)</td>
<td>Core Material</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(1)</td>
<td>Manufacturer’s Characteristic Certificate in respect of grade of lamination used. (Please furnish test certificate)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(2)</td>
<td>Remarks regarding rusting and smoothness of core.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(3)</td>
<td>Whether laminations used for top and bottom yoke are in one piece.</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(II)</td>
<td>Core Construction:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(1)</td>
<td>No. of Steps</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>(2)</td>
<td>Dimension of Steps</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Step No.</td>
<td>1</td>
<td>2</td>
<td>3</td>
</tr>
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<td>As offered:</td>
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<td>W mm</td>
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<td>T mm</td>
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<td>As found:</td>
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<td>W mm</td>
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<td></td>
<td>T mm</td>
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<td>(3) Core Dia (mm)</td>
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<td></td>
<td>(4) Total cross Section area of core</td>
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<td>(5) Effective cross Sectional area of core</td>
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<td></td>
<td>(6) Clamping arrangement</td>
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<td></td>
<td>(i) Channel Size</td>
<td></td>
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<td></td>
<td>(ii) Bolt size and No.</td>
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<td>(iii) Tie Rods size and No.</td>
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<tr>
<td>(iv) <strong>Painting</strong></td>
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<tr>
<td>(a) Channels</td>
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<tr>
<td>(b) Tie Rods</td>
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<tr>
<td>(c) Bolts</td>
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<tr>
<td>(7) Whether top yoke is cut for LV connection.</td>
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<td>(8) If yes, at 7 above, whether reinforcement is done.</td>
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<tr>
<td>(9) Size of Support Channels provided for Core base and bottom yoke (Single piece of channels are only acceptable) This will not be applicable for Amorphous core. For Amorphous core, core clamps with locking arrangement with tank base cover will be provided. This will not be applicable for Amorphous core. For Amorphous core, core clamps with locking arrangement</td>
<td></td>
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<tr>
<td>(10) Thickness of insulation provided between core base and support channel.</td>
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<tr>
<td>(11) core length (leg center to leg center)</td>
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<tr>
<td>(12) Window height</td>
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<tr>
<td>(13) Core height</td>
<td></td>
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<tr>
<td>(14) Core weight only (without channels etc.)</td>
<td></td>
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<tr>
<td><strong>(E) INSPECTION OF WINDING</strong></td>
<td></td>
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<tr>
<td><strong>(I) Winding material</strong></td>
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<tr>
<td>(1) Material used for</td>
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<tr>
<td>(a) HV winding</td>
<td></td>
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</table>
### New Initiative on Material Mobilisation

Report of Committee A

<table>
<thead>
<tr>
<th></th>
<th>(b) LV winding</th>
<th></th>
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<tbody>
<tr>
<td>2</td>
<td>Grade of material for</td>
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<tr>
<td></td>
<td>(a) HV winding</td>
<td>(b) LV winding</td>
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<tr>
<td>3</td>
<td>Test certificate of manufacturer (enclose copy) for winding material of:</td>
<td></td>
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<td></td>
<td>(a) HV</td>
<td>(b) LV</td>
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#### II) CONSTRUCTIONAL DETAILS

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<tr>
<td>1</td>
<td>Size of Cross Sectional area of conductor for:</td>
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<tr>
<td></td>
<td>(a) HV winding</td>
<td></td>
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<tr>
<td></td>
<td>(b) LV winding</td>
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<tr>
<td>2</td>
<td>Type of insulation for conductor of:</td>
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<tr>
<td></td>
<td>(a) HV winding</td>
<td>(b) LV winding</td>
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<tr>
<td>3</td>
<td>Diameter of wire used for delta formation (mm)</td>
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<tr>
<td>4</td>
<td>Diameter of coils in:</td>
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<tr>
<td></td>
<td>(a) LV winding</td>
<td></td>
</tr>
<tr>
<td></td>
<td>i) Internal dia (mm)</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ii) Outer dia (mm)</td>
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<tr>
<td></td>
<td>(b) HV winding</td>
<td></td>
</tr>
<tr>
<td></td>
<td>i) Internal dia (mm)</td>
<td></td>
</tr>
<tr>
<td></td>
<td>ii) Outer dia (mm)</td>
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<tr>
<td>5</td>
<td>Current Density of winding material used for:</td>
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</table>
New Initiative on Material Mobilisation
Report of Committee A

<table>
<thead>
<tr>
<th></th>
<th>(a) HV</th>
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<tbody>
<tr>
<td>(b)</td>
<td>LV</td>
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</table>

(6) Whether neutral formation on top.

(7) HV Coils/ Phase

<table>
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<tr>
<th></th>
<th>Number</th>
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<tbody>
<tr>
<td>(a)</td>
<td></td>
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<tr>
<td>(b)</td>
<td>Turns / coil</td>
<td></td>
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<tr>
<td>(c)</td>
<td>Total turns</td>
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</table>

(8) LV Coils/ Phase

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<tr>
<th></th>
<th>Number</th>
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<td>(a)</td>
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<tr>
<td>(b)</td>
<td>Turns / coil</td>
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<tr>
<td>(c)</td>
<td>Total turns</td>
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</table>

(9) Method of HV Coil Joints

(10) Total weight of coils of

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<table>
<thead>
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<tbody>
<tr>
<td>a)</td>
<td>LV winding (kg)</td>
</tr>
<tr>
<td>b)</td>
<td>HV winding (kg)</td>
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</table>

(F) **INSULATION MATERIALS:**

(I) **MATERIAL:**

1) Craft paper

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<td>(a)</td>
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<tr>
<td>(b)</td>
<td>Thickness (mm)</td>
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<td>(c)</td>
<td>Test Certificate of manufacturer (enclose copy).</td>
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2) Press Board

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<tbody>
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<td>(a)</td>
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<tr>
<td>(b)</td>
<td>Thickness (mm)</td>
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<tr>
<td><strong>c)</strong></td>
<td>Test Certificate of manufacturer (enclose copy).</td>
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<tr>
<td><strong>3)</strong></td>
<td>Material used for top and bottom yoke and insulation</td>
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<tr>
<td><strong>(II)</strong></td>
<td><strong>Type and thickness of material used:</strong></td>
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<td></td>
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<td></td>
</tr>
<tr>
<td>a)</td>
<td>Between core and LV</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>b)</td>
<td>Spacers</td>
<td></td>
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<tr>
<td>c)</td>
<td>Inter layer</td>
<td></td>
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<tr>
<td>d)</td>
<td>Between HV and LV winding</td>
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<td>e)</td>
<td>Between phases</td>
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<tr>
<td>f)</td>
<td>End insulation</td>
<td></td>
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<tr>
<td><strong>(G)</strong></td>
<td><strong>CLEARANCES</strong> : (mm)</td>
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<tr>
<td><strong>(I)</strong></td>
<td><strong>Related to core and windings</strong></td>
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</tr>
<tr>
<td>1)</td>
<td>LV to Core (Radial)</td>
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<tr>
<td>2)</td>
<td>Between HV and LV</td>
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<tr>
<td>3) (i)</td>
<td>Phase to phase between HV Conductor</td>
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<tr>
<td></td>
<td>(ii) Whether two Nos. Press Board each of minimum 1 mm thick provided to cover the tie rods</td>
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<tr>
<td>4)</td>
<td>Thickness of locking spacers between LV coils (mm)</td>
<td></td>
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<tr>
<td>5)</td>
<td>Axial wedges between HV and LV coils / phase (Nos.)</td>
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<tr>
<td>6)</td>
<td>No. of radial spacers per phase between HV coils</td>
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<tr>
<td>7)</td>
<td>Size of duct between LV and HV winding (mm)</td>
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</tbody>
</table>
### (II) Between core - coil assembly and tank: (mm)

1) Between winding and body:
   - a) Tank lengthwise
   - b) Tank Breadth wise

2) Clearance between top cover and top yoke upto 100 kVA and between top cover and top most live part of tap changing switch

### (H) TANK:

1) **Constructional details:**
   1) Rectangular shape
   2) Thickness of side wall (mm)
   3) Thickness of top and bottom plate (mm)
   4) Provision of slopping top cover

2) Tank internal dimensions (mm)
   - a) Length
   - b) Breadth
   - c) Height
     - (i) On LV side
     - (ii) On LV side

3) **General details:**
   1) Inside painted by varnish/oil corrosion resistant paint (please specify which type of coating done).
   2) Gasket between top cover and tank
     - (i) Material
     - (ii) Thickness (mm)
     - (iii) Jointing over taps (mm)
   3) Reinforcement of welded angle (specify size and No. of angle provided) on side walls or tank.

4) Provision of lifting lugs:
   - b) Whether lugs of 8 mm thick MS Plate provided
   - c) Whether reinforced by added plates
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<table>
<thead>
<tr>
<th>Sl. No</th>
<th>Particulars</th>
<th>As offered</th>
<th>As observed</th>
<th>Deviation and Remarks</th>
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<tbody>
<tr>
<td>(I)</td>
<td><strong>RAIDATORS</strong> :</td>
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<tr>
<td>1.</td>
<td>Fin Radiators of 1.25 mm thick sheet</td>
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<tr>
<td>a)</td>
<td>Dimension of each fin (LxBxT)</td>
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<tr>
<td>b)</td>
<td>Fins per radiator</td>
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<tr>
<td>c)</td>
<td>Total No. of radiators</td>
<td></td>
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<tr>
<td>2.</td>
<td>Verification of manufacturer’s test certificate regarding Heat dissipation (excluding Top and Bottom) in w/sq m</td>
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<td>3.</td>
<td>Verification of position of radiator with respect to bushing.</td>
<td></td>
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<tr>
<td>(J)</td>
<td><strong>CONSERVATOR</strong> :</td>
<td></td>
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</tr>
<tr>
<td>1.</td>
<td>Dimensions (L x D) (in mm)</td>
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<tr>
<td>2.</td>
<td>Volume (m^3)</td>
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<tr>
<td>3.</td>
<td>Inside dia of Conservator tank pipe (mm)</td>
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<td>4.</td>
<td>Whether conservator outlet pipe is projected approx. 20 mm inside the conservator tank</td>
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<tr>
<td>5.</td>
<td>Whether arrangement made so that oil does not fall on the active parts</td>
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<tr>
<td>6.</td>
<td>Whether die cast metal oil level gauge indicator having three positions at ( - 5^0 C, 30^0 C and 98^0 C) is provided</td>
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<td>7.</td>
<td>Whether drain plug and filling hole with cover is provided.</td>
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<tr>
<td>8.</td>
<td>Inner side of the conservator Tank painted with-</td>
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<tr>
<td>(K)</td>
<td><strong>BREATHER</strong> :</td>
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</table>
1. Whether Die cast Aluminium body breather for silica gel provided.

2. Make

3. Capacity

<table>
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<tr>
<th>Sl. No</th>
<th>Particulars</th>
<th>As offered</th>
<th>As observed</th>
<th>Deviation and Remarks</th>
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<tbody>
<tr>
<td><strong>(L)</strong></td>
<td>TERMINALS :</td>
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<tr>
<td>1.</td>
<td>Material whether of Brass Rods/ Tinned Conner</td>
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<tr>
<td></td>
<td>a) HV</td>
<td></td>
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<tr>
<td></td>
<td>b) LV</td>
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<td></td>
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<tr>
<td>2.</td>
<td>Size (dia in mm)</td>
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<tr>
<td></td>
<td>a) HV</td>
<td></td>
<td></td>
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</tr>
<tr>
<td></td>
<td>b) LV</td>
<td></td>
<td></td>
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<tr>
<td>3.</td>
<td>Method of Star connection formed on LV side of 6mm thick (Should use Al./Cu. Flat bolted/ brazed with crimped lugs on winding alternatively for 63 and 100 kVA ratings brazing is done covered with tubular sleeve duly crimped). - Please state dimensions of Al/</td>
<td></td>
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<tr>
<td>4.</td>
<td>Method of Connection of LV winding to LV Bushing (end of winding should be crimped with lugs (Al/Cu) and bolted with bushing stud)</td>
<td></td>
<td></td>
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<tr>
<td>5.</td>
<td>Method of Connection of HV winding to HV bushing (Copper joint should be done by using silver brazing alloy and for Aluminium, brazing rod or with tubular connector crimped at three spots)</td>
<td></td>
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<tr>
<td>6.</td>
<td>Whether SRB Ptube/insulated paper used for formation of Delta on HV</td>
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<tr>
<td><strong>7.</strong></td>
<td>Whether Empire sleeves used on the portion of HV winding joining to HV bushing.</td>
<td></td>
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<tr>
<td><strong>8.</strong></td>
<td>Whether neutral formation is covered with cotton tape.</td>
<td></td>
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<tr>
<td><strong>4.</strong></td>
<td>Whether arrangement for studs for fitting of HV bushing are in diamond shape (so)</td>
<td></td>
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<tr>
<td><strong>5.</strong></td>
<td>Position of mounting of LV bushings.</td>
<td></td>
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<tr>
<td><strong>5.</strong></td>
<td>Bushing Clearance: (mm)</td>
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</tr>
<tr>
<td>a)</td>
<td>LV to Earth</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>b)</td>
<td>HV to Earth</td>
<td></td>
<td></td>
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<tr>
<td>c)</td>
<td>Between LV Bushings</td>
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<tr>
<td>d)</td>
<td>Between HV Bushings</td>
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<tr>
<td><strong>(N)</strong></td>
<td>TANK BASE CHANNEL / ROLLERS:</td>
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<tr>
<td>1.</td>
<td>Size of channel (mm)</td>
<td></td>
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<tr>
<td>2.</td>
<td>Whether channels welded across the length of the tank.</td>
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<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>Size and type of roller (mm)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>(O)</strong></td>
<td>OIL:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td>Name of supplier</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2.</td>
<td>Break down voltage of oil: (kV)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>i)</td>
<td>Filled in tanked transformer</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ii)</td>
<td>In storage tank (to be tested by Inspecting Officer)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td>Supplier's test certificate (enclose copy)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>(P)</strong></td>
<td>ENGRAVING:</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td>Engraving / punching Sl. No. and name of firm on top channel / clamp or on separate plate which is firmly welded to the top channel</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>i)</td>
<td>On bottom of clamping channel of core-coil assembly</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ii)</td>
<td>Engraving of Sl. No. and name of firm on side wall and top cover of tank along with date</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>(Q)</strong></td>
<td>MS plate of size 125x125 mm welded on width side of stiffener</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>i)</td>
<td>Following details engraved (as per approved CDR):</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a)</td>
<td>Serial Number</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>b)</td>
<td>Name of firm</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>c)</td>
<td>Order No. and Date</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>d)</td>
<td>Rating</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>e)</td>
<td>Name of Inspecting Officer</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>f)</td>
<td>Designation</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>g)</td>
<td>Date of dispatch</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
### NAME PLATE DETAILS:
Whether Name Plate is as per approved drawing.

### Colour of Transformer:
1. Tank body colour shall be as per Annexure-Paint which is attached herewith.
2. Conservator colour shall be as per Annexure-Paint which is attached herewith.

### CHECKING OF TESTING FACILITIES:
(Calibration certificate also to be checked for validity.)

### TESTS:
1. No Load Current
2. No Load Loss
3. % Impedance
4. Load Losses
5. Insulation Resistance Test
6. Vector Group Test (phase relationship)
7. Ratio and Polarity test relationship
8. Transformer Oil Test (Break Down Voltage)
9. Magnetic Balance
10. Measurement of winding resistance (HV and LV both)
11. Induced over voltage withstand test (Double voltage and Double frequency)
12. Separate source power frequency withstand test at 28 kV for HV and 3 kV for LV (one minute)
13. Air pressure/ Oil leakage Test
14. Vacuum test
15. Unbalanced current test
16. Temperature rise (Heat Run) test.

We have specifically checked the following and found the same as per G.T.P./deviations observed as mentioned against each:

1. Rustlessness of CRGO laminations used
2. Core steps
3. Core area
4. Core weight
5. Winding cross sectional area
   a) LV
   b) HV
6. Weight of windings
7. Clearance between winding and wall of tank (mm)
   a) Length-wise
   b) Breadth-wise
8. Clearance between top of yoke/ top most live part of tap changer to tank cover
9. Details of Neutral formation
10. Connections to bushings:
Annexure - A

Check-list for Inspection of Prime quality CRGO for Transformers

During inspection of PRIME CRGO, the following points needs to be checked by the Transformer manufacturer. Utility’s inspector shall verify all these points during inspection:

ii) In case PRIME CRGO cutting is at works of Transformer Manufacturer:

Review of documents:

- Purchase Order (unpriced) to PRIME CRGO supplier/Authorised Agency
- Manufacturer’s test certificate
- Invoice of the Supplier
- Packing List
- Bill of Lading
- Bill of Entry Certificate by Customs Deptt.

Reconciliation Statement as per format below
- Certificate of Origin
- BIS Certification

Format for Reconciliation/Traceability records
- Packing List No./date /Quantity of PRIME CRGO received

a) LV

b) HV

xi) Slope of tank top

xii) Position of mounting of bushings
Inspection of PRIME CRGO Coils:

PRIME CRGO—Manufacturer’s Identification Slip on PRIME CRGO Coils

Visual Inspection of PRIME CRGO Coils offered as per packing list (for verification of coil details as per Test certificate & healthiness of packaging).

Unique numbering inside of each sample of PRIME CRGO coil and verification of records to be maintained in the register for consumption of CRGO coil.

ISI logo sticker on packed mother coil and ISI logo in Material TC.

2.2. During inspection of PRIME CRGO, surveillance testing of sample shall be carried out for Stacking Factor, Permeability, Specific watt loss at 1.5 Tesla and/or 1.7 Tesla depending on the grade of PRIME CRGO and aging test etc. applicable as per relevant IS/IEC standard, Tech. Spec., MQP and Transformer manufacturer plant standard.

**Inspection Clearance Report would be issued after this inspection**

3. Inspection of PRIME CRGO laminations: Transformer manufacturer will maintain records for traceability of laminations to prime CRGO coils and burr/bow on laminations shall be measured. Utility can review these records on surveillance basis.

4. Inspection at the time of core building:

Visual Inspection of PRIME CRGO laminations. In case of suspected mix-up/rusting/decoloration, samples may be taken for testing on surveillance basis for tests mentioned in A.2.2 above.

Above tests shall be witnessed by Utility. In case testing facilities are not available at Manufacturer’s work, the sample(s) sealed by Utility to be sent to approved labs for testing.

**Inspection Clearance Report would be issued after this inspection**

(ii) In case PRIME CRGO cutting is at Sub-vendor of Transformer Manufacturer:

Review of documents:
New Initiative on Material Mobilisation
Report of Committee A

Purchase Order (unpriced) to PRIME CRGO supplier/ Authorised Agency

Purchase Order (unpriced) to Core Cutter

Manufacturer test certificate

Invoice of the Supplier

Packing List

Bill of Lading

Bill of Entry Certificate by Customs Deptt.

Reconciliation Statement as per format below

Certificate of origin

BIS Certification

**Format for Traceability records as below:-**

Packing List No./date /Quantity of PRIME CRGO received

Name of Manufacturer

Manufacturer test certificate No./date

<table>
<thead>
<tr>
<th>Serial No.</th>
<th>Name of Customer</th>
<th>Details of package/job</th>
<th>Drawing Reference</th>
<th>Quantity Involved</th>
<th>Cumulative Quantity Consumed</th>
<th>Balance stock</th>
<th>Dispatch Details</th>
</tr>
</thead>
</table>

.1 Inspection of PRIME CRGO Coils:

PRIME CRGO-Manufacturer’s Identification Slip on PRIME CRGO Coils

**Visual Inspection of PRIME CRGO Coils offered as per packing list ( for verification of coil details as per Test certificate & healthiness of packaging).**

Unique numbering inside of each sample of PRIME CRGO coil and verification of records to be maintained in the register for consumption of CRGO coil.

**ISI logo sticker on packed mother coil and ISI logo in Material TC.**

2.2. During inspection of PRIME CRGO, surveillance testing of sample shall be carried out for Stacking Factor, Permeability, Specific watt loss at 1.5 Tesla and/or 1.7 Tesla, thickness depending on the grade of PRIME CRGO and aging test etc. applicable as per relevant IS/ IEC standard, Tech. Spec., MQP and Transformer manufacturer plant standard.

**Inspection Clearance Report would be issued after this inspection**

3 Inspection of PRIME CRGO laminations:
Transformer manufacturer representative will inspect laminations and issue their internal Inspection Clearance Report. Inspection will comprise of review of traceability to prime CRGO coils, visual Inspection of PRIME CRGO laminations and record of burr/bow. After clearance given by transformer manufacturer, Utility will issue an Inspection Clearance Report after record review. If so desired by Utility, their representative may also join transformer manufacturer representative during this inspection.

**Inspection Clearance Report would be issued after this inspection**

vii) Inspection at the time of core building:

Visual Inspection of PRIME CRGO laminations. In case of suspected mix-up/rusting/decoloration, samples may be taken for testing on surveillance basis for tests mentioned in B.2.2.

**Inspection Clearance Report would be issued after this inspection**

**NOTE :-**

a) Transformer Manufacturer to ensure that PRIME CRGO is procured from POWERGRID approved vendors and CRGO manufacturer should have valid BIS Certificate for respective offered Grade.

14.2 Transformer Manufacturer should also involve themselves for ensuring the quality of CRGO laminations at their Core Cutter’s works. They should visit the works of their Core cutter and carry out necessary checks.

b) General

If a surveillance sample is drawn and sent to TPL (if testing facility not available with the manufacturer), the Transformer manufacturer can continue manufacturing at their own risk and cost pending TPL test report on PRIME CRGO sample drawn. Decision for acceptance of PRIME CRGO shall be based upon report of the sample drawn.

**These checks shall be read in-conjunction with approved Quality Plan, specification as a whole and conditions of contract.**

**Sampling Plan (PRIME CRGO)**

33 / 11 kV

-1st transformer and subsequently at random 10% of Transformers (min. 1) offered for inspection.

DTs and other ratings

-1st transformer and subsequently at random 2% of Transformers (min. 1) offered for inspection.

**NOTE:-** One sample for each lot of CRGO shall be drawn on surveillance basis. CRGO has to be procured only from POWERGRID approved vendors. List of such vendors is available at the following website. Since the list is dynamic in nature, the site may be checked from time to time to see the list of approved vendors.

http://apps.powergridindia.com/ims/ComponentList/Power-former%20upto%20420%20kV-CM%20List.pdf
**Power Transformers**

1  **SCOPE**

1.1 This specification provides for design, engineering, manufacture, assembly, stage inspection, final inspection and testing before dispatch, packing and delivery at destination stores by road transport, transit insurance of 3.15/5/6.3/8/10/12.5 MVA, 33/11 KV Power Transformer(s), complete with all fittings, accessories, associated equipment's, spares, 10% extra Transformer Oil, required for its satisfactory operation in any of the sub-stations of the purchaser.

1.2 The core shall be constructed either from high grade, non-aging Cold Rolled Grain Oriented (CRGO) silicon steel laminations conforming to HIB grade of BIS certified with lamination thickness not more than 0.23mm to 0.27mm or better (Quoted grade and type shall be used). The maximum flux density in any part of the cores and yoke at normal voltage and frequency shall be such that it should under 10% overvoltage condition should not be more than 1.9 Tesla. The supplier shall provide saturation curve of the core material, proposed to be used. Laminations of different grade(s) and different thickness (s) are not allowed to be used in any manner or under any circumstances.

1.3 The scope of supply includes the provision of type test. The equipment offered should have been successfully type tested within five years from date of tender and the designs should have been in satisfactory operation for a period not less than three years as on the date of order. Compliance shall be demonstrated by submitting, (i) authenticated copies of the type test reports and (ii) performance certificates from the users, specifically from Central Govt./State Govt. or their undertakings.

1.4 The Power Transformer shall conform in all respects to highest standards of engineering, design, workmanship, this specification and the latest revisions of relevant standards at the time of offer and the employer shall have the power to reject any work or material, which, in his judgment, is not in full accordance therewith. The Transformer(s) offered, shall be complete with all components, necessary for their effective and trouble free operation. Such components shall be deemed to be within the scope of supply, irrespective of whether those are specifically brought
out in this specification and / or the commercial order or not.

The Engineer reserves the right to reject the transformers if on testing the losses exceed the declared losses beyond tolerance limit as per IS or the temperature rise in oil and / or winding exceeds the value, specified in technical particular or impedance value differ from the guaranteed value including tolerance as per this specification and if any of the test results do not match with the values, given in the guaranteed technical particulars and as per technical specification.

