



ODISHA POWER TRANSMISSION CORPORATION LTD

TECHNICAL SPECIFICATION

FOR

20MVA, 132/33 KV POWER TRANSFORMER

TECHNICAL SPECIFICATION

<u>Sl. No.</u>	<u>TITLE.</u>
1.0	SCOPE.
2.0	Standards
3.0	Auxiliary Power Supply.
4.0	Principal Parameters.
5.0	General Technical Requirements.
5.1	Duty requirements.
5.2	Transformer Losses
5.3	Clearance.
5.4	Constructional Details.
5.4.1	Tank and Tank Accessories.
5.4.2	Valves and Location.
5.4.3	Joints and Gaskets.
5.4.4	Pressure relief device.
5.4.5	Earthing terminals.
5.4.6	Corrosion Protection.
5.4.7	Rating, diagram and valve plates.
5.4.8	Core.
5.4.9	Windings.
5.4.10	Gas and Oil actuated relays.
5.4.11	Temperature indicating devices and alarms.
5.4.12	Cooling equipment and its control.
5.4.13	Voltage selection and control.
5.4.14	Supervisory control.
5.4.15	Terminal and connection arrangements.
5.4.16	Specification for control cabinets.
5.4.17	Insulating Oil.
5.4.18	Cleaning, painting and tropicalisation.
5.4.19	Bolts and Nuts.
5.4.20	Wiring and cabling.
5.4.21	Fittings.
5.4.22	Limits of Temperature rise.
5.4.23	Motors & MCBs.
5.4.24	Spanners & Special tools.
5.4.25	List of Mandatory Spares.
6.0	INSPECTION AND TESTING.
6.1	Testing facilities
6.2	General
6.3	Stage Inspection.
6.4	Final Inspection
6.4.1	Type Tests & Special Tests
6.4.2	Routine Tests
6.4.3	Challenge Test
6.4.4	Tests on site
7.0	TEST REPORTS.

8.0	LIST OF TRANSFORMER ACCESSORIES AND TEST CERTIFICATES REQUIRED FOR THEM.
9.0	INSPECTION.
9.1	General.
9.2	Inspection Programme.
9.3	Pre-shipment check at supplier's works.
9.4	Recommended commissioning checks.
10.0	QUALITY ASSURANCE PLAN.
11.0	DOCUMENTATION.
12.0	PACKING AND FORWARDING.
13.0	SUPERVISION OF ERECTION, TESTING AND COMMISSIONING.
14.0	QUANTITY AND DELIVERY REQUIREMENTS.
15.0	VALUES QUOTED IN G.T.P. AND LOSS CALCULATION.
16.0	METHOD OF TECHNICAL EVALUATION.

ANNEXURES

<u>Sl. No.</u>	<u>Title.</u>
I.	Maximum Flux Density and Core Weight calculation.
II.	Details of Loss Calculations.
III.	Guaranteed Technical Particulars.

SECTION - IV.

TECHNICAL SPECIFICATION

1.0 SCOPE:-

- 1.1 This Specification provides for design, engineering, manufacture, assembly, stage inspection, final inspection and testing before despatch, packing and delivery at destination Sub-station by road transport, unloading on plinth at site(if the plinth is not ready at the time of unloading, then the transformer shall be unloaded at the nearest accessible point to plinth) and supervision of erection, testing and commissioning of 20MVA, 132/33KV Power Transformer, complete with all fittings, accessories, associated equipments and spares, required for its satisfactory operation in any of the sub-stations of the State of Odisha.
- 1.2 The scope of supply includes the provision of training for Purchaser's personnel.
- 1.3 The transformers shall conform in all respects to high standards of engineering, design, workmanship and the 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. 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.
- 1.4 The transformer(s), to be supplied against this specification shall be suitable for satisfactory continuous operation under the following Topographical and Meteorological conditions:-

a)	Maximum ambient air temperature (°C) -	50	
b)	Minimum ambient air temperature (°C)-	0	
c)	Average daily ambient air temperature (°C)-	32	
d)	Relative humidity (%) -	100	
e)	Average rainfall per annum (cm)-	150	
f)	Maximum altitude above mean Sea level (m)-		1000
g)	Maximum wind pressure (Kg/m²)-	80.84	
h)	Isoceraunic level (days/year)-	70	
i)	Seismic withstand factor(g)	0.3	
j)	Wind Velocity-(Wind Zone to IS875) (m/sec)	50	
k)	Pollution level to IEC815	Heavy	
l)	Air-borne contamination, if any	Highly Polluted	

2.0 STANDARDS:-

- 2.1 All transformers and associated equipments and accessories shall, except where modified by this Specification, be designed, manufactured and tested in accordance with the latest editions of the relevant International (IEC), Indian (IS) and British (BS) standards. In case of conflict, the order of precedence shall be (1) IEC, (2) IS, (3) Other.

Reference to particular standard or recommendation in this Specification does not relieve the Supplier of the necessity of providing goods and services, complying with other relevant standards or recommendations.

The list of standards, provided in this Specification is not to be considered exhaustive and the supplier shall ensure that equipments, supplied under this contract meet the requirements of the relevant standard whether or not it is mentioned here.

IEC	IS	BS/other	Title
60076	2026	171	Power Transformers
P-1-2000			
P-2-1993			
P-3,5-2000			
P-6-1997			
-	-	6056	Methods of measurement of transformer and Reactor sound levels
-	-	4360	Weldable structural steel
-	-	61	Threads for light gauge copper tube and fittings
-	-	3600	Steel pipes and tubes for pressure purpose
-	-	4504	Flanges for pipes, valves and fittings
529	13947	EN60529	Enclosures for electrical apparatus (App.C-13947)
214	-	4571	On load tap changers
60137(1995)	2099	223	Bushings for alternating voltages above 1000V
-	3347	-	Dimensions for porcelain transformer bushing for use in lightly polluted atmospheres
223	-	4963	Tests on hollow insulators
60354(1991)	6600	BSCP-0160	Loading guide for transformers
606	-	-	Application guide for power transformers
60296(Amd1-1986)	335	BS-14	Specification for unused mineral insulating oil for Transformers and reactors
34	325	-	Three phase Induction Motors
185	2705	-	Current Transformers
518	-	-	Dimensional standardization of terminals for HV Equipment
616	5578 (11353)	-	Terminal and tapping markings for Power Transformers
-	1886	-	Code of practice for installation and maintenance of Transformers
-	3639	-	Fittings and accessories for power transformers
-	3637	-	Gas operated relays
-	6272	-	Industrial cooling fans
-	4691	-	Degrees of protection provided by enclosures for rotating electrical machines
186	3156		Specification for voltage transformers
617	-	-	Graphical Symbols for drawings
-	2629	729	Galvanising
-	2633	-	Methods of testing uniformity for zinc coated articles

-	5	-	Colours for ready mixed paints and enamels
-	2147	-	Degrees of protection provided by enclosures for Low voltage switchgears and control gears
-	3401/1992	-	Silicagel
	9434	-	Guide for sampling and analysis of dissolved gas in oil filled equipment.
	12676	-	Oil impregnated paper insulated Bushing Dimension and requirements.
60071, P-1-1993	-	-	Insulation Co-ordination
P-2-1996			
-	375	-	Markings & Arrangements for switchgear Bus bars, Main connections and Auxiliary wiring
-	3638/1996	-	Application Guide for Gas operated Relays.
60214(1989)	8468	-	On-load Tap-changer.
-	8269	-	Methods for switching Impulse Test on High Voltage Insulators.
-	10028/1981	-	Installation of Transformers.
	(Part-2)		
-	10028/1981	-	Maintenance of Transformers.
	(Part-3)		
-	10561/1983	-	Application Guide of Power Transformers.
60542,			
Amd 1-1988	8468/1997	-	Application Guide for On-load Tap-changer.
-	8263	-	Method for Radio Interference Tests on High Voltage Insulators.
-	3202	-	Code of practice for climate proofing of Electrical Equipment.
-	6702/1972	-	Method for determination of Electric strength of Insulating Oils.
-	6103/1971	-	Method of Test for specific Resistance of Elect. Insulating Liquids.
-	6262/1971	-	Method of Test for power factor and Dielectric Constant of Electrical Insulating Liquids.
-	6104/1971	-	Method of Test for Interfacial Tension of oil against water by the Ring Method.
60034,			
P1-22(1972-2000)	-	-	Rotating Electrical Machines.
60044,	-	-	Instrument Transformers.
Amd P1-2000,			
P-6-1992			
60060,	-	-	High Voltage Test Techniques.
P-1-1989,			
Amd P-2-1996			
60085 (1994)	-	-	Thermal Evaluation and classification of Elect. Insulation.
60270 (1981)	-	-	Partial Discharge Measurements.

60404-8-7 (1998)	-	-	Specification for Individual Materials-Cold Rolled Grain oriented Electrical Steel sheet and strip delivered in fully processed state
60529 (Amd 1-1999)	-	-	Degree of protection, provided by enclosures (IP-Code)
60551(Amd 1-1995)	-	-	Determination of Transformer and Reactor Sound Levels.
60567(1992)	-	-	Guide for sampling Gases and oil from oil-filled Electrical equipment for the analysis of free and Dissolved Gases
60599(1999)	-	-	Mineral Oil-Impregnated Electrical Equipment in service-Guide to the Interpretation of Dissolved and Free Gases Analysis.
60722 (1982)	-	-	Guide to the Lightning and Switching Impulse Testing of Power Transformers and Reactors.
60815 (1986)	-	-	Guide for selection of Insulators in respect of polluted conditions.
60947, P-1-7 (1984-2000)	-	-	Low voltage switchgear & control gear.
	-	IEEE C 57.93	IEEE Guides for Installation of Liquid Immersed
		1995	Power Transformers.
-	-	IEEE Std 80	Guide for safety and AC Sub-station Grounding.
-	-	IEEE Std 979	Guide for Sub-station Fire protection.
-	-	IEEE Std 980	Guide for containment and control of oil spills in Sub-stations.
-	-	CBIP Pub.295/	Manual on Transformers.
		2006	
-	-	NFPA	National Fire Protection Association.
-	-	NEMA--	
		Standard No.1.	
-	-	Indian Electricity	-
		Rules-1956.	

2.2 The standards, mentioned above are available from:

Standard:	Name and Address:
IS	Bureau of Indian Standards, Manak Bhawan, 9-Bahadur Sahah Zafar Marg, New Delhi - 110001, India.
IEC	International Electro Technical Commission, Bureau Central dela Commission, Electro Technique International, 1-Ruede Verembe, Geneva, SWITZERLAND.

2.3 Transformer meeting with requirements of other authoritative International Standards that ensure equal or better performance than the standards, mentioned above shall also be considered. When the transformer, offered by the supplier conforms to other standards, salient points of difference between standards adopted and the standards,

specified in this specification shall be clearly brought out in the offer. Two copies of such standards with authentic translation in English shall be furnished along-with the offer.

3.0 AUXILIARY POWER SUPPLY:-

Auxiliary electrical equipment shall be suitable for operation on the following supply system.

- | | | |
|-----|--|--|
| (a) | Power devices like drive motors of Rating 1KW and above. | 415V, 3Phase, 4 Wire, 50 Hz, neutral Grounded AC supply. |
| (b) | Lighting, space heaters and KW Meters. | 240V, single phase, 50Hz, neutral Grounded AC supply. |
| (c) | Alarm control and protective Devices. | 220V, DC, 2 Wire. |

Each of the foregoing supplies shall be made available by the purchaser at the terminal point for each transformer for operation of accessories and auxiliary equipment. Supplier's scope includes supply of interconnecting cables, terminal boxes etc. The above supply voltage may vary as below and all devices shall be suitable for continuous operation over entire range of voltages.

- | | | |
|------|--------------|---|
| (i) | AC Supply: - | Voltage $\pm 10\%$
Frequency $\pm 5\%$ |
| (ii) | DC Supply: - | - 15% to + 10% |

4.0 PRINCIPAL PARAMETERS:-

The transformer shall conform to the following specific parameters:-

Sl. No.	Item.	Specification.
1	Type of Power Transformer/Installation.	3 Phase Core type, 2 winding transformer, suitable for outdoor installation and suitable for bi-directional flow of power
2	Type of Mounting.	On wheels, mounted on rails.
3	Suitable for rated system frequency.	50 Hz ($\pm 5\%$).
4	(a) Maximum system voltage ratio (HV/LV)	145 KV/36KV.
	(b) Nominal voltage Ratio (HV/LV)	132 KV/33 KV.
5	No. of Phases.	3 (Three)
6	No. of Windings.	Two winding Transformer
7	Type of Cooling.	ONAN/ONAF
NOTE: - ONAN- Oil Natural Air Natural. ONAF - Oil Natural Air Forced.		
8	MVA Rating corresponding to cooling system.	<u>20 MVA</u>
	(a) ONAN cooling.	80% - 16MVA
	(b) ONAF cooling.	100% - 20 MVA
9	Method of connection.	HV - Star LV - Star
10	Connection symbol.	YNyn0
11	System Earthing.	Effectively solidly earthed (Neutral of both H.V. & L.V.)

