BIDDING DOCUMENT
FOR

"Supply of Disc Insulators against Line Maintenance work under Central Assam Region, AEGCL"

(E-Tender)

VOLUME -2

BID IDENTIFICATION NO: AEGCL/MD/CGM/CAR/Disc_Insulator/Bid/1
https://assamtenders.gov.in

Fund: O&M(HQ), CAR for FY 2025-26

ASSAM ELECTRICITY GRID CORPORATION LIMITED

Section-1
SCOPE AND GENERAL TECHNICAL CONDITIONS

1.1.0 INTENT OF THE SPECIFICATION

1.1.1 This volume of the specification deals with the general technical information & criteria for design, manufacture, supply & delivery of equipment/material as defined in Volume-1.

1.1.2 The provisions of this section shall supplement all the detailed Technical Specifications and requirements brought out herein. The Contractor's proposal shall be based on the use of materials complying fully with the requirements specified herein.

1.2.0 SCOPE

1.2.1 The work involves design, engineering, manufacture, assembly, inspection, testing at manufacturer's works before dispatch, packing, supply, including insurance during transit, delivery at site **(as per Annexure-I)** of various equipment and materials as specified in subsequent Clauses and Sections.

1.2.2 It is not the intent to specify completely herein all details of design and construction of the equipment and accessories. However, the equipment and accessories shall conform in all respects to high standards of engineering, design and workmanship and be capable of performing in continuous operation up to the bidder's guarantees in a manner acceptable to the Purchaser. The Purchaser will interpret the meaning of drawings and specifications and shall be entitled to reject any work or material, which in his judgement is not in full accordance therewith.

1.2.3 The major items of works included in the scope of this specification are listed below: -

i) Design, engineering, manufacture, assembly and testing at manufacturer's works of I) 70KN Disc Insulator, II) 90KN Disc Insulator, III) 120KN Disc Insulator as specified in the BoQ.

ii) Loading at manufacturer's works, transportation and delivery to site, including unloading at destination site.

1.2.4 The various items of supply are described very briefly in the schedule of Bid Form, Prices & Other Schedules and annexure. The various items as defined in these schedules shall be read in conjunction with the corresponding section in the technical specifications including amendments and, additions if any.

1.2.5 The bidder is required to fill up the BOQ/price schedule as given in the e-tendering portal.

1.3.0 DESIGN IMPROVEMENTS

1.3.1 The Employer or the Contractor may propose changes in the specification and if the parties agree upon any such changes and the cost implication, the specification shall be modified accordingly.

1.4.0 DESIGN CO-ORDINATION

1.4.1 Wherever, the design is in the scope of Contractor, the Contractor shall be responsible for the selection and design of appropriate material/item to provide the best coordinated performance of the entire system. The basic design requirements are detailed out in this

Specification. The design of various components, sub- assemblies and assemblies shall be so done that it facilitates easy field assembly and maintenance.

1.5.0 DESIGN REVIEW MEETING

1.5.1 The contractor may be called upon to attend design review meetings with the Employer, and the consultants of the Employer during the period of Contract. The contractor shall attend such meetings at his own cost in Assam or at mutually agreed venue as and when required. Such review meeting will be held generally minimum once a month or the frequency of these meeting shall be mutually agreed between the Employer and the Contractor. Frequency of Design Review Meetings shall depend upon the project requirement to ensure project implementation as per the Master Programme.

1.6.0 PACKING

1.6.1 All the materials shall be suitably protected, coated, covered or boxed and crated to prevent damage or deterioration during transit, handling and storage at Site till the time of erection. The CONTRACTOR shall be responsible for any loss or damage during transportation, handling and storage due to improper packing.

1.6.2 The CONTRACTOR shall include and provide for securely protecting and packing the materials so as to avoid loss or damage during transport by air, sea, rail and road.

1.6.3 All packing shall allow for easy removal and checking at site. Wherever necessary, proper arrangement for attaching slings for lifting shall be provided. All packages shall be clearly marked for with signs showing 'up' and 'down' on the sides of boxes, and handling and unpacking instructions as considered necessary. Special precaution shall be taken to prevent rusting of steel and iron parts during transit by sea.

1.6.4 The cases containing easily damageable material shall be very carefully packed and marked with appropriate caution symbols, i.e., fragile, handle with care, use no hook etc. wherever applicable.

1.6.5 Each package shall be legibly marked by the-CONTRACTOR at his expenses showing the details such as description and quantity of contents, the name of the consignee and address, the gross and net weights of the package, the name of the CONTRACTOR etc.