2 SPECIFIC TECHNICAL REQUIREMENTS

1 Rated MVA (ONAN rating) 3.15/5/6.3/8/10/12.5MVA
2 No. of phases 3
3 Type of installation Outdoor
4 Frequency 50 Hz (± 5%)
5 Cooling medium Insulating Oil (ONAN)
6 Type of mounting On Wheels, Mounted on rails.
7 Rated voltage
   a) High voltage winding 33KV
   b) Low voltage winding 11KV

8 Highest continuous system voltage
   a) Maximum system voltage ratio (HV / LV) 33KV /11 KV
   b) Rated voltage ratio (HV / LV) Two winding Transformers
9 No. of windings ONAN (Oil natural / Air natural)
10 Type of cooling 100%
11 MVA Rating corresponding to ONAN
   Cooling system
   Method of connection:
   HV : Delta
   LV : Star
13 Connection symbol Dyn 11
14 System earthing Neutral of LV side to be solidly earthed.
15 Intended regular cyclic overloading of windings
   a) Anticipated unbalanced loading Around 10%
   b) Anticipated continuous loading of windings (HV / LV) 110 % of rated current
17 a) Type of tap changer (For 3.15, 5, 6.3, 8, 10 & 12.5 MVA only)
On or Off load tap changer as per BOQ

b) Range of taping
   
   + 5% to – 15% in 9 equal steps of 2.5% each for
   Off-load tap and in 17 equal steps of 1.25% each for
   On-load tap changer on HV winding

18. Neutral terminal to be brought out
19. Over Voltage operating capability and duration
   112.5 % of rated voltage
   (continuous)

20. Maximum Flux Density in any part of the core and yoke at rated MVA
    with +12.5% combined voltage and frequency
    variation from rated voltage and frequency.
    1.9 Tesla

21. Insulation levels for windings:
    - 33KV  11KV
      1.2 / 50 microsecond wave shape Impulse
      withstand (KVP)
      a) Power frequency voltage withstand (KVrms)
      --

22. Type of winding insulation
    a) HV winding
    Uniform
    b) LV winding

23. Withstand time for three phase short circuit
    2 Seconds

24. Noise level at rated voltage and frequency
    As per NEMA Publication No. TR-1.

25. Permissible Temperature rise over ambient temperature shall be as per IS-2026

26. Minimum clearances in air (mm) :-
    Phase to Phase  Phase to ground
    a) HV          400   320
    b) LV          280   140

28. Terminals
    a. HV winding line end 36 KV oil filled communicating type porcelain bushings (Anti-fog type)
    b. LV winding 12 KV porcelain type of bushing (Anti-fog type) – for outdoor 11 KV breakers

    **(11KV Power cables shall be used for extending supply to 11KV breakers in case of indoor circuit breakers. The termination of 11 KV cables on LV bushing shall be through extended copper bus bars suitable to hold power cables termination. A metallic cable termination box, completely sealed, shall be installed on LV side of the transformer in which cables shall enter from bottom gland plates.)**

29. Insulation level of bushing
    LV   HV
### New Initiative on Material Mobilisation

**Report of Committee A**

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>a) Lightning Impulse withstand (KVP)</td>
<td>170</td>
<td>75</td>
</tr>
<tr>
<td>b) 1 Minute Power Frequency withstand voltage (KV –rms )</td>
<td>70</td>
<td>28</td>
</tr>
<tr>
<td>c) Creepage distance (mm) (minimum)</td>
<td>900</td>
<td>300</td>
</tr>
<tr>
<td>30</td>
<td>Material of HV &amp; LV Conductor</td>
<td>Electrolytic Copper</td>
</tr>
<tr>
<td>31</td>
<td>Maximum current density for HV and LV winding for rated current</td>
<td>As per best practice</td>
</tr>
</tbody>
</table>

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>32</td>
<td>Polarization index (HV to LV, HV to Earth &amp; LV to earth)</td>
<td></td>
</tr>
<tr>
<td>IR Test = 1 minute value/ 15 secs. value will not be less than 1.5</td>
<td></td>
<td></td>
</tr>
<tr>
<td>IR Test = 10 minutes value / 1 minute value will not be more than 5 and less than 1.5</td>
<td></td>
<td></td>
</tr>
<tr>
<td>33</td>
<td>Core Assembly</td>
<td>Boltless type</td>
</tr>
<tr>
<td>34</td>
<td>Temperature Indicator</td>
<td></td>
</tr>
<tr>
<td>a) Oil</td>
<td>One number</td>
<td></td>
</tr>
<tr>
<td>b) Winding</td>
<td>One number</td>
<td></td>
</tr>
</tbody>
</table>

#### 35. **Losses**: - The losses shall not exceed the value given below

<table>
<thead>
<tr>
<th>MVA Rating</th>
<th>No-load losses (Fixed loss)</th>
<th>Load losses at 75°C</th>
<th>Percentage impedance voltage on normal tap and</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.15</td>
<td>3</td>
<td>16</td>
<td>7.15</td>
</tr>
<tr>
<td>5</td>
<td>4</td>
<td>23</td>
<td>7.15</td>
</tr>
<tr>
<td>6.3</td>
<td>4.6</td>
<td>36</td>
<td>7.15</td>
</tr>
<tr>
<td>8</td>
<td>5.5</td>
<td>40</td>
<td>8.35</td>
</tr>
<tr>
<td>10</td>
<td>7</td>
<td>50</td>
<td>8.35</td>
</tr>
<tr>
<td>12.5</td>
<td>7.5</td>
<td>65</td>
<td>10</td>
</tr>
</tbody>
</table>

#### 2.1 **MARSHALLING BOX**

A metal enclosed, weather, vermin and dust proof marshalling box fitted with required glands, locks, glass door, terminal Board, heater with switch, illumination lamp with switch etc. shall be provided with each transformer to accommodate temperature indicators, terminal blocks etc. It shall have degree of protection of IP 55 or better as per IS: 2147 (Refer Clause 3.12).

#### 2.2 **CAPITALIZATION OF LOSSES AND LIQUIDATED DAMAGES**

Capitalisation of losses will be as per Annexure B which is attached herewith. No (+)ve tolerance shall be allowed at any point of time, on the quoted losses after the award. In case, the losses during type testing
routine testing etc. are found above the quoted losses, the award shall stand cancelled. In such a case, the CPG money shall also be forfeited.

2.3 PERFORMANCE

i) Transformer shall be capable of withstanding for two seconds without damage to any external short circuit, with the short circuit MVA available at the terminals.

ii) The maximum flux density in any part of the core and yoke at rated Voltage and frequency shall be such that the flux density with +12.5% combined voltage and frequency variation from rated voltage and frequency shall not exceed 1.9 Tesla.

iii) Transformer shall under exceptional circumstances due to sudden disconnection of the load, be capable of operating at the voltage approximately 25% above normal rated voltage for a period of not exceeding one minute and 40% above normal for a period of 5 seconds.

iv) The transformer may be operated continuously without danger on any particular tapping at the rated MVA± 1.25% of the voltage corresponding to the tapping.

v) The thermal ability to withstand short circuit shall be demonstrated by calculation.

vi) Transformer shall be capable of withstanding thermal and mechanical stress caused by any symmetrical and asymmetrical faults on any winding.

2.4 DRAWINGS/ DOCUMENTS INCORPORATING THE FOLLOWING PARTICULARS SHALL BE SUBMITTED WITH THE BID

a) General outline drawing showing shipping dimensions and overall dimensions, net weights and shipping weights, quality of insulating oil, spacing of wheels in either direction of motion, location of coolers, marshalling box and tap changers etc.

b) Assembly drawings of core, windings etc. and weights of main components / parts.

c) Height of center line on HV and LV connectors of transformers from the rail top level.

d) Dimensions of the largest part to be transported.

e) GA drawings / details of various types of bushing

f) Tap changing and Name Plate diagram
g) Type test certificates of similar transformers.

h) Illustrative & descriptive literature of the Transformer.

i) Maintenance and Operating Instructions.

2.5 MISCELLANEOUS

i) Padlocks along with duplicate keys as asked for various valves, marshalling box etc. shall be supplied by the contractor, wherever locking arrangement is provided.

ii) Foundation bolts for wheel locking devices of Transformer shall be supplied by the Contractor.

2.6 DELIVERY

The full quantity of the equipments shall be delivered as per the delivery schedule appended to this specification.

2.7 SCHEDULES

All Schedules annexed to the specification shall be duly filled by the bidder separately.

2.8 ALTITUDE FACTOR

If the equipment is to be installed in the hilly area, necessary correction factors as given in the Indian Standard for oil temperature rise, insulation level etc. shall be applied to the Standard Technical Parameters given above.

2.9 NAME PLATE

Transformer rating plate shall contain the information as given in clause 15 of IS-2026 (part-I). The details on rating plate shall be finalized during the detailed engineering. Further, each transformer shall have inscription of Employer’s name. The name plate shall also include (i) The short circuit rating, (ii) Measured no load current and no load losses at rated voltage and rated frequency, (iii) measured load losses at 75° C (normal tap only), (iv) D.C resistance of each winding at 75° C.
3. SERVICE CONDITIONS

The service conditions shall be as follows: (To be confirmed by PIA as per locality of project)

<table>
<thead>
<tr>
<th></th>
<th>Plain area</th>
<th>Hilly area</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum altitude above sea level</td>
<td>1000m</td>
<td>5000m</td>
</tr>
<tr>
<td>Maximum ambient air temperature</td>
<td>50° C</td>
<td>50° C</td>
</tr>
<tr>
<td>Maximum daily average ambient air temperature</td>
<td>35° C</td>
<td>40° C</td>
</tr>
<tr>
<td>Minimum ambient air temperature</td>
<td>-5° C</td>
<td>-30° C</td>
</tr>
<tr>
<td>Maximum temperature attainable by an object exposed to the sun</td>
<td>60° C</td>
<td>60° C</td>
</tr>
<tr>
<td>Maximum yearly weighted average ambient temperature</td>
<td>32° C</td>
<td>32° C</td>
</tr>
<tr>
<td>Maximum relative humidity</td>
<td>100%</td>
<td>100%</td>
</tr>
<tr>
<td>Average number of thunderstorm days per annum (isokeraunic level)</td>
<td>70</td>
<td>70</td>
</tr>
<tr>
<td>Average number of rainy days per annum</td>
<td>120</td>
<td>120</td>
</tr>
<tr>
<td>Average annual rainfall</td>
<td>1500 mm</td>
<td>1500 mm</td>
</tr>
<tr>
<td>Maximum wind pressure</td>
<td>260Kg/m²</td>
<td>260Kg/m²</td>
</tr>
</tbody>
</table>

* HP, J&K, Uttrakhand, Sikkim, Assam, Meghalaya, Manipur, Nagaland, Tripura and Mizoram will be considered as Hilly Area.

Environmentally, the region where the equipment will be installed includes coastal areas, subject to high relative humidity, which can give rise to condensation. Onshore winds will frequently be salt laden. On occasions, the combination of salt and condensation may create pollution conditions for outdoor insulators. Therefore, outdoor material and equipment shall be designed and protected for use in exposed, heavily polluted, salty, corrosive, tropical and humid coastal atmosphere.

4. SYSTEM CONDITIONS

The equipment shall be suitable for installation in supply systems of the following characteristics.

Frequency

50 Hz± 5%

Nominal system voltages

33 KV

11 KV

Maximum system voltages

33KV System

36.3 KV

11 KV System

12 KV

33KV System

31.5KA
Nominal short circuit level (Basing on apparent power)

<table>
<thead>
<tr>
<th>System</th>
<th>Nominal Short Circuit Level</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>11 KV System</td>
<td>13.1KA</td>
<td></td>
</tr>
</tbody>
</table>

Insulation levels: 1.2/50 μ sec impulse withstand voltage

<table>
<thead>
<tr>
<th>System</th>
<th>Insulation Levels</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>33 KV System</td>
<td>170KV (peak)</td>
<td></td>
</tr>
<tr>
<td>11 KV System</td>
<td>75 KV (peak)</td>
<td></td>
</tr>
<tr>
<td>33 KV System</td>
<td>70KV (rms)</td>
<td></td>
</tr>
<tr>
<td>11 KV System</td>
<td>28KV (rms)</td>
<td></td>
</tr>
</tbody>
</table>

Power frequency one minute withstand (wet and dry) voltage

<table>
<thead>
<tr>
<th>System</th>
<th>Power Frequency One Minute Withstand Voltage</th>
</tr>
</thead>
<tbody>
<tr>
<td>33 KV System</td>
<td>70KV (rms)</td>
</tr>
<tr>
<td>11 KV System</td>
<td>28KV (rms)</td>
</tr>
</tbody>
</table>

Neutral earthing arrangements

<table>
<thead>
<tr>
<th>System</th>
<th>Neutral Earthing Arrangements</th>
</tr>
</thead>
<tbody>
<tr>
<td>11 KV System</td>
<td>Solidly earthed</td>
</tr>
</tbody>
</table>

5 CODES & STANDARDS

5.1 (i) The design, material, fabrication, manufacture, inspection, testing before dispatch and performance of power transformers at site shall comply with all currently applicable statutory regulations and safety codes in the locality where the equipment will be installed. The equipment shall also conform to the latest applicable standards and codes of practice. Nothing in this specification shall be construed to relieve the contractor of this responsibility.

5.2 The equipment and materials covered by this specification shall conform to the latest applicable provision of the following standards.

- IS:5 Colour for ready mixed paints
- IS:325 Three Phase Induction Motors
- IS:335 New insulating oil for transformers, switch gears
- IS:1271 Classification of insulating materials for electrical machinery and apparatus in relation to their stability in services
- IS:2026(Part I to IV) Power Transformer
- IS:2071 Method of high voltage testing
- IS:2099 High voltage porcelain bushings
- IS:2147 Degree of protection
- IS:2705 Current Transformers
- IS:3202 Code of practice for climate proofing of electrical equipment
- IS:3347 Dimensions for porcelain Transformer Bushings
- IS:3637 Gas operated relays
IS:3639  Fittings and accessories for power Transformers
IS:5561  Electric Power Connectors
IS:6600/BS:CP“10:0  Guide for loading of oil immersed Transformers
IS:10028  Code of practice for selection, installation and maintenance of transformers, Part I, II and III
C.B.I.P. Publication  Manual on Transformers

If the standard is not quoted for any item, it shall be presumed that the latest version of Indian Standard shall be applicable to that item.

The equipment complying other internationally accepted standards, may also be considered if they ensure performance superior to the Indian Standards.

5.3 **DRAWINGS**

a) The contractor shall furnish, within fifteen days after issuing of Letter of Award. Six copies each of the following drawings/documents incorporating the transformer rating for approval.

i) Detailed overall general arrangement drawing showing front and side elevations and plan of the transformer and all accessories including radiators and external features with details of dimensions, spacing of wheels in either direction of motion, net weights and shipping weights, crane lift for un-tanking, size of lugs and eyes, bushing lifting dimensions, clearances between HV and L.V terminals and ground, quantity of insulating oil etc.

ii) Assembly drawings of core and winging and weights of main components / parts

iii) Foundation plan showing loading on each wheel land jacking points with respect to centre line of transformer.

iv) GA drawings details of bushing and terminal connectors.

v) Name plate drawing with terminal marking and connection diagrams.

vi) Wheel locking arrangement drawing.

vii) Transportation dimensions drawings.

Viii) Magnetization characteristic curves of PS class neutral and phase side current transformers, if applicable.

ix) Interconnection diagrams.

x) Over fluxing withstand time characteristic of transformer.
xi) GA drawing of marshalling box.

xii) Control scheme/wiring diagram of marshalling box.

xiii) Technical leaflets of major components and fittings.

xiv) As built drawings of schematics, wiring diagram etc.

xv) Setting of oil temperature indicator, winding temperature indicator.

xvi) Completed technical data sheets.

xvii) Details including write-up of tap changing gear.

xviii) HV & LV bushing.

xix) Bushing Assembly.

xx) Bi-metallic connector suitable for connection to 100 mm2 up to 232 mm2 AAAC Conductor.

xxi) GA of LV cable Box.

xxii) Radiator type assembly.

b) All drawings, documents, technical data sheets and test certificates, results calculations shall be furnished.

5.4 Any approval given to the detailed drawings by the Employer’s shall not relieve the contractor of the responsibility for correctness of the drawing and in the manufacture of the equipment. The approval given by the employer shall be general with overall responsibility with contractor.

6. **GENERAL CONSTRUCTIONAL FEATURES**

6.1 All material used shall be of best quality and of the class most suitable for working under the conditions specified and shall withstand the variations of temperature and atmospheric conditions without distortion or deterioration or the setting up of undue stresses which may impair suitability of the various parts for the work which they have to perform.
6.2 Similar parts particularly removable ones shall be interchangeable.

6.3 Pipes and pipe fittings, screws, studs, nuts and bolts used for external connections shall be as per the relevant standards. Steel bolts and nuts exposed to atmosphere shall be galvanized.

6.4 Nuts, bolts and pins used inside the transformers and tap changer compartments shall be provided with lock washer or locknuts.

6.5 Exposed parts shall not have pockets where water can collect.

6.6 Internal design of transformer shall ensure that air is not trapped in any location.

6.7 Material in contact with oil shall be such as not to contribute to the formation of acid in oil. Surface in contact with oil shall not be galvanized or cadmium plated.

6.8 Labels, indelibly marked, shall be provided for all identifiable accessories like Relays, switches, current transformers etc. All label plates shall be of in corrodible material.

6.9 All internal connections and fastenings shall be capable of operating under overloads and over-excitation, allowed as per specified stands without injury.

6.10 Transformer and accessories shall be designed to facilitate proper operation, inspection, maintenance and repairs.

6.11 No patching, plugging, shimming or other such means of overcoming defects, discrepancies or errors will be accepted.

6.12 Schematic Drawing of the wiring, including external cables shall be put under the prospane sheet on the inside door of the transformer marshalling box.

6.13 **Painting**

6.13.1 All paints shall be applied in accordance with the paint manufacturer’s recommendations. Particular attention shall be paid to the following:

a) Proper storage to avoid exposure as well as extremes of temperature.
b) Surface preparation prior to painting.
c) Mixing and thinning.
d) Application of paints and the recommended limit on time intervals between coats.
e) Shelf life for storage.

6.13.1.1 All paints, when applied in normal full coat, shall be free from runs, sags, wrinkles, patchiness, brush marks or other defects.

6.13.1.2 All primers shall be well marked into the surface, particularly in areas where painting is evident, and the first priming coat shall be applied as soon as possible after cleaning. The paint shall be applied by airless spray according to the manufacturer’s recommendations. However, wherever airless spray is not possible, conventional spray be used with prior approval of Employer.

6.13.1.3 The supplier shall, prior to painting protect nameplates, lettering gauges, sight glasses, light fittings and similar such items.

6.13.2 Cleaning and Surface Preparation

6.13.2.1 After all machining, forming and welding has been completed, all steel work surfaces shall be thoroughly cleaned of rust, scale, welding slag or spatter and other contamination prior to any painting.

6.13.2.2 Steel surfaces shall be prepared by Sand/Shot blast cleaning or Chemical cleaning by Seven tank process including Phosphate to the appropriate quality.

6.13.2.3 The pressure and Volume of the compressed air supply for the blast cleaning shall meet the work requirements and shall be sufficiently free from all water contamination prior to any painting.

6.13.2.4 Chipping, scraping and steel wire brushing using manual or power driven tools cannot remove firmly adherent mill-scale and shall only be used where blast cleaning is impractical.

6.13.3 Protective Coating As soon as all items have been cleaned and within four hours of the subsequent drying, they shall be given suitable anticorrosion protection.

6.13.4 Paint Material

Followings are the type of paints that may be suitably used for the items to be painted at shop and supply of matching paint to site:

i) Heat resistant paint (Hot oil proof) for inside surface.

ii) For external surfaces one coat of Thermo Setting Paint or 2 coats of Zinc chromate followed by 2 coats of POLYURETHANE. The color of the finishing coats shall be dark admiral grey conforming to No.632 or IS 5:1961.
6.13.5 Painting Procedure

6.13.5.1 All painting shall be carried out in conformity with both specifications and with the paint manufacture’s recommendations. All paints in any one particular system. Whether shop or site applied, shall originate from one paint manufacturer.

6.13.5.2 Particular attention shall be paid to the manufacture’s instructions on storage, mixing, thinning and pot life. The paint shall only be applied in the manner detailed by the manufacturer e.g. brush, roller, conventional or airless spray and shall be applied under the manufacturer’s recommended conditions. Minimum and maximum time intervals between coats shall be closely followed.

6.13.5.3 All prepared steel surfaces should be primed before visible re-rusting occurs or within 4 hours whichever is sooner. Chemical treated steel surfaces shall be primed as soon as the surface is dry and while the surface is warm.

6.13.5.4 Where the quality of film is impaired by excess film thickness, (wrinkling, mud cracking or general softness) the supplier shall remove the unsatisfactory paint coatings and apply another. As a general rule, dry film thickness should not exceed the specified minimum dry film thickness by more than 25%. In all instances, where two or more coats of the same paints are specifies, such coatings may or may not be of contrasting colors.

6.13.5.5 Paint applied to items that are not be painted, shall be removed at supplier’s expense, leaving the surface clean, un-stained and undamaged.

6.13.6 Damages to Paints Work

6.13.6.1 Any damage occurring to any part of the painting scheme shall be made good to the same standard of corrosion protection and appearance as that originally employed.

6.13.6.2 Any damaged paint work shall be made as follows:

a) The damaged area, together with an area extending 25mm around its boundary, shall be cleaned down to bare metal.

b) A priming coat shall immediately applied, followed by a full paint finish equal to that originally applied and extending 50mm around the perimeter of the originally damaged.

6.13.6.3 The repainted surface shall present a smooth surface. This shall be obtained by carefully chamfering the paint edges before & after priming.
6.13.7 **Dry Film Thickness**

6.13.7.1 To the maximum extent practicable, the coats shall be applied as a continuous film of uniform thickness and free of pores. Over-spray, skips, runs, sags and drips should be avoided. The different coats may or may not be same color.

6.13.7.2 Each coat of paint shall allowed to hardened before the next is applied as per manufacture’s recommendations.

6.13.7.3 Particular attention must be paid to full film thickness at edges.

6.13.7.4 The requirement for the dry film thickness (DFT) of paint and the material to be used shall be as given below:

<table>
<thead>
<tr>
<th>Sl.No</th>
<th>Paint Type</th>
<th>Area to be painted</th>
<th>No of Coats</th>
<th>Total Dry film thickness (Mic)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Liquid paint</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>a)</td>
<td>Zinc Chromate(Primer)</td>
<td>Out side</td>
<td>02</td>
<td>45 micron</td>
</tr>
<tr>
<td>b)</td>
<td>POLYURETHANE</td>
<td>Out side</td>
<td>02</td>
<td>35 micron</td>
</tr>
</tbody>
</table>

7.1 **DETAILED DESCRIPTION**

7.2 **Tank**

7.2.1 The Transformer tank and cover shall be fabricated from high grade low carbon plate steel of tested quality. The tank and the shall be of welded construction.

7.2.2 Tank shall be designed to permit lifting by crane or jacks of the complete transformer assembly filed with oil. Suitable lugs and bossed shall be provided for this purpose.

7.2.3 All breams, flanges, lifting lugs, braces and permanent parts attached to the tank shall be welded and where practicable, they shall be double welded.

7.2.4 The main tank body of the transformer, excluding tap changing compartments and radiators, shall be capable of withstanding pressure of 760mm of Hg.

7.2.5 Inspection hole(s) with welded flange(s) and bolted cover(s) shall be provided on the tank cover. The inspection hole(s) shall be of sufficient size to afford easy access to the lower ends of the bushings, terminals etc.
7.2.6 Gaskets of nitrile rubber or equivalent shall be used to ensure perfect oil tightness. All gaskets shall be closed design (without open ends) and shall be of one piece only. Rubber gaskets used for flange type connections of the various oil compartments, shall be laid in grooves or in groove-equivalent sections on bolt sides of the gasket, throughout their total length. Care shall be taken to secure uniformly distributed mechanical strength over the gaskets and retains throughout the total length. Gaskets of neoprene and / or any kind of impregnated / bonded core or cork only which can easily be damaged by over-pressing are not acceptable. Use of hemp as gasket material is also not acceptable.

7.2.7 Suitable guides shall be provided for positioning the various parts during assemble or dismantling. Adequate space shall be provided between the cores and windings and the bottom of the tank for collection of any sediment.

7.3 **Tank Cover**

The transformer top shall be provided with a detachable tank cover with bolted flanged gasket joint. Lifting lugs shall be provided for removing the cover. The surface of the cover shall be suitable sloped so that it does not retain rain water.