12	Percentage Impedances on normal tap and MVA base corresponding to HV/LV rating and applicable tolerances:	%Impedance with Tolerance 10+10%(Tol.) (No negative tolerance is allowed)		
NOTE: - No reactor either inside or outside the tank shall be used to achieve above % Imp. Value.				
13	Intended regular cyclic overloading of windings.	As per IEC76-1,Clause 4.2		
14	a)Anticipated unbalanced loading. b)Anticipated Continuous loading of windings(H.V and L.V)	< 10% 110% of rated current		
15	Tap changing gear: - (i) Type. (ii) Provided on. (iii) Tap range. (iv) Tap step. (v) Automatic control required? (vi) Remote control panel required? (vii) DC supply. (viii) Supervisory control provision required? (ix) Marshalling kiosk required? (x) No. of Transformers in parallel for which auto control to be suitable. (xi) Current rating of OLTC (xii) Short circuit current rating of OLTC	In Tank, Hi-speed Resistor Type On load. H.V. side - 15% to +5%. 1.25% of 132KV Yes. Yes. As per Specification. Yes. Yes. 4 (Maximum). 350A(Min.) 6KA(Min.)		
16	Over voltage operating capability and duration.	125% rated voltage for 60 seconds. 140% rated voltage for 5 seconds. 110% rated voltage continuous		
17	Minimum Air core reactance of HV windings.	20%		
18	Minimum knee point voltage (This will be determined during no load test method that 10% increase in voltage from 110% rated voltage causes the excitation current to increase not by more than 50%).	At 110% of rated voltage.		
19	Maximum Flux Density in any part of the core and yoke at rated MVA, Maximum System voltage [145 KV/36 KV] and minimum system frequency [48.5 HZ] [In Tesla].	1.6 Tesla		
20	Insulation levels:- For windings:- (a) 1.2/50 microsecond wave Shape Impulse Withstand (KVP). (b) Power frequency voltage withstand (KV-rms). (c) Separate source/Applied Voltage withstand voltage(KV-rms)	<u>HV</u> 650 275 38	<u>HVN</u> 95 38 38	<u>LV & LVN</u> 170 70 70
21	Type of winding insulation:- (a) HV (b) LV winding.	Graded. Full.		
22	a)Withstand time for three phase short circuit at Terminals.	5 seconds.		

	b) System short circuit level for which the transformer shall be capable to withstand.	31.5KA(rms)-132KV 25.0KA(rms)-33KV	
23	Partial discharge	As per relevant up-to-date IEC	
24	Noise level at rated voltage and frequency.	As per latest NEMA Std. Tr-1.	
25	Permissible Temperature Rise over ambient Temperature. (Both for ONAN & ONAF Ratings)		
	(i) Of top oil measured by thermometer	40° C (MAX.)	
	(ii) Of winding measured by resistance Method	45° C (MAX.)	
	(iii) Reference ambient temperature	50° C [MAX.]	
26	Minimum clearances in air (mm):-	Phase to phase.	Phase to ground
	(a) HV	1600	1380
	(b) LV	400	320
	(c) HV to LV	1300	-
27	Terminals.		
	(a) HV winding line end.	145 KV RIP condenser bushing	
	(b) LV Winding & LV Neutral	36KV oil-filled porcelain Communicating type bushing(Anti-fog type)	
	(c) HV Neutral	52KV RIP condenser bushing	
28	Bushing current rating.	1. 145 KV - 1250 Amp. 2. 36 KV - 1000 Amp. 3. 52 KV(N) - 1000 Amp. 4. 36KV(N)-1000Amp.	
29	Maximum Radio Interference Voltage level at 1 MHZ & 1.1 times max. Rms phase to ground Voltage for HV winding.	500 micro volts.	
30	Minimum visual corona extinction voltage	As per ISS/IEC	
31	(a) Number of cooler banks required per Transformer.	Minimum of two.	
	(b) Rating of each bank as % of total loss.	Not greater than 50%.	
	(d) No. of Fans.	Adequate number of fans of 18"/24" sweep with one No. stand-by fan in each bank.	
32	Insulation level of bushing.		
	(a) Lightning Impulse withstand (KVP)	HV LV LV(N) HV(N)	
	(b) 1 Minute Power Frequency withstand Voltage (KV - rms). Dry/Wet	650 170 170 250	
	(c) Creepage distance (mm./KV). (min.)	305/275 77/70 77/70 105/95	
	(d) Maximum Tan Delta for bushings at ambient Temp. (Tan delta shall be measured at ambient temperature. No temperature correction factor shall be applied)	3625 900 900 1300	
		< 0.004	
33	Material of HV & LV Conductor.	Copper.	
34	Accommodation on tank for outdoor neutral C.Ts.	Yes. Bracket is to be provided on the main tank of the transformer for installation of outdoor NCTs for both HV & LV and the required clearances for the same are to be maintained as per this specification.	

35	Neutral side C.T. for owner's use:	
	(i) Type.	Single phase,outdoor mounted
	(ii) Quantity.	Two(one in H.V side & one in L.V side)
	(iii) Voltage class.	36 KV.
	(iv) No. of cores.	One
	(v) Current ratio (A/A).	As per system requirement
	(vi) Turn ratio.	Identical to turns ratio, provided on HV and LV side.
	(vii) Knee point voltage.	600 volts.
	(viii) Class of Accuracy.	P.S.
	(ix) Maximum secondary winding resistance (Ohms).	5 at 75°C.
	(x) Maximum Excitation current at minimum Knee Point Voltage	25 mA
	(xi) Location for mounting.	Bracket mounted on tank(with neutral lead for connection for Neutral Bushing to NCT).
	(xii) Secondary current rating	One Amp.
	(NOTE: - HV - High Voltage, LV -Low Voltage.)	
36	(a)Maximum current density for HV & LV windings for rated current.	2.8 A/ mm ²
	(b) Maximum Tan Delta for winding at ambient Temp.	< 0.005
	(Tan delta shall be measured at ambient temperature. No temperature correction factor shall be applied)	
37	Type of oil preservation.	Air- cell type.
38	(i) Minimum Insulation resistance at an ambient Temperature of 30 deg. C with 5KV Megger for 600 seconds duration.	HV /E & LV/E-3000 M-ohms HV /LV-4000 M-ohms
	ii)Polarisation index i.e. ratio of IR values at 600 sec. to 60 sec. for H.V. to Earth, L.V. to Earth and H.V to L.V	Shall be greater than or equal to 2, as per Cl.No-7.2.13.4 IEEE Standard C57.152-2013
39.	Zero Sequence Impedance	Shall be 80% or more of the positive Sequence value
40.	Core Assembly	BOLTLESS TYPE
41.	No of pressure relieve device to be provided	Adequate

5.0 GENERAL TECHNICAL REQUIREMENTS: -

5.1 Duty Requirements.

5.1.1 The transformer will be used for bi-directional flow of rated power.

5.1.2 The transformer and all its accessories like C.Ts. shall be designed to withstand without injury, the thermal and mechanical effects of a short circuit at the terminals of any winding with full voltage, maintained on all other windings for duration of five seconds. The bidder is to furnish the supporting calculation towards above along with the bid offer. The short circuit level of the H.V. system to which the subject Transformer will be connected is 31.5KA(rms, 3-phase fault) for 132KV and 25KA for 33KV system.

5.1.3 The transformer shall be capable of being loaded in accordance with IS: 6600 upto loads of 150 %. There shall be no limitation imposed by bushings, tap changer etc.

- 5.1.4 The transformer shall be capable of being operated without danger on any tapping at the rated KVA with voltage variation of $\pm 10\%$ corresponding to the voltage of that tapping.
- 5.1.5 Radio interference and Noise level:
- (i) The transformers shall be designed with particular attention to suppression of maximum harmonic voltage, especially the third and fifth so as to minimize interference with communication circuits.
 - (ii) The noise level, when energized at normal voltage and frequency with fans and pumps running shall not exceed, when measured under standard conditions, the values, specified in NEMA, TR-1.
The transformer noise levels shall be measured as a routine test and in accordance with IEC-60551:1981.
- 5.1.6 Transformer shall be capable of operating under the natural cooled condition upto the specified load. The forced cooling equipment shall come into operation by preset contacts of winding temperature indicator and the transformer shall operate as a forced cooled unit, as ONAF upto specified load. Cooling shall be so designed that during total failure of power supply to cooling fans, the transformer shall be able to operate at full load for at least ten (10) minutes without the calculated winding hot spot temperature exceeding 150 degree centigrade. Also stopping of one or two cooling fans should not have any effect on the cooling system. Transformers fitted with two coolers each capable of dissipating 50 percent of the loss at continuous maximum rating shall be capable of operating for 20 minutes in the event of failure of the blowers, associated with one cooler, without the calculated winding hot spot temperature exceeding 115 degree centigrade at continuous maximum rating.
- 5.1.7 Transformer shall be capable of withstanding thermal and mechanical stresses, caused by symmetrical or asymmetrical faults on any winding.
- 5.1.8 Transformer shall accept, without injurious heating, combined voltage and frequency fluctuation, which produces the following over fluxing condition:
- i) 125% for 1 minute The base voltage and frequency refer
140% for 5 seconds. to those mentioned in Clause 4.0 (3& 4).
 - ii) Over fluxing withstand characteristics upto 170% shall be submitted along with the bid.

5.2.0 **TRANSFORMER LOSSES:-**

- 5.2.1 The bidder shall indicate values of No load losses (iron losses), load losses (copper losses) and auxiliary losses in his bid, which shall be firm.
- 5.2.2 **The Maximum permissible losses of the above transformer shall be as follows.**
- i) No Load Loss at rated voltage and rated frequency - **11kW**,
 - ii) Load loss at rated output, rated frequency & at 75°C – **60kW**
 - i) Auxiliary(Cooler) loss at rated output, rated frequency & at ambient temp – **01kW**

5.2.3 **Liquidated damage for excessive losses:-**

On testing, if it is found that actual losses are more than the above values but within the tolerance limit as per IEC-60076; Pt-I(latest version), an undisputed liquidated damages shall be recovered from the supplier at the following rates: -

- (i) For each KW of excess in 'No Load losses...' **Rs.5,23,098.00/KW**
- (ii) For each KW of excess in 'Load losses' and "auxiliary losses" **Rs.3,13,858.00/KW**

For fractional of Kilowatt, penalties shall be applied on prorata basis. No bonus shall be

payable for losses, which are less than those, stated in the Bid.

The purchaser reserves the right to reject the transformer, if on testing, the losses exceed the declared losses, beyond tolerance limits as per IEC **or** the temperature rise in oil **and/or** winding exceed the values as specified in technical particulars **or** impedance value differs 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. The purchaser reserves the right to retain the rejected transformer and take it into service until the supplier replaces it, at no extra cost to the purchaser by a new transformer. Alternatively, the supplier shall repair or replace the transformer in a reasonable period, as decided by the purchaser to purchaser's satisfaction at no extra cost to the purchaser.

- 5.2.4 **In case of failure of the transformer, the supplier shall take back the faulty transformer from its plinth for repair at their own cost (or replace the transformer with a new transformer) and deliver, at their own cost, unload at the destination sub-station transformer plinth within three months period from the date of intimation of defects to the satisfaction of the owner, at free of cost.** If the repair/replacement will not be completed within three months, then the supplier shall pay penalty @ 0.5% of the contract price for each calendar week of delay from the end of three months period from the date of intimation of defects. Also, the Purchaser reserves the right for forfeiture of the total Composite Bank Guarantee and all the Securities, available with OPTCL, in case the Supplier fails to pay the penalty by one month before the expiry of the guarantee period. Also, this will be taken as adverse in all future tenders.

5.3 **CLEARANCE :-**

The overall dimensions of the transformer shall allow for sufficient clearances for installation in a 145 KV switchyard with bay width of 10500 mm and boom height of 11 m.