SECTION-2: TECHNICAL SPECIFICATION OF DISC INSULATORS FOR SUBSTATION AND TRANSMISSION LINE WORKS

2.1.0 SCOPE.

2.1.1 This specification provides for design, manufacture, engineering, inspection and testing before dispatch, packing and delivery at site, testing and commissioning for manufacturers of disc Insulators as per technical requirements furnished in this specification.

These insulators are to be used in suspension and tension insulator strings for the suspension and anchoring of the conductors on EHV transmission line towers.

2.1.2 Following are the list of documents constituting this package.

(i) Technical specification.
(ii) Technical data sheet.
(iii) Drawings of insulators

2.1.3 All the above volumes along with amendments there of shall be read and interpreted together. However, in case of a contradiction between the "Technical Specification" and any other volume, the provisions of this volume will prevail.

2.1.4 The insulators shall conform in all respects to high standards of engineering, design, workmanship and latest revisions of relevant standards at the time of offer and purchaser shall have the power to reject any work or material which in his judgment, is not in full accordance therewith.

2.2.0 STANDARDS:

2.2.1 Except as modified in this specification, the disc/porcelain long rod insulators shall conform to the following Indian Standards, which also includes latest revisions and amendments if any. Equivalent International and Internally recognized standards to which some of these standards generally correspond are also listed below.

Sl. No.	Indian Standard	Title.	International Standard.
1.	IS: 206	Method for Chemical Analysis of Slab Zinc.	
2.	IS: 209	Specification for Zinc.	BS: 3436
3.	IS: 731	Porcelain insulators for overhead power lines with a normal voltage greater than 1000V	BS: 137(I&II); IEC 60274 IEC 60383
4.	IS: 2071 Part-(I)	Method of High Voltage Testing.	
	Part-(II)	High voltage test techniques, detailing test procedures and statistical checks for confidence limits.	
	Part-(III)	Measuring devices for high voltage testing, providing specifications and requirements for measuring equipment.	
5.	IS: 2121 (Part-I)	Specification of Conductors and Earth wire Accessories for Overhead Power lines. Armour Rods, Binding wires and tapes for conductor.	

6.	IS: 2486	Specification for Insulator fittings for overhead power lines with a nominal voltage greater than 1000V.	
	Part – I	General Requirement and Tests.	BS: 3288
	Part – II	Dimensional Requirements.	IEC: 60120
	Part – III	Locking devices.	IEC: 60372
7.	IS: 2629	Recommended practice for Hot Dip Galvanisation for iron and steel.	
8.	IS: 2633	Testing for Uniformity of Coating of Zinc coated articles.	
9.	IS: 3138	Hexagonal Bolts & Nuts.	ISO/R 947 & ISO/R 272
10.	IS: 3188	Dimensions for Disc Insulators.	IEC: 60305
11.	IS: 4218	Metric Screw Threads	ISO/R 68-1969 R 26-1963, R 262-1969 & R965-1969
12.	IS: 6745	Determination of weight of zinc coating on zinc coated iron and steel articles.	
13.	IS: 8263	Methods of RIV Test of HV insulators.	IEC 60437 NEMA Publication No.107/1964 CISPR
14.	IS: 8269	Methods for switching impulse Test on HV insulators.	IEC: 60506
15.	IS: 8269	Thermal mechanical performance test and mechanical performance test on string insulator units.	IEC: 60575
16	IEC	Ceramic Long Rod Insulators	IEC: 60433

2.2.2 The standards mentioned above are available from

Reference.	Name & Address:
BS	British Standards, British Standards Institution, 101, Pentonvile Road, N- 19 ND, U.K
IEC / CISPR	International Electro technical commission Electro Technique International. 1, Rue de verembe Geneva SWITZERLAND.

IS	Bureau of Indian Standards, Manak Bhavan, 9 Bahadurshah Zafar Marg, New Delhi-110001
ISO	International Organisation for Standardization. Danish Board of Standardization Dansk Standardizing Sraat Aurehoegvej-12 DK-2900 Helleprup DENMARK.

2.3.0 PRINCIPAL PARAMETERS

2.3.1 DETAILS OF DISC INSULATORS:

2.3.1.1 The Insulator strings shall consist of standard discs for use in three phases. 50 Hz effectively earthed 33/132/220 KV transmission system of AEGCL in a moderately polluted atmosphere. The discs shall be cap and pin, ball and socket type. Radio interference data and have characteristics as shown in Table-I and all ferrous parts shall be hot dip galvanized as per the latest edition of IS 2629. The zinc to be used for making sleeves shall be 99.95 % pure.