7.4 **UNDER CARRIAGE**

7.4.1 The transformer tank filled with oil shall be supported on steel structure with detachable plain rollers. Suitable channels for movement of roller with transformer shall be space accordingly, rollers wheels shall be provided with suitable rollers bearings, which will resist rust and corrosion and shall be equipped with fittings for lubrication.

7.5 **CORE**

7.5.1 Each lamination shall be insulated such that it will not deteriorate due to mechanical pressure and the action of hot transformer oil.

7.5.2 The core shall be constructed either from high grade, non-aging Cold Rolled Grain Oriented (CRGO) silicon steel laminations conforming to HIB grade with lamination thickness not more than 0.23mm to 0.27mm or better (Quoted grade and type shall be used). The maximum flux density in any part of the cores and yoke at normal voltage and frequency shall not be more than 1.69 Tesla. The Bidder shall provide saturation curve of the core material, proposed to be used. Laminations of different grade(s) and different thickness (s) are not allowed to be used in any
manner or under any circumstances.

CRGO steel for core shall be purchased only from the approved vendors, list of which is available at http://apps.powergridindia.com/ims/ComponentList/Power-former%20upto%20420%20kV-CM%20List.pdf

7.5.3 The bidder should offer the core for inspection starting from the destination port to enable Employer for deputing inspecting officers for detail verification as given below and approval by the Employer during the manufacturing stage. Bidder’s call notice for the purpose should be accompanied with the following documents as applicable as a proof towards use of prime core material: The core coils, if found suitable, are to be sealed with proper seals which shall be opened in presence of the inspecting officers during core- cutting at the manufacturer’s or it’s sub-vendor’s premises as per approved design drawing.

a) Purchase Order No. & Date.
b) Invoice of the supplier
c) Mills test certificate
d) Packing list
e) Bill of lading
f) Bill of entry certificate to customs

Core material shall be directly procured either from the manufacturer or through their accredited marketing organization of repute, but not through any agent.

Please refer to “Check-list for Inspection of Prime quality CRGO for Transformers” attached at Annexure-A. It is mandatory to follow the procedure given in this Annexure.

7.5.4 The laminations shall be free of all burrs and sharp projections. Each sheet shall have an insulting coating resistant to the action of hot oil.

7.5.5 The insulation structure for the core to bolts and core to clamp plates, shall be such as to withstand 2000 V DC voltage for one minute.

7.5.6 The completed core and coil shall be so assembled that the axis and the plane of the outer surface of the core assemble shall not deviate from the vertical plane by more than 25mm.

7.5.7 All steel sections used for supporting the core shall be thoroughly shot or sand blasted, after cutting, drilling and welding.

7.5.8 The finally assembled core with all the clamping structures shall be free from deformation and shall not vibrate during operation.
7.5.9 The core clamping structure shall be designed to minimize eddy current loss.

7.5.10 The framework and clamping arrangements shall be securely earthed.

7.5.11 The core shall be carefully assembled and rigidly clamped to ensure adequate mechanical strength.

7.5.12 Oil ducts shall be provided, where necessary, to ensure adequate cooling inside the core. The welding structure and major insulation shall not obstruct the free flow of oil through such ducts.

7.5.13 The design of magnetic circuit shall be such as to avoid static discharges, development of short circuit paths within itself or to the earth clamping structure and production of flux component at right angle to the plane of the lamination, which may cause local heating. The supporting framework of the cores shall be so designed as to avoid the presence of pockets, which would prevent complete emptying of the tank through the drain valve or cause trapping of air during filling.

7.5.14 The construction is to be of boltless core type. The core shall be provided with lugs suitable for lifting the complete core and coil assembly. The core and coil assemble shall be so fixed in the tank that shifting will not occur during transport or short circuits.

7.5.15 The temperature gradient between core & surrounding oil shall be maintained less than 20 deg. Centigrade. The manufacturer shall demonstrate this either through test (procurement to be mutually agreed) or by calculation.

7.6 INTERNAL EARTHING

7.6.1 All internal metal parts of the transformer, with the exception of individual laminations and their individual clamping plates shall be earthed.

7.6.2 The top clamping structure shall be connected to the tank by a copper strap. The bottom clamping structure shall be earthed by one or more the following methods:
   a) By connection through vertical tie-rods to the top structure.
   b) By direct metal to metal contact with the tank base.
   c) By a connection to the structure on the same side of the core as the main earth connection to the tank.

7.6.3 The magnetic circuit shall be connected to the clamping structure at one point only and this shall be
brought out of the top cover of the transformer tank through a suitably rated insulator. A disconnecting link shall be provided on transformer tank to facilitate disconnections from ground for IR measurement purpose.

7.6.4 Coil clamping rings of metal at earth potential shall be connected to the adjacent core clamping structure on the same side as the main earth connections.

7.7 **WINDING**

7.7.1 Winding shall be subjected to a shrinking and seasoning process, so that no further shrinkage occurs during service. Adjustable devices shall be provided for taking up possible shrinkage in service. 7.6.2 All low voltage windings for use in the circular coil concentric winding shall be wound on a performed insulating cylinder for mechanical protection of the winding in handling and placing around the core.

7.7.2 Winding shall not contain sharp bends which might damage the insulation or produce high dielectric stresses. No strip conductor wound on edge shall have width exceeding six times the thickness.

The conductors shall be of electrolytic grade copper free from scales and burrs. The conductor insulation shall be made from high-density (at least 0.75 gm/cc) paper having high mechanical strength. The barrier insulation including spacers shall be made from high-density pre-compressed pressboard (1.1 gm/cc minimum for load bearing and 1 to 1.3 gm/cc minimum for non-load bearing) to minimize dimensional changes.

7.7.3 Materials used in the insulation and assembly of the windings shall be insoluble, non catalytic and chemically inactive in the hot transformer oil and shall not soften or the otherwise affected under the operating conditions.

7.7.4 Winding and connections shall be braced to withstand shocks during transport or short circuit.

7.7.5 Permanent current carrying joints in the windings and leads shall be welded or brazed. Clamping bolts for current carrying parts inside oil shall be made of oil resistant material which shall not be affected by acidity in the oil steel bolts, if used, shall be suitably treated.

7.7.6 Terminals of all windings shall be brought out of the tank through bushings for external connections.

7.6.6.1 The completed core and coil assemble shall be dried in vacuum at not more than 0.5mm of mercury absolute pressure and shall be immediately impregnated with oil after the drying
process to ensure the elimination of air and moisture within the insulation. Vacuum may be applied in either vacuum over or in the transformer tank.

7.6.6.2 The winding shall be so designed that all coil assemblies of identical voltage ratings shall be interchangeable and field repairs to the winding can be made readily without special equipment. The coils shall have high dielectric strength.

7.6.6.3 Coils shall be made of continuous smooth high grade electrolytic copper conductor, shaped and braced to provide for expansion and contraction due to temperature changes.

7.6.6.4 Adequate barriers shall be provided between coils and core and between high and low voltage coil. End turn shall have additional protection against abnormal line disturbances.

7.6.6.5 The insulation of winding shall be designed to withstand voltage stress arising from surge in transmission lines due to atmospheric or transient conditions caused by switching etc.

7.6.6.6 Tapping shall not be brought out from inside the coil or from intermediate turns and shall be so arranged as to preserve as far as possible magnetic balance of transformer at all voltage ratios.

7.6.6.7 Magnitude of impulse surges transferred from HV to LV windings by electromagnetic induction and capacitance coupling shall be limited to BILL of LV winding.

7.7 **INSULATING OIL**

7.7.1 The insulating oil for the transformer shall be of EHV grade, generally conforming to IS: 335. No inhibitors shall be used in the oil.

7.7.2 The quantity of oil required for the first filling of the transformer and its full specification shall be stated in the bid. Transformer shall supplied complete with all fittings, accessories and new transformer oil required for first filling plus 10% extra oil. The extra quantity of oil shall be supplied in non-returnable drums along with the oil required for the radiator banks.

7.7.3 The design and materials used in the construction of the transformer shall be such as to reduce the risk of the development of acidity in the oil.

7.7.4 The oil parameters shall be as per Table-1 of IS 335.

7.8 **VALVES**
i) Valves shall be of forged carbon steel upto 50mm size and of gun mental or of cast iron bodies with gun metal fittings for sizes above 50mm. They shall be of full way type with screwed ends and shall be opened by turning counter clockwise when facing the hand wheel. There shall be no oil leakage when the valves are in closed position.

Each valve shall be provided with an indicator to show the open and closed positions and shall be provided with facility for padlocking in either open or closed position. All screwed valves shall be furnished with pipe plugs for protection. Padlocks with duplicate keys shall be supplied along with the valves.

ii) All valves except screwed valves shall be provided with flanges having machined faced drilled to suit the applicable requirements, Oil tight blanking plates shall be provided for each connection for use when any radiator is detached and for all valves opening to atmosphere. If any special radiator valve tools are required the contractor shall supply the same.

iii) Each transformer shall be provided with following valves on the tank:

a) Drain valve so located as to completely drain the tank & to be provided with locking arrangement.

b) Two filter valves on diagonally opposite corners of 50mm size & to be provided with locking arrangement.

c) Oil sampling valves not less than 8mm at top and bottom of main tank & to be provided with locking arrangement.

d) One 15mm air release plug.

e) Valves between radiators and tank. Drain and filter valves shall be suitable for applying vacuum as specified in the specifications.

7.9 ACCESSORIES

7.9.1 Bushing

i) All porcelain used in bushings shall be homogeneous, non-porous, uniformly glazed to brown colour and free from blisters, burns and other defects.

ii) Stress due to expansion and contraction in any part of the bushing shall not lead to deterioration.
iii) Bushing shall be designed and tested to comply with the applicable standards.

iv) Bushing rated for 400A and above shall have non-ferrous flanges and hardware.

v) Fittings made of steel or malleable iron shall be galvanized

vi) Bushing shall be so located on the transformers that full flashover strength will be utilized. Minimum clearances as required for the BIL shall be realized between live parts and live parts to earthed structures.

vii) All applicable routine and type tests certificates of the bushings shall be furnished for approval.

viii) Bushing shall be supplied with bi-metallic terminal connector/ clamp/ washers suitable for fixing to bushing terminal and the Employers specified conductors. The connector/clamp shall be rated to carry the bushing rated current without exceeding a temperature rise of 550 °C over an ambient of 500 °C. The connector/clamp shall be designed to be corona free at the maximum rated line to ground voltage.

ix) Bushing of identical voltage rating shall be interchangeable.

x) The insulation class of high voltage neutral bushing shall be properly coordinated with the insulation class of the neutral of the low voltage winding.

xi) Each bushing shall be so coordinated with the transformer insulation that all flashover will occur outside the tank.

xii) The extended bushing bus bars shall be used for termination of 11 KV cables. LV busing shall be housed in completely sealed metallic enclosure.

xiii) Sheet steel, weather, vermin and dust proof cable box fitted with required glands, locks, glass door, terminal Board, heater with switch, illumination lamp with switch, water-tight hinged and padlocked door of a suitable construction shall be provided with each transformer to accommodate 11 KV cables etc. The box shall have slopping roof and the interior and exterior painting shall be in accordance with the specification. Padlock along with duplicate keys shall be supplied for marshaling box. The degree of protection shall be IP-55 or better. To prevent internal condensation, a metal clad heater with thermostat shall be provided. The heater shall be controlled by a MCB of suitable rating mounted in the box. The ventilation louvers, suitably padded with felt, shall also be provided. The louvers shall be provided with suitable felt pads to prevent ingress of dust. All incoming cables shall enter the kiosk from the bottom and the
minimum 4mm thick, non-magnetic, gland plate shall not be less than 600 mm from the base of the box. The gland plate and associated compartment shall be sealed in suitable manner to prevent the ingress of moisture from the cable trench – for those transformers which are used in partly indoor substation, If required as per BOQ, a cable box for LV bushings shall be provided.

7.9.2 Protection & Measuring Devices

i) Oil Conservator Tank

a) The Conservator tank shall have adequate capacity between highest and lowest visible levels to meet the requirement of expansion of the total cold oil volume in the transformer and cooling equipment.

b) The conservator tank shall be bolted into position so that it can be remove for cleaning purposes.

c) The conservator shall be fitted with magnetic oil level gauge with low level electrically insulated alarm contact.

d) Plain conservator fitted with silica gel breather.

ii) Pressure Relief Device.

The pressure relief device provided shall be of sufficient size for rapid release of any pressure that may be generated in the tank and which may result in damage of the equipment. The device shall operate at a static pressure of less than the hydraulic test pressure of transformer tank. It shall be mounted direct on the tank. A pair of electrically insulated contract shall be provided for alarm and tripping.

iii) Buchholz Relay

A double float type Buchholz relay shall be provided. Any gas evolved in the transformer shall collect in this relay. The relay shall be provided with a test cock suitable for a flexible pipe connection for checking its operation. A copper tube shall be connected from the gas collector to a valve located about 1200 mm above ground level to facilitate sampling with the transformer in service. The device shall be provided with two electrically independent potential free contracts, one for alarm on gas accumulation and the other for tripping on sudden rise of pressure.
iv) **Temperature Indicator**

a) **Oil Temperature Indicator (OTI)**

The transformers shall be provided with a micro switch contact type thermometer with 150 mm dial for top oil temperature indication. The thermometer shall have adjustable, electrically independent potential free alarm and trip contacts. Maximum reading pointer and resetting device shall be mounted in the local control panel. A temperature sensing element suitably located in a pocket on top oil shall be furnished. This shall be connected to the OTI by means of capillary tubing. Accuracy class of OTI shall be ± 1% or better. One No electrical contact capable of operating at 5 A ac at 230 volt supply.

b) **Winding Temperature Indicator (WTI)**

A device for measuring the hot spot temperature of the winding shall be provided. It shall comprise the following.

i) Temperature sensing element.

ii) Image Coil.

iii) Micro switch contacts.

iv) Auxiliary CTS, If required to match the image coil, shall be furnished and mounted in the local control panel.

v) 150mm dial local indicating instrument with maximum reading pointer mounted in local panel and with adjustable electrically independent ungrounded contacts, besides that required for control of cooling equipment, one for high winding temperature alarm and on for trip.

vi) Two number electrical contact each capable of operating at 5 A ac at 230 Volt supply.

7.9.3 **Oil Preservation Equipment**

7.9.3.1 **Oil Sealing**

The oil preservation shall be diaphragm type oil sealing in conservator to prevent oxidation and contamination of oil due to contact with atmospheric moisture.
The conservator shall be fitted with a dehydrating filter breather. It shall be so designed that.

i) Passage of air is through a dust filter & Silica gel.

ii) Silica gel is isolate from atmosphere by an oil seal.

iii) Moisture absorption indicated by a change in colour of the crystals of the silica gel can be easily observed from a distance.

iv) Breather is mounted not more than 1400 mm above rail top level.

7.10 MARSHALLING BOX

i) Sheet steel, weather, vermin and dust proof marshaling box fitted with required glands, locks, glass door, terminal Board, heater with switch, illumination lamp with switch, water- tight hinged and padlocked door of a suitable construction shall be provided with each transformer to accommodate temperature indicators, terminal blocks etc. The box shall have slopping roof and the interior and exterior painting shall be in accordance with the specification. Padlock along with duplicate keys shall be supplied for marshaling box. The degree of protection shall be IP-55 or better.

ii) The schematic diagram of the circuitry inside the marshaling box be prepared and fixed inside the door under a propone sheet.

iii) The marshaling box shall accommodate the following equipment:

a) Temperature indicators.

b) Space for accommodating Control & Protection equipment in future for the cooling fan (for ONAF type cooling, may be provided in future).

c) Terminal blocks and gland plates for incoming and outgoing cables.

All the above equipment except c) shall be mounted on panels and back of panel wiring shall be used for inter-connection. The temperature indicators shall be so mounted that the dials are not more than 1600 mm from the ground level and the door (s) of the compartment(s) shall be provided with glazed window of adequate size. The transformer shall be erected on a plinth which shall be 2.5 feet above ground level.
iv) To prevent internal condensation, a metal clad heater with thermostat shall be provided. The heater shall be controlled by a MCB of suitable rating mounted in the box. The ventilation louvers, suitably padded with felt, shall also be provided. The louvers shall be provided with suitable felt pads to prevent ingress of dust.

v) All incoming cables shall enter the kiosk from the bottom and the gland plate shall not be less than 450 mm from the base of the box. The gland plate and associated compartment shall be sealed in suitable manner to prevent the ingress of moisture from the cable trench.

7.11 TAPCHANGER

7.11.1 ON-LOAD TAP-CHANGERS

i) The 3.15/5/6.3/8/10/12.5 MVA transformers shall be provided with On-load Taps. Specification of OLTC is attached herewith as Annexure.

ii) The Transformer with off-load tap changing gear shall have taps ranging from +5% to -15% in 9 equal steps of 2.5% each for Off Load Tap.

iii) The tap changing switch shall be located in a convenient position so that it can be operated from ground level. The switch handle shall be provided with locking arrangement along with tap position indication, thus enabling the switch to be locked in position.

7.12 FITTINGS AND ACCESSORIES

The following fittings and accessories shall be provided on the transformers:

i) Conservator with isolating valves, oil filling hole with cap and drain valve. The conservator vessel shall be filled with constant oil pressure diaphragm oil sealing system.

ii) Magnetic type oil level gauge (150 mm dia) with low oil level alarm contacts.

iii) Prismatic/ toughened glass oil level gauge.

iv) Silica gel breather with oil seal and connecting pipe complete with first fill of activated silica gel or Alumina mounted at a level of 1300 mm above ground level.

v) A double float type Buchholz relay with isolating valve. Bleeding pipe and a testing cock, the test cock shall be suitable for a flexible (pipe connection for checking its operation). A 5mm dia.
Copper pipe shall be connected from the relay test cock to a valve located at a suitable height above ground level to facilitate sampling of gas with the transformer in service. Interconnection between gas collection box and relay shall also be provided. The device shall be provided with two electrically independent ungrounded contacts, one for alarm on gas accumulation and the other for tripping on sudden oil surge. These contacts shall be wired upto transformer marshaling box. The relay shall be provided with shut off valve on the conservator side as well as on the tank side.

vi) Pressure relief devices (including pressure relief valve) and necessary air equalizer connection between this and the conservator with necessary alarm and trip contacts.

vii) Air release plugs in the top cover.

viii) Inspection cover, access holes with bolted covers for access to inner ends of bushing etc.

ix) Winding temperature (hot spot) indicating device for local mounting complete in all respects. Winding temperature indicator shall have two set of contacts to operate at different settings:

a) To provide winding temperature high alarm

b) To provide temperature too high trip

x) Dial thermometer with pocket for oil temperature indicator with one set of alarm and one set of trip contacts and maximum reading pointer.

xi) Lifting eyes or lugs for the top cover, core and coils and for the complete transformer.

xii) Jacking pads

xiii) Haulage lugs.

xiv) Protected type mercury / alcohol in glass thermometer and a pocket to house the same.

xv) Top and bottom filter valves on diagonally opposite ends with pad locking arrangement on both valves.

xvi) Top and bottom sampling valves.

xvii) Drain valve with pad locking arrangement
xviii) Rating and connection diagram plate.

xix) Two numbers tank earthing terminals with associated nuts and bolts for connections to Employer’s grounding strip.

xx) Marshaling Box (MB)

xxi) Shut off valve on both sides of flexible pipe connections between radiator bank and transformer tank.

xxii) Cooling Accessories:

   a) Requisite number of radiators provided with :-

      - One shut off valve on top

      - One shut off valve at bottom

      - Air release device on top

      - Drain and sampling device at bottom

      - Lifting lugs.

   b) Air release device and oil drain plug on oil pipe connectors:

xxiii) Terminal marking plates for Current Transformer and Main Transformer

xxiv) On/Off Load Tap changer as per BOQ

xxv) Oil Preservation Equipment

xxvi) Oil Temperature indicator

xxvii) Transformer shall be supplied with all control cable, WTI & OTI, sensing cable, glands, lugs etc (complete control).
New Initiative on Material Mobilisation
Report of Committee A

**Note:**

1. The fittings listed above are indicative and any other fittings which are generally required for satisfactory operation of the transformer are deemed to be included in the quoted price of the transformer.

2. The contacts of various devices required for alarm and trip shall be potential free and shall be adequately rated for continuous, making and breaking current duties as specified.

**7.13 CONTROL CONNECTIONS AND INSTRUMENT AND WIRING TERMINAL BOARD AND FUSES**

i) Normally no fuses shall be used anywhere instead of fuses MCB's (both in AC & DC circuits) shall be used. Only in cases where a MCB cannot replace a fuse due to system requirements, a HRC fuse can be accepted.

ii) All wiring connections, terminal boards, fuses MCB's and links shall be suitable for tropical atmosphere. Any wiring liable to be in contact with oil shall have oil resisting insulation and the bare ends of stranded wire shall be sweated together to prevent seepage of oil along the wire.

iii) Panel connections shall be neatly and squarely fixed to the panel. All instruments and panel wiring shall be run in PVC or non-rusting metal cleats of the compression type. All wiring to a panel shall be taken from suitable terminal boards.

iv) Where conduits are used, the runs shall be laid with suitable falls, and the lowest parts of the run shall be external to the boxes. All conduit runs shall be adequately drained and ventilated. Conduits shall not be run at or below ground level.

v) When 400 volt connections are taken through junction boxes or marshaling boxes, they shall be adequately screened and 400 volts Danger Notice must be affixed to the outside of the junction boxes or marshaling box. Proper colour code for Red, Yellow, Blue wires shall be followed.

vi) All box wiring shall be in accordance with relevant ISS. All wiring shall be of stranded copper (48 strands) of 1100 Volt grade and size not less than 2.5 sq.mm

vii) All wires on panels and all multi-core cables shall have ferrules, for easy identifications, which bear the same number at both ends, as indicated in the relevant drawing.
viii) At those points of interconnection between the wiring carried out by separate contractors, where a change of number cannot be avoided double ferrules shall be provided on each wire. The change of numbering shall be shown on the appropriate diagram of the equipment.

ix) The same ferrule number shall not be used on wires in different circuits on the same panels.

x) Ferrules shall be of white insulating material and shall be provided with glossy finish to prevent the adhesion of dirt. They shall be clearly and durably marked in black and shall not be affected by dampness or oil.

xi) Stranded wires shall be terminated with tinned Ross Courtney terminals, claw washers or crimped tubular lugs. Separate washers shall be suited to the size of the wire terminated. Wiring shall, in general, be accommodated on the sides of the box and the wires for each circuit shall be separately grouped. Back of panel wiring shall be arranged so that access to the connecting items of relays and other apparatus is not impeded.

xii) All circuits in which the voltage exceeds 125 volts, shall be kept physically separated from the remaining wiring. The function of each circuit shall be marked on the associated terminal boards.

xiii) Where apparatus is mounted on panels, all metal cases shall be separately earthed by means of stranded (48 No.) copper wire of strip having a cross section of not less than 2 sq. mm where strip is used, the joints shall be sweated. The copper wire shall have green coloured insulation for earth connections.

xiv) All wiring diagram for control and relay panel shall preferably be drawn as viewed from the back and shall show the terminal boards arranged as in services.

xv) Terminal block rows should be spaced adequately not less than 100 mm apart to permit convenient access to external cables and terminations.

xvi) Terminal blocks shall be placed with respect to the cable gland (at a minimum distance of 200 mm) as to permit satisfactory arrangement of multicore cable tails.

xvii) Terminal blocks shall have pairs of terminals for incoming and outgoing wires. Insulating barriers shall be provided between adjacent connections. The height of the barriers and the spacing between terminals shall be such as to give adequate protection while allowing easy access to terminals. The terminals shall be adequately protected with insulating dust proof covers. No live metal shall be exposed at the back of the terminal boards. CT terminals shall have shorting
facilities. The terminals for CTs should have provision to insert banana plugs and with isolating links.

xviii) All interconnecting wiring, as per the final approved scheme between accessories of transformer and marshaling box is included in the scope of this specification and shall be done by the Transformer supplier.

xix) The schematic diagram shall be drawn and fixed under a transparent prospane sheet on the inner side of the marshaling box cover.

xx) To avoid condensation in the Marshaling Box, a space heater shall be provided with an MCB and thermostat.

xxi) Suitable MV, CFL light shall be provided in the Marshaling Box for lightning purpose.

\ 7.14 RADIO INTERFERENCE AND NOISE LEVEL

Transformers shall be designed with particular care to suppress at least the third and fifth harmonic voltages so as to minimize interference with communication circuits. Transformer noise level when energized at normal voltage and frequency shall be as per NEMA stipulations.