5.4 **CONSTRUCTIONAL DETAILS:**

The features and constructional details of Power transformer shall be in accordance with the requirements, stated hereunder:-

5.4.1 **TANK AND TANK ACCESSORIES:**

5.4.1.1 **TANK:-**

- (a) The transformer shall be enclosed in a suitably stiffened welded steel tank such that the transformer can be lifted and transported without permanent deformation or oil leakage. The construction shall employ weldable, low carbon, tested quality structural steel of an approved grade to BS: 4360. The transformer tank shall have rectangular shape. The minimum thickness of base and tank cover shall be 12mm. and that of sides is 8mm.
- (b) The tank of the transformer shall be complete with all accessories and shall be designed so as to allow complete transformer in the tank and filled with oil, to be lifted by crane or jacks, transported by road or rail without over-straining any joint and without causing subsequent leakage of oil.
- (c) All seams and those joints, not required to be opened at site shall be factory-welded and wherever possible they shall be double welded. After completion of tank construction and before painting, dye penetration test shall be carried out on welded parts of jacking bosses, lifting lugs and all load bearing members. Also radiographic tests shall be carried out on 5% of total weld length. The requirement of post-weld heat treatment for tank/stress relieving parts shall be based on recommendations of

BS: 5500, Table 4.4.3.1.

- (d) All necessary precautions shall be taken to prevent ingress of moisture between flange plates, around gaskets and O-rings, at insulator/flange interfaces etc. due to high humidity.
- (e) Tank stiffeners shall be provided, if required, for general rigidity and these shall be designed to prevent retention of water.
- (f) The transformer tank shall be of conventional type construction. In case the joint is welded, it shall be provided with flanges, suitable for repeated welding. The joint shall be provided with a suitable gasket to prevent weld splatter inside the tank. Proper tank shielding shall be done to prevent excessive temperature rise of the joint.
- (g) The main tank body excluding tap-changing compartments, radiators and coolers shall be capable of withstanding vacuums i.e. 100.64 KN/m² of gauge pressure, 760 mm of Hg.
- (h) The tank shall be designed to withstand:-
 - (i) Mechanical shocks during transportation.
 - (ii) Vacuum filling of oil.
 - (iii) Continuous internal pressure of 35 KN/m² over normal hydrostatic pressure of oil.
 - (iv) Short circuit forces.
- (i) Wherever possible, the transformer tank and its accessories shall be designed without pockets wherein gas may collect. Where pockets cannot be avoided, pipes shall be provided to vent the gas into the main expansion pipe. The vent pipes shall have minimum inside diameter of 15 mm except for short branch pipes, which may be 6 mm minimum inside diameter.
- (j) All joints other than those, which may have to be broken, shall be welded, when required, they shall be double-welded. All bolted joints to the tank shall be fitted with suitable oil-tight gaskets, which shall give a satisfactory service under the operating conditions and guaranteed temperature-rise conditions. Special attention shall be given to the methods of making hot oil tight joints between the tank and the cover as also between the cover and the bushing and all other outlets to ensure that the joints can be remade satisfactorily at site and with ease with the help of semi-skilled labour. If gasket is compressible, metallic stops shall be provided to prevent over compression.
- (k) Adequate space shall be provided at the bottom of the tank for collection of sediments.
- (l) The base of each tank shall be so designed that it shall be possible to move the complete unit by skidding in any direction without injury when using plates or rails.
- (m) Tank shields shall be such that no magnetic fields shall exist outside the tank. They shall be of magnetically permeable material. If required, impermeable shields shall be provided at the coil ends. Tank shield shall not resonate when excited at the natural frequency of the equipment. Bidder may confirm use of tank shields in the schedule of additional information.
- (n) Suitable guides shall be provided in the tank for positioning the core and coil assembly.
- (o) The tank shall be designed such that it can be mounted on the plinth directly.
- (p) When the transformers are provided with separately mounted radiators, flexible joints shall be provided in the main oil pipes, connecting the transformer tank to the radiator banks to reduce vibration and facilitate erection and dismantling.
- (q) The transformer tank, fittings, radiators and all accessories shall be designed to

withstand seismic acceleration, as specified.

- (r) All connections, bolted to the tank shall be fitted with suitable gas oil resistant gaskets, made of such a material that no serious deterioration occurs under service conditions. Gaskets of nitrile rubber or equivalent shall be used to ensure perfect oil tightness. All gaskets shall be of closed design (without open ends) and shall be of one piece only. Rubber gaskets, used for flange connections of the various oil compartments shall be laid in grooves or in groove-equivalent retainers on both sides of the gaskets throughout their total length. Care shall be taken to secure uniformly distributed mechanical pressure over the gaskets and retainers throughout the total length. Gaskets of neoprene and/or any kind of impregnated/ bonded cork or cork only which can easily be damaged by over-pressing are not acceptable. Use of hemp as gasket material is also not acceptable.

5.4.1.2 **LIFTING AND HAULAGE FACILITIES :-**

The transformer tank shall be provided with: -

- (a) Lifting lugs, suitable for the weight of the transformer, including core and windings, fittings and with the tank, filled with oil.
- (b) At least four jacking lugs and where required, with lugs suitably positioned for transport on a beam transporter.
- (c) Haulage lugs to enable a steel rope to be used safely for haulage in any direction.
- (d) The transformer must be provided with clearly marked locations for the fixing of jacks. The free space between the bottom of the tank and the fixing for jacks must be 300 - 350 mm.

5.4.1.3 **FOUNDATIONS, CABLE DUCTING ETC.:-**

The Supplier will have to liaise with the Purchaser or its authorised contractor immediately after Design approval to finalize the detailed design of the following:-

- Transformer main tank foundations.
- Cooler bank foundations.
- Marshalling kiosk/control cabinet location and foundation.
- Cable ducting requirements.
- Adequate bunding design for the complete containment of all oil spills.
- Any other civil/electrical requirements for the installation of the transformer.

5.4.1.4 **TANK COVER:**

- (a) The tank cover shall be of adequate strength, shall not distort when lifted and shall be provided with suitable flanges having sufficient and properly spaced bolts. At least two adequately sized inspection openings, one at each end of the tank shall be provided for easy access to the internal connections of bushings, winding connections and earthing links. The inspection covers shall not weigh more than 25 Kg. The inspection cover shall be provided with lifting handles.
- (b) The tank and cover shall be designed in such a manner so as to leave no external pockets in which water can lodge, no internal pockets in which oil can remain when draining the tank or in which air can be trapped when filling the tank, and to provide easy access to all external surfaces for painting. The design of the tank cover should not present a safety hazard to personnel working on top of the unit.
- (c) It must be possible to remove any bushing without removing the tank cover.
- (d) One pocket shall be provided for stem type thermometer in addition to those for the Bulbs of the oil temperature and winding temperature indicators. These pockets shall be located in the position of the maximum oil temperature and it must be possible to remove any bulb without lowering the oil level in the tank. Captive screwed caps shall

be provided to prevent the ingress of water to the thermometer pockets when they are not in use.

- (e) Bushings, turrets, covers of inspection opening, thermometer pockets etc. shall be designed to prevent ingress of water into or leakage of oil from the tank.
- (f) All bolted connections shall be fitted with weather proof, hot oil resistant gasket in between for complete oil tightness. If gasket is compressible, metallic stops shall be provided to prevent over-compression.
- (g) The top part of the tank cover shall be sloped to prevent retention of rain water and shall not distort when lifted.
- (h) The tank cover and all covers for mounting, cleaning, man-holes, hand holes and inspection openings on tank etc. shall be earthed by suitable grounding conductors of the flexible type, having a cross-section of minimum 95 mm². Appropriate earthing studs with bolts and washers, made of stainless steel shall be provided.

5.4.1.5 **AXLES AND WHEELS:**

- (a) The transformer shall be designed with flanged bi-directional wheels and axles of a suitable size to carry the full weight of the transformer, oil and accessories. These shall be so designed as not to deflect excessively to interfere with the movement of the transformer. Wheels, axles and bearings shall be fully corrosion - resistant and complete with fittings to facilitate lubrication.
- (b) Suitable locking arrangement along with foundation bolts shall be provided for the wheels to prevent accidental movement of the transformer.
- (c) The wheels are required to swivel and they shall be arranged so that they can be turned through an angle of 90 degrees when the tank is jacked up to clear of rails. Means shall be provided for locking the swivel movements in positions parallel to and at right angles to the longitudinal axis of the tank.
- (d) The rail track gauge shall be 5'6" (1676 mm) along longer axis as well as along shorter axis.
- (e) Foundation layout details will be furnished by the supplier during detailed Engineering.

5.4.1.6. **ANTI-EARTHQUAKE CLAMPING DEVICE :-**

To prevent transformer movement during earthquake, clamping device shall be provided for fixing the transformer to the foundation. The Bidder shall supply necessary bolts for embedding in the concrete foundation. The arrangements shall be such that the transformer can be fixed to or unfastened from these bolts, as desired. The fixing of the transformer to the foundation shall be designed to withstand seismic events to the extent that a static co-efficient of 0.3 g. applied in the direction of least resistance to that loading, will not cause the transformer or clamping devices as well as bolts to be over-stressed. Special steps must be taken to prevent mal-operation of Buchholz relay in such conditions.

The details of the device used and its adequacy, suitability and design calculations to withstand seismic load shall be brought out in the additional information schedule.

5.4.1.7 **CONSERVATOR VESSELS, OIL GAUGES AND BREATHERS:-**

- (a) A conservator, complete with sump and drain valve shall be provided in such a position, so as not to obstruct the electrical connections to the transformer having a capacity between highest and lowest visible levels of 7½% of the total cold oil volume in the Transformer and the cooling equipment from minimum ambient temperature to 100 Degree C. The minimum indicated oil level shall be with the feed pipe from the main tank covered with not less than 15 mm depth of oil and the indicated range of oil level

shall be minimum to maximum.

- (b) If the sump is formed by extending the feeding pipe inside the conservator vessel, this extension shall be for at least 25 mm. The conservator shall be designed so that it can be completely drained by means of the drain valve provided, when mounted as in service.
- (c) The conservator tank shall be bolted on to its support of mounting to allow for its removal for cleaning/repair. It shall be bolted onto the main tank to allow for its removal for cleaning/repair.
- (d) The conservator for main tank shall be fitted with a magnetic oil level gauge with low oil level, electrically insulated alarm contacts. The indicator shall have the minimum and maximum levels, indicated along with the normal level at an oil temperature of 25° C. The temperature markings shall preferably be integral with the level-indicating device. The gauge should be readable from the transformer base level. Sight glasses of oil level indicators shall be of laminated security glass. Sight glasses of transparent plastics will not be accepted.
- (e) Taps or valves shall not be fitted to oil gauge.
- (f) The oil connection from the transformer tank to the conservator vessel shall be arranged at a rising angle of 3 to 9 degrees to the horizontal upto the Buchholz Relay and shall consist of 80 mm inside diameter pipes as per IS: 3639.
- (g) A valve shall be provided at the conservator to cut off the oil supply to the transformer, after providing a straight run of pipe for at least a length of five times the internal diameter of the pipe on the tank side of the gas and oil-actuated relay and at least three times the internal diameter of the pipe on the conservator side of the gas and oil-actuated relay.
- (h) The conservator tank shall be equipped with a nitrile rubber diaphragm or bag filled with dry air, which isolates the transformer oil space from the ambient air. The bag shall work satisfactorily and without damage at all anticipated oil temperatures.
- (i) Provision shall be made for monitoring the integrity of rubber bag and giving an electrical alarm when the bag is damaged.
- (j) The space inside the bag is to be connected to ambient air through a removable silica-gel type breather with oil trap and dust filter and mounted about 1400 mm above ground. No valve is to be placed between this breather and the conservator. The moisture absorption, indicated by change in colour of the tinted crystals inside the breather can be easily observed from distance. Minimum quantity of silica gel will be 1 Kg. for every 3500 ltrs. of oil in the tank. The containers for the dehydrating agent shall be of transparent plastics. The quality of plastic material shall be got approved from the purchaser.
- (k) The conservator for the OLTC/diverter switch can be either an integral, but completely separated part of the main conservator or a separate oil tank. It shall have a prismatic or magnetic oil level gauge.

5.4.2 VALVES AND LOCATION: -

5.4.2.1 General: -

- (a) Blank flanges, plates or captive screw caps shall be fitted to all valves and pipe ends, not normally connected in service.
- (b) The omission of any, or the provision of alternative arrangements to the listed requirements, which alter the functional nature of the valve system, will not be accepted.
- (c) **All valves upto and including 100 mm shall be of gun metal. Larger valves may be of gun metal or may have cast iron bodies with gun metal fittings. They shall be of the**

full way type with internal screw and shall be opened by turning counter clockwise when facing the hand wheel.