2.3.1.2 The size of disc insulator, minimum creepage distance the number to be used in different type of strings, their electromechanical strength and mechanical strength of insulator string along with hardware shall be as follows:

PRINCIPAL PARAMETERS OF THE DISC INSULATORS: -

Sl. No.	Type of String.	Size of disc. Insulator (mm)	Minimum creepage distance of each disc (mm),	No. of standard discs 132 KV /220 KV/400kV	Electro-mechanical strength of insulator string fittings (KN)
1.	Single suspension	255 x 145	320	1x9/1x14 /-	70 KN/90 KN Normal Disc Insulator
2.	Double suspension.	-do-	-do-	2x9/2x14 /-	70 KN/90 KN Normal Disc Insulator
3	Single suspension	255 x 145	430	1x9/1x14 /-	70 KN/90 KN Antifog Insulator
4	Double suspension.	-do-	-do-	2x9/2x14 /-	70 KN/90 KN Antifog Disc Insulator
5.	Single Suspension	280 x 145	430	1x10/1x15 /-	120 KN Anti fog Disc insulator
6.	Double suspension	280 x 145	430	2x10/2x15 /-	120 KN Anti fog Disc insulator

7.	Single Tension	305 X 170	475	1x10/1x15/1x25	160 KN Anti fog Disc insulator
8.	Double Tension	305 X 170	475	2x10/2x15/2x25	160 KN Anti fog Disc insulator
9.	Single Suspension	280 x 145	430	1x10/1x15/1x25	120 KN Anti fog Disc insulator
10.	Double suspension	280 x 145	430	2x10/2x15/2x25	120 KN Anti fog Disc insulator

2.3.2 SPECIFICATION DRAWINGS:

2.3.2.1: The Specification in respect of the disc insulators are described, the specification is for information and guidance of the bidder only. The drawings to be furnished by the supplier shall be as per his own design and manufacture and in line with the specification.

2.4.1 Porcelain glaze:

The finished porcelain shall be glazed in brown colour. The glaze shall cover all exposed parts of the insulator and shall have a good lusture, smooth surface and good performance under the extreme weather conditions of a tropical climate. It shall not crack or chip by ageing under the normal service conditions. The glaze shall have the same coefficient of expansion as of the porcelain body throughout the working temperature range.

2.4.2 METAL PARTS:

2.4.2.1 Cap and Ball Pins: Ball pins shall be made with drop forged steel caps with malleable cast iron. They shall be in one single piece and duly hot dip galvanized. They shall not contain parts or pieces joined together welded, shrink fitted or by any other process from more than one piece of materials. The pins shall be of high tensile steel, drop forged and heat-treated. The caps shall be cast with good quality black heart malleable cast iron and annealed. Galvanizing shall be by the hot dip process with a heavy coating of zinc of very high purity. The bidder shall specify the grade composition and mechanical properties of steel used for caps and pins. The cap and pin shall be of such design that it will not yield or distort under the specified mechanical load in such a manner as to change the relative spacing of the insulators or add other stresses to the shells. The insulator caps shall be of the socket type provided with nonferrous metal or stainless-steel cotter pins and shall provide positive locking of the coupling.

2.4.2.2 Security Clips: The security clips shall be made of phosphor bronze or of stainless steel.

2.4.3 FILLER MATERIAL:

Cement to be used, as a filler material be quick setting, fast curing Portland cement. It shall not cause fracture by expansion or loosening by contraction. Cement shall not react chemically with metal parts in contact with it and its thickness shall be as small and as uniform as possible.

2.4.4 MATERIALS DESIGN AND WORKMANSHIP:

2.4.4.1 GENERAL:

(I) All raw materials to be used in the manufacture of these insulators shall be subject to strict raw

material quality control and to stage testing/ quality control during manufacturing stage to ensure the quality of the final end product. Manufacturing shall conform to the best engineering practices adopted in the field of extra high voltage transmission. Bidders shall therefore offer insulators as are guaranteed by them for satisfactory performance on Transmission lines.
(II) The design, manufacturing process and material control at various stages be such as to give maximum working load, highest mobility, best resistance to corrosion, good finish elimination of sharp edges and corners to limit corona and radio interference voltages.

2.4.4.2 INSULATOR SHELL:
The design of the insulator shells shall be such that stresses due to expansion and contraction in any part of the insulator shall not lead to deterioration. Shells with cracks shall be eliminated by temperature cycle test followed by mallet test. Shells shall be dried under controlled conditions of humidity and temperature.