8 INSPECTION AND TESTING

(i) The Contractor shall carry out a comprehensive inspection and testing programme during manufacture of the transformer. This is, however, not intended to form a comprehensive programme as it is contractor’s responsibility to draw up and carry out such a programme duly approved by the Employer.

(ii) Transformer of each rating will be as per pre-type tested design.

(iii) The pre-shipment checks shall also be carried out by the contractor.

(iv) The requirements on site tests are as listed in the specifications.

(v) Certified test report and oscillograms shall be furnished to the Employer Consultants for evaluation as per the schedule of distribution of documents. The Contractor shall also evaluate the test results and rectify the defects in the equipment based on his and the Employers evaluations of the tests without any extra charges to the Employer. Manufacturer’s Test
Certificates in respect of all associated auxiliary and ancillary equipment shall be furnished.

(vi) The bidder shall state in his proposal the testing facilities available at his works. In case full testing facilities are not available, the bidder shall state the method proposed to be adopted so as to ascertain the transformer characteristics corresponding to full capacity.

8.1 INSPECTION

Transformers not manufactured as per Type-Tested design shall be rejected.

i) Tank and Conservator

a) Inspection of major weld.

b) Crack detection of major strength weld seams by dye penetration test.

and further dimensional check.

d) Leakage test of the conservator.

ii) Core

a) Sample testing of core materials for checking specific loss, properties, magnetization characteristics and thickness.

b) Check on the quality of varnish if used on the stampings.

c) Check on the amount of burrs.

d) Visual and dimensional check during assembly stage.

e) Check on completed core for measurement of iron loss, determination of maximum flux density,

f) Visual and dimensional checks for straightness and roundness of core, thickness of limbs and suitability of clamps.

g) High voltage DC test (2 KV for one minute) between core and clamps.

Please refer to “Check-list for Inspection of Prime quality CRGO for Transformers” attached at Annexure-A. It is mandatory to follow the procedure given in this Annexure.

iii) Insulating Material

a) Sample check for physical properties of materials.
b) Check for dielectric strength

c) Check for the reaction of hot oil on insulating materials.

iv) Winding

   a) Sample check on winding conductor for mechanical and electrical conductivity.

   b) Visual and dimensional checks on conductor for scratches, dent mark etc.

   c) Sample check on insulating paper for PH value, electric strength.

   d) Check for the bonding of the insulating paper with conductor.

   e) Check and ensure that physical condition of all materials taken for windings is satisfactory and free of dust.

   f) Check for absence of short circuit between parallel strands.

v) Checks Before Drying Process

   a) Check condition of insulation on the conductor and between the windings.

   b) Check insulation distance between high voltage connections, between high voltage connection cables and earth and other live parts.

   c) Check insulating distances between low voltage connections and earth and other parts.

   d) Insulating test for core earthing.

vi) Check During Drying Process


   b) Check for completeness of drying

vii) Assembled Transformer
a) Check completed transformer against approved outline drawing, provision for all fittings, finish level etc.

b) Jacking test on the assembled Transformer.

viii) Oil All standard tests in accordance with IS: 335 shall be carried out on Transformer oil sample before filling in the transformer.

ix) Test Report for bought out items The contractor shall submit the test reports for all bought out / sub contracted items for approval.

a) Buchholz relay

b) Sudden pressure rise relay on Main Tank

c) Winding temperature indicators (for TX capacity 5 MVA )

d) Oil temperature indicators

e) Bushings

f) Bushing current transformers in neutral (If Provided)

g) Marshaling box

h) On/Off Load Tap changer as per BOQ

i) Any other item required to complete the works.

j) Porcelain, bushings, bushing current transformers, wherever provided, winding coolers, control devices, insulating oil and other associated equipment shall be tested by the contractor in accordance with relevant IS . If such requirement is purchased by the contractor on a sub-contract, he shall have them tested to comply with these requirements.

8.2 FACTORY TESTS
i) All standards routine tests in accordance IS: 2026 with dielectric tests corresponding as per latest amendments to IS: 2026 shall be carried out.

ii) All auxiliary equipment shall be tested as per the relevant IS. Test certificates shall be submitted for bought out items.

iii) High voltage withstand test shall be performed on auxiliary equipment and wiring after complete assembly.

iv) Following additional routine tests shall also be carried out on each transformer:

a) Magnetic Circuit Test Each core shall be tested for 1 minute at 2000 Volt AC

b) Oil leakage test on transformer

8.2.1 Type Test

8.2.1.1 The measurements and tests should be carried out in accordance with the standard specified in each case as indicated in the following table if the same tests were not conducted earlier at CPRI or any NABL accredited Laboratory on the transformers of the offered design without any cost implication on employer.

<table>
<thead>
<tr>
<th>Type Test Standard</th>
<th>Standard</th>
</tr>
</thead>
<tbody>
<tr>
<td>Temperature Rise Test</td>
<td>IEC 76/IS 2026/IS 6000</td>
</tr>
<tr>
<td>Impulse Voltage Withstand Test, including Full Waves and Chopped Waves as listed below</td>
<td>IEC 76/IS 2026</td>
</tr>
<tr>
<td>Noise Level Measurement</td>
<td>IEC 551</td>
</tr>
</tbody>
</table>

In accordance with IEC 76-3 the following sequence of impulses should have been/should be applied;

- One full wave at 50% BIL;
- One full wave at 100% BIL;
- One chopped wave at 50% BIL
- Two chopped waves at 100% BIL and
- Two full waves at 100% BIL.

8.2.1.2 If the type test report(s) submitted by the bidder do not fulfill the criteria, as stipulated in this technical specification/ Bidder’s offer, the relevant type test(s) has/ have to be
conducted by the Bidder at his own cost in CPRI/ NABL accredited laboratory in the presence of employers representative(s) without any financial liability to employer in the event of order placed on him.

8.2.1.3 The offered transformer must be manufactured as per type tested design. A copy of type test certificate must be submitted by manufacturer to Engineer/Employer. Transformers offered without type tested however design shall not be accepted. In case manufacturer agrees for type testing of transformers, testing shall be conducted on manufacturer’s cost. No claim shall be acceptable towards type testing. The transformers shall be accepted only on acceptance of type testing results by employer.

8.2.1.4 The supplier shall furnish calculations in accordance with IS: 2026 to demonstrate the Thermal ability of the transformers to withstand Short Circuit forces.

8.2.1(A) Special Test

The short circuit test shall be a mandatory test for each design shall be supplied by the manufacturer and no exception shall be allowed. The test shall be conducted as per latest standard tabled below:

<table>
<thead>
<tr>
<th>Short Circuit Test</th>
<th>IEC 76 / IS 2026</th>
</tr>
</thead>
</table>

8.2.2 STAGE INSPECTION

The supplier shall offer the core, windings and tank of each transformer for inspection by the Employers representative(s). During stage Inspection, all the measurements like diameter, window height, leg Centre, stack width, stack thickness, thickness of laminations etc. for core assembly, conductor size, Insulation thickness, I.D., O.D, winding height, major and minor insulations for both H.V and L.V windings, length, breadth, height and thickness of plates of Transformer tank, the quality of fittings and accessories will be taken / determined. The supplier can offer for final inspection of the transformers subject to clearance of the stage Inspection report by the Employer.

8.2.3 Routine Tests

Transformer routine tests shall include tests stated in latest issue of IS: 2026 (Part –1). These tests shall also include but shall not be limited to the following:

(i) Measurement of winding DC resistance.
(ii) Voltage ratio on each tapping and check of voltage vector relationship.

(iii) Impedance voltage at all tappings.

(iv) Magnetic circuit test as per relevant ISS or CBIP manual or latest standard being followed.

(v) Measurement of Load losses at normal tap and extreme taps.

(vi) No load losses and no load current at rated voltage and rated frequency, also at 25% to 120% of rated voltage in steps.

(vii) Absorption index i.e insulation resistance for 15 seconds and 60 seconds (R 60/R 15) and polarization index i.e Insulation Resistance for 10 minutes and one minute (R 10 mt/R 1 mt).

(viii) Induced over voltage withstand test.

(ix) Separate source voltage withstand test.

(x) Tan delta measurement and capacitance of each winding to earth (with all other windings earthed) & between all windings connected together to earth.

(xi) Measurement of zero sequence impedance

(xii) Tests on On/Off Load Tap changer as per BOQ (fully assembled on transformer) as per IS 2026

(xiii) Auxiliary circuit tests

(xiv) Oil BDV tests

(xv) Measurement of neutral unbalance current which shall not exceed 2% of the full rated current of the transformer.

(xvi) Magnetic balance test

(xvii) Leakage test.
Six (6) set of certified test reports and oscillographs shall be submitted for evaluation prior to dispatch of the equipment. The contractor shall also evaluate the test results and shall correct any defect indicated by his and Employers evaluation of the tests without charge to the Employer.

8.4 TANK TESTS

a) Oil leakage Test:

The tank and oil filled compartments shall be tested for oil tightness completely filled with air or oil of viscosity not greater than that of insulating oil conforming to IS : 335 at the ambient temperature and applying a pressure equal to the normal pressure plus 35 KN/ m2 measured at the base of the tank. The pressure shall be maintained for a period of not less than 12 hours of oil and one hour for air and during that time no leak shall occur.

b) Pressure Test

Where required by the Employer, one transformer tank of each size together with its radiator, conservator vessel and other fittings shall be subjected to a pressure corresponding to twice the normal head of oil or to the normal pressure plus 35 KN/ m2 whichever is lower, measured at the base of the tank and maintained for one hour.

c) Vacuum Test

One transformer tank of each size shall be subjected to the vacuum pressure of 60 mm of mercury. The tanks designed for full vacuum shall be tested at an internal pressure of 3.33 KN/m2 (25 mm of mercury) for one hour. The permanent deflection of flat plates after the vacuum has been released shall not exceed the value specified in C.B.I.P. Manual on Transformers (Revised 1999) without affecting the performance of the transformer.

8.5 PRE-SHIPMENT CHECK AT MANUFACTURERS WORKS

i) Check for proper packing and preservation of accessories like radiators, bushings, explosions vent, dehydrating breather, rollers, buchholz relay, control cubicle connecting pipes and conservator etc.

ii) Check for proper provision of bracing to arrest the movement of core and winding assembly inside the tank.
iii) Gas tightness test to conform tightness.

8.6 INSPECTION AND TESTING AT SITE

On receipt of transformer at site, shall be performed detailed inspection covering areas right from the receipt of material up to commissioning stage. An indicative program of inspection as envisaged by the Engineer is given below.

8.6.1 Receipt and Storage Checks

i) Check and record conditions of each package visible parts of the transformers etc for any damage.

ii) Check and record the gas pressure in the transformer tank as well as in the gas cylinder.

iii) Visual check of core and coils before filling up with oil and also check condition of core and winding in general.

8.6.2 Installation Checks

i) Inspection and performance testing of accessories like tap changers etc.

ii) Check choking of the tubes of radiators

iii) Test on oil samples taken from main tank top and bottom and cooling system. Samples should be taken only after the oil has been allowed to settle for 24 hours.

iv) Check the whole assembly for tightness, general appearance etc.

v) Oil leakage tests.

8.6.3 Pre-Commissioning Tests
After the transformer is installed, the following pre-commissioning tests and checks shall be done before putting the transformer in service.

i) Megger Test

ii) Phase relationship test (Vector group test)

iii) Buchholz relay alarm & surge operation test (Physical)

iv) Ratio test on all taps

v) Low oil level (in conservator) alarm

vi) Temperature Indicators (Physical)

vii) Marshaling kiosk (Physical)

8.6.4 The following additional checks shall be made:

i) All oil valves are incorrect position closed or opened as required

ii) All air pocket are cleared.

iii) Thermometer pockets are filled with oil

iv) Oil is at correct level in the bushing, conservator, diverter switch & tank etc.

v) Earthing connections are made.

vi) Bushing arcing horn is set correctly and gap distance is recorded.

vii) C T polarity and ratio is correct.

8.7 PERFORMANCE

The performance of the transformer shall be measured on the following aspects.

i) The transformer shall be capable of being operated without danger on any tapping at the rated KVA with voltage variations and ± 10% corresponding to the voltage of the tapping

ii) Radio interference and Noise Level
iii) The transformer shall be designed with particular attention to the suppression of third and fifth harmonics so as to minimize interference with communication circuits.

8.8 FAULT CONDITIONS

a) The transformer shall be capable of withstanding for two(2) seconds without damages any external short circuit to earth

b) Transformer shall be capable of withstanding thermal and mechanical stresses conveyed by symmetrical or asymmetrical faults on any winding. This shall be demonstrated through calculation as per IS : 2026.

c) Transformer shall accept, without injurious heating, combined voltage and frequency fluctuation which produce the 125% over fluxing condition for one minute and 140% for 5 seconds.

8.9 WITNESSING OF TESTS AND EXCESSIVE LOSSES

i) The Employer reserves the right to reject the Transformer if losses exceed the maximum specified as per Clause No 2. SPECIFIC TECHNICAL REQUIREMENTS (STANDARD CONDITIONS), item-35 of this specification or if temperature rise of oil and winding exceed the values specified at item -26 of the above clause.

9 LIQUIDATED DAMAGES FOR EXCESSIVE LOSSES

There is no positive tolerance on the guaranteed losses offered by the bidder. However, the transformer(s) shall be rejected out rightly, if any of the losses i.e. no load loss or load loss or both exceed (s) the guaranteed maximum permissible loss figures quoted by the bidder in the Technical Data Schedule with the bid.

10 SPARE PARTS

In case the manufacturer goes out of production of spare parts, then he shall make available the drawings of spare parts and specification of materials at no extra cost to the Employer to fabricate or procure spare parts from other sources.
Mandatory Spare Parts

The suppliers shall provide the following mandatory spare parts for each of Transformer supplied
1. H.V. & L.V. Bushing & Studs – Each 2 Nos
2. Bimetallic connector for H.V & L.V. Bushings – Each 2 sets

10.1 INSTRUCTION MANUAL

Eight sets of the instruction manuals shall be supplied at least four (4) weeks before the actual dispatch of equipment. The manuals shall be in bound volumes and shall contain all the drawings and information required for erection, operation and maintenance of the transformer. The manuals shall include amongst other, the following particular:

a) Marked erection prints identifying the components, parts of the transformer as dispatched with assembly drawings.

b) Detailed dimensions, assembly and description of all auxiliaries.

c) Detailed views of the core and winding assembly, winding connections and tapings tap changer construction etc. These drawings are required for carrying out overhauling operation at site.

d) Salient technical particulars of the transformer.

e) Copies of all final approved drawings.

f) Detailed O&M instructions with periodical check lists and Performa etc.

10.2 COMPLETENESS OF EQUIPMENT

All fittings and accessories, which may not be specifically mentioned in the specification but which are necessary for the satisfactory operation of the transformer, shall be deemed to be included in the specification and shall be furnished by the supplier without extra charges. The equipment shall be complete in all details whether such details are mentioned in the specification or not, without any financial liability to the Employer under any circumstances.

11.0 COMMISSIONING

The utility will give a 10 days’ notice to the supplier of transformer before commissioning. The manufacturer will depute his representative to supervise the commissioning. In case, the manufacturer fails to depute his representative, the utility will go ahead with the commissioning
and under these circumstances, it would be deemed that commissioning is done as per recommendations of manufacturer.

12.0 GUARANTEE

The manufacturers of the transformer shall provide a guarantee of 60 months from the date of receipt of transformer at the stores of the Utility. In case the transformer fails within the guarantee period, the supplier will depute his representative within 15 days from date of intimation by the utility for joint inspection. In case, the failure is due to the reasons attributed to supplier, the transformer will be replaced/repaired by the supplier within 2 months from the date of joint inspection.

Annexure-B

Methodology for computing total owning cost for Power Transformer

\[
\text{TOC} = \text{IC} + (A \times \text{Wi}) + (B \times \text{Wc}) ; \text{ Losses in KW}
\]

Where,

<table>
<thead>
<tr>
<th>Term</th>
<th>Description</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>TOC</td>
<td>Total Owning Cost</td>
<td></td>
</tr>
<tr>
<td>IC</td>
<td>Initial cost including taxes of transformer as quoted by the manufacturer</td>
<td></td>
</tr>
<tr>
<td>A factor</td>
<td>Cost of no load losses in Rs/KW</td>
<td>(A = 33447)</td>
</tr>
<tr>
<td>B factor</td>
<td>Cost of load losses in Rs/KW</td>
<td>(B = 151616)</td>
</tr>
<tr>
<td>Wi</td>
<td>No load losses quoted by the manufacturer in KW</td>
<td></td>
</tr>
<tr>
<td>Wc</td>
<td>Load losses quoted by the manufacturer in KW</td>
<td></td>
</tr>
</tbody>
</table>
ON LOAD TAP CHANGER FOR 33/11KV POWER TRANSFORMER

The tapping range of On Load Tap Changer shall be +5% to -15% in steps of 1.25% each. The no of taps shall be 17. The On Load Tap Changer shall be supplied with RTCC panel and AVR (Automatic Voltage Regulating Relay).

The Continuous current rating of the tap changer shall be based on connected winding rating and shall have liberal and ample margin. Lower rated tap changers connected in parallel are not acceptable.

The on-load tap changing equipment shall have the provision for mechanical and electrical control from a local position and electrical control from a remote position. For local mechanical operation, the operating handle shall be brought outside the tank for operation from floor level with provision to lock the handle in each tap position. Remote electrical operation shall have an AUTO-MANUAL selection at the remote location. When selected AUTO, the tap changing gear shall maintain steady voltage within practical limit on the transformers secondary bus from which the reference shall not respond to transient variation of voltage due to grid disturbance and system fault.

The required voltage relay shall not be sensitive to frequency variation and shall be suitable for sensing voltage from the secondary of potential transformers mounted on the 66KV, 33KV, or 11KV bus.

The tap changer shall be provided with over-current protection in order to prevent the tap-change operation during a short circuit, which would greatly stress the contacts of the diverter switch. The function of protection shall be arranged as follows;

(i) Whenever over current occurs, the control circuit for commanding OLTC motor operation shall be blocked by the normally close contacts of the over current relays.

(ii) If during tap change over current occurs, the OLTC motor circuit shall be blocked through the mechanical cam switch, which is close from the very beginning to the very end of every tap change operation and to the normally open contacts of the over current relays. The stop action of the motor shall be made through the motor brake contactor.

The design of the tap changing equipment shall be such that the mechanism will not stop in any intermediate position; however, if the mechanism through faulty operation does stop in an intermediate position, the full load must be carried by the transformer without injury to the equipment. The mechanical position indicator shall be equipped in the motor drive cubicle. The motor shall be designed to be of step control. In any case the operation shall be of step by step.

The voltage regulating relay shall be supplied together with the timer and under voltage relay. The signal order from the voltage regulating relay to execute the tap changer operation, when the regulating voltage is out of the voltage regulating level shall be designed to be delayed by the adjustable timer. If the control voltage abnormally falls, the movement of the tap changer shall be locked by the contact of the under voltage relay, even if the contacts of the voltage regulating relay are working.
The control circuit of the transformer shall be completely designed and provisions shall be made for parallel operation with another transformer.

The following accessories, control and selector switches and other necessary accessories shall be furnished.

Remote tap changer control board
(Placed in the control room)
- Voltmeter
- “AUTO-MANUAL” control switch
- “RAISE-LOWER” control switch
- Tap position indicator
- Tap changer operation program indicator.

Transformer Tap Changer driving mechanism control cubicle
- “REMOTE-LOCAL-TEST” selector switch
- “AUTOMATIC-MANUAL” control switch
- “RAISE-LOWER” control switch
- Tap position indicator
- Tap changer operation program indicator
- Voltmeter
- Tap change operation counter
- Means for manual operation when power supply is lost

Annexure - A

Check-list for Inspection of Prime quality CRGO for Transformers
During inspection of PRIME CRGO, the following points needs to be checked by the Transformer manufacturer. Utility’s inspector shall verify all these points during inspection:

i) In case PRIME CRGO cutting is at works of Transformer Manufacturer:

Review of documents:

- Purchase Order (unpriced) to PRIME CRGO supplier/Authorised Agency
- Manufacturer’s test certificate
- Invoice of the Supplier
Packing List

Bill of Lading

Bill of Entry Certificate by Customs Deptt.

Reconciliation Statement as per format below
Certificate of Origin
BIS Certification

**Format for Reconciliation/Traceability records**

Packing List No./date /Quantity of PRIME CRGO received
Name of Manufacturer
Manufacturer test certificate No./date

<table>
<thead>
<tr>
<th>Serial No.</th>
<th>Details of Package/Job</th>
<th>Drawing Reference</th>
<th>Quantity Involved</th>
<th>Commulative Quantity Consumed</th>
<th>Balance Stock</th>
</tr>
</thead>
<tbody>
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<td></td>
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</tbody>
</table>

(i).1 Inspection of PRIME CRGO Coils:

PRIME CRGO-Manufacturer’s Identification Slip on PRIME CRGO Coils
Visual Inspection of PRIME CRGO Coils offered as per packing list (for verification of coil details as per Test certificate & healthiness of packaging).
Unique numbering inside of each sample of PRIME CRGO coil and verification of records to be maintained in the register for consumption of CRGO coil.
ISI logo sticker on packed mother coil and ISI logo in Material TC.

2.2. During inspection of PRIME CRGO, surveillance testing of sample shall be carried out for Stacking Factor, Permeability, Specific watt loss at 1.5 Tesla and/or 1.7 Tesla depending on the grade of PRIME CRGO and aging test etc. applicable as per relevant IS/IEC standard, Tech. Spec., MQP and Transformer manufacturer plant standard.

**Inspection Clearance Report would be issued after this inspection**

3 Inspection of PRIME CRGO laminations: Transformer manufacturer will maintain records for traceability of laminations to prime CRGO coils and burr/bow on laminations shall be measured. Utility can review these records on surveillance basis.
4. **Inspection at the time of core building:**

   Visual Inspection of PRIME CRGO laminations. In case of suspected mix-up/ rusting/decoloration, samples may be taken for testing on surveillance basis for tests mentioned in A.2.2 above.

   Above tests shall be witnessed by Utility. In case testing facilities are not available at Manufacturer’s work, the sample(s) sealed by Utility to be sent to approved labs for testing.

   **Inspection Clearance Report would be issued after this inspection**

   (i) **In case PRIME CRGO cutting is at Sub-vendor of Transformer Manufacturer:**

   Review of documents:

   - Purchase Order (unpriced) to PRIME CRGO supplier/ Authorised Agency
   - Purchase Order (unpriced) to Core Cutter
   - Manufacturer test certificate
   - Invoice of the Supplier
   - Packing List
   - Bill of Lading
   - Bill of Entry Certificate by Customs Deptt.
   - Reconciliation Statement as per format below
   - Certificate of origin
   - BIS Certification

   **Format for Traceability records as below:-**

<table>
<thead>
<tr>
<th>Serial No.</th>
<th>Name of Customer</th>
<th>Details of Package/Job</th>
<th>Drawing Reference</th>
<th>Quantity Involved</th>
<th>Commulative Quantity Consumed</th>
<th>Balance Stock</th>
<th>Dispatch details</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

   (ii) **.1 Inspection of PRIME CRGO Coils:**
PRIME CRGO-Manufacturer’s Identification Slip on PRIME CRGO Coils
Visual Inspection of PRIME CRGO Coils offered as per packing list (for verification of coil details as per Test certificate & healthiness of packaging).
Unique numbering inside of each sample of PRIME CRGO coil and verification of records to be maintained in the register for consumption of CRGO coil.
ISI logo sticker on packed mother coil and ISI logo in Material TC.

2.2. During inspection of PRIME CRGO, surveillance testing of sample shall be carried out for Stacking Factor, Permeability, Specific watt loss at 1.5 Tesla and/or 1.7 Tesla, thickness depending on the grade of PRIME CRGO and aging test etc. applicable as per relevant IS/IEC standard, Tech. Spec., MQP and Transformer manufacturer plant standard.

**Inspection Clearance Report would be issued after this inspection**

3 Inspection of PRIME CRGO laminations:
   Transformer manufacturer representative will inspect laminations and issue their internal Inspection Clearance Report. Inspection will comprise of review of traceability to prime CRGO coils, visual Inspection of PRIME CRGO laminations and record of burr/bow. After clearance given by transformer manufacturer, Utility will issue an Inspection Clearance Report after record review. If so desired by Utility, their representative may also join transformer manufacturer representative during this inspection.

**Inspection Clearance Report would be issued after this inspection**

vi) Inspection at the time of core building:

Visual Inspection of PRIME CRGO laminations. In case of suspected mix-up/rusting/decoloration, samples may be taken for testing on surveillance basis for tests mentioned in B.2.2.