- (d) Means shall be provided for padlocking the valves in the open and closed positions. Provision is not required for locking individual radiator valves.
- (e) Every valve shall be provided with an indicator to show clearly the position of the valve.
- (f) All valves shall be provided with flanges having machined faces.
- (g) All valves shall be suitable for continuous operation with transformer oil at 100° C.
- (h) Suitable valves shall be provided to take sample of oil from OLTC chamber during Operation of the transformer.
- (i) Oil sampling valves shall have provision to fix rubber hose of 10 mm size to facilitate oil sampling.
- (j) Each transformer shall be fitted with the valves, identified in the following Sub-sections as a minimum requirement.

5.4.2.2 MAIN TANK:-

- (a) One 50 mm (NW 50) bore filter valve located near to the top of the tank.
- (b) One 50 mm (NW 50) bore filter valve located near to the bottom of the tank and diagonally opposite to the filter valve required against (a). Where design permits, this valve may be combined with item (c).
- (c) One 50 mm (NW 50) drain valve with such arrangements as may be necessary inside the tank to ensure that the tank can be completely drained of oil as far as practicable. This valve shall also be provided with an approved oil sampling device.
- (d) Two 25 mm (NW 25) oil valves for taking oil samples from the top and bottom of the tank. The top-oil sampling point shall be brought down to be accessible from ground level.
- (e) A flanged 50 mm (NW 50) valve suitably positioned near the top of the main tank for the connection by the Purchaser of a 'Hydran' monitor.
- (f) A 100 mm (NW 100) flange for the vacuum control switch tank will be provided on the tank cover.

5.4.2.3 CONSERVATOR:-

- (a) One valve between the conservator and gas actuated relay for the main tank and, where appropriate, for the tap change diverter switch tank.
- (b) One drain valve for oil conservator tank so arranged that the tank can be completely drained of all oil. It shall also be fitted with an oil-filling hole with cap.

5.4.2.4 TAP CHANGER/DIVERTER SWITCH :-

50 mm filter and 50 mm (NW 50) drain valve where selector switches are contained in a separate tank.

5.4.2.5 RADIATORS AND COOLER BANKS:-

Valves of adequate size as per 'CBIP Manual on Transformers (Publication No. 275)' at each point of connection to the tank shall be provided.

5.4.2.6 Air release plug(s) of adequate size shall be provided.

5.4.3 JOINTS AND GASKETS:-

- (a) All joint faces shall be arranged to prevent the ingress of water or leakage of oil with a minimum of gasket surface exposed to the action of oil or air.
- (b) Nitrile base cork or equivalent shall be used for gaskets. Oil resistant synthetic rubber

gaskets are not permissible except where the synthetic rubber is used as a bonding medium for cork or similar material or where metal inserts are provided to limit compression.

- (c) Gaskets shall be consistent with the provision of a good seal and full details of all gaskets sealing arrangement shall be shown on the drawings.

5.4.4 **PRESSURE RELIEF DEVICE:-**

- (a) An approved pressure relief device of sufficient size shall be provided for rapid release of any pressure that may be generated within the tank and which might result in damage to the equipment. It shall positively operate, at a pressure of 7+/-1PSi (48+/-6.8KN/Sq.mm) and automatically reset when pressure falls below this value. There will be no leakage of oil after resetting of PRD. Means shall be provided to prevent the ingress of rain or dust. Pressure relief devices of the type mounted below normal oil level shall be of the resetting type once the dangerous pressure has been reduced to prevent unnecessary release of oil.
- (b) Contacts shall be provided for alarm and trip and initiation on operation of the device. Baffles shall be provided when necessary to safely control the direction in which oil or gas is ejected.
- (c) Unless otherwise approved, the relief device shall be mounted on the main tank and if on the cover, shall be fitted with a skirt projecting 25 mm. inside the tank to prevent gas accumulation.
- (d) One of the following methods shall be used for relieving or equalising the pressures in the pressure relief device.
 - (i) An equaliser pipe connecting the pressure relief device to the conservator or
 - (ii) The fitting of silicagel breather to the pressure relief device, the breather being mounted in suitable position for access at ground level.
- (e) Loss of oil on operation of the relief device shall be contained within the transformer oil retaining area.
- (f) The bidders shall furnish constructional, design details of pressure relief device(s) and calculations along with the bids to prove that the size and setting of pressure relief device(s) is adequate, considering the rating of the transformer, the quantity of oil in the Transformer and the insulating oil will not catch fire in case of any short/ground fault inside the transformer.

5.4.5 **EARTHING TERMINALS:**

Two substantial steel flag type terminals (each having two tapped holes with M10 bolts, plain and spring washers), capable of carrying for 5 seconds the full lower voltage short circuit current of the transformer and suitable for connection to 50 x 8 mm. Galvanised steel flat shall be located one on either side and near to the bottom of the transformer to facilitate connection to the local earthing system. The supplier shall provide earthing strips up to the ground level. Also each radiator, marshalling Kiosk, OLTC etc. shall be suitably earthed to the transformer tank or else have earthing terminals as appropriate.

5.4.6 **CORROSION PROTECTION:**

5.4.6.1 General:

- (a) Bidders shall state clearly the corrosion protection, applied to aluminum and aluminum-alloy parts.
- (b) Bidders shall draw attention to all exposed points in their equipment at which aluminum or aluminum- alloy parts are in contact with or in close proximity to other metals and shall state clearly the protection employed at each point to

exclude air and moisture.

- (c) A full description of the corrosion prevention system, proposed by the Bidder shall be given and this is subject to acceptance by the purchaser. This description shall include details of surface preparation, rust inhibition, and paint thickness, treatment of fasteners and painting of surfaces in contact with oil.

5.4.6.2 The minimum standards acceptable to the purchaser are:-

- (a) Hot Rolled Steel:

- (i) Grit blasting to grade sa 2.5 of ISO 8501-1.
- (ii) Epoxy-base zinc primer. Coating thickness 25 micrometer.
- (iii) Zinc spraying of tank bottom. Thickness 100 micrometer.
- (iv) Epoxy-based micaceous iron-oxide paint. Coating thickness 40 micrometer.
- (v) Alkyd or phenolic-based micaceous iron-oxide paint. Coating thickness-40 micrometer.

- (b) Radiators and Fasteners larger than 12 mm:-

- (i) Hot dip galvanized to IS: 2633.
- (ii) Cleaning and surface preparation followed by paint treatment as specified above.

- (c) Smaller fasteners, cable clips:-

Use of non-ferrous material, stainless steel or appropriate plated components.

5.4.7 **RATING, DIAGRAM AND VALVE PLATES:-**

The following plates or an approved combined plate shall be fixed to each transformer Tank at an average height of 1500 mm above the ground level:-

- (a) A rating plate bearing the data, specified in IEC 76 Part - I. This plate shall also include: -
 - (i) The short circuit current rating.
 - (ii) Time factor for each winding measured.
 - (iii) Measured no load current and no load losses at rated voltage and rated frequency.
 - (iv) Measured load losses at 75° C (Normal tap only).
 - (v) D.C. resistance of each winding at 75° C.
- (b) A diagram plate showing in an approved manner, the internal connections and the voltage vector relationship of the several windings, in accordance with IEC 76 Part-I with the transformer voltage ratio for each tap and, in addition, a plan view of the transformer giving the correct physical relationship of the terminals.
- (c) A plate showing the location and function of all valves and air-release cocks or plugs. This plate shall also if necessary warn operators to refer to the Maintenance Instructions before applying vacuum.
- (d) Current transformers Rating Plate.
- (e) Diagram plate, indicating the oil levels in the conservators dependent on the oil temperature.
- (f) Loading plan plate, showing transport dimensions and masses. This plate shall also warn the erection staff not to remove any cover, before filling the tank with oil to such a level where the windings are not exposed to the atmosphere. This shall be fixed directly on to the transformer tank and shall not be removed for transport.
- (g) Identification plates, alpha-numerical number in an approved manner, for all fans, marshalling cabinets, breathers, valves, cocks, accessories etc. (minimum size: 110mm x 50mm) rigidly fastened by rivets on corrosion proof base plates.

In addition, the function (description) of the related devices shall be clearly indicated on these plates. The alphanumerical numbers on the identification plates shall be of such a size as to be clearly legible from the floor level.

- (h) Plates, showing all control, measuring and monitoring circuits and terminal blocks. These plates shall be rigidly fixed at the inner side of the hinged door of the concerned marshalling kiosk.
- (i) Plates, showing the control circuit/ block diagram of the OLTC. These plates shall be rigidly fixed at the inner side of the hinged door of the motor drive cubicle.

Out door arranged plates are to be of polished stainless steel of top quality only (back ground clear, engraving black, depth of engraving 0.5mm) stainless steel, capable of withstanding the rigours of continuous outdoor service at site. Plates, arranged inside control and marshalling cubicles may be of material in accordance with manufacturer's standard, e.g. glass -fibre reinforced synthetic resin (subject for approval). All plates other than those located on tank cover shall be easily and clearly legible from ground level.

5.4.8. **CORE:**

- (a) The core shall be constructed from high grade non-ageing cold rolled super grain oriented silicon steel laminations, known as HIB steel as trade name having high permeability and low hysteresis loss. B-H and specific loss curve shall be furnished in support of these materials. Laminations of one particular thickness i.e. 0.23mm. or 0.27mm. or better (quoted grade and type) shall be used. Laminations of different grade(s) and different thickness(s) are not allowed to be used in any manner or under any circumstance.
- (b) After being sheared, the lamination shall be treated to remove all burrs and shall be reannealed to remove all residual stress. The insulation of the lamination, which is to be stated in the tender, shall be inert to the action of the hot transformer oil and pressure.
- (c) The design of the magnetic circuit shall be such as to achieve minimum possible active and reactive core losses during the entire life of the transformer.
- (d) The design of the magnetic circuit shall be such as to avoid static discharges, development of short circuit paths within itself or to the earthed clamping structure and production of flux component at right angles to the plane of laminations, which may cause local heating. The joints of limbs and yokes shall be designed and constructed to keep the no-load losses and the hot spot temperature in the magnetic core as well as the noise level as low as possible.
- (e) The core and winding shall be capable of withstanding the shock during transport, installation, service and adequate provision shall be made to prevent movement of core and winding relative to tank during these conditions and reduce vibrations to a minimum for all operating conditions. Care shall also be taken to secure uniformly distributed mechanical pressure over all the laminations to prevent setting of the core and to limit noise and vibration to a minimum under service conditions.
- (f) The Transformer shall be of **BOLTLESS** core design. The Bidders shall furnish the following documentary evidence towards their experience and performance in such type of design.
 - 1) Purchase order
 - 2) Approved drawings & GTP
 - 3) Any other documents related to boltless core design.
- (g) All steel sections, used for supporting the core shall be thoroughly sandblasted

after cutting, drilling and welding. Any non-magnetic or high resistance alloy shall be of established quality.

- (h) When bell type construction is offered, suitable projecting guides shall be provided on core assembly to facilitate removal of tank. The supporting framework of core shall be so designed so as to avoid presence of pockets, which would prevent complete emptying of the tank through drain valve or cause trapping of air during oil filling.
- (i) The core shall be provided with lugs suitable for lifting the complete core and coil assembly of the transformer.
- (j) The core and coil shall be so fixed in the tank that shifting will not occur when the Transformer is moved or during a short circuit.
- (k) Oil ducts shall be provided where necessary to ensure adequate cooling. The winding structure and major insulation shall not obstruct the free flow of oil through such ducts. Where the magnetic circuit is divided into pockets by cooling ducts parallel to the planes of laminations or by insulating material above 0.25 mm thick, tinned copper strip bridging pieces shall be inserted to maintain electrical continuity between pockets.
- (l) The temperature gradient between the core and surrounding oil shall be maintained less than 20°C. The manufacturer shall demonstrate this either through a test (procedure to be mutually agreed) OR by a calculation.
- (m) The transformer shall be designed in such a way that the maximum flux density in any part of the core and yoke at rated M.V.A, minimum frequency and highest system voltage shall not exceed 1.6 Tesla. The Tenderer shall establish this by calculation as per given format.
- (n) **Minimum knee point voltage is 110% of rated voltage. Accordingly, the operating flux density for design should be carefully chosen within the stipulated value to achieve the above minimum knee point voltage. The tenderer shall quote the practical achievable no load current at different percentages of rated voltage as per Guaranteed Technical Particulars along with a linear graph confirming the above said knee point voltage which will be verified during no load test method that 10% increase in voltage from 110% rated voltage causes the excitation current to increase not by more than 50%.**
- (o) The tenderer will offer the core for inspection and approval by the Purchaser during manufacturing stage. Tenderer's notice for this purpose shall be accompanied with the following documents towards use of prime core.
 - (i) Invoice of the supplier.
 - (ii) Mill's test certificates.
 - (iii) Packing list.
 - (iv) Bill of lading.
 - (v) Bill of entry certificates by customs.
- (p) Core material shall be directly procured either from the manufacturer or through their accredited marketing organizations of repute and not through any agent. All the core import documents must be in the name of the transformer manufacturer or in the name of the accredited marketing organizations of CRGO manufacturer.
- (q) The bidder should preferably have in-house core-cutting facility for proper monitoring and control on quality and also to avoid any possibility of mixing of prime material with defective/ second grade material. However, the core-cutting operation may be witnessed by OPTCL's representatives) at the works of the manufacturer and specific loss, other tests will be conducted on samples of

core materials, selected at random by OPTCL's representative.