2.4.4.3 METAL PARTS:
i) The pin and cap shall be designed to transmit the mechanical stress to the shell by compression and develop uniform mechanical strength in the insulator. The cap shall be circular with the inner and outer surfaces concentric and of such design that it will not yield or distort under loaded conditions. The head portion of the pinball shall be suitably designed so that when the insulator is under tension the stresses are uniformly distributed over the pinhole portion of the shell. The pinball shall move freely in the cap socket either during assembly of a string or during erection of a string or when a string is placed in position.
ii) Metal caps shall be free from cracks, seams, shrinks, air holes, blowholes and rough edges. All metal surfaces shall be perfectly smooth with no projecting part or irregularities, which may cause corona. All load bearing surfaces shall be smooth and uniform so as to distribute the loading stress uniformly. Pins shall not show any microscopically visible cracks, inclusions and voids.

2.4.4.4 GALVANIZING:
All ferrous parts, shall be hot dip galvanized in accordance with IS: 2629. The zinc to be used for galvanizing shall conform to grade Zn 99.95 as per IS: 209. The zinc coating shall be uniform, smoothly adherent, reasonably light, continuous and free from impurities such as flux, ash, rust stains, bulky white deposits and blisters. Before ball fittings are galvanized, all die flashing on the shank and on the bearing surface of the ball shall be carefully removed without reducing the designed dimensional requirements.

2.4.4.5 CEMENTING:
The insulator design shall. Be such that the insulating medium shall not directly engaged with hard metal. The surface of porcelain and coated with resilient paint to offset the effect of difference in thermal expansions of these materials. High quality Portland cement shall be used for cementing the porcelain to the cap & pin.

2.4.4.6 SECURITY CLIPS (LOCKING DEVICES)
The security clips to be used as locking device for ball and socket coupling shall be „R‟ shaped hump type to provide for positive locking of the coupling as per IS: 2486 (Part-IV). The legs of the security clips shall allow for spreading after installation to prevent complete withdrawal from the socket. The locking device shall resilient corrosion resistant and of sufficient mechanical strength. There shall be no possibility of the locking device to be displaced or be capable of rotation, which placed in position, and under no circumstances shall it allow separation of insulator units and fittings. „W‟ type security clips are also acceptable. The hole for the security clip shall be counter

sunk and the clip shall be of such design that the eye of the clip may be engaged by a hot line clip puller to provide for disengagement under energized conditions. The force required for pulling the clip into its unlocked positions shall not be less than 50 N (5 kg.) or more than 500 N (50 kgs.).

2.4.4.7 MARKING:
Each insulator shall have the rated combined mechanical and electrical strength marked clearly on the porcelain surface. Each insulator shall also bear symbols identifying the manufacturer, month, and year of manufacture. Marking on porcelain shall be printed, not impressed, and shall be applied before firing.

2.4.5 BALL AND SOCKET DESIGNATION:
The dimensions of the ball and sockets for 70 and 90 KN insulator strings shall be of 16 mm and for 120 KN and 160 KN insulator strings shall be of 20 mm designation in accordance with the standard dimensions stated in IS: 2486 (Part-II).

2.4.6-DIMENSIONAL TOLERANCE OF INSULATOR DISCS:
It shall be ensured that the dimensions of the disc insulators are within the limits specified below:

Sl. No.	Diameter of Disc (mm)	Standard in Mm	Maximum	Minimum
1.	70 KN/90 KN & 120 KN	**255/255 & 280**	As per IS	As per IS
2.	160 KN	305	As per IS	As per IS
(b)				
Sl. No.	Ball to Ball spacing Between Discs (mm)	Standard in Mm	Maximum	Minimum
1.	70 KN/90 KN/120 KN	**145**	As per IS	As per IS
2.	160 KN	170	As per IS	As per IS

NOTE: Tolerance as per relevant IS (Latest edition).