**Inspection Clearance Report would be issued after this inspection**

**NOTE :-**

a) Transformer Manufacturer to ensure that PRIME CRGO is procured from POWERGRID approved vendors and CRGO manufacturer should have valid BIS Certificate for respective offered Grade.

14.1 Transformer Manufacturer should also involve themselves for ensuring the quality of CRGO laminations at their Core Cutter’s works. They should visit the works of their Core cutter and carry out necessary checks.

a) General

If a surveillance sample is drawn and sent to TPL (if testing facility not available with the manufacturer), the Transformer manufacturer can continue manufacturing at their own risk and cost pending TPL test report on
PRIME CRGO sample drawn. Decision for acceptance of PRIME CRGO shall be based upon report of the sample drawn.

These checks shall be read in conjunction with approved Quality Plan, specification as a whole and conditions of contract.

**Sampling Plan (PRIME CRGO)**

33 / 11 kV
- 1st transformer and subsequently at random 10% of Transformers (min. 1) offered for inspection.

DTs and other ratings
- 1st transformer and subsequently at random 2% of Transformers (min. 1) offered for inspection.

**NOTE:**- One sample for each lot of CRGO shall be drawn on surveillance basis.

CRGO has to be procured only from POWERGRID approved vendors. List of such vendors is available at the following website. Since the list is dynamic in nature, the site may be checked from time to time to see the list of approved vendors.

http://apps.powergridindia.com/ims/ComponentList/Power-former%20upto%20420%20kV-CM%20List.pdf

1. **AAA CONDUCTOR**

1.1 **TECHNICAL DESCRIPTION OF AAAC CONDUCTOR**

**DETAILS OF CONDUCTORS**

1.1.1 The AAAC Conductors shall generally conform to IS: 398 (Part-IV), IEC:104-1987 except where otherwise specified herein.

1.1.2 The details of the AAAC Conductors of various sizes are given in the enclosed Table-1

1.2 **WORKMANSHIP**

1.2.1 All the Al-alloy strands shall be smooth, uniform and free from all imperfections, such as spills and splits, die marks, scratches, abrasions, etc., after drawing and also after stranding.

1.2.2 The finished conductor shall be smooth, compact, uniform and free from all imperfections including kinks (protrusion of wires), scuff marks, dents, pressmarks, cut marks, wire cross over, over riding, looseness (wire being dislocated by finger/hand pressure and/or unusual bangle noise on tapping), material inclusions, white rust, powder formation or black spot (on account of reaction with trapped rain water etc.), dirt, grit etc.

1.3 **JOINTS IN WIRES**

1.3.1 No joint shall be permitted in any layer of finished conductor.
1.4 STRANDING
In all constructions, the successive layers shall be stranded in opposite directions. The wires in each layer shall be evenly and closely stranded round the underlying wire or wires. The outer most layer of wires shall have a right hand lay. The lay ratio shall be as follow.

<table>
<thead>
<tr>
<th>Number of wires in conductor</th>
<th>3/6 Wire layer</th>
<th>12 Wire layer</th>
<th>18 Wire layer</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td>10</td>
<td>14</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>10</td>
<td>14</td>
<td>-</td>
</tr>
<tr>
<td>19</td>
<td>10</td>
<td>16</td>
<td>10</td>
</tr>
<tr>
<td>37</td>
<td>10</td>
<td>17</td>
<td>10</td>
</tr>
</tbody>
</table>

1.5 TOLERANCES
The manufacturing tolerances in diameter of individual aluminium alloy strand shall be as per Table-I.

1.6 MATERIALS
1.6.1 ALUMINUM ALLOY
The wire shall be of heat treated aluminum, magnesium silicon alloy having a composition appropriate to the mechanical & electrical properties as specified in IS 398(Part-4).

The Aluminum Alloy strands drawn from heat treated aluminium alloy redraw rods conforming to Type B as per IEC:104-latest amendment. The chemical composition conform of redrawn rods shall to IS 1997-91, as given below:

<table>
<thead>
<tr>
<th>Elements</th>
<th>Percent</th>
</tr>
</thead>
<tbody>
<tr>
<td>Si</td>
<td>0.50-0.90</td>
</tr>
<tr>
<td>Mg</td>
<td>0.60-0.90</td>
</tr>
</tbody>
</table>
1.7  
**STANDARD LENGTH**

1.7.1 The standard length of the conductor shall be 2000 meters. A tolerance of +/-5% on the standard length offered by the Bidder shall be permitted. All lengths outside this limit of tolerance shall be treated as random lengths. The conductor drums shall be adequate to wind one or more standard length of 2000 meters of SQUIRREL/WEASEL/RABIT/RACOON/DOG/PANTHER AAA conductor.

1.7.2 Random lengths will be accepted provided no length is less than 70% of the standard length and the total quantity of such random lengths shall not be more than 10% of the total quantity ordered.

1.7.3 Bidder shall also indicate the maximum single length, above the standard length, he can manufacture in the guaranteed technical particulars of offer. The Owner reserves the right to place orders for the above lengths on the same terms and conditions applicable for the standard lengths during the execution of the Contract.

1.8  
**TESTS AND STANDARDS**

The following tests to be conducted for AAAC conductors shall conform to IS 398(Part -IV) 1979 and IEC 888 & 889.

1.8.1  
**TYPE/PERIODIC**

The following tests shall be conducted on samples of each type of conductor:

a)  
UTS test on stranded conductor
1.8.2 ACCEPTANCE TESTS

(a) Visual check for joints scratches etc. and length measurement of conductor by rewinding

(b) Dimensional check on Al-alloy strands

(c) Check for lay-ratio

(d) Elongation test

(e) Breaking load/tensile test on Aluminum alloy strands

(f) DC resistance test on Aluminum alloy strands

(g) Wrap test on Aluminum alloy strands IEC 104, IEC 1089

(h) Visual and dimensional check on drum IS:1778-1980

1.8.3 ROUTINE TEST
(a) Check to ensure that there are no joints.

(b) Check that there are no cuts, fins etc. on the strands.

(c) Check that drums are as per Specification.

(d) All acceptance test as mentioned above to be carried out on each coil.

1.8.4 TESTS DURING MANUFACTURE

(a) Chemical analysis of 

   Aluminum alloy used for making strands 

   ) Annexure-A

1.8.5 TESTING EXPENSES

i) The type test charges for the conductor should be quoted in the relevant schedule of Bid Proposal Sheets.

ii) Contractor shall indicate the laboratories in which they propose to conduct the type tests. They shall ensure that adequate facilities are available in the laboratories and the tests can be completed in these laboratories within the time schedule guaranteed by them.

iii) In case of failure in any type test, the Contractor is either required to manufacture fresh sample lot and repeat all the tests successfully once or repeat that particular type test three times successfully on the sample selected from the already manufactured lot at his own expenses. In case a fresh lot is manufactured for testing, then the lot already manufactured shall be rejected.
iv) The entire cost of testing for the acceptance and routine tests and Tests during manufacture specified herein shall be treated as included in the quoted unit price of conductor, except for the expenses of the inspector/Owner's representative.

v) In case of failure in any type test, if repeat type tests are required to be conducted, then all the expenses for deputation of Inspector/Owner's representative shall be deducted from the contract price. Also if on receipt of the Contractor's notice of testing, the Owner's representative does not find 'The material or testing facilities' to be ready for testing the expenses incurred by the Owner for re-deputation shall be deducted from contract price.

1.8.6 ADDITIONAL TESTS

i) The Owner reserves the right of having at his own expenses any other test(s) of reasonable nature carried out at Contractor’s premises, at site or in any other place in addition to the aforesaid type, acceptance and routine tests to satisfy himself that the materials comply with the Specifications.

ii) The Owner also reserves the right to conduct all the tests mentioned in this specification at his own expense on the samples drawn from the site at Contractor’s premises or at any other test centre. In case of evidence of non-compliance, it shall be binding on the part of Contractor to prove the compliance of the items to the technical specifications by repeat tests, or correction of deficiencies, or replacement of defective items all without any extra cost to the Owner.

1.8.7 SAMPLE BATCH FOR TYPE TESTING

i) The Contractor shall offer material for selection of samples for type testing only
after getting Quality Assurance Plan approved from Owner’s Quality Assurance Deptt. The sample shall be manufactured strictly in accordance with the Quality Assurance Plan approved by Owner.

ii) The Contractor shall offer at least three drums for selection of sample required for conducting all the type tests.

iii) The Contractor is required to carry out all the acceptance tests successfully in presence of Owner’s representative before sample selection.

1.8.8 TEST REPORTS

i) Copies of type test reports shall be furnished in at least six copies along with one original. One copy will be returned duly certified by the Owner only after which the commercial production of the material shall start.

ii) Record of routine test reports shall be maintained by the Supplier at his works for periodic inspection by the Owner’s representative.

iii) Test Certificates of tests during manufacture shall be maintained by the Contractor. These shall be produced for verification as and when desired by the Owner.

1.9 INSPECTION

1.9.1 The Owner’s representative shall at all times be entitled to have access to the works and all places of manufacture, where conductor shall be manufactured and representative shall have full facilities for unrestricted inspection of the Contractor’s works, raw materials and process of manufacture for conducting necessary tests as detailed herein.

1.9.2 The Contractor shall keep the Owner informed in advance of the time of starting and of the progress of manufacture of conductor in its various stages so that arrangements can be made for inspection.

1.9.3 No material shall be dispatched from its point of manufacture before it has been
satisfactorily inspected and tested, unless the inspection is waived off by the Owner in writing. In the latter case also, the conductor shall be dispatched only after satisfactory testing for all tests specified herein have been completed.

1.9.4 The acceptance of any quantity of material shall in no way relieve the Contractor of any of his responsibilities for meeting all requirements of the Specification, and shall not prevent subsequent rejection if such material is later found to be defective.

1.9.5 TEST FACILITIES

The following additional test facilities shall be available at the Contractor’s works:

i) Calibration of various testing and measuring equipment including tensile testing machine, resistance measurement facilities, burette, thermometer, barometer etc.

ii) Standard resistance for calibration of resistance bridges.

iii) Finished conductor shall be checked for length verification and surface finish on separate rewinding machine at reduced speed (variable from 8 to 16 meters per minute). The rewinding facilities shall have appropriate clutch system and free of vibrations, jerks etc. with traverse laying facilities.

1.10 PACKING

1.10.1 The conductor shall be supplied in non-returnable, strong, wooden drums provided with lagging of adequate strength, constructed to protect the conductor against any damage and displacement during transit, storage and subsequent handling and stringing operations in the field. The Contractor shall be responsible for any loss or damage during transportation handling and storage due to improper packing. The drums shall generally conform to IS:1778-1980, except as otherwise specified hereinafter.
1.10.2 The drums shall be suitable for wheel mounting and for letting off the conductor under a minimum controlled tension of the order of 5 KN.

1.10.3 The Contractor should submit their proposed drum drawings along with the bid.

1.10.4 The Contractor may offer more than one length of the conductor in a single drum.

1.10.5 All wooden components shall be manufactured out of seasoned soft wood free from defects that may materially weaken the component parts of the drums. Preservative treatment shall be applied to the entire drum with preservatives of a quality, which is not harmful to the conductor.

1.10.6 The flanges shall be of two ply construction with a total thickness of 64 mm with each ply at right angles to the adjacent ply and nailed together. The nails shall be driven from the inside face flange, punched and then clenched on the outer face. Flange boards shall not be less than the nominal thickness by more than 2 mm. There shall not be less than 2 nails per board in each circle. Where a slot is cut in the flange to receive the inner end of the conductor the entrance shall be in line with the periphery of the barrel.

1.10.7 The wooden battens used for making the barrel of the conductor shall be of segmental type. These shall be nailed to the barrel supports with at least two nails. The battens shall be closely butted and shall provide a round barrel with smooth external surface. The edges of the battens shall be rounded or chamfered to avoid damage to the conductor.

1.10.8 Barrel studs shall be used for the construction of drums. The flanges shall be holed and the barrel supports slotted to receive them. The barrel studs shall be threaded over a length on either end, sufficient to accommodate washers, spindle plates and nuts for fixing flanges at the required spacing.

1.10.9 Normally, the nuts on the studs shall stand protruded of the flanges. All the nails used on the inner surface of the flanges and the drum barrel shall be counter sunk. The ends of barrel shall generally be flushed with the top of the nuts.
1.10.10 The inner cheek of the flanges and drum barrel surface shall be painted with a bitumen based paint.

1.10.11 Before reeling, card board or double corrugated or thick bituminous water-proof bamboo paper or HDPE sheet shall be secured to the drum barrel and inside of flanges of the drum by means of a suitable commercial adhesive material. The paper should be dried before use. After reeling the conductor the exposed surface of the outer layer of conductor shall be wrapped with thin polythene sheet across the flanges to preserve the conductor from dirt, grit and damage during transportation and handling and also to prevent ingress of rain water during storage/transport.

1.10.12 A minimum space of 75 mm for conductor shall be provided between the inner surface of the external protective lagging and outer layer of the conductor. Outside the protective lagging, there shall be minimum of two binders consisting of hoop iron/ galvanized steel wire. Each protective lagging shall have two recesses to accommodate the binders.

1.10.13 Each batten shall be securely nailed across grains as far as possible to the flange, edges with at least 2 nails per end. The length of the nails shall not be less than twice the thickness of the battens. The nails shall not protrude above the general surface and shall not have exposed sharp, edges or allow the battens to be released due to corrosion.

1.10.14 The nuts on the barrel studs shall be tack welded on the one side in order to fully secure them. On the second end, a spring washer shall be used.

1.10.15 A steel collar shall be used to secure all barrel studs. This collar shall be located between the washers and the steal drum and secured to the central steel plate by welding.

1.10.16 Outside the protective lagging, there shall be minimum of two binder consisting of hoop iron/ galvanized steel wire. Each protective lagging shall have two recesses to accommodate the binders.

1.10.17 The conductor ends shall be properly sealed and secured with the help of U-nail on the side of one of the flanges to avoid loosening of the conductor layers during transit and handling.

1.10.18 As an alternative to wooden drum Contractor may also supply the conductors in
non-returnable painted steel drums. After preparation of steel surface according to IS: 9954, synthetic enamel paint shall be applied after application of one coat of primer. Wooden/Steel drum will be treated at par for evaluation purpose and accordingly the Contractor should quote in the package.

1.11 MARKING

Each drum shall have the following information stenciled on it in indelible ink along with other essential data:

   a. Contract/Award letter number.
   b. Name and address of consignee.
   c. Manufacturer’s name and address.
   d. Drum and lot number
   e. Size and type of conductor
   f. Length of conductor in meters
   g. Arrow marking for unwinding
   h. Position of the conductor ends
   i. Number of turns in the outer most layer.
   j. Gross weight of drum after putting lagging.
   k. Average weight of the drum without lagging.
   l. Net weight of the conductor in the drum.
   m. Month and year of manufacture of conductor

The above should be indicated in the packing list also.

1.12 VERIFICATION OF CONDUCTOR LENGTH

The Owner reserves the right to verify the length of conductor after unreeling at least Two (2) percent of the drums in a lot offered for inspection.

For the balance drums, length verification shall be done by the owner based on report/certification from Manufacturer/Contractor.

1.13 STANDARDS

1.13.1 The conductor shall conform to the following Indian/International Standards, which shall mean latest revisions, with amendments/changes adopted and published, unless specifically stated otherwise in the Specification.
1.13.2 In the event of the supply of conductor conforming to standards other than specified, the Bidder shall confirm in his bid that these standards are equivalent to those specified. In case of award, salient features of comparison between the standards proposed by the Contractor and those specified in this document will be provided by the Contractor to establish their equivalence.

<table>
<thead>
<tr>
<th>SL NO.</th>
<th>Indian Standard</th>
<th>Title</th>
<th>International Standard</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>IS:398 (Part-IV)</td>
<td>Aluminum Alloy stranded conductor</td>
<td>IEC: 208-1966</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>BS:3242-1970</td>
</tr>
<tr>
<td>3</td>
<td>IS:1778-1980 Reels</td>
<td>Reels and Drums for bare conductors</td>
<td>BS:1559-1949</td>
</tr>
</tbody>
</table>

**ANNEXURE-A**

**1.0 TESTS ON AAAC CONDUCTORS**

**1.1 UTS Test on Stranded Conductor**

Circles perpendicular to the axis of the conductor shall be marked at two places on a sample of conductor of minimum 5 m length between fixing arrangement suitably fixed on a tensile testing machine. The load shall be increased at a steady rate up to 50% of minimum specified UTS and held for one minute. The circles drawn shall not be distorted due to relative movement of strands. Thereafter the load shall be increased at steady rate to minimum UTS and held for one minute. The Conductor sample shall not fail during this period. The applied load shall then be increased until the failing load is reached and the value recorded.

**1.2 D.C. Resistance Test on Stranded Conductor**

On a conductor sample of minimum 5m length two contact-clamps shall be fixed with a predetermined bolt torque. The resistance shall be measured by a Kelvin double bridge by placing the clamps initially zero meter and subsequently one meter apart. The test shall be repeated at least five times and the average value recorded. The value obtained shall be corrected to the value at 20°C as per IS:398- (Part-V)-1982. The resistance corrected at 20°C shall conform to the requirements of this Specification.
1.3 **CHEMICAL ANALYSIS OF ALUMINIUM ALLOY**

Samples taken from the Aluminium alloy ingots/coils/strands shall be chemically/spectrographically analyzed. The same shall be in conformity to the requirements stated in this Specification.

1.4 **VISUAL AND DIMENSIONAL CHECK ON DRUMS**

The drums shall be visually and dimensionally checked to ensure that they conform to the requirements of this Specification.

1.5 **VISUAL CHECK FOR JOINTS, SCRATCHES ETC.**

Conductor drums shall be rewound in the presence of the Owner. The Owner shall visually check for scratches, joints etc. and that the conductor generally conforms to the requirements of this Specification. Two percent (2%) drums from each lot shall be rewound in the presence of the Owner’s representative.

1.6 **DIMENSIONAL CHECK ON ALUMINUM ALLOY STRANDS**

The individual strands shall be dimensionally checked to ensure that they conform to the requirement of this Specification.

1.7 **CHECK FOR LAY-RATIOS OF VARIOUS LAYERS**

The lay-ratios of various layers shall be checked to ensure that they conform to the requirements of this Specification.

1.8 **TORSION AND ELONGATION TESTS ON ALUMINUM ALLOY STRANDS**

The test procedures shall be as per clause No. 10.3 of IEC : 888. In torsion test, the number of complete twists before fracture shall not be less than 18 on a length equal to 100 times the standard diameter of the strand. In case test sample length is less or more than 100 times the stranded diameter of the strand, the minimum number of twists will be proportioned to the length and if number comes in the fraction then it will be rounded off to next higher whole number. In elongation test, the elongation of the strand shall not be less than 4% for a gauge length of 250 mm.

1.9 **CHECK ON BARREL BATTE N STRENGTH OF DRUMS**

The details regarding barrel batten strength test will be discussed and mutually agreed to by the Contractor & Owner in the Quality Assurance Programme.

1.10 **Breaking Load Test on Individual Aluminium Alloy Wires**
The test shall be conducted on Aluminum alloy wires. The breaking load of one specimen cut from each of the samples taken shall be determined by means of suitable tensile testing machine. The load shall be applied gradually so the jaws of the testing machine shall be not less than 25 mm/min. and not greater than 100 mm./min. The ultimate breaking load of the specimens shall be not less than the values specified in the Specification.

1.11 RESISTANCE TEST ON ALUMINUM ALLOY WIRE

The test shall be conducted on aluminium alloy wires only, conforming to procedure as per IEC: 889. The electrical resistance of one specimen of aluminium wire cut from each of the samples taken shall be measured at ambient temperature. The measured resistance shall be corrected to the value corresponding to 20 degree C. by means of following formula.

\[
\frac{1}{R_{20}} = \frac{R_T}{1 + \alpha \times (T - 20)}
\]

Where

\[R_{20}\] = Resistance corrected at 20 degrees C.

\[R_T\] = Resistance measured at T degrees C.

\[\alpha\] = Constant mass temperature coefficient of resistance 0.004.

\[T\] = Ambient temperature during measurement

This resistance calculated to 20 degrees C. shall be not more than the maximum value specified in the specification.
### Table-1

**Details of parameters of AAA conductor**

<table>
<thead>
<tr>
<th>S.N</th>
<th>Parameter</th>
<th>Squirrel</th>
<th>Weasel</th>
<th>Rabbit</th>
<th>Raccon</th>
<th>DOG</th>
<th>wolf</th>
<th>Panther</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Total sectional area of conductor</td>
<td>22</td>
<td>34</td>
<td>55</td>
<td>80</td>
<td>100</td>
<td>173</td>
<td>232</td>
</tr>
<tr>
<td>2</td>
<td>(No of Al strand/dia in mm)</td>
<td>7/2.00</td>
<td>7/2.50</td>
<td>7/3.15</td>
<td>7/3.81</td>
<td>7/4.26</td>
<td>19/3.40</td>
<td>19/3.94</td>
</tr>
<tr>
<td>3</td>
<td>Overall diameter</td>
<td>6</td>
<td>7.5</td>
<td>9.45</td>
<td>11.43</td>
<td>12.78</td>
<td>17</td>
<td>19.7</td>
</tr>
<tr>
<td>4</td>
<td>approx mass (kg/km)</td>
<td>60.16</td>
<td>94</td>
<td>149.2</td>
<td>218.26</td>
<td>272.86</td>
<td>474.02</td>
<td>636.67</td>
</tr>
<tr>
<td>5</td>
<td>Resistance at 20 deg cel (ohms/km)</td>
<td>1.541</td>
<td>0.99</td>
<td>0.621</td>
<td>0.425</td>
<td>0.339</td>
<td>0.1969</td>
<td>0.1471</td>
</tr>
<tr>
<td>6</td>
<td>approx calculated breaking load (kN)</td>
<td>6.45</td>
<td>10.11</td>
<td>16.03</td>
<td>23.41</td>
<td>29.26</td>
<td>50.54</td>
<td>68.05</td>
</tr>
<tr>
<td>7</td>
<td>Final modulus of Elasticity, GN/sqm (kg/sq cm)</td>
<td>0.6324 x 10 (pwr 6)</td>
<td>0.6324 x 10</td>
<td>0.6324 x 10</td>
<td>0.6324 x 10</td>
<td>0.6324 x 10</td>
<td>0.612x10</td>
<td>0.612x10</td>
</tr>
<tr>
<td>8</td>
<td>Coefficient of linear Expansion/°C (pwr -6)</td>
<td>23.0 X10</td>
<td>23.0 X10</td>
<td>23.0 X10</td>
<td>23.0 X10</td>
<td>23.0 X10</td>
<td>23.0 X10</td>
<td>23.0 X10</td>
</tr>
<tr>
<td>9</td>
<td>Details of Aluminium</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>S.N.</td>
<td>Parameter Description</td>
<td>Squirrel</td>
<td>Weasel</td>
<td>Rabbit</td>
<td>Raccoon</td>
<td>DOG</td>
<td>Wolf</td>
<td>Panther</td>
</tr>
<tr>
<td>------</td>
<td>---------------------------------------------------------------------------------------</td>
<td>-----------</td>
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<td>---------</td>
</tr>
<tr>
<td>a</td>
<td>Minimum breaking load of the strand before stranding (kN)</td>
<td>0.97</td>
<td>1.52</td>
<td>2.41</td>
<td>3.52</td>
<td>4.4</td>
<td>2.8</td>
<td>3.77</td>
</tr>
<tr>
<td>b</td>
<td>Minimum breaking load of the strand after stranding (kN)</td>
<td>0.92</td>
<td>1.44</td>
<td>2.29</td>
<td>3.34</td>
<td>4.18</td>
<td>2.66</td>
<td>3.58</td>
</tr>
<tr>
<td>c</td>
<td>Maximum DC resistance of strands at 20 deg C (ohms/km)</td>
<td>10.653</td>
<td>6.845</td>
<td>4.29</td>
<td>2.938</td>
<td>2.345</td>
<td>3.677</td>
<td>2.746</td>
</tr>
<tr>
<td>d</td>
<td>Mass (kg/km)</td>
<td>8.482</td>
<td>13.25</td>
<td>21.04</td>
<td>30.78</td>
<td>38.48</td>
<td>24.51</td>
<td>32.92</td>
</tr>
<tr>
<td>e</td>
<td>Diameter</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>i</td>
<td>Nominal</td>
<td>2.0</td>
<td>2.50</td>
<td>3.15</td>
<td>3.81</td>
<td>4.26</td>
<td>3.40</td>
<td>3.94</td>
</tr>
<tr>
<td>ii</td>
<td>Maximum</td>
<td>2.02</td>
<td>2.53</td>
<td>3.18</td>
<td>3.85</td>
<td>4.30</td>
<td>3.43</td>
<td>3.98</td>
</tr>
<tr>
<td>iii</td>
<td>Minimum</td>
<td>1.98</td>
<td>2.47</td>
<td>3.12</td>
<td>3.77</td>
<td>4.22</td>
<td>3.37</td>
<td>3.90</td>
</tr>
</tbody>
</table>

2. **ACSR CONDUCTOR**
1. **SCOPE**

This section covers design, manufacture, testing before dispatch, packing, supply and delivery for destination of Kms of ACSR Squirrel, Weasel, Rabbit*, Racoon, Dog and Panther Conductor.