The following procedure is to be adopted for those manufacturers who have no in-house core-cutting facility:

- (1) In the offer, against tender for transformers, the bidder should mention names of at least three manufacturers of Transformer core material who have at least 5 (five) years experience in manufacturing of Transformer grade core. The Transformer manufacturer (TM) can purchase the core from such manufacturer(s) for which approval will be accorded by OPTCL.
- (2) The bidder should specify the grade, thickness of core material in the offer along with submission of all graphs/ documents, relating to the grade of core material, offered by them.
- (3) The documents, as mentioned against Sl. '0' should be submitted to OPTCL, once the core materials are landed in any of the Indian ports/at the works of the accredited marketing organizations of CRGO manufacturer and same should be offered to OPTCL for inspection. The representative, deputed by OPTCL for such inspection will record the following informations:-
 - a) Purchase order No. & Date.
 - b) No. of packed coils with package Nos.
 - c) Gross weight.
 - d) Net weight
 - e) Port of loading.
 - f) Port of discharge.
 - g) Name of the ocean vessel.
 - h) Grade and thickness of core material.
 - i) Any other information, as mentioned on the body of packed coils.
- (4) The bidder in its offer will mention the names of at least three Sub-vendors, to whom they intend to assign their core cutting. Such sub-vendors should have been approved by other Electricity Boards/ Electrical utilities and are accredited by some International recognised certification body like ISO: 9000 etc., to ensure that a minimum quality parameters and tolerances are maintained. The experience, the details of core-cutting facilities, finishing and testing facilities etc., as available with such sub-vendors should be clearly outlined in the bid.
- (5) On award of contract, the TM is to assign the core-cutting to such sub-vendor(s) for which approval is to be given by OPTCL
- (6) After the packed core coils are received by the OPTCL's approved sub-vendors, the TM is to offer the same to OPTCL for deputing representative(s) to first note down the details as per SL (3) above and witness the cutting of cores and relevant tests on core samples.
- (7) The TM will offer the core materials for inspection during assembly stage and witnessing the stage inspection and relevant tests.
- (8) Tenderer shall furnish along with the bid the calculation towards Air-core reactance of H.V. winding and maximum peak value of magnetising in- rush current and shall justify that the transformer will not trip due to this during initial charging and subsequent chargings.
- (9) Tenderer shall furnish along with the bid the calculation towards Air-core reactance of H.V. winding and maximum peak value of magnetising in- rush current and shall justify that the transformer will not trip due to this during initial charging and

subsequent chargings.

5.4.8.1 **EARTHING OF CORE CLAMPING STRUCTURE :**

The top main core clamping structure shall be connected to the tank body by a copper strip. The bottom clamping structure shall be earthed by one or more of 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 maintained by the weight of the core and windings.
- (c) By a connection to the top structure on the same side of the core as the main earth connection to the tank.

5.4.8.2. **EARTHING OF MAGNETIC CIRCUITS :**

- (a) The magnetic circuit shall be earthed to clamping structure at one point only through a removable link, placed in an accessible position just beneath an inspection opening in the tank cover and which, by disconnection, will enable the insulation between the core and clamping plates etc. to be tested at voltages upto 2.0KV(rms). The removable link shall have adequate section to carry ground fault current.
- (b) When magnetic circuits are subdivided into separate isolated sections by ducts perpendiculars to the plane laminations, all such sections shall be earthed.

5.4.8.3 **SIZE OF EARTHING CONNECTIONS:-**

To be proposed by the manufacturer for the Purchaser's approval.

5.4.9. **WINDINGS:-**

- (a) The supplier shall ensure that the windings of all EHV class transformers are made in dust proof, conditioned atmosphere. **He shall furnish the facilities, available in this regard at his works along with the bid.**
- (b) The windings for system rated voltages of 132 KV shall have graded insulation, as defined in IEC-76 and IS-2026. The winding for 33 KV shall be fully insulated.
- (c) All neutral points shall be insulated to withstand the applied test voltage as per above standards.
- (d) The neutral ends of star connected three phase windings shall be connected at points, which are accessible from manholes in the cover and brought out via one bushing.
- (e) The conductors for the windings and connecting leads shall be of electrolytic grade copper, free from scales and burrs and shall have properly rounded corners to reduce electrostatic flux concentration.
- (f) The current density, adopted for all the windings shall not exceed 2.8 Ampere/sq.mm. The total net cross-sectional area of the strip conductors for calculating the current density for each winding shall be obtained after deducting the copper area, lost due to rounding up of the sharp edges of the rectangular conductors.
- (g) The copper conductors, used in the coil structure shall be best suitable to the requirements and all permanent current carrying joints of the windings and the leads shall be welded or braced or crimped.
- (h) The coils shall be supported between adjacent sections by insulating spacers and the barriers, bracings and other insulation, which shall be arranged to ensure a free circulation of the oil and to reduce hot spots in the windings. The stacks of windings shall receive adequate shrinkage treatment before final assembly.

Adjustable devices shall be provided for taking up any possible shrinkage of coils in services.

- (i) The transformer shall be designed to withstand impulse and power frequency test voltages as specified in IEC 76 and IS: 2026.
- (j) The windings shall be capable of withstanding axial and radial forces during fault conditions as per clause No.5.1.2. of this specification. **The detailed calculation towards the above should be furnished along with the bid.**
- (k) The short circuit temperature rise should not exceed the limits, fixed as per IS:2026. **The calculation towards the above for 132 KV and 33 KV windings shall be furnished along with the bid.**
- (l) The insulation of transformer windings and connections shall be free from insulating compounds which are liable to soften, ooze out, shrink or collapse or be catalytic and chemically active in the hot transformer oil during service. The dielectric strength of winding insulation shall conform to the values, given in IS: 2026, as amended up to date.
- (m) The coil clamping arrangement and the finished dimensions of any oil duct shall be such as will not impede the free circulation of oil through the ducts.
- (n) No strip conductor wound on edge shall have a width exceeding six times its thickness.
- (o) The conductors shall be transposed at sufficient intervals in order to minimize eddy currents and equalize the distribution of currents and temperatures along the windings.
- (p) The windings and leads of all transformers shall be able to withstand the shocks, which may occur through rough handling and vibration during transport, switching and other transient service conditions including external short circuit. Adequate barriers shall be provided between windings and core and between windings. All leads or bars from the windings to the terminal boxes and bushings shall be rigidly supported. Stresses on coils and connections must be avoided.
- (q) The windings shall be located in a manner, which will ensure that they remain electro-magnetically balanced and their magnetic centres remain co-incident under all conditions of operations.
- (r) Tappings shall be so arranged as to preserve the magnetic balance of the transformer at all voltage ratios.
- (s) The coils should be made up, shaped and braced to provide for expansion and contraction due to temperature changes.
- (t) Coil clamping rings, if provided, shall be of steel or of suitable insulating material.
- (u) All threaded connections shall be provided with locking facilities. All leads from the winding to the terminal board and bushing shall be rigidly supported to prevent injury from vibration. Guide tubes shall be used, where practicable.
- (v) The assembled core and windings shall be vacuum dried and suitably impregnated before removal from the treating tank.
- (w) Where coil-clamping rings are of metal at earth potential, each ring shall be connected to the adjacent core clamping structure on the same side of the transformer as the main earth connection. However, same shall be proposed by the manufacturer for the Purchaser's approval.
- (x) Washers in contact with non-ferrous parts, which carry current, shall be of phosphorous bronze.
- (y) The tenderer should have in house availability of vapour phase Drying (VPD) plant for proper drying of the insulation. In case VPD facility is not available, the

bidder will prove that the method of drying adopted by them is equivalent or better than VPD in terms of level of dryness and other benefits of VPD.

- (z) The air-core reactance of HV winding of Transformer shall not be less than 20%.
- (aa) The transformer shall be designed to withstand a DC current of 10A per phase without injurious heating.
- (cc) Tan delta value for windings shall be less than 0.005. Tan delta shall be measured at ambient temperature. No temperature correction factor shall be applied.
- (dd) The arrangement of the core and windings shall be in the following manner:-

CORE-LV-HV-REGULATING

5.4.10. GAS AND OIL-ACTUATED RELAYS:-

- (a) Each transformer shall be fitted with gas and oil-actuated relay equipment having alarm contacts, which close on collection of gas or low oil level, and tripping contacts which close following oil surge conditions. Separate relays shall be provided for on load tap changer.
 - (b) Each gas and oil-actuated relay shall be provided with a test cock to take a flexible pipe connection for checking the operation of the relay.
 - (c) Each relay shall be fitted with a calibrated glass window for indication of gas volume.
 - (d) To allow gas to be collected at ground level, a small bore pipe shall be connected to the gas release cock of the gas and oil-actuated relay and brought down to a point, approximately 1400 mm above ground level,. Where it shall be terminated by a cock, which shall have provision for locking to prevent unauthorized operation.
 - (e) The design of the relay mounting arrangements, the associated pipe work and the cooling plant shall be such that mal-operation of the relay will not take place under normal service conditions, including starting or stopping of oil circulating pumps whether by manual or automatic control under all operating temperatures.
 - (f) The pipe work shall be so arranged that all gas arising from the transformer will pass into the gas and oil-actuated relay. The oil circuit through the relay must not form a delivery path in parallel with any circulating oil pipe, nor is to be tied into or connected through the pressure relief vent. Sharp bends in the pipe work shall be avoided. For this reason, bushing turrets, if fitted shall have vent pipes, which will route any gas collection through the relay.
 - (g) A machined surface shall be provided on the top of each relay to facilitate the setting of the relays and to check the mounting angle in the expansion pipe and the cross level of the relay.
 - (h) A straight run of pipe work shall be provided for a length of five times the internal diameter of the pipe on the conservator side of the gas and oil-actuated relay.
 - (i) The surge float contacts shall close at a rate of steady oil flow between the following limits. As far as possible, the limits shall also be met when the relay is subjected to oil surge conditions, produced by rapid opening of a lever operated gate valve.
 - (j) The relays shall be so located as to be easily accessible from the top of the tank.
- Oil Pipe Connection I.D. (mm) Operational Limits for Relay.

[Rising angles of 1° to 9°.]

25 700-1300

50	750 - 1400
75	900 - 1600

- test:
- (k) The gas collection contacts shall operate within the angle limits, specified for
 - (l) When a transformer is provided with two conservators, the gas and oil - actuated relays shall be arranged as follows:
 - (i) If the two conservators are connected to the transformer by a common oil pipe, one relay shall be installed in the common pipe.
 - (ii) If the two conservators are piped separately to the transformer, two relays shall be installed, one in each pipe connection.
 - (m) The clearance between oil pipe work and live metal shall be not less than the minimum clearances as per standard practice.

5.4.11. **TEMPERATURE INDICATING DEVICES AND ALARMS:-**

The Transformer shall be provided with approved devices for indicating the oil temperature and hot spot winding temperature of each winding. The devices shall have a dial type indicator and in addition, a pointer to register the highest temperature reached and re-setting device. Each temperature device shall have three separate contacts fitted, one of which shall be used to control the cooling plant motors, one to give an alarm and one to trip the associated circuit breakers.

(a) Oil Temperature Indicator (OTI)

The thermometer for top oil temperature indication should be of 150mm. dial type. 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 $\pm 1.5\%$ or better. The temperature indicator dials shall have linear graduations to clearly read at least every 2 deg. C.

(b) Winding Temperature Indicator (WTI).

A device for measuring the hot spot temperature of each of the HV/LV windings shall be provided. It shall comprise of the following:-

- i) Temperature sensing element.
- ii) Image Coil.
- iii) Auxiliary CTS, if required to match the image coil, shall be provided and mounted in the cooler control cabinet. For autotransformers, an additional CT is required in the lead to the primary terminal to give a true image of the temperature in the common/secondary winding. The current transformers shall be of class 1, and the rated primary current shall correspond to the rated current of the related transformer winding. The effective resulting rated secondary current shall be 2A. Matching units between current transformers and thermal replicas shall not be provided.
- iv) 150 mm diameter local indicating instrument with maximum reading pointer, mounted in cooler control cabinet and with two adjustable electrically independent ungrounded contacts (besides that required for control of cooling equipment), one for high winding temperature alarm and one for trip. The temperature indicator dials shall have linear graduations to clearly read at least 2 deg. C
- v) Calibration device.
- vi) In addition to the above, the following indication equipment shall be provided for each winding for remote indication.