(2.4.7) GUARANTEED TECHNICAL PARTICULARS FOR ANTIFOG DISC INSULATORS

Sl. No.	DESCRIPTION	70 KN	90 KN	120KN	160 KN
1.	Manufacture's name & address				
2	Type of Insulator	Ball & Socket	Ball & socket	Ball & socket	Ball & socket
3	Size of ball & socket	16B	16B	20	20
4	Dimensions				
(a)	Disc diameter	255	255	280	305
(b)	Unit spacing	145	145	145	170

(c)	Creepage distance of the single insulator-mm	430	430	430	475
5	Electro-mechanical strength of single insulator-kN	70	90	120	160
6	Materials of shell	Porcelain	Porcelain	Porcelain	Porcelain
7	**Electrical value**				
7.1	Power frequency Withstand Voltage Disc				
	(a) Dry-kV (rms)	80	80	85	90
	(b) Wet-kV (rms)	45	45	50	50
7.2	Power frequency Flashover Voltage Disc				
	(a) Dry-kV (rms)	85	85	90	95
	(b) Wet-kV (rms)	50	50	55	55
7.3	Impulse Withstand Voltage Disc				
	1.2/50 micro second				
	(a) Positive – kV(Peak)	125	125	130	135
	(b) Negative – kV(Peak)	125	125	130	135
7.4	Impulse Flashover Voltage Disc				
	1.2/50 micro second				
	(a) Positive – kV(Peak)	135	135	140	145
	(b) Negative – kV(Peak)	130	130	135	140

2.4.8 INTERCHANGEABILITY:

The insulators inclusive of the ball and socket fittings shall be of standard design suitable for use with hardware fittings of any make conforming to relevant Indian Standards.

2.4.9 CORONA AND RIV PERFORMANCE:

All surfaces shall be even, smooth, without cuts, abrasions or projections. No part shall be subject to excessive localized pressure. The metal parts and porcelain shall not produce any noise-generating corona under all operating conditions

2.5.0 SUITABILITY FOR LIVE LINE MAINTENANCE:

The insulator shall be compatible for use with hot line or live line maintenance techniques so that usual hot line operation can be carried out with easy speed and safety.

2.5.1 FREEDOM FROM DEFECTS:

Insulators shall have none of the following defects:

1) Ball pin shake.
2) Cementing defects near the pin like small blow holes, small hair cracks lumps etc.
3) Sand fall defects on the surface of the insulator.

2.5.2 INSULATOR STRINGS:

2.5.2.1 TYPE AND RATING:

The insulator strings shall be formed with standard discs described in this specification for use on 3 phases 132/220 KV 50 Hz effectively earthed systems in an atmosphere with pollution level as indicated in project synopsis. Suspension insulator strings for use with suspension/tangent towers are to be fitted with discs 70/90 KN EMS rating while tension insulator strings for use with Anchor/ Tension towers are to be fitted with discs of 120 KN / 160 KN EMS level rating.

2.5.2.2 STRING SIZE:

The sizes of the disc insulator, the number to be used in different types of strings, their electro-mechanical strength and minimum nominal creep age distance shall be as given in clause 2.3.1.2.

2.5.3 STRING CHARACTERISTICS:

2.5.3.1 The characteristics of the complete string shall be as follows:

Sl. No.	**Description.**	**Suspension.**		**Tension.**	
		132KV	**220kV**	**132KV**	**220KV**
I	Switching surge withstand voltage (dry& wet) KV Peak	-	-	-	-
II	Lighting impulse withstand voltage (dry) KV Peak.	650	1050	650	1050
III	Power frequency withstand voltage (wet) KV r.m.s.	275	460	275	460
IV.	Corona extinction voltage level KV rms	-	176	-	176
V	Max. RIV for comp. Etc. strong including corona rings at 156 KV (rms). … hours clamps etc. at 1.1. times maximum knee to ground voltage (micro volts).	-	500	-	500
VI.	Mechanical failing load for each string (kgf)	6500	11500	11500	15500
VII.	No deformation load for each string (kgf)	-	7705	-	10385
VIII	Max. voltage across any disc.	13%	13%	13%	13%

2.5.3.2 Insulator units after assembly shall be concentric and coaxial within limits as permitted by Indian Standards.

2.5.3.3 The strings design shall be such that when units are coupled together there shall be contact between the shell of one unit and metal of the adjacent unit.

Section-3

Annexure-I (Destinations for Supply of BoQ Items)

Sl. NO	Item Description	Unit	Qty	Location	Consignee
1	70KN Disc Insulator	Nos	1400	**220kV Samaguri GSS**	AGM, 220KV Samaguri GSS Division, Nagaon
2	90KN Disc Insulator	Nos	1600		
3	120KN Disc Insulator	Nos	900		
4.	70KN Disc Insulator	Nos	400	**132kV Panchgram GSS**	AGM, 132kV Panchgram GSS Division, Cachar
5.	90KN Disc Insulator	Nos	10		
6.	120KN Disc Insulator	Nos	0		