2. **STANDARDS**

The Conductor shall also comply in all respects with the IS: 398(Part-II)-1996 with latest amendments unless otherwise stipulated in this specification or any other International Standards which ensure equal or higher quality material.

The ACSR Conductor shall also conform to the following standards.

<table>
<thead>
<tr>
<th>Sl. No</th>
<th>Indian Standards</th>
<th>Title</th>
<th>International</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Part-II</td>
<td>Aluminum conductors</td>
<td>IEC-209-1966</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Galvanized steel reinforced</td>
<td>BS-215(Part-II)</td>
</tr>
<tr>
<td>3</td>
<td>IS:1521-1972</td>
<td>Method of Tensile Testing of Steel wire</td>
<td>ISO/R89-1959</td>
</tr>
<tr>
<td>4</td>
<td>IS:1778-1980</td>
<td>Reels and Drums for Bare conductors</td>
<td>BS-1559-1949</td>
</tr>
<tr>
<td>5</td>
<td>IS:1841-1978</td>
<td>E.C. Grade Aluminum rod produced by rolling</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>IS:2629-1966</td>
<td>Recommended practice for Hot Dip Galvanizing of iron and steel</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>IS:2633-1986</td>
<td>Method of testing uniformity of coating of zinc coated articles.</td>
<td></td>
</tr>
<tr>
<td>8</td>
<td>IS:4826-1968</td>
<td>Galvanized coatings on round steel wires.</td>
<td>ASTM A472-729</td>
</tr>
<tr>
<td>9</td>
<td>IS:5484-1978</td>
<td>E.C. Grade Aluminium rod produced by continuous casting and rolling.</td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>IS:6745-1972</td>
<td>Methods of determination of weight of zinc-coating of zinc coated iron and steel articles</td>
<td>BS-443-1969</td>
</tr>
</tbody>
</table>

Offers conforming to standards other than IS-398 shall be accompanied by the English version of relevant standards in support of the guaranteed technical particulars to be furnished as per format enclosed.

3. **GENERAL TECHNICAL REQUIREMENTS**

The General Technical Requirements are given in Section-II. The Conductor shall conform to these technical requirements.

The Bidder shall furnish guaranteed technical particulars in Section-III.
3.1. **MATERIALS/WORKMANSHIP**

3.1.1. The material offered shall be of best quality and workmanship. The steel cored aluminum conductor strands shall consist of hard drawn aluminum wire manufactured from not less than 99.5% pure electrolytic aluminum rods of E.C. grade and copper content not exceeding 0.04%. They shall have the same properties and characteristics as prescribed in IEC: 889-1987. The steel wire shall be made from material produced either by the acid or basic open hearth process or by electric furnace process or basic oxygen process. Steel wire drawn from Bessemer process shall not be used.

3.1.2. The steel wires shall be evenly and uniformly coated with electrolytic high grade, 99.95% purity zinc complying with the latest issue of IS-209 for zinc. The uniformity of zinc coating and the weight of coating shall be in accordance with Section-II and shall be tested and determined according to the latest IS-2633 or any other authoritative standard.

3.1.3. The steel strands shall be hot dip galvanized as per IS: 4826. The coating shall be smooth, continuous, and of uniform thickness, free from imperfections and shall withstand minimum three dips after stranding in standard preere test. The steel strands shall be preformed and postformed in order to prevent spreading of strands in the event of cutting of composite core wire. The properties and characteristics of finished strands and individual wires shall be as prescribed in IEC: 888-1987. If tested after stranding, reference shall also be made to cl. 4.1.1 and cl. 4.2.3 of IS: 4826.

4. **CONDUCTOR PARAMETERS**

The Parameters of individual strands and composite steel cored aluminum conductor, shall be in accordance with the values given in Section-II. Creep in a conductor is attributed partly due to settlement of strands and partly due to non-elastic elongation of metal when subjected to load. The manufacturer of conductor shall furnish the amount of creep which will take place in 10, 20, 30, 40 and 50 years along with the supporting calculations. The calculations should be based on everyday temperature of 32 °C and everyday tension of 25% of UTS of conductor of 11/33 KV Lines.

5. **TOLERANCES**

The tolerances on standard diameter of Aluminum and Steel wires shall be as detailed in specific technical requirements.

The cross-section of any wire shall not depart from circularity by more than an amount corresponding to the tolerance on the standard diameter.
The details of diameters, lay ratios of Aluminum and steel wires shall be in accordance with the Section-II "Technical Requirements".

6. **SURFACE CONDITIONS**

All aluminum and steel strands shall be smooth, and free from all imperfections, spills/and splits. The finished conductor shall be smooth, compact, uniform and free from all imperfections including spills and splits, die marks, scratches, abrasions, scuff marks, kinks (protrusion of wires), dents, pressmarks, cut marks, wire cross-over, overriding looseness, pressure and/or unusual bangle noise on tapping, material inclusions, white rust, powder formation or black spots (on account of reaction with trapped rain water etc.,), dirt, grit, etc. The surface of conductor shall be free from points, sharp edges, abrasions or other departures from smoothness or uniformity of surface contour that would increase radio interference and corona losses. When subjected to tension upto 50% of the ultimate strength of the conductor, the surface shall not depart from the cylindrical form nor any part of the component parts or strands move relative to each other in such a way as to get out of place and disturb the longitudinal smoothness of the conductor.

7. **JOINTS IN WIRES**

7.1. **Aluminum wires**

During stranding, no aluminum wire welds shall be made for the purpose of achieving the required conductor length.

No joint shall be permitted in the individual aluminum wires in the outer most layer of the finished Conductor. However, joints in the 12 wire & 18 wire inner layer of the conductor are permitted but these joints shall be made by the cold pressure butt welding and shall be such that no two such joints shall be within 15 meters of each other in the complete stranded conductor.

7.2. **Steel wires**

There shall be no joints in finished steel wires forming the core of the steel reinforced aluminum conductor.

8. **STRANDING**

The wires used in construction of the stranded conductor, shall, before stranding, satisfy all requirements of IS-398 (Part-II) 1996.
In all constructions, the successive layers shall be stranded in opposite directions. The wires in each layer shall be evenly and closely stranded round the underlying wire or wires. The outer most layer of wires shall have a right hand lay. The lay ratio of the different layers shall be within the limits given under Section-II.

9. PACKING

9.1. The conductor shall be supplied in non-returnable strong wooden drums provided with lagging of adequate strength constructed to protect the conductor against any damage and displacement during transit, storage and subsequent handling and stringing operations in the field. The drums shall generally conform to IS-1778-1980 and latest version except as otherwise specified hereinafter. The conductor drums shall be adequate to wind one or more standard length of 2500 meters of SQUIRREL/WEASEL/RABIT/RACOON/DOG/ PANTHER ACSR conductor.

9.2. The drums shall be suitable for wheel mounting and for letting off the conductor under a minimum controlled tension of the order of 5KN. The conductor drums shall be provided with necessary clamping arrangements so as to be suitable for tension stringing of power conductor.

9.3. The bidders should submit their drawings of the conductor drums along with the bid. After placement of letter of intent the Manufacturer shall submit four copies of fully dimensioned drawing of the drum for Employer's approval. After getting approval from the Employer, Manufacturer shall submit 30 more copies of the approved drawings for further distribution and field use.

9.4. All wooden components shall be manufactured out of seasoned soft wood free from defects that may materially weaken the component parts of the drums. Preservative treatment for anti-termite/anti fungus shall be applied to the entire drum with preservatives of a quality which is not harmful to the conductor.

9.5. All flanges shall be 2-ply construction with 64 mm thickness. Each ply shall be nailed and clenched together at approximately 90 degrees. Nails shall be driven from the inside face of the flange, punched and then clenched on the outer face. Flange boards shall not be less than the nominal thickness by more than 2 mm. There shall not be less than 2 nails per board in each circle.

9.6. The wooden battens used for making the barrel of the conductor shall be of segmental type. These shall be nailed to the barrel supports with at least two nails. The battens shall be closely butted and shall provide a round barrel with smooth external surface. The edges of the battens shall be rounded or chamfered to avoid damage to the conductor.
9.7. Barrel studs shall be used for construction of drums. The flanges shall be holed and the barrel supports slotted to receive them. The barrel studs shall be threaded over a length on either end, sufficient to accommodate washers, spindle plates and nuts for fixing flanges at the required spacing.

9.8. Normally, the nuts on the studs shall stand protruded of the flanges. All the nails used on the inner surface of the flanges and the drum barrel shall be countersunk. The ends of the barrel shall generally be flushed with the top of the nuts.

9.9. The inner cheek of the flanges and drum barrel surface shall be painted with bitumen based paint.

9.10. Before reeling, card board or double corrugated or thick bituminized waterproof bamboo paper or HDPE sheet shall be secured to the drum barrel and inside of flanges of the drum by means of a suitable commercial adhesive material. The paper should be dried before use. After reeling the conductor the exposed surface of the outer layer of conductor shall be wrapped with thin polythene sheet across the flanges to preserve the conductor from dirt, grit and damage during transportation and handling and also to prevent ingress of rain water during storage/transport.

9.11. A minimum space of 75 mm shall be provided between the inner surface of the external protective lagging and outer layer of the conductor. Outside the protective lagging, there shall be minimum of two binders consisting of hoop iron/galvanized steel wire. Each protective lagging shall have two recesses to accommodate the binders.

9.12. Each batten shall be securely nailed across grains as far as possible to the flange edges with at least 2 nails per end. The length of the nails shall not be less than twice the thickness of the battens. The nail shall not protrude above the general surface and shall not have exposed sharp edges or allow the battens to be released due to corrosion.

9.13. The conductor ends shall be properly sealed and secured with the help of U-nails on one side of the flanges.

9.14. Only standard lengths of conductor shall be wound on each drum. The method of lagging to be employed shall be clearly stated in the tender.

9.15. As an alternative to wooden drum Bidder may also supply the conductors in non-returnable painted steel drums. The painting shall conform to IS:9954-1981, reaffirmed in 1992. Wooden/steel drum will be treated at par for evaluation purpose and accordingly the Bidder should quote the package.

10. LABELLING AND MARKING
The drum number shall be branded or gauged or stencilled into the flange. An arrow shall be marked on the sides of the drum, together with the words "Roll this way". Each drum shall have the following information provided on the outside of the flange stencilled with indelible ink.

i) Manufacturer's name and address.
iii) Size and type of conductor.
iv) Net weight of the conductor.
v) Gross weight of the conductor and drum.
vi) Length of the conductor.
vii) Position of the conductor end.
viii) Drum and lot number.
ix) Name and address of the consignee.
x) Month and year of manufacture.
xii) The drum may also be marked with standard specification as per which the conductor is manufactured.

11. STANDARD LENGTHS

11.1. The standard length of the conductor shall be 2500 metres. A tolerance of plus or minus 5% on the standard length offered by the bidder shall be permitted. All lengths outside this limit of tolerance shall be treated as random lengths.

11.2. Random lengths will be accepted provided no length is less than 70% of the standard length and total quantity of such random length shall not be more than 10% of the total quantity order. When one number random length has been manufactured at any time, five (5) more individual lengths, each equivalent to the above random length with a tolerance of +/- 5% shall also be manufactured and all above six random lengths shall be dispatched in the same shipment. At any point, the cumulative quantity supplied including such random lengths shall not be more than 12.5% of the total cumulative quantity supplied including such random lengths. However, the last 20% of the quantity ordered shall be supplied only in standard length as specified.

11.3. Bidder shall also indicate the maximum single length, above the standard length, he can manufacture in the guaranteed technical particulars of offer. This is required for special stretches like river crossing etc. The Employer reserves the right to place orders for the above lengths on the same terms and conditions applicable for the standard lengths during the pendency of the Contract.

12. QUALITY ASSURANCE PLAN
A Quality Assurance Plan including customer hold points covering the manufacturing activities of the material shall be required to be submitted by the tenderer to the Employer along with the tender. The Quality Assurance Plan after the same is found acceptable, will be approved by the Employer.

The contractor shall follow the approved Quality Assurance Plan in true spirit. If desired by the Employer, he shall give access to all the documents and materials to satisfy the Employer that the Quality Assurance Plan is being properly followed.

13. TESTING

13.1. SELECTION OF TEST SAMPLES FOR TYPE TESTS

13.1.1. The samples shall be taken from a continuous length of conductor and subjected to all the tests specified in clause 14.

13.2. SELECTION OF TEST SAMPLES FOR ACCEPTANCE TESTS

13.2.1. Before dispatch from the works individual wire and finished steel cored aluminum conductor shall be subjected to the tests as specified in IS:398 or any other authoritative standard.

13.2.2. Sample for individual wires for test shall be taken before stranding from outer ends of not less than ten per cent of the spools in the case of aluminum wire and ten per cent of the wire coils in the case of steel wires. If samples are taken after stranding, they shall be obtained by cutting 1.2 meters from the outer ends of the finished conductor from not more than 10 per cent of the finished reels.

13.2.3. The routine tests shall be same as acceptance test. The manufacturer will draw samples for routine tests as per Cl. 13.1.1 or 13.1.2 of IS: 398 (Part 2) and will maintain the record of routine tests for buyer’s review. For acceptance tests, the sample shall be taken as per Cl. 13.1.2 of IS: 398 (Part 2).

14. TESTS

The following tests shall be carried out on sample/samples of conductor.
14.1 **Type Tests**

(i) Visual examination
(ii) Measurement of diameters of individual aluminum and steel wires.
(iii) Measurement of lay ratio of each layer
(iv) Breaking load test
(v) Ductility test
(vi) Wrapping test
(vii) Resistance test on aluminum wires.
(viii) DC resistance Test on aluminum wires.
(ix) Galvanizing test
(x) Surface condition test
(xi) Stress Strain test
(xii) Procedure qualification test on welded joint of Aluminum Strands.

**NOTE:** The type test reports shall not be older than FIVE years and shall be valid up to expiry of validity of offer.
The above additional lists if not conducted earlier, shall be done under the subject project package at no extra cost.

14.2 **Acceptance tests and Routine tests**

(ii) Visual and dimensional check on drum.
(iii) Visual examination
(iv) Measurement of diameters of individual aluminum and steel wires.
(v) Measurement of lay ratio of each layer
(vi) Breaking load test
(vii) Ductility test
(viii) Wrapping test
(ix) Resistance test on aluminum wires.
(x) DC resistance Test on Composite Conductor.
(xi) Galvanizing test

14.3 **Tests During Manufacture**

The following tests during manufacture shall be carried out.

(i) Chemical analysis of zinc used for galvanising,
(ii) Chemical analysis of aluminum used for making aluminum strands,
(iii) Chemical analysis of steel used for making steel strands,

14.4 **Visual examination**
The conductor shall be examined visually for good workmanship and general surface finish of the conductor. The conductor drums shall be rewound in the presence of Inspecting Officer. The Inspector will initially check for Scratches, Joints etc., and that the conductor shall generally conform to the requirements of the specifications/IS 398(Part-II)-1996.

14.5 Measurement of diameters of individual Aluminum and Steel Wires.

The diameters of individual Aluminum and Steel Wires shall be checked to ensure they conform to the requirements of this specification.

14.6 Measurement of lay-ratios

The lay-ratios of each layer of the conductor shall be measured and checked to ensure they conform to the requirements of this specification and IS:398 (Part-II)-1996.

14.7 Breaking load test

a) Breaking load test on complete conductor.

Circles perpendicular to the axis of the conductor shall be marked at two places on a sample of conductor of minimum 5m length between fixing arrangement suitably fixed on a tensile testing machine. The load shall be increased at a steady rate upto 50% of minimum specified UTS and held for one minute. The circles drawn shall not be distorted due to relative movement of strands. Thereafter the load shall be increased at steady rate to 100% of UTS and held for one minute. The Conductor sample shall not fail during this period. The applied load shall then be increased until the failing load is reached and the value recorded.

b) Breaking load test on individual aluminum and galvanized steel wires.

This test shall be conducted on both Aluminum and Galvanized steel wires. The breaking load of one specimen cut from each of the samples taken shall be determined by means of suitable tensile testing machine. The load shall be applied gradually and the rate of separation of the jaws of the testing machine shall be not less than 25 mm/min. and not greater than 100 mm./min. The ultimate breaking load of the specimens shall be not less than the values specified in the Section-II.

14.8 Ductility Test
For the purpose of this test both torsion and elongation tests shall be carried out on galvanized steel wires only.

14.9 **Torsion Test**

One specimen cut from each of the samples taken shall be gripped in two vices exactly 15 cms. apart. One of the vices shall be made to revolve at a speed not exceeding one revolution per second and the other shall be capable of moving longitudinally to allow for contraction or expansion during testing. A small tensile load not exceeding 2 (two) percent of the breaking load of the wire shall be applied to the samples during testing. The test shall be continued until fracture occurs and the fracture shall show a smooth surface at right angles to the axis of the wire. After fracture, the specimen shall be free from helical splits. The sample shall withstand a number of twists equivalent to not less than 18 on length equal to 100 times the diameter. When twisted after stranding the number of complete twists before fracture occurs shall be not less than 16 on a length equal to 100 times the diameter of the wire. In case test sample length is less or more than 100 times the stranded diameter of the strand, the minimum number of twists will be proportioned to the length and if number comes in the fraction then it will be rounded off to the next higher whole number. The fracture shall show a smooth surface at right angles to the axis of the wire.

14.10 **Elongation Test**

The elongation of one specimen cut from each of the samples taken shall be determined. The specimen shall be straightened by hand and an original gauge length of 200 mm. shall be marked on the wire. A tensile load shall be applied as described in 1.1.4.6.2.1 and the elongation shall be measured after the fractured ends have been fitted together. If the fracture occurs outside the gauge marks, or within 25 mm. of either mark and the required elongation is not obtained, the test shall be disregarded and another test conducted. When tested before stranding, the elongation shall be not less than 4 percent and when tested after stranding, the elongation shall be not less than 3.5 percent.

14.11 **Wrapping Test**

This test shall be conducted on both Aluminum and Galvanized steel wires.

14.11.1 **Aluminum wires**

One specimen cut from each of the samples of aluminum wires shall be wrapped round a wire of its own diameter to form a close helix of 8 turns. Six turns
shall then be unwrapped and closely wrapped in the same direction as before. The wire shall not break or show any crack.

14.11.2 Galvanized steel wires

One specimen cut from each of the samples of galvanized steel wire taken shall be wrapped round a mandrel of diameter equal to 4 times the wire diameter to form a close helix of 8 turns. Six turns shall then be unwrapped and again closely wrapped in the same direction as before. The wire shall not break.

14.12 Resistance Test

This test shall be conducted on aluminum wires only, conforming to procedure as per IEC:889. The electrical resistance of one specimen of aluminum wire cut from each of the samples taken shall be measured at ambient temperature. The measured resistance shall be corrected to the value corresponding to 20 degrees C. by means of following formula.

\[ R_{20} = \frac{R_T}{1 + \alpha \times (T-20)} \]

Where

\( R_{20} \) = Resistance corrected at 20 degrees C.

\( R_T \) = Resistance measured at T degrees C.

\( \alpha \) = Constant mass temperature coefficient of resistance

0.004. \( T \) = Ambient temperature during measurement

This resistance calculated to 20 degrees C. shall be not more than the maximum value specified in section-II.

14.13 Galvanizing Test

This test shall be conducted on galvanized steel wires only. The uniformity of Zinc coating and the weight of coating shall be in accordance with IS 4826-1979.
14.14 Surface Condition Test

A sample of the finished conductor for use in 11/33 KV system having a minimum length of 5 meters with compression type dead end clamps compressed on both ends in such manner as to permit the conductor to take its normal straight line shape, shall be subjected to a tension of 50 percent of the UTS of the conductor. The surface shall not depart from its cylindrical shape nor shall the strands move relative to each other so as to get out of place or disturb the longitudinal smoothness of conductor. The measured diameter at any place shall be not less than the sum of the minimum specified diameters of the individual aluminum and steel strands as indicated in Section-II.

14.15 Stress-Strain Test

The test is contemplated only to collect the creep data of the conductor from the manufacturer. A sample of conductor of minimum 10 meters length shall be suitably compressed with dead end clamps. (applicable only for conductors of nominal aluminium area 100 sq. mm and above)

15. TEST SET-UP

15.1. The test sample shall be supported in a trough over its full length and the trough adjusted so that the conductor will not be lifted by more than 10mm under tension. This shall be ascertained by actual measurement.

15.2. The distance between the clamp and the sleeve mouth shall be monitored with callipers during the test to ensure that, after the test, it does not change by more than 1mm + 0.1mm from the value before the test.

15.3. The conductor strain shall be evaluated from the measured displacements at the two ends of the gauge length of the sample. The gauge reference targets shall be attached to the clamps which lock the steel and aluminum wires together. Target plates may be used with dial gauges or displacement transducers and care shall be taken to position the plates perpendicular to the conductor. Twisting the conductor, lifting it and moving it from side-to-side by the maximum amounts expected during the test should introduce no more than 0.3mm error in the reading.

16. TEST LOADS FOR COMPLETE CONDUCTOR

The loading conditions for repeated stress-strain tests for complete conductor shall be as follows:

16.1. 1KN load shall be applied initially to straighten the conductor. The load shall be
removed after straightening and then the strain gauges are to be set at zero tension.

16.2. For non-continuous stress-strain data, the strain readings at 1KN intervals at lower tensions and 5 KN intervals above 30% of UTS shall be recorded.
16.3. The sample shall be reloaded to 30% of UTS and held for 1 hour. Readings are to be noted after 5, 10, 15, 30, 45 and 60 minutes during the hold period. The load shall be released then after the hold period.

16.4. The sample shall be reloaded to 50% of UTS and held for 1 hour. Readings are to be noted after 5, 10, 15, 30, 45 and 60 minutes during the hold period. The load shall be released then after the hold period.

16.5. Reloading upto 70% of UTS shall be done and held for 1 hour. Readings are to be noted after 5, 10, 15, 30, 45 and 60 minutes. The load shall be released.

16.6. Reloading upto 85% of UTS shall be done and held for 1 hour. Readings are to be noted after 5, 10, 15, 30, 45 and 60 minutes and the load shall be released then.

16.7. Tension shall be applied again and shall be increased uniformly until the actual breaking strength is reached. Simultaneous readings of tension and elongation shall be recorded upto 90% of UTS at the intervals described under Clause 16.6.

17. **TEST LOADS FOR STEEL CORE ONLY** (applicable only for conductors of nominal aluminum area 100 sq. mm and above)

The loading conditions for repeated stress-strain tests for the steel core of ACSR shall be as follows:

17.1. The test shall consist of successive applications of load applied in a manner similar to that for the complete conductor at 30%, 50%, 70% and 85% of UTS.

17.2. The steel core shall be loaded until the elongation at the beginning of each hold period corresponds to that obtained on the complete conductor at 30%, 50%, 70% and 85% of UTS respectively.

18. **STRESS-STRAIN CURVES**

The design stress-strain curve shall be obtained by drawing a smooth curve through the 0.5 and 1 hour points at 30%, 50% and 70% of UTS loadings. The presence of any aluminum slack that can be related to any observed extrusion entering the span from the compression dead ends shall be removed from the lower ends of the design curves. Both the laboratory and standard stress-strain curves shall be submitted to the Employer along with test results. The stress-strain data obtained during the test shall be corrected to the standard temperature i.e. 20 deg.C.
19. **DC RESISTANCE TEST ON COMPOSITE CONDUCTOR**

On a conductor sample of minimum 5m length, two contact clamps shall be fixed with a pre-determined bolt torque. The resistance of the sample shall be measured by a Kelvin double bridge by placing the clamps initially zero meter and subsequently one meter apart. The test shall be repeated at least five times and the average value recorded. The value obtained shall be corrected to the value at 20 deg C as per clause no. 12.8 of IS:398 (Part-II)-1982/1996. The corrected resistance value at 20 deg C shall conform to the requirements of this specification.