1. Conventional Remote winding temperature indicator & Remote Oil temperature indicator: - It shall be suitable for flush mounting on RTCC panel. The difference between local and remote indication at any given time shall not exceed 1 deg. C.
 2. Auxiliary supply, if required, in RTCC panel, for above, shall be 220V DC only.
 3. The drawing showing details of above shall be submitted to the purchaser.
 4. Accuracy class of WTI & OTI shall be +/- 1.5% or better.
 5. Any special cable(s), required for shielding purpose for connection between cooler control cabinet and remote winding temperature indicator control circuit shall be in Bidder's scope.
- (c) The winding temperature indicators shall be housed in the cooler control cabinet/marshalling kiosk. The tripping contacts of the winding temperature indicators shall be adjustable to close between 80°C and 150°C and to re-open when the temperature has fallen by not more than 10°C.
- (d) The alarm contacts and the contacts used to control the cooling plant motors on the above devices shall be adjustable to close between 50°C and 100°C and to re-open when the temperature has fallen by a desired amount between 10° C and 15° C.
- (e) All contacts shall be adjustable to a scale and must be accessible on removal of the relay cover. Alarm and trip circuit contacts shall be suitable for making or breaking 150 VA between the limits of 30 and 250 Volts AC or DC and of making 500 VA between the limits of 110 and 250 V DC. Cooler motor control contacts shall be suitable for operating the cooler contactors direct, or if necessary, through an interposing relay.
- (f) The temperature indicators in the marshalling kiosk shall be so designed that it is possible to move the pointers by hand for the purpose of checking the operation of the contacts and associated equipment.
- (g) The working parts of the instrument shall be made visible by the provision of cut-away dials and glass-fronted covers. All setting and error adjustment devices shall be easily accessible.
- (h) Connections shall be brought from the device to terminal boards, placed inside the marshalling cubicle.
- (i) Terminals, links and a 63 mm moving iron ammeter shall be provided in the marshalling kiosk for each WTI for: -
- (i) Checking the output of the current transformer.
 - (ii) Testing the current transformer and thermal image characteristics.
 - (iii) Disconnecting the bulb heaters from the current transformer secondary circuit to enable the instrument to be used as an oil temperature indicator.
- (j) Sight glasses of temperature indicators shall be of laminated security glass. Sight glasses of transparent plastics will not be accepted.

5.4.12. COOLLING EQUIPMENT AND ITS CONTROLS:

5.4.12.1. Cooling Equipment:

- (a) The Cooler shall be designed using 2 x 50 % radiator banks.
- (b) Each radiator bank shall have its own cooling fans, shut off valves, lifting lugs,

- top and bottom oil filling valves, air release plug, a drain valve and thermometer pocket, fitted with captive screw cap on the inlet and outlet oil pipes.
- (c) One standby fan of at least 20% capacity shall also be provided and identified with each radiator bank.
 - (d) Cooling fans shall not be directly mounted on radiator bank which may cause undue vibration.
 - (e) The exhaust airflow from cooling fan shall not be directed towards the main tank in any case.
 - (f) Cooling fans for each radiator bank shall be located so as to prevent ingress of rainwater.
 - (g) It shall be possible to remove the blower complete with motor without disturbing or dismantling the cooler structure framework.
 - (h) The blades of cooling fans shall be of galvanised steel or cast aluminum alloy unless otherwise approved. Thickness of galvanization shall be minimum 55 microns.
 - (i) Blower casings shall be made of galvanised steel of thickness not less than 2 mm or aluminum alloy and shall be suitably stiffened by angles or tees.
 - (j) Galvanised wire guards with mesh not exceeding 12.5 mm shall be provided to prevent accidental contact with the blades. Guards shall also be provided over all moving parts. Guards shall be designed such that blades and other moving parts can not be touched by test fingers to IEC - 529:1976 (BSEN60529). Direction of rotation shall be indicated.
 - (k) Cooling fan motors shall be suitable for operation from 415 volts, three phase and 50 Hz power supply and shall conform to IS: 325. The motor winding insulation shall be conventional class 'B' type. Motors shall have hose proof enclosure - equivalent to IP: 55 as per IS: 4691.
 - (l) Each cooling fan motor shall be provided with starter thermal overload and short circuit protection.
- (m) **Each radiator shall be provided with the following items: -**
- One shut off valve at the top.
 - One shut-off valve at the bottom.
 - Air release device at the top.
 - Lifting lugs to lift entire cooling assembly.
 - Air release device and oil plug on oil pipe connections.
 - Loose blanking plates for blanking off the main oil connections.
 - Visual oil flow indicators, fitted with the electrical contacts to close when oil is not flowing. Contacts are to be connected in the cooler fail alarm circuit.
- Each radiator bank shall be provided with the following items: -**
- Main and sampling device at the bottom.
 - Expansion joints, one each on top and bottom cooler pipe connections.
 - A thermometer pocket fitted with captive screw cap, in the inlet and in the outlet oil pipes.
- (n) **Coolers shall be so designed as to be accessible for cleaning and painting to prevent accumulation of water on the outer surfaces to completely drain oil in the tank and to ensure against formation of gas pockets when the tank is being filled.**
- N. B.:** -The omission of any or the provision of alternative arrangements to the above requirements will not be accepted.
- (o) **OIL PIPES AND FLANGES :**
- All oil piping, necessary for connecting of each transformer to its conservator, cooler banks etc. shall be supplied under this contract.

- The oil piping shall be of approved material with machined flanged joints.
- Copper pipe work is to comply with BS.61.
- Dimensions of steel pipes shall be in accordance with BS. 3600: 1973 and the drilling of all pipe flanges shall comply with BS: 4504:1969.
- An approved expansion piece shall be provided in each oil pipe connection between the transformer and each oil cooler bank.
- All necessary pipe supports, foundation bolts and all other attachments are to be provided.
- It shall be possible to drain any section of pipe work independently of the rest and drain valves or plugs shall be provided as necessary to meet this requirement

5.4.12.2. **COOLING EQUIPMENT CONTROL (ONAN/ONAF COOLING):-**

- (a) Automatic operation control (switching in and out) of fans shall be provided (with temperature change) from contacts of winding temperature indicator. The supplier shall recommend the setting of WTI for automatic change over of cooler control from ONAN to ONAF. The setting shall be such that hunting i.e., frequent start operations for small temperature differential do not occur.
- (b) Suitable manual control facility for cooler fans with manual/automatic select or switches and push buttons shall be provided.

5.4.12.3. **INDICATING DEVICES:-**

Following lamp indications shall be provided in cooler control cabinet.

- Fan 'ON' Fan 'OFF'.
- Cooling system 'On Automatic Control'.
- Cooling system 'On Manual'.
- Selector switch in 'auto' or 'manual' for each fan.
- 415 volts cooler supply auto changeover.
- Cooler supply failure for each supply.
- Cooling fan failure for each fan.
- Control supply failure for main and stand by.
- One potential free initiating contact for all the above indications shall be wired independently to the terminal blocks of cooler control cabinet exclusively for purchaser's use.
- A 12-window annunciator shall be provided in the RTCC panel for visual and audible signaling of important functions of cooling equipment and tap changer.

5.4.12.4. **COOLER CONTROL CABINET:**

- (a) Each transformer unit shall be provided with a cooler control cabinet.
- (b) The cooler control cabinet shall have all necessary devices, meant for cooler control and local temperature indicators. All the contacts of various protective devices, mounted on the transformer shall also be wired upto the terminal board in the cooler control cabinet. All the secondary terminals of the bushing CTs shall also be wired up to the terminal board at the cooler control cabinet.
- (c) The cooler control cabinet shall have two (2) sections. One section shall have the control equipment, exclusively meant for cooler control. The other section shall house the temperature indicators, auxiliary CTs. and the terminal boards, meant for termination of various alarm and trip contacts as well as various bushing CT Secondaries. Alternatively, the two sections may be provided as two separate panels, depending on the standard practices of the supplier.

- (d) The temperature indicators shall be so mounted that the dials are not more than 1600 mm from ground level. Glazed door of suitable size shall be provided for convenience of reading.

5.4.12.5. **TERMINAL BLOCK:**

- (a) The terminal blocks('ELMEX' Make, Type – OAT 6 or its equivalent), to be provided shall be fully enclosed with removable covers and made of moulded, non-inflammable plastic material with block and barriers, moulded integrally. Such block shall have washer and binding screws for external circuit wire connections, a white marking strip for circuit identification and moulded plastic cover. All terminals shall be clearly marked with identification numbers or letters to facilitate connection to external wiring.
- (b) All internal wiring to be connected to the external equipment shall terminate on terminal blocks, preferably vertically mounted on the side of each panel. The terminal blocks shall be 1100 V grade and have 10 Amps continuous rating moulded piece, complete with insulated barriers, non-disconnecting stud type terminals, washers, nuts and lock nuts. Terminal block design shall include a white fibre-marking strip with clear plastic, slipon/clipon terminal cover. Markings on the terminal strips shall correspond to wire number and terminal numbers on the wiring diagrams.
- (c) Terminal blocks for current transformer's secondary leads shall be provided with test links and isolating facilities. Also current transformer secondary leads shall be provided with short-circuiting and earthing facilities.
- (d) At least 20% spare terminals shall be provided on each panel and these spare terminals shall be uniformly distributed on all terminal blocks.
- (e) Unless otherwise specified, terminal blocks shall be suitable for connecting the following conductors on each side.
 - (i) For all circuits except current transformer circuits, minimum of two nos. 2.5 sq.mm copper.
 - (ii) For all CT circuits, minimum of two nos. 4 sq. mm. copper.
- (f) There shall be a minimum edge-to-edge clearance of 250 mm. between the first row of terminal block and the associated cable gland plate. Also the clearance between two rows of terminal blocks shall be minimum of 150 mm.
- (g) Arrangement of the terminal block assemblies and the wiring channel within the enclosure shall be such that a row of terminal blocks is run parallel and in close proximity long each side of the wiring duct to be provided for convenient attachment of internal panel wiring. The side of the terminal block, opposite the wiring duct shall be reserved for the owner's external cable connection. All adjacent terminal blocks shall also share this field-wiring corridor. A steel strip shall be connected between adjacent terminal block rows at 450 mm intervals for support of incoming cables.
- (h) The number and sizes of the purchaser's multi-core incoming cable will be furnished to the Bidder after placement of the order.

5.4.12.6 **LABELS.**

- a) Labels shall be provided for all the apparatus such as relays, switches, fuses etc., contained in control cabinets/marshalling box.
- b) Description labels for mounting indoor or inside control cabinets/marshalling box shall be of such material that will ensure permanence of lettering. A matt of satin finish shall be provided to avoid dazzle from reflected light. Labels, mounted on dark surfaces shall have white lettering on a black background. All plates shall be of a material, which will not get corroded.

- c) Labeling shall be clear, concise and adequate.
- d) Labels shall be supplied as far as possible in the following four standard sizes
 - (i) Label for fuses and links shall measure approximately 28mm. to 45mm by 13mm. to 19mm. and lettering of 3mm to 6mm. shall be used according to the amount of inscription required. The lettering shall have strokes of approximately 1mm. width.
 - (ii) Labels for relays, contactors, thermal devices and similar apparatus shall measure 65mm. by 20mm. and shall have lettering as specified in (i) above.
 - (iii) Labels for controllers and changeover switches shall measure 70mm. by 30 mm and where practicable have 20 mm lettering with 1.5 mm strokes.
 - (iv) The labels for the doors of junction boxes, marshalling boxes and similar equipment shall measure 125 mm x 50 mm and have 13 mm, lettering with 1.5 mm wide strokes.
- (e) The labels for mounting outdoor shall be weather and corrosion proof. The letters/diagrams thereon shall be framed by etching or other such process, which will ensure permanence of the lettering/markings.
- (f) Labels shall be attached to panels with brass screws or with steel screws which have received rust preventive treatment.