20. **PROCEDURE QUALIFICATION TEST ON WELDED ALUMINUM STRANDS.**

Two Aluminum wires shall be welded as per the approved quality plan and shall be subjected to tensile load. The breaking strength of the welded joint of the wire shall not be less than the guaranteed breaking strength of individual strands.

21. **CHEMICAL ANALYSIS OF ALUMINUM AND STEEL**

Samples taken from the Aluminum and Steel ingots / coils/ strands shall be chemically/ spectrographically analyzed. The same shall be in conformity with the requirements stated in this specification.

22. **CHEMICAL ANALYSIS OF ZINC**

Samples taken from the zinc ingots shall be chemically / spectrographically analysed. The same shall be in conformity with the requirements stated in this specification.

23. **VISUAL AND DIMENSIONAL CHECK ON DRUMS**

The drums shall be visually and dimensionally checked to ensure that they conform to the requirements of this specification.

24. **REJECTION AND RETEST**

24.1. In case of failure in any type test, the Manufacturer is either required to manufacture fresh sample lot and repeat all the tests successfully once or repeat that particular type test three times successfully on the sample selected from the already manufactured lot at his own expenses. In case a fresh lot is manufactured for testing then the lot already manufactured shall be rejected.
24.2. If samples are taken for test after stranding and if any selected reel fails in the retest, the manufacturer may test each and every reel and submit them for further inspection. All rejected material shall be suitably marked and segregated.

25. **CHECKING AND VERIFICATION OF LENGTH OF CONDUCTOR**

The contractor should arrange for inspection by the representative of the Employer specially authorised for this purpose. At least 50% of the total number of drums of conductor subject to minimum of two taken at random should be checked to ascertain the length of conductor. Arrangements should be made available in the works of the manufacturer for transferring the conductor from one reel to another at the same time measuring the length of the conductor so transferred by means of a meter.

26. **ADDITIONAL TESTS**

The Employer reserves the right of having at his own expenses any other test(s) of reasonable nature carried out at Bidder's premises, at site, or in any other standard Laboratory in addition to the aforesaid type, acceptance and routine tests to satisfy himself that the materials comply with the specifications.

27. **TESTING EXPENSES**

27.1. The breakup of the testing charges for the type tests specified shall be indicated separately.

27.2. Bidder shall indicate the laboratories in which they propose to conduct the type test. They shall ensure that adequate facilities are available in the laboratories and the tests can be completed in these laboratories within the time schedule guaranteed by them.

27.3. The entire cost of testing for the acceptance and routine tests and tests during manufacture specified herein shall be treated as included in the quoted unit price of the conductor, except for the expenses of the inspector/Employer's representative.

27.4. In case of failure in any type test, if repeat type tests are required to be conducted then all the expenses for deputation of Inspector/Employer's representative shall be deducted from the contract price. Also if on receipt of the Manufacturer's notice of testing, the Employer's representative does not find 'plant' to be ready for testing, the expenses incurred by the Employer for re-deputation shall be deducted from contract price.

28. **TEST REPORTS**
28.1. Copies of type test reports shall be furnished in at least six copies along with one original. One copy will be returned duly certified by the Employer only after which the commercial production of the material shall start.

28.2. Record of Routine test reports shall be maintained by the Manufacturer at his works for periodic inspection by the Employer's representative.

28.3. Test certificates of Tests during manufacture shall be maintained by the Manufacturer. These shall be produced for verification as and when desired by the Employer.

29. TEST FACILITIES

The following additional test facilities shall be available at the Manufacturer's works:

(i) Calibration of various testing and measuring equipment including tensile testing machine, resistance measurement facilities, burette, thermometer, barometer, etc.

(ii) Standard resistance for calibration of resistance bridges.

(iii) Finished Conductor shall be checked for length verification and surface finish on separate rewinding machine at reduced speed (variable from 8 to 16 meters per minute). The rewinding facilities shall have appropriate clutch system and be free of vibrations, jerks etc. with traverse laying facilities.

30. INSPECTION

30.1. The Employer's representative shall, at all times, be entitled to have access to the works and all places of manufacture where conductor shall be manufactured and the representative shall have full facilities for unrestricted inspection of the Bidder's works, raw materials and process of manufacture and conducting necessary tests as detailed herein.

30.2. The Bidder shall keep the Employer informed in advance of the time of starting and of the progress of manufacture of conductor in its various stages so that arrangements can be made for inspection.

30.3. The contractor will intimate the Employer about carrying out of the tests at least 45 days in advance of the scheduled date of tests during which the Employer will arrange to depute his representative/s to be present at the time of carrying out of the tests. Six (6) copies of the test reports shall be submitted.
30.4. No material shall be dispatched from its point of manufacture before it has been satisfactorily inspected and tested, Unless the inspection is waived off by the employer in writing. In the later case also, the conductor shall be dispatched only after satisfactory testing for all tests specified herein has been completed and approved by the employer.

30.5. The acceptance of any quantity of material shall in no way relieve the Bidder of any of his responsibilities for meeting all requirements of the specification, and shall not prevent subsequent rejection if such material is later found to be defective.

30.6. At least 50% of the total number of drums subject to minimum of two in any lot put up for inspection, shall be selected at random to ascertain the length of conductor by the following method:

"At the works of the manufacturer of the conductor, the conductor shall be transferred from one drum to another at the same time measuring its length with the help of a graduated pulley and Cyclometer. The difference in the average length thus obtained and as declared by the Bidder in the packing list shall be applied to all the drums if the conductor is found short during checking".

31. **SCHEDULE OF DEVIATIONS/VARIATIONS**

If the tenderer has any exceptions to any of the clause/s laid down in this specification, these should be clearly stated in the schedule of deviations / variations.

**SECTION - II  SPECIFIC TECHNICAL REQUIREMENTS SCOPE**

This section of the specification covers climatic and isoceraunic conditions, specific technical particulars, schedule of requirements & desired deliveries, for conductor for 11/33 kV lines.

**1. CLIMATIC & ISOCERAUNIC CONDITIONS TO BE SPECIFIED BY EMPLOYER**

1.11 Maximum Temperature

a) Conductor °C.

1.22 Minimum Temperature °C.
1.3 i) Max. ambient temperature °C

ii) Mean annual / every day temperature °C

2.5 Relative humidity

i) Maximum %

ii) Minimum %

2.6 Average Rainfall (Max.) mm per annum

2.7a) Rainy months May to Sept.

15 Rainy days in a year (days)

2.8 Average number of thunder storm

2.9 Altitude varying from sea level

2.10 Basic horizontal Seismic Co-efficient (horizontal) Basic vertical Seismic Co-efficient

2.11 System Particulars

a) Line Voltage (kV)

b) Highest System Voltage (kV)

c) Number of Circuits

d) Frequency HZ

e) Neutral

f) Short circuit level (KA)

2. SPECIFIC TECHNICAL REQUIREMENTS
<table>
<thead>
<tr>
<th>CONDUCTOR:</th>
<th></th>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Conductor:</td>
<td>Rabbit/Raccoon/Dog/Weasel/Panther ACSR</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2. IS applicable:</td>
<td>IS-398 (part-II) 1996 latest revision</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3. Wire Diameter</td>
<td>Aluminium (mm)</td>
<td>6/3.35</td>
<td>6/4.06</td>
<td>6/4.72</td>
<td>6/2.59</td>
</tr>
<tr>
<td></td>
<td>Steel(mm)</td>
<td>1/3.35</td>
<td>1/4.09</td>
<td>7/1.57</td>
<td>1/2.59</td>
</tr>
<tr>
<td>4. Number of strands:</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Steel centre</td>
<td>1</td>
<td>1</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td></td>
<td>1st steel layer</td>
<td>-</td>
<td>6</td>
<td>6</td>
<td>6</td>
</tr>
<tr>
<td></td>
<td>1st Aluminium layer</td>
<td>6</td>
<td>6</td>
<td>6</td>
<td>6</td>
</tr>
<tr>
<td></td>
<td>2nd Aluminium layer</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5. Sectional Area of Aluminium (sq. mm.)</td>
<td>52.88</td>
<td>78.83</td>
<td>105</td>
<td>31.61</td>
<td>212.1</td>
</tr>
<tr>
<td>6. Total Sectional Area(sq.mm.)</td>
<td>61.7</td>
<td>91.97</td>
<td>118.5</td>
<td>36.88</td>
<td>261.5</td>
</tr>
<tr>
<td>7. Overall diameter(mm)</td>
<td>10.05</td>
<td>12.27</td>
<td>14.15</td>
<td>7.77</td>
<td>21</td>
</tr>
<tr>
<td>8. Approximate weight(Kg./Km.)</td>
<td>10.05</td>
<td>12.27</td>
<td>14.15</td>
<td>7.77</td>
<td>21</td>
</tr>
<tr>
<td>9. Calculated D.C resistance at 20 degrees C., maximum. (Ohms/Km)</td>
<td>0.552</td>
<td>4.371</td>
<td>2.2792</td>
<td>0.9289</td>
<td>0.139</td>
</tr>
<tr>
<td>10. Ultimate tensile strength (KN)</td>
<td>18.25</td>
<td>26.91</td>
<td>32.41</td>
<td>11.12</td>
<td>89.67</td>
</tr>
</tbody>
</table>
11. Final modulus of elasticity (GN/sq.m) | 79 | 79 | 75 | 79 | 80

12. Coefficient of linear expansion x 10-6 per°C | 19.1 | 19.1 | 19.8 | 19.1 | 17.8

13. Lay ratio

<table>
<thead>
<tr>
<th>Steel core 6 wire layer</th>
<th>Max</th>
<th>Min</th>
<th>Max</th>
<th>Min</th>
<th>Max</th>
<th>Min</th>
<th>Max</th>
<th>Min</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>28</td>
<td>13</td>
<td>28</td>
<td>13</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Aluminium 1st layer</th>
<th>Max</th>
<th>Min</th>
<th>Max</th>
<th>Min</th>
<th>Max</th>
<th>Min</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>14</td>
<td>10</td>
<td>14</td>
<td>10</td>
<td>14</td>
<td>10</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>2nd layer</th>
<th>Max</th>
<th>Min</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>16</td>
<td>10</td>
</tr>
</tbody>
</table>

14. Technical Particulars

<table>
<thead>
<tr>
<th>a. Diameter-mm</th>
<th>Rabbit</th>
<th>Raccon</th>
<th>Dog</th>
<th>Weasel</th>
<th>Panther</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Al</td>
<td>Steel</td>
<td>Al</td>
<td>Steel</td>
<td>Al</td>
</tr>
<tr>
<td>Standard(mm)</td>
<td>3.35</td>
<td>3.35</td>
<td>4.09</td>
<td>4.09</td>
<td>1.57</td>
</tr>
<tr>
<td>Maximum (mm)</td>
<td>3.42</td>
<td>3.38</td>
<td>4.17</td>
<td>4.13</td>
<td>1.60</td>
</tr>
<tr>
<td>Minimum (mm)</td>
<td>3.28</td>
<td>3.32</td>
<td>4.01</td>
<td>4.05</td>
<td>1.54</td>
</tr>
</tbody>
</table>

| b. Cross-sectional area of nominal diameter wire (mm²) | 8.814 | 8.814 | 13.14 | 13.14 | 1.936 | 17.50 | 5.269 | 5.269 | 7.069 | 7.069 |

| c. Weight (Kg/Km) | 68.75 | 23.82 | 102.48 | 35.51 | 15.10 | 47.30 | 41.09 | 14.24 | 55.13 | 19.11 |

| d. Min. breaking load (KN) | Before stranding | 11.58 | 1.43 | 17.27 | 2.08 | 2.70 | 2.78 | 6.92 | 0.89 | 9.29 | 1.17 |
|                           | After Stranding  | 11.00 | 1.36 | 16.4  | 1.98 | 2.57 | 2.64 | 6.57 | 0.85 | 8.83 | 1.11 |
| e. D.C. resistance at 20°C min. (Ohm/Km) | -3.265 | -2.194 | 1.65 | -5.49 | -4.079 |
15. Zinc coating of steel core:
   (i) The steel strands shall be hot dip galvanized as per IS: 4826.


   (iii) Quality of Zinc: IS-209/1979 or latest edition.

16. Joints in strands

16.1 Steel: Not permitted

16.2 **Aluminium**: No joint shall be permitted in the Aluminum wires in the outer most layer of the ACSR conductor. But permitted in the inner layers such that no two such joints are within 15 meters of each other in the complete stranded conductor.

15. Chemical composition of high carbon steel wire:

<table>
<thead>
<tr>
<th>Element</th>
<th>% Composition</th>
</tr>
</thead>
<tbody>
<tr>
<td>i) Carbon</td>
<td>0.5 to 0.85</td>
</tr>
<tr>
<td>ii) Manganese</td>
<td>0.5 to 1.10</td>
</tr>
<tr>
<td>iii) Phosphorus</td>
<td>Not more than 0.035</td>
</tr>
<tr>
<td>iv) Sulphur</td>
<td>Not more than 0.045</td>
</tr>
<tr>
<td>v) Silicon</td>
<td>0.10 to 0.35</td>
</tr>
</tbody>
</table>
AERIAL BUNCHED CABLES FOR 33kV LINES

SCOPE: This specification covers requirements of XLPE insulated, 33 kV Aerial Bunched Cables for overhead lines.

1. Qualifying Requirement of AB Cable Manufacturer/Supplier

2. The manufacturer should have manufactured, successfully type tested and supplied at least one hundred (100) kms of 33 kV or above voltage grade XLPE armoured and/or AB Cable in the last five (5) years as on the date of bid opening.

2. COMPOSITION OF THE CABLE

The Composite cable shall comprise three single-core cables twisted around a bare aluminium alloy messenger wire, which will carry the weight of the cable.

3. RATED VOLTAGE

The rated voltage of the cables shall be 33 kV and the maximum operating voltage shall be 36 kV.

4. APPLICABLE STANDARDS

Unless otherwise stipulated in this Specification, the following standards shall be applicable:

i) IS: 7098 (part-II) – 1985 – Cross linked Polyethylene Insulated PVC Sheathed Cables.
ii) IS:9130-1984-Conductors for Insulated Cables
iii) IS: 398 (Part-IV) – 1979 – Aluminium Alloy Conductors.

5. DETAILS OF SINGLE CORE CABLE

5.1 The cable conductors shall be or round standard and compacted aluminium, of nominal cross sectional area 95 mm2.

5.2 Conductor Screen

The conductor screen shall be of extruded semi-conducting cross linked polyethylene compound of thickness as per relevant IS.
5.3 **Insulation**

The insulation screen shall as per IS:7098 part 2.

5.4 **Insulation Screen**

The insulation screen shall comprise extruded semi-conducting compound and/or semi-conducting tape.

5.5 **Metallic Screen**

The metallic screen shall consist of aluminium tape/sheath.

5.6 **Outer Sheath**

The outer sheath shall be black polyethylene.

6. **MESSENGER (NEUTRAL CONDUCTOR)**

6.1 The bare messenger wire shall be of 120 mm² (nominal area) aluminium alloy, generally conforming to IS:398 (Part IV) – 1979, comprising multi strands and shall be suitably compacted to have smooth round surface to avoid damage to the outer insulating sheath of single-core phase cables twisted around the messenger.

6.2 There shall be no joints in any wire of the stranded messenger conductor except those made in the base rod or wire before finally drawing.

7. **TESTS**

7.1 The following tests shall be carried out on the single-core cables as per IS-7098 (Part-II).

7.1.1 **Type Tests**

a) Tests on conductor:

   i) Tensile test

   ii) Wrapping test
b) Tests for thickness of insulation and sheath

c) Physical tests for insulation:
   i) Tensile strength and elongation at break
   ii) Agency in air oven
   iii) Hot test
   iv) Shrinkage test
   v) Water absorption

d) Tests for outer sheath:
   i) Tensile strength and elongation at break
   ii) Ageing in air oven
   iii) Shrinkage test
   iv) Hot deformation
   v) Bleeding and blooming test.

e) Partial discharge test
f) Bending test
g) Dielectric Power factor test:
   i) As a function of voltage
   ii) As a function of temperature
h) Insulation resistance test

g) Heating cycle test
k) High voltage test
l) Flammability test

7.1.2 Acceptance Test

a) Tensile Test
b) Wrapping Test

c) Conductor resistance test
7.1.3 Routine Tests

a) Conductor resistance test
b) Partial Discharge Test
c) High voltage test

7.2 The following tests shall be carried out on the bare messenger wire in accordance with IS:398 (Part-IV).

Type Tests/Acceptance Test

a) Breaking Load Test (on finished wire)
b) Elongation Test
c) Resistance Test

8. PACKING AND MARKING

8.1 Packing

Cables shall be supplied in returnable wooden drums conforming to IS: 10418. The standard length of the bunched cable in each drum shall be 250 meters (+/-) 10%. Other lengths may be acceptable subject to the approval of employer/purchaser.

8.2 Marketing
The Cable drum shall carry the information as per the requirements of IS: 7098 (Part-II). However, exact details of marketing/embossing, color of outer sheath etc. will be as per the detailed purchase order.

8.3 Suitable identification marks shall be given on the outer sheath to clearly distinguish three phases of the bunched cable.
AERIAL BUNCHED CABLES FOR 11kV LINES

**SCOPE:** This specification covers requirements of XLPE insulated, 11kV Aerial Bunched Cables for overhead lines.

1.0 Qualifying Requirement of AB Cable Manufacturer/Supplier

The manufacturer should have manufactured, successfully type tested and supplied at least one hundred (100) kms of 11kV or above voltage grade XLPE armoured and/or AB cable in the last five (5) years as on the date of bid opening.

2. COMPOSITION OF THE CABLE

The composite cable shall compose three single-core cables twisted around a bare aluminium alloy messenger wire, which will carry the weight of the cable.

3. RATED VOLTAGE

The rated voltage of the cables shall be 6.35 kV/11kV and the maximum operating voltage shall be 12 kV.

4. APPLICABLE STANDARDS

Unless otherwise stipulated in this specification, the following standards shall be applicable:

i) IS:7098 (part-II) – 1985 – Cross linked Polyethylene Insulated PVC Sheathed Cables

ii) IS:8130-1984-Conductors for Insulated Cables

iii) IS:398 (Part-IV) – 1979 – Aluminium Alloy Conductors

5. DETAILS OF SINGLE CORE CABLE

5.1 The cable conductors shall be of round, stranded and compacted aluminium of nominal cross sectional area 35 mm² and 70 mm². Corresponding nominal conductor diameter and number of wires in the conductor shall be as given in clause 5.7.

5.2 Conductor Screen

The conductors screen shall be of extruded semi-conducting cross linked polyethylene compound of thickness not less than 0.5 mm.
5.3 Insulation

The Insulation screen shall be as per IS:7098 (Part II).

5.4 Insulation screen

The Insulation screen shall comprise extruded semi-conducting compound and/or semi-conducting tape. Thickness of the screen shall be not less than 0.6 mm.

5.5 Outer Sheath

The outer sheath shall be black polyethylene. The nominal thickness of sheath shall be 1.8mm and it shall conform to the technical requirements of ST-3 of EIC-502.

5.6 Dimensional and Electrical Data

The Dimensional and Electrical Data for single –core cable is given below:

<table>
<thead>
<tr>
<th>S.No.</th>
<th>Description</th>
<th>Nominal area of conductors</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>35 mm²</td>
</tr>
<tr>
<td>I.</td>
<td>Nominal conductor diameter(mm)/No. of wires in conductor</td>
<td>6.8/6</td>
</tr>
<tr>
<td>II.</td>
<td>Approx over dia of cable (mm)</td>
<td>22</td>
</tr>
<tr>
<td>III.</td>
<td>Max D.C. resistance at 200ºC</td>
<td>0.868</td>
</tr>
<tr>
<td>IV.</td>
<td>Max SC current for 1 Sec. KA</td>
<td>3.4</td>
</tr>
<tr>
<td>V.</td>
<td>Max continuous load (amps)</td>
<td>106</td>
</tr>
</tbody>
</table>

Note: Due to limitation of short circuit current rating, it is recommended that 70mm² cable is used as the base line for the first 4-5kms from the 33/11kV substation and thereafter the lower size of cable i.e. 35mm² can be used depending upon the line loading. Normally the current loading of 70mm² cable should not exceed 145amps and that of 35mm² cable as 95 amps. For a maximum ambient temperature of 50°C.

6. MESSENGER (NEUTRAL CONDUCTOR)

6.1 The bare messenger wire shall be of 70 mm² (nominal area) aluminium alloy, generally conforming to IS:398 (Part IV) – 1979, comprising of seven(7) strands and shall be suitably compacted to have smooth round surface to avoid damage to the outer insulating sheath of single-core phase cables twisted around the messenger.

6.2 There shall be no joints in any wire of the stranded messenger conductor except those made in the base rod or wire before finally drawing.
6.3 The technical characteristics of messenger wire shall be as follows:

<table>
<thead>
<tr>
<th></th>
<th>Description</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>i.</td>
<td>Nominal sectional area (mm²)</td>
<td>70</td>
</tr>
<tr>
<td>ii.</td>
<td>Nos. of wire</td>
<td>7</td>
</tr>
<tr>
<td>iii.</td>
<td>Nominal dia of wires / compacted conductor (approx.) mm</td>
<td>3.5/10</td>
</tr>
<tr>
<td>iv.</td>
<td>Approx. Mass kg/Km</td>
<td>184</td>
</tr>
<tr>
<td>v.</td>
<td>D.C resistance at 20°C Ohm/Km</td>
<td>0.493</td>
</tr>
<tr>
<td>vi.</td>
<td>Breaking load (KN)</td>
<td>20</td>
</tr>
<tr>
<td>vii.</td>
<td>Modulus of elasticity (approx.) KN/mm²</td>
<td>59</td>
</tr>
<tr>
<td>viii.</td>
<td>Coefficient of linear expansion</td>
<td>$23 \times 10^{-6}$°C</td>
</tr>
</tbody>
</table>

Note: the value of item v above is to be guaranteed. A tolerance of (-) 5% is permissible on the value in item vi above.

7. DESIGNATION AND PARAMETER OF FINISHED CABLES

The designation and parameter of finished cables are given in the following table:

<table>
<thead>
<tr>
<th>S.No.</th>
<th>Designation</th>
<th>Complete bunched cables</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Overall dia approx</td>
</tr>
<tr>
<td>I.</td>
<td>3 x 35+70</td>
<td>53</td>
</tr>
<tr>
<td>II.</td>
<td>3 x 70+70</td>
<td>59</td>
</tr>
</tbody>
</table>

Note: the first part of the designation refers to the number and size of phase conductor and the second to the size of messenger wire. The sizes shown represent the nominal cross sectional area in mm.

8. TESTS

8.1 The following tests shall be carried out on the single-core cables as per IS-7098 (Part-II).

8.1.1 Type Tests

a) Tests on conductor:

i) Tensile test

ii) Wrapping test
iii) Resistance test

b) Tests for thickness of insulation and sheath

c) Physical tests for insulation:

i) Tensile strength and elongation at break

ii) Agency in air oven

iii) Hot test
iv) Shrinkage test
v) Water absorption

d) Tests for outer sheath:

i) Tensile strength and elongation at break

ii) Ageing in air oven

iii) Shrinkage test
vi) Hot deformation
vii) Bleeding and blooming test.

e) Partial discharge test
f) Bending test
g) Dielectric Power factor test:
i) As a function of voltage
ii) As a function of temperature

h) Insulation resistance test

g) Heating cycle test

k) High voltage test
l) Flammability test

8.1.2 Acceptance Test

a) Tensile Test

b) Wrapping Test
c) Conductor resistance test

d) Test for thickness of insulation and sheath

e) Hot set test for insulation

f) Tensile strength and elongation at break test for insulation and sheath

g) Partial discharge test

h) High voltage test

i) Insulation resistance (volume resistivity) test

8.1.3 **Routine Tests**

a) Conductor resistance test

b) Partial Discharge Test

c) High voltage test

8.2 **The following tests shall be carried out on the bare messenger wire in accordance with IS:398 (Part-IV).**

Type Tests/Acceptance Test

a) Breaking Load Test (on finished wire

b) Elongation Test

c) Resistance Test

9. **PACKING AND MARKING**

9.1 **Packing**

Cables shall be supplied in returnable wooden drums conforming to IS: 10418. The standard length of the bunched cable in each drum shall be 1000 meters (+/-) 10%. Other lengths may be acceptable subject to the approval of employer/purchaser.
9.2 **Marking**

The Cable drum shall carry the information as per the requirements of IS: 7098 (Part-II). However, exact details of marking/embossing, color of outer sheath etc. Will be as per the detailed purchase order.

9.3 Suitable identification marks shall be given on the outer sheath to clearly distinguish three phases of the bunched cable.

2. **LT Aerial Bunched Cables**

(APPLICABLE FOR LT AB CABLE WITH XLPE INSULATION ONLY)

1. **SCOPE:**

This specification covers XLPE insulated Aluminum cable twisted over a central bare Aluminum Alloy messenger wire for use of L.T. Over-Headlines in Rural Electrification System. The Aerial Bunched cable and messenger wire should be confirming to IS.

(Sizes: of the cable)

1.01 1X16 (Ph) + 1X25 (bare messenger cum neutral) SQ. MM.
1.02 1X16 (Ph) + 1X25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.03 3X16(Ph)+1X25 (bare messenger cum neutral) SQ. MM.
1.04 3 X 16(Ph) +1x25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.05 1X25(Ph)+1x25 (bare messenger cum neutral) SQ. MM.
1.06 1X25(Ph) + 1X25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.07 3X25(Ph)+1x25 (bare messenger cum neutral) SQ. MM.
1.08 3 X 25(Ph) +1x25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.09 1X35(Ph)+1X25 (bare messenger cum neutral) SQ. MM.
1.10 1x35(Ph) + 1X25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.11 3X35(Ph)+1X25 (bare messenger cum neutral) SQ. MM.
1.12 3X35 (Ph) + 1x25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.13 3X50(Ph)+1X35 (bare messenger cum neutral) SQ. MM.
1.14 3X50 (Ph)+1x35 (bare messenger cum neutral) +1x16 (insulated Street lighting) SQ. MM.
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1.15  3X95(Ph)+1X70 (bare messenger cum neutral) SQ. MM.
1.16  3X95(Ph)+1X70 (bare messenger cum neutral) SQ. MM.+1x16 (insulated Street lighting)SQ. MM.

2. RATED VOLTAGE:

The rated voltage of the AB cables shall be 1100 volts

3. APPLICABLE STANDARDS:

Unless otherwise stipulated in this specification the following Standards shall be applicable.


ii) IS – 8130/1984 : Conductors for insulated cables.


iv) IS – 10418/1982 : Drums for electric cables

4. GENERAL:

The AB cable covered under this specification should be suitable for use on three phase, 4 wire earthed system for working voltage up to 1100 V. It should confirm the relevant standards stated above and others if applicable.

The phase conductor shall be 95 mm², 50 mm², 35 mm, 25 mm² and 16 mm² XLPE insulated and the messenger-cum-neutral conductor of sizes 70 mm², 35 mm² and 25 mm² shall be bare heat treated aluminium-magnesium-silicon alloy wires containing 0.5% magnesium and approximately 0.5% silicon confirming to IS: 398 (Part-IV):1979 and its latest amendment, if any.

5. PHASE CONDUCTORS:

5.1 The phase & street lighting conductor shall be provided cross linked poly ethylene insulation applied by extrusion. The thickness of insulation shall not be less than 1.2 mm up to 35mm² and shall not be less than 1.5 mm for above 35mm² at any point and insulation shall be so applied that it fits closely on the conductor and it shall be possible to remove it without damaging the conductor. The insulated conductors shall generally conform to the standards IS-14255:1995.

5.2 The phase conductors shall be provided with one, two & three ‘ridges’ for easy identification.
5.3 The tensile strength of the aluminum wire used in the conductor shall not be less 90 N/m².

5.4 The standard size and technical characteristics of the phase conductors shall be as shown in the Table-1.

TABLE-I

<table>
<thead>
<tr>
<th>Nominal Sectional area in mm²</th>
<th>No. of Strands</th>
<th>Diameter of Compacted conductor in mm</th>
<th>Approx. Mass Kg/KM's.</th>
<th>Max. DC Résistance at 20ºc (Ohm/km)</th>
<th>Insulation Thickness in mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
<td>6</td>
</tr>
<tr>
<td>16</td>
<td>7</td>
<td>4.4</td>
<td>42</td>
<td>1.91</td>
<td>1.2</td>
</tr>
<tr>
<td>25</td>
<td>7</td>
<td>5.6</td>
<td>65</td>
<td>1.20</td>
<td>1.2</td>
</tr>
<tr>
<td>35</td>
<td>7</td>
<td>6.7</td>
<td>95</td>
<td>0.868</td>
<td>1.2</td>
</tr>
<tr>
<td>50</td>
<td>7</td>
<td>8.0</td>
<td>127</td>
<td>0.641</td>
<td>1.5</td>
</tr>
<tr>
<td>95</td>
<td>19</td>
<td>11.0</td>
<td>266</td>
<td>0.320</td>
<td>1.5</td>
</tr>
</tbody>
</table>

NOTE: 1) The resistance values given in col.5 are the max. permissible.

Tolerance of + 5% is allowable on dimension.

6. MESSENGER-CUM-NEUTRAL WIRE:

6.1 The bare messenger wire shall be of aluminium alloy generally confirming to IS–398/Pt.IV/94 composed of 7 strands and shall be suitable compacted or stranded to have smooth round surface to avoid damages to the overall insulation of phase & neutral conductor twisted around the messenger.

6.2 There shall be no joint in any wire of the stranded messenger Conductor except these made in the base rod or wires before final drawing.

6.3 The sizes and other technical characteristics of the messenger wire shall be as given in the Table No.2.

TABLE –2
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<table>
<thead>
<tr>
<th>Nominal Sectional Area in mm²</th>
<th>No. of strands</th>
<th>Diameter of Compacted conductor in mm</th>
<th>Diameter of Stranded conductor in mm</th>
<th>Approx. Mass Kgs/KM</th>
<th>Max. DC Resistance</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
<td>6</td>
</tr>
<tr>
<td>25</td>
<td>7</td>
<td>5.6</td>
<td>6.42</td>
<td>65</td>
<td>1.380</td>
</tr>
<tr>
<td>35</td>
<td>7</td>
<td>6.7</td>
<td>7.56</td>
<td>95</td>
<td>0.986</td>
</tr>
<tr>
<td>70</td>
<td>7</td>
<td>9.4</td>
<td>10.65</td>
<td>196</td>
<td>0.492</td>
</tr>
</tbody>
</table>

NOTE: while limiting values in col. 3 is to be guaranteed a tolerance of + 5% will be permissible.

7. **XLPE INSULATION:**

The insulation shall generally conform to IS-14255

<table>
<thead>
<tr>
<th>Sr.No.</th>
<th>Property</th>
<th>Requirement</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Tensile Strength</td>
<td>12.5 N / mm² Min</td>
</tr>
<tr>
<td>2</td>
<td>Elongation at break</td>
<td>200 % Min.</td>
</tr>
<tr>
<td>3</td>
<td>Ageing in air over</td>
<td></td>
</tr>
<tr>
<td>a</td>
<td>Treatment: Temperature &amp; duration</td>
<td>135 ± 3ºC &amp; 7 days</td>
</tr>
<tr>
<td>b</td>
<td>Tensile strength variation</td>
<td>± 25% Max.</td>
</tr>
<tr>
<td>c</td>
<td>Elongation variation</td>
<td>± 25% Max.</td>
</tr>
<tr>
<td>4</td>
<td>Hot Set</td>
<td></td>
</tr>
<tr>
<td>a</td>
<td>Treatment temperature,</td>
<td>200 ± 3ºC,</td>
</tr>
<tr>
<td>b</td>
<td>Time</td>
<td>15 minutes</td>
</tr>
<tr>
<td>c</td>
<td>Under load, mechanical stresses</td>
<td>20 N /cm².</td>
</tr>
<tr>
<td>5</td>
<td>Elongation under load</td>
<td>175 % max.</td>
</tr>
<tr>
<td>6</td>
<td>Permanent elongation (set) after cooling</td>
<td>15 % Max</td>
</tr>
<tr>
<td>7</td>
<td>Shrinkage</td>
<td></td>
</tr>
<tr>
<td>a</td>
<td>Treatment temperature duration</td>
<td>130 ± 3ºC</td>
</tr>
<tr>
<td>b</td>
<td>Shrinkage</td>
<td>4% Max</td>
</tr>
<tr>
<td></td>
<td></td>
<td>For 1 hour</td>
</tr>
</tbody>
</table>
8. **TYPE TEST:**

A. **Test for Phase/Street Light Conductors**

   (ii) Tensile Test (IS-8130)

   (iii) Wrapping Test (IS-8130)

   (iv) Conductor Resistance Test (IS-8130)

B. **Test for Messenger:**

   (i) Breaking load test (to be made on finished conductor) - (IS-398/ Pt.IV/ 1994 with latest revision)

   (ii) Elongation test (IS - 398 / Pt.IV/1994)

   (iii) Resistance test (IS - 398 / Pt. IV /1994)

   (iv) If insulated , the test of insulation as per relevant IS will be applicable

C. **Physical test for XLPE insulation**

   (iii) Tensile strength and Elongation at break

   (iv) Ageing in air oven

   (v) Hot set test

   (vi) Shrinkage test
(vii) Water absorption (Gravimetric)

(viii) Carbon black 1. Content & 2. Dispersion

D. Test for thickness of insulation

E. Insulation Resistance (Volume Resistivity) Test

F. High Voltage Test

Note: The Manufacturer should submit the entire above type test of Govt. of India’s approved Laboratory along with their offer.

Optional Test:

Bending test on the completed cable:

Bending test shall be performed on a sample of complete cable. The sample shall be bent around a test mandrel at room temperature for at least one complete turn. It shall then be unwound and the process shall be repeated after turning the sample around its axis 180°. The cycle of this operation shall be then repeated twice.

The diameter of mandrel shall be 10 (D+d).

Where

\[ D = \text{Actual diameter of cable (i.e. the min. circumscribing diameter in mm)} \]
\[ d = \text{Actual diameter of the phase conductor in mm} \]

No cracks visible to the naked eye are allowed.

9. ACCEPTANCE TESTS:

Tests for Phase / Street Light Conductors:

a. Tensile test (for Phase / Street light conductor)

b. Wrapping test (for Phase / Street light conductor)
c. Breaking load test for messenger conductor

d. Elongation test for messenger conductor

e. Conductor Resistance test

f. Test for thickness of insulation

g. Tensile strength and elongation at break test

h. Hot set test (For XLPE insulation)

i. Insulation Resistance test

j. High voltage test

10. PACKING MARKING:

10.1 The LT AB cable shall be wound in nonreturnable drums conforming to IS-10418/1982 “Specification for Reels and Drums for bare wire” of the latest version thereof. The drums shall be marked with the following:

b) Manufacturers name

c) Trade mark if any

d) Drum number

e) Size of Conductor

f) Size of Messenger

g) Voltage grade

h) Number of lengths of pieces of Cable in each drum

i) Gross mass of the packing

j) Net mass of Cable
k) ISI mark

10.2 The drums shall be of such a construction as to assure delivery of conductor in field free from displacement and damage and should be able to withstand all stresses due to handling and the stringing operation so that cable surface not dented, scratched or damaged in any way during transport and erection. The cable shall be properly lugged on the drums.

10.3 The cable drums should be suitable for wheel mounting.

11. STANDARD LENGTH:

The standard length of drum will be 500 meter with ± 5%

Non-standard Length:

Nonstandard length not less than 50% of the standard length shall be accepted to the extent of 10% of the ordered quantity.

12. INSPECTION:

All tests and inspections shall be made at the place of manufacturer unless otherwise especially agreed upon by the manufacturer and purchaser at the time of purchase. The manufacturer shall afford the inspector representing the purchaser all reasonable facilities, without charge, to satisfy him that the material is being furnished in accordance with this specification.

13. EXPERIENCE:

The manufacturer must have some experience of manufacturer and supply of this cable to any Electricity Board. Copy of order executed and performance report may be submitted along with the offer.

14. TYPE TEST CERTIFICATES:

The duly attested copy of Type Test Certificate of the offered sizes of AB cable, as per IS: 14255/1995 with latest amendment/revision be submitted from any Govt. laboratory or from a NABL accredited laboratory along with the offer. Type Test Certificate shall not be more than Five Years Old from Date of supply.
However, if the same are not available at the time of bidding, the same may be submitted after order but before commencement of supply.

In case, the bidder is not able to submit the Type Test Certificate from any Govt. laboratory or from a NABL accredited laboratory for any size of cable, the same shall be conducted by the bidder free of cost without any additional financial liability on utility. For this purpose, Type test Report of a phase wire or messenger wire once tested shall be accepted for all other combination. For example, if 1x16 + 25 sq mm and 3x35 + 25 sq mm already tested then this will be valid for 3x16+25 sq mm (as phase wire of 16 sq mm and messenger wire of 25 sq mm are already tested) and for 3x35 + 25 sq mm + 16 sq mm (as phase wire of 35 & 16 sq mm and messenger wire of 25 sq mm are already tested).

15. **SUBMISSION OF ISI LICENSE FOR IS14255:1995**

The Manufacturer are required to submit duly attested photo copy of the valid ISI License up to the date of delivery for supply of these AB cables/wires and they should also submit GTP failing which, the offer would be ignored.

16. **IMPORTANT:**

In absence of valid ISI License/GTP duly filled in and copy of type test certificate of Govt. approved Laboratory, duly attested by authorized person, offer will be liable to be ignored without any further correspondence.

17. **ISI MARKING:**

The material supplied shall be conforming to Indian Standard Specification and also with ISI marking as applicable and even after inspection of the lot, if the materials received at site is found without ISI marking, the lot shall be rejected and no further correspondence shall be entertained in this regard.

Exact details of marking/embossing, color of outer sheath etc. will be as per the detailed purchase order.
GUARANTEED TECHNICAL PARTICULARS (G.T.P.)

Technical information and Guaranteed Technical Particulars (G.T.P.) for LT Aerial Bunched Cable (XLPE insulated only) of sizes:

1.01 1X16 (Ph) + 1X25 (bare messenger cum neutral) SQ. MM.
1.02 1X16 (Ph) + 1X25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.03 3X16(Ph)+1X25 (bare messenger cum neutral) SQ. MM.
1.04 3 X 16(Ph) +1x25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.05 1X25(Ph)+1x25 (bare messenger cum neutral) SQ. MM.
1.06 1X25(Ph) + 1X25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.07 3X25(Ph)+1X25 (bare messenger cum neutral) SQ. MM.
1.08 3 X 25(Ph) +1x25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.09 1X35(Ph)+1X25 (bare messenger cum neutral) SQ. MM.
1.10 1x35(Ph) + 1X25 (bare messenger cum neutral) + 1x16 (insulated Street lighting) SQ. MM.
1.11 3X35(Ph)+1X25 (bare messenger cum neutral) SQ. MM.
1.12 3X35 (Ph) + 1x25 (bare messenger cum neutral)+ 1x16 (insulated Street lighting) SQ. MM.
1.13 3X50(Ph)+1X35 (bare messenger cum neutral) SQ. MM.
1.14 3X50 (Ph)+1x35 (bare messenger cum neutral) +1x16 (insulated Street lighting) SQ. MM.
1.15 3X95(Ph)+1X70 (bare messenger cum neutral) SQ. MM.
1.16 3X95(Ph)+1X70 (bare messenger cum neutral) SQ. MM.+1x16 (insulated Street lighting)SQ. MM.

PART – A

Manufacturer has to confirm following important requirements:

<table>
<thead>
<tr>
<th>Sr. No.</th>
<th>Particulars</th>
<th>confirmation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>AB Cable shall be manufactured and supplied Confirming to IS: 14255/1995</td>
<td>Yes</td>
</tr>
</tbody>
</table>
### New Initiative on Material Mobilisation

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<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>2</td>
<td>Cable drums/label shall bear ISI Mark</td>
<td>Yes</td>
</tr>
<tr>
<td>3</td>
<td>ISI License shall remain valid till order is Completed</td>
<td>Yes</td>
</tr>
<tr>
<td>4</td>
<td>Colour of XLPE Insulation – Black</td>
<td></td>
</tr>
<tr>
<td>4a</td>
<td>1X16 + 1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4b</td>
<td>1X16 + 1X25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4c</td>
<td>3X16+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4d</td>
<td>3 X 16 +1x25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4e</td>
<td>1X25+1x25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4f</td>
<td>1X25 + 1X25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4g</td>
<td>3X25+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4h</td>
<td>3 X 25 +1x25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4i</td>
<td>1X35+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4j</td>
<td>1X35 + 1X25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4k</td>
<td>3X35+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4l</td>
<td>3X35 + 1x25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4m</td>
<td>3X50+1X35 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4n</td>
<td>3X50 +1x35 +1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4o</td>
<td>3X95+1X70 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>4p</td>
<td>3X95+1X70 +1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>5</td>
<td>Shape – compacted</td>
<td>Yes</td>
</tr>
<tr>
<td>6</td>
<td>Standard length in case 500 mtrs+ 5 % tolerance longer length acceptable</td>
<td>Yes</td>
</tr>
<tr>
<td>7</td>
<td>Non-Standard length  50% of Std. length up to 10%of ordered quantity</td>
<td>Yes</td>
</tr>
<tr>
<td>8</td>
<td>Packing shall contain only one Length.</td>
<td>Yes</td>
</tr>
<tr>
<td>9</td>
<td>Packing material: Wooden drums as per IS: 10418/1982 duly painted</td>
<td>Yes</td>
</tr>
<tr>
<td>9a</td>
<td>1X16 + 1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9b</td>
<td>1X16 + 1X25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9c</td>
<td>3X16+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9d</td>
<td>3 X 16 +1x25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>Description</td>
<td>Yes/No</td>
</tr>
<tr>
<td>---</td>
<td>-----------------------------------------------------------------------------</td>
<td>--------</td>
</tr>
<tr>
<td>9e</td>
<td>1X25+1x25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9f</td>
<td>1X25 + 1X25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9g</td>
<td>3X25+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9h</td>
<td>3 X 25 +1x25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9i</td>
<td>1X35+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9j</td>
<td>1x35 + 1X25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9k</td>
<td>3X35+1X25 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9l</td>
<td>3X35 + 1x25 + 1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9m</td>
<td>3X50+1X35 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9n</td>
<td>3X50 +1x35 +1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9o</td>
<td>3X95+1X70 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>9p</td>
<td>3X95+1X70 +1x16 SQ. MM.</td>
<td>Yes</td>
</tr>
<tr>
<td>10</td>
<td>Following shall be embossed on cable &amp; Marking on drum shall be as per IS: 14255/1995</td>
<td>Yes</td>
</tr>
<tr>
<td>10a</td>
<td>Purchaser (Employee)</td>
<td>Yes</td>
</tr>
<tr>
<td>10b</td>
<td>1100 Volts</td>
<td>Yes</td>
</tr>
<tr>
<td>10c</td>
<td>IS:14255/1995</td>
<td>Yes</td>
</tr>
<tr>
<td>10d</td>
<td>Year of manufacture</td>
<td>Yes</td>
</tr>
<tr>
<td>10e</td>
<td>Trade Mark</td>
<td>Yes</td>
</tr>
<tr>
<td>11</td>
<td>Conductor –</td>
<td></td>
</tr>
<tr>
<td>11a</td>
<td>For Phase 16 mm² ,25 mm², 35 mm², 50 mm² &amp; 95 mm² Aluminium as per IS 8130/1984</td>
<td>Yes</td>
</tr>
<tr>
<td>11b</td>
<td>For Messenger wire 25 mm², 35 mm² &amp; 70 mm² Aluminium Alloy as per IS 398/Pt.IV/1994</td>
<td>Yes</td>
</tr>
<tr>
<td>12</td>
<td>Maximum Conductor resistance at 20ºC For Phase Conductor</td>
<td></td>
</tr>
<tr>
<td>12a</td>
<td>16 mm² Conductor – 1.91 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td>12b</td>
<td>25 mm² Conductor – 1.20 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td>12c</td>
<td>35 mm² Conductor – 0.868 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td>12d</td>
<td>50 mm² Conductor – 0.641 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td>12e</td>
<td>95 mm² Conductor – 0.320 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>For messenger conductor</td>
<td></td>
</tr>
<tr>
<td>12e</td>
<td>25 mm² Conductor – 1.380 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td>12f</td>
<td>35 mm² Conductor – 0.986 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td>12g</td>
<td>70 mm² Conductor – 0.492 Ohm/KM</td>
<td>Yes</td>
</tr>
<tr>
<td>13</td>
<td>Minimum average XLPE Insulation thickness for AB Cable</td>
<td></td>
</tr>
<tr>
<td>13a</td>
<td>16 mm² - 1.2 mm</td>
<td>Yes</td>
</tr>
<tr>
<td>13b</td>
<td>25 mm² - 1.2 mm</td>
<td>Yes</td>
</tr>
<tr>
<td>13c</td>
<td>35 mm² - 1.2 mm</td>
<td>Yes</td>
</tr>
<tr>
<td>13d</td>
<td>50 mm² - 1.5 mm</td>
<td>Yes</td>
</tr>
<tr>
<td>-----</td>
<td>----------------</td>
<td>-----</td>
</tr>
<tr>
<td>13f</td>
<td>95 mm² - 1.5 mm</td>
<td>Yes</td>
</tr>
<tr>
<td>14</td>
<td>Volume resistivity of insulation</td>
<td></td>
</tr>
<tr>
<td>14a</td>
<td>At 27°C – 1 x 10^13 Ohm·cm. Min</td>
<td>Yes</td>
</tr>
<tr>
<td>14b</td>
<td>At 70°C – 1 x 10^11 Ohm·cm. Min</td>
<td>Yes</td>
</tr>
<tr>
<td>15</td>
<td>Tensile strength of Insulation &amp; sheath -12.5 N/mm² Min.</td>
<td>Yes</td>
</tr>
<tr>
<td>16</td>
<td>Elongation at break of Insulation and Sheath –200% Min.</td>
<td>Yes</td>
</tr>
<tr>
<td>17</td>
<td>Overall tolerance in supply of ordered total quantity shall be ± 2 % (Plus and minus two %)</td>
<td>Yes</td>
</tr>
</tbody>
</table>
Manufacturer has to furnish below details about material for information:

<table>
<thead>
<tr>
<th>Sr. No.</th>
<th>Particulars</th>
<th>confirmation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>ISI License for IS:14255/1995</td>
<td>Yes</td>
</tr>
<tr>
<td>1a</td>
<td>Number</td>
<td></td>
</tr>
<tr>
<td>1b</td>
<td>Date of expiry</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>Approximate weight of 1000 meters length (Weight in Kgs.)</td>
<td></td>
</tr>
<tr>
<td>2a</td>
<td>Size of cable</td>
<td>Alum.</td>
</tr>
<tr>
<td></td>
<td>1X16 + 1X25 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>1X16 + 1X25 + 1x16 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3X16+1X25 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3 X 16 +1x25 + 1x16 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>1X25+1x25 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>1X25 + 1X25 + 1x16 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3X25+1X25 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3 X 25 +1x25 + 1x16 SQ. MM.</td>
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</tr>
<tr>
<td></td>
<td>1X35+1X25 SQ. MM.</td>
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</tr>
<tr>
<td></td>
<td>1x35 + 1X25 + 1x16 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3X35+1X25 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3X35 + 1x25 + 1x16 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3X50+1X35 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td></td>
<td>3X50 +1x35 +1x16 SQ. MM.</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>Cable Conductor, Circular Compacted?</td>
<td>Yes</td>
</tr>
</tbody>
</table>
PART – C (ENCLOSURES)

Manufacturers have to enclose following documents and has to confirm for the same

<table>
<thead>
<tr>
<th>Sr. No.</th>
<th>Particulars</th>
<th>confirmation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>ISI License</td>
<td>Yes</td>
</tr>
<tr>
<td>2</td>
<td>Proof if applied for renewal of ISI License</td>
<td>Yes</td>
</tr>
<tr>
<td>3</td>
<td>TYPE TEST CERTIFICATE: Type test certificate from Govt. of India approved Laboratory</td>
<td>Yes</td>
</tr>
<tr>
<td></td>
<td>Size of AB Cable</td>
<td></td>
</tr>
<tr>
<td>a</td>
<td>Name of Lab. &amp; City Name</td>
<td></td>
</tr>
<tr>
<td>b</td>
<td>T.R. No.</td>
<td></td>
</tr>
<tr>
<td>c</td>
<td>Date</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>List of plant and machinery</td>
<td>Yes</td>
</tr>
<tr>
<td>5</td>
<td>List of testing facility available</td>
<td>Yes</td>
</tr>
<tr>
<td>6</td>
<td>List of orders pending/executed</td>
<td>Yes</td>
</tr>
<tr>
<td>6a</td>
<td>with Employer</td>
<td>Yes</td>
</tr>
<tr>
<td>6b</td>
<td>with agencies other than Sr. no. 6(a)</td>
<td>Yes</td>
</tr>
</tbody>
</table>