5.4.13 **VOLTAGE SELECTION AND CONTROL :**

5.4.13.1. **On load tap changers:**

5.4.13.1.1 **General:**

- (a) The OLTC shall be of In Tank, Hi Speed Resistor type.
- (b) OLTC gear shall be motor-operated for local as well as remote electrical operation. An external hand wheel/handle shall be provided for local manual operation.
- (c) On-load tap-changer shall be sourced from reputed manufacturer and it should be type tested as per relevant IEC-60214 and test methods shall be in full conformance to the procedures, indicated in IEC-60214.
- (d) The details of the method of diversion of the load current during tap-changing, the mechanical construction of the gear and control features of OLTC gear shall be submitted with the bid. Information regarding the service experience on the gear and a list of important users shall be furnished. The tap-changer shall change the effective transformation ratio without producing phase displacement.
- (e) The current diverting contacts shall be housed in a separate oil chamber, not communicating with the oil in the main tank of the transformer. On load tap changer shall have maximum rated through current to meet the normal rated load as well as over-load as per standards. The OLTC should also be suitable for an occasional switching at 200% of the OLTC rating as per IEC-60214 which shall be validated with by the type test. The OLTC shall have BIL rating and short circuit withstand current as per relevant IEC standards.
- (f) All terminals shall be clearly and permanently marked with numbers corresponding to the cables connected thereto.
- (g) Tap positions shall be numbered consecutively ranging from one upwards. Tap one being the highest voltage ratio.
- (h) Current rating and voltage steps shall be as specified.
- (i) On-load tap changers shall comply with IEC 214:1976 and BS: 4571:1970 and shall be suitable for power flow in both the directions. **Only designs, which have been type tested in accordance with these standards will be accepted. All the type test certificates as per the above standards shall be submitted along with the tender bid.**
- (j) Current making and breaking switches, associated with the tap selectors shall be contained in a tank in which the head of oil is maintained by means, completely

independent of that on the transformer itself.

- (k) Details of maintaining oil separation, oil levels, oil draining/filling/sampling, detection of oil surges and provision of alarm and trip contacts will be dependent on the design of tap-changer and be to the approval of the purchaser. However, a suitable pressure relief device shall be provided for all on-load tap changer compartments. It should be possible to inspect the diverter switch contacts without having to lower the oil in the transformer. Contact tips should be replaceable.
- (l) Transformer on load tap changers shall be equipped with a fixed resistor network, capable of providing discrete voltage steps for input to the supervisory system.
- (m) The Bidder shall indicate the safeguards in order to avoid harmful arcing at the current diverting contacts in the event of operation of the OLTC gear under overload conditions of the transformer.
- (n) Any 'DROP DOWN' tanks, associated with the tap changing apparatus shall be fitted with guide rods to control the movements during lifting or lowering.
- (o) All relays and operating devices shall operate correctly at any voltage between the limits specified.
- (p) The OLTC shall be suitably protected through oil surge relay. This surge relay shall be tested for an oil flow velocity of 1.20 +/- 0.20 m/s.

5.4.13.1.2. **MECHANISMS:**

- (a) The drive mechanism chamber shall be mounted on the tank in an accessible position. It should be adequately ventilated and provided with anti-condensation metal clad heaters with thermostatic control. All components inside shall be protected against corrosion, deterioration due to condensation, fungi etc. The door shall be pad-lockable.
- (b) The tap change mechanism shall be designed in such a way that when a tap change has been initiated, it will be completed independently of the operation of the control relays and switches. If a failure of the auxiliary supply during tap change or any other contingency would result in that movement, not being completed, an approved means shall be provided to safeguard the transformer and its auxiliary equipment.
- (c) Limit switches shall be provided to prevent over-running of the tap changing mechanism. These shall be directly connected in the operating motor circuit. In addition, mechanical stops shall be fitted to prevent over-running of the mechanism under any condition. For on-load tap change equipment, these stops shall withstand the full torque of the driving mechanism without damage to the tap change equipment. Limit switches may be connected in the control circuit of the operating motor, provided that a mechanical de-clutching mechanism is incorporated.
- (d) Thermal devices or other approved means shall be provided to protect the motor and control circuit.
- (e) A permanently legible lubrication chart shall be provided and fitted inside the tap-changing chamber.

5.4.13.1.3 **TAP CHANGE CONTROL PHILOSOPHY:-**

5.4.13.1.3.1 **General:**

The following operating conditions are applicable to the on-load tap changer controls:-

- (a) It must not be possible to operate the electric drive when the manual operating gear is in use.
- (b) It must not be possible for two electric control points to be in operation at the same time.
- (c) Operation from a control switch shall cause one tap movement only unless the control

switch is returned to the off position between successive operations. Subsequent tap changes shall be initiated only by a new or repeat command.

- (d) It shall not be possible for any transformer operating in parallel with one or more other transformers in a group to be more than one tap out of step with the other transformers in the group. On load tap changers shall be equipped with a time delayed INCOMPLETE STEP alarm, consisting of a normally open contact which closes if the tap changer fails to make a complete tap change. The alarm shall not operate for momentary loss of auxiliary power.
- (e) All electrical control switches and local manual operating gear shall be clearly labelled in an approved manner to indicate the direction of tap changing i.e., raise and lower tap number.

5.4.13.1.3.2. **Manual Control:**

- (a) The cranking device for manual operation of the OLTC gear shall be removable and suitable for operation by a man, standing at ground level.
- (b) The manual control shall be considered as back up to the motor operated control and shall be inter locked with the motor to block motor start up during manual operation. The manual operating mechanism shall be labeled to show the direction of operation for raising the terminal voltage and vice-versa.
- (c) Manual tap position indicator which shall be complete with the following:-
 - (i) Mechanical tap position indicator which shall be clearly visible from near the transformer.
 - (ii) A mechanical operation counter.
 - (iii) Mechanical stops to prevent over-cranking of the mechanism beyond the extreme tap positions.

5.4.13.1.3.3. **Local and Remote Control:**

Equipment for local, manual and electrical operation shall be provided in an outdoor cubicle. Electrical remote control equipment shall also be supplied on the tap changer. The following control facilities shall be provided: -

- (a) 'Local - Remote' Selector Switch, mounted in the local OLTC, control cabinet. When the selector switch is in 'local' position, it shall be possible to operate the 'raise-lower' control switches, specified in (b) below. Remote control of the raise- lower functions shall be inhibited. When the selector switch is in 'remote' position, the local OLTC control cabinet mounted 'raise-lower' switch, specified in clause (b) below shall be inoperative. Remote control of the raise/lower function shall be possible from the remote control panel. The 'local-remote' selector switch shall have at least two spare contacts per position, which are closed in that position, but open in the other position.
- (b) A 'raise-lower' control switch/push button shall be provided in the local OLTC control cabinet. This switch shall be operative only when 'local-remote' selector switch is in 'local' position.
- (c) An 'ON-OFF' tap changer control switch shall be provided in the local OLTC control cabinet of the transformer. The tap changer shall be in operative in the 'OFF' position. The 'OFF-ON' switch shall have at least one spare contact per position, which is closed in that position, but open in the other position.

5.4.13.1.3.4. **Remote group control:-**

The offered OLTC control scheme shall have provision of remote electrical group control during the parallel operation of transformer. This is in addition to independent control of OLTC.

- (a) A four position selector switch having 'Master', 'Follower', 'Independent' and 'Off'

position shall be provided in the remote OLTC control panel for each transformer. This shall be wired to enable operator to select operation of OLTC in either 'Master', 'Follower', 'Independent' or 'Off' mode.

- (b) Out of step relays with timer contacts shall also be provided to give alarm and indication in case tap position in all the transformers under group control are not in same position.
- (c) Master Position: If the selector switch is in Master position, it shall be possible to control the OLTC units in the OLTC units in the follower mode by operating the controls of the master unit. Independent operation of the units under Follower mode shall be prevented. However, the units under Independent mode will be controlled independently.
- (d) Follower Position: - If the selector switch is in follower mode, control of OLTC shall be possible only from panel of the Master Unit.
- (e) Independent Position: - In this position of selector switch, control of OLTC of individual unit only shall be possible.

5.4.13.1.4. **Control Circuits**:- The control circuits shall comply with following conditions:-

- (a) An interlock to cut off electrical control automatically upon recourse being taken to the manual control.
- (b) Re-enforcement of the initiating impulse for a tap changer, ensuring a positive completion, once initiated to the next (higher or lower) tap.
- (c) "Step-by-step" operation ensuring only one tap change from each tap changing impulse and a lockout of the mechanism if the control switch (or push button) remains in the "operation" position.
- (d) An interlock to cut out electrical control when it tends to operate the gear beyond either of the extreme tap positions.
- (e) An electrical interlock to cut-off a counter impulse for reverse step change being initiated during a progressing tap change and until the mechanism comes to rest and resets circuits for the new position.
- (f) Tap change in progress indication shall be provided by means of an indicating lamp at the purchaser's control panel. Necessary contacts for this and for remote tap position indicator at purchaser's control panel shall be provided by the Bidder.
- (g) Protective apparatus, considered essential by the Bidder according to specialties of the gear.

5.4.13.1.5. **Indications**:-

Apparatus of an approved type shall be provided on each transformer:-

- (a) To give indication mechanically at the transformer and electrically at the remote control point of the number of the tapping in use.
- (b) To give electrical indication, separate from that specified above, of tap position at the remote supervisory point. Suitable tap position transducer to be incorporated for indication.
- (c) To give indication at the remote control point and at the supervisory control point that a tap change is in progress, this indication to continue until the tap change is complete.
- (d) To give indication at the remote control point and at the supervisory control point when transformers operating in parallel are out of step.
- (e) To indicate at the tap change mechanism the number of operations, completed by the equipment. A six digit counter should be provided for this.

5.4.13.2. **LOCAL CONTROL CABINET**:-

The local OLTC control cabinet shall house all necessary devices, meant for OLTC control and

indication. It shall be complete with the following: -

- (a) A circuit breaker/contactors with thermal overload devices for controlling the A.C. auxiliary supply to the OLTC motor.
- (b) Cubicle light with door switch.
- (c) Space heaters to prevent condensation.
- (d) Padlocking arrangement for hinged door of cabinet.
- (e) Cable terminal glands for power and control cables to the OLTC gear.

5.4.13.3. REMOTE CONTROL PANELS:-

- a) All controls, alarms and indications for transformers shall be incorporated within the appropriate switchgear control panels. The supplier shall provide all indications, relays, switches etc. for remote indication and operation of the transformer from the substation control room. Comprehensive and detailed instructions shall be provided to the purchaser regarding correct installation of this remote panel.
- (b) The remote tap changer control panel shall be mounted in the purchaser's control room. Size and colour of the panel shall be to the approval of the purchaser.
- (c) Operation of remote control scheme shall be entirely suitable for the distance between the transformer and remote control panel. Details of the connection of the remote control panel to the transformer shall be provided by the supplier.
- (d) **The RTCC panel shall be compatible to SCADA operations.**
- (e) The standard requirements (which may be varied to suit manufacturer's design) shall be outlined in the following sub-clauses:

5.4.13.3.1. INSTRUMENTS:

- (a) Voltmeter (voltage at the low voltage terminals of the transformer).
- (b) Tap position indicator
- (c) Conventional winding & oil temperature indicator.

5.4.13.3.2. RELAYS:

- (a) Supervisory interface.

5.4.13.5.3. CONTROLS:

- (a) Automatic/non-automatic voltage control selector switch.
- (b) Remote/supervisory tap change control selector switch.
- (c) Raise/lower push-buttons.
- (d) Independent/Master/Follower selector switch.

5.4.13.5.4. INDICATIONS AND ALARMS :

- (a) Tap changer on manual control - white lamp.
- (b) Tap change in progress - white lamp.
- (c) Tap change out of step-alarm.
- (d) Cooling equipment running-white lamp.
- (e) Cooling equipment failure-alarm.
- (f) Tap changer supply voltage failure-alarm.
- (g) Tap change incomplete step-alarm.

5.4.13.6. AUXILIARY SUPPLY FOR OLTC CONTROL AND POWER CIRCUIT :-

Auxiliary supplies as indicated in the specification will be provided by the purchaser at any one place. All loads shall be fed by one of the two feeders through an electrically interlocked automatic transfer switch, housed in the marshalling Kiosk. The design feature for the transfer switch shall include the following: -

- (a) Provision for the selection of one of the feeders as normal source and the other as

standby.

- (b) Upon failure of normal source, the loads shall be automatically transferred after an adjustable time delay to the stand by source.
- (c) Indication for failure of the normal source and for transfer to standby source and also for failure to transfer shall be provided locally as well as at the remote control panel.
- (d) Automatic re-transfers to normal source with an adjustable time delay following re-energisation of the normal source.
- (e) Both the transfer and the re-transfer shall be dead transfers and AC feeders shall not be paralleled at any time.
- (f) Necessary isolating switches, MCBs and other components for the above power supply transfer arrangement shall be provided by the supplier.

5.4.14. **SUPERVISORY CONTROL:-**

5.4.14.1 **General:-**

- (a) Tap change control equipment shall be suitable for supervisory control and indication with make before break multi-way switch-having one potential free contact for each tap position. This switch shall be provided in addition to any other switch/switches, which may be required in remote tap position indication.
- (b) Transformer on-load tap changer shall be equipped with a fixed resistor network, capable of providing discrete voltage steps for input to the supervisory system.
- (c) Transformer tap change control will be effected from the sub-station control room with facilities for remote control from the supervisory control centre. Provision for such supervisory control shall be included in this contract.
- (d) The supervisory facilities, outlined in the following sub-clauses will be required and control circuit design must make provision for these.

5.4.14.2. **CONTROLS:**

- (a) Tap change control remote/supervisory select/deselect:-
N.B. :- Selection of supervisory control shall render voltage control non-automatic.
- (b) Tap position Raise/lower.

5.4.14. 3 **INDICATIONS AND ALARMS:**

- (a) Tap change remote/supervisory indication.
- (b) Tap position indication through appropriate transducer.
- (c) Tap change out of step alarm.
- (d) Tap changer auto/non-auto indication.
- (e) Independent/master/follower indication.
- (f) Tap change in progress indication.
- (g) AVR reference voltage failure alarm.
- (h) Tap changing incomplete (TCINCL).
- (i) Tap changer supply failure alarm.
- (j) Cooling equipment running indication.
- (k) Cooling equipment failure alarm.
- (l) All contacts for supervisory alarms and indications shall be potential free.

5.4.15. **TERMINAL AND CONNECTION ARRANGEMENTS :**

5.4.15.1 **RATING :** Current rating shall be 1.5 times the rated current of the transformer.

5.4.15.2. **OUTDOOR BUSHINGS:**

- a) Bushings shall be robust and designed for adequate cantilever strength to meet the

requirement of seismic condition, substation layout and movement along with the spare transformer with bushing erected and provided with proper support from one foundation to another foundation within the substation area. The electrical and mechanical characteristics of bushings shall be in accordance with IEC: 60137/DIN 42530. All details of the bushing shall be submitted for approval and design review. Bushings must have been type tested successfully as per IS: 2099/IEC-60137. The type test report need to be furnished during approval stage.

b) Bushing for voltage of 52 kV and above shall be RIP bushing with composite polymer insulator. 36 kV bushing shall be solid porcelain or oil communicating type.

c) RIP type bushing shall be provided with tap for capacitance and tan delta test. Test taps relying on pressure contacts against the outer earth layer of the bushing is not acceptable.

d) Where current transformers are specified, the bushings shall be removable without disturbing the current transformers.

e) Bushings of identical rating shall be interchangeable to optimize the requirement of spares.

f) Porcelain used in bushing manufacture shall be homogenous, free from lamination, cavities and other flaws or imperfections that might affect the mechanical or dielectric quality and shall be thoroughly vitrified, tough and impervious to moisture.

g) Composite polymer insulator shall be seamless sheath of a silicone rubber compound. The housing & weather sheds should have silicon content of minimum 30% by weight. It should protect the bushing against environmental influences, external pollution and humidity. The interface between the housing and the core must be uniform and without voids. The strength of the bond shall be greater than the tearing strength of the polymer. The manufacturer shall follow non-destructive technique (N.D.T.) to check the quality of jointing of the housing interface with the core. The technique being followed with detailed procedure and sampling shall be decided during finalization of QAP.

The weather sheds of the insulators shall be of alternate shed profile as per IEC 60815-3. The weather sheds shall be vulcanized to the sheath (extrusion process) or moulded as part of the sheath (injection moulding process) and free from imperfections. The vulcanization for extrusion process shall be at high temperature and for injection moulding shall be at high temperature & high pressure. Any seams / burrs protruding axially along the insulator, resulting from the injection moulding process shall be removed completely without causing any damage to the housing. The track resistance of housing and shed material shall be class 1A4.5 according to IEC60587. The strength of the weather shed to sheath interface shall be greater than the tearing strength of the polymer. The composite insulator shall be capable of high pressure washing.

End fittings shall be free from cracks, seams, shrinks, air holes and rough edges. End fittings should be effectively, sealed to prevent moisture ingress, effectiveness of sealing system must be supported by test documents. All surfaces of the metal parts shall be perfectly smooth with the projecting points or irregularities which may cause corona. All load bearing surfaces shall be smooth and uniform so as to distribute the loading stresses uniformly.

The hollow silicone composite insulators shall comply with the requirements of the IEC publications IEC 61462 and the relevant parts of IEC 62217. The design of the composite insulators shall be tested and verified according to IEC 61462 (Type & Routine test).

h) Clamps and fittings shall be of hot dip galvanized /stainless steel.

i) Bushing turrets shall be provided with vent pipes, to route any gas collection through the Buchholz relay.

j) No arcing horns shall be provided on the bushings.

k) RIP bushings shall be specially packed to avoid any damage during transit & suitable for long storage with non-returnable packing wooden boxes with hinged type cover, without any gaps between wooden planks. Packing box opening cover with nails/ screws type packing arrangement shall not be acceptable. Bushing oil end portion shall be fitted with metal housing with positive dry air pressure and a suitable pressure monitoring device shall be fitted on the metal housing during storage to avoid direct contact with moisture with epoxy. Alternatively oil filled metal housing with suitable arrangement for taking care oil expansion due to temperature variations shall also be acceptable. Manufacturer shall submit drawings / documents of packing for approval during detail engineering. Detail method for storage of bushing including accessories shall be brought out in the instruction manual.

l) The terminal marking and their physical position shall be as per IEC: 60076.

m) Tan Delta measurement at variable frequency (in range of 20 Hz to 350 Hz) shall be carried out on each condenser type bushing at transformer manufacturing works as routine test before dispatch and the result shall be compared at site during commissioning to verify the healthiness of the bushing. If the bushing Tan Delta goes beyond 0.005 or increase is more than 0.001 within the guarantee period with respect to the pre-commissioning values, the contractor shall arrange to replace the defective bushing by new one. No temperature correction factor shall be applicable for Tan Delta.

5.4.15.3. **TERMINAL CONNECTORS:**

- (a) Bushing terminals shall be provided with terminal connectors of approved type and size for connection to external parts. Terminal connectors, offered must have been successfully type tested as per IS: 5561.
- (b)
 - (i) All castings shall be free from blow holes, surface blisters, cracks and cavities. All sharp edges and corners shall be blurred and rounded off. The aluminum alloy castings, if used, shall conform to designation A6 of IS: 617.
 - (ii) No part of clamp shall be less than 10 mm. Thick.
 - (iii) All ferrous parts shall be hot dip galvanised conforming to IS: 2633. Spring washers and H.T. bolts shall be dectrogalvanised conforming to IS: 1573.
 - (iv) For bimetallic clamp, copper alloy linear of minimum thickness of 2 mm. Shall be cast integral with aluminum body.
 - (v) Flexible connectors shall be made from tinned copper sheets.
 - (vi) Size of terminal/conductor for which the clamp is suitable and rated current under site conditions shall be embossed/punched on each component of the clamp, except hardware.
 - (vii) All current carrying parts shall be designed and manufactured to have minimum contact resistance.
 - (viii) The short time rating of terminal connector shall not be less than the short time rating of respective bushing.
 - (ix) Terminal connectors shall be subject to all type, routine and acceptance tests as per IS: 5561 (latest).
 - (x) Malleable cast iron for terminal connectors or any of its parts and accessories shall not be acceptable.
 - (xi) Bolts and Nuts used shall be of stainless steel or galvanized/passivated mild steel.

5.4.15.4. **TERMINAL MARKING:**

Transformer terminals are to be provided with phase markings to the requirements of IEC- 616 and are subject to the agreement of the purchaser. Transformer terminals shall be silver/tin-plated copper.

5.4.15.5 **NEUTRAL EARTHING:**

The neutral terminals shall be brought to ground level by a brass or tinned copper grounding bar of approved size which shall be supported from the tank with porcelain insulators and connected to purchaser's local earth grid. The supplier must liaise with the purchaser or its approved contractor to finalise the details of installation of this earthing and mounting of the outdoor neutral C.T. on this.

5.4.16. **SPECIFICATION FOR CONTROL CABINETS:**

- (a) Control cabinets shall be of the free standing floor mounting type.
- (b) Control cabinet of the operating mechanism shall be made out of 3 mm thick sheet steel or 10 mm thick aluminium plate or casting. Hinged door shall be provided with pad locking arrangement. Sloping rain hood shall be provided to cover all sides. 15 mm thick neoprene or better type of gaskets shall be provided to ensure degree of protection of at least IP-55 as per IS: 2147.
- (c) Bus bars shall be of tinned copper of adequate cross-section to carry the normal current without exceeding the permissible temperature rise over an ambient temperature of 50 degree centigrade outside the cubicle. The buses shall be braced to withstand forces corresponding to short circuit current of 25KA.
- (d) Motors rated 1 KW and above being controlled from the control cabinet would be suitable for operation on a 415V, 3 Phase, 50 HZ system. Fractional KW motors would be suitable for operation on a 240V, 1- Phase, 50 HZ supply system.
- (e) Isolating switches shall be group operated units (3 pole for use on 3-MCBS phase supply systems and 2 pole for single phase supply systems) quick make quick break type, capable of breaking safely and without deterioration, the rated current of the associated circuit. Switch handle shall have provision for locking in both fully open and fully closed positions.
- (f) Push button shall be rated for not less than 6 Amps. 415V A.C. or 2 Amps, 220/110V D.C. and shall be flush mounted on the cabinet door and provided with appropriate nameplates. Red, Green and Amber indicating lamps shall be flush mounted.
- (g) For motors upto 5 KW, contactors shall be direct-on-line, air break, single throw type and shall be suitable for making and breaking the stalled current of the associated motor which shall be assumed equal to 6.5 times the full load current of the motor at 0.2 p.f. For motors above 5 KW, automatic star delta type starters shall be provided. 3 Pole contactors shall be furnished for 3 Phase motors and 2 Pole contactors for single phase motors. Reversing contactors shall be provided with electrical interlocks between forward and reverse contactors. If possible, mechanical interlocks shall also be provided. Contactors shall be suitable for uninterrupted duty and shall be of duty category class AC4 as defined in IS: 2959. The main contacts of the contactors shall be silver plated and the insulation class for the coils shall be class E or better. The dropout voltage of the contactors shall not exceed 70% of the rated voltage.
- (h) Contactors shall be provided with a three element positive acting, ambient temperature compensated, time lagged, hand reset type, thermal overload relay with adjustable setting. Hand reset button shall be flush with the front door of the cabinet and suitable for resetting with starter compartment door closed.

- (i) Single phase preventer relay shall be provided for 3 Phase motors to provide positive protection against single phasing.
- (j) Mini starters shall be provided with no volt coils, whenever required.
- (k) Purchaser's power cables will be of 1100/650 Volts grade stranded aluminum conductor PVC insulated, PVC sheathed, single steel wire armoured and PVC jacketed. All necessary cable terminating accessories such as glands, crimp type tinned copper lugs etc. for power as well as control cables shall be included in Bidder's scope of supply. Suitable brass cable glands shall be provided for cable entry.
- (l) Wiring for all control circuits shall be carried out with 1100/650 Volts grade PVC insulated tinned copper stranded conductors of sizes not smaller than 2.5 mm. At least 20% spare terminal blocks for control wire termination shall be provided on each panel. The terminal blocks shall be of non-disconnecting stand type. All terminals shall be provided with ferrules, indelibly marked or numbered and these identifications shall correspond to the designations on the relevant wiring diagrams. The terminals shall be rated for adequate capacity which shall not be less than 10Amps.
- (m) Separate terminal blocks shall be provided for terminating circuits of various voltage classes. CT loads shall be terminated on a separate block and shall have provision for short circuiting the CT secondary terminals.
- (n) Control cabinet shall be provided with 240V, 1 Phase, 50 HZ, 20 W fluorescent light fixture and a suitably rated 240 V, 1 Phase, 5 Amps, 3 Pin socket for hand lamps.
- (o) Strip heaters shall be provided inside each cabinet complete with thermostat (preferably differential type) to prevent moisture condensation. Heaters shall be controlled by suitably rated double pole miniature circuit breakers.
- (p) Signal lamps, provided shall be of neon screw type with series resistors, enclosed in bakelite body. Each signal lamp shall be provided with a fuse, integrally mounted in the lamp body.
- (q) Electric measuring instruments shall be of moving iron type. Ammeters for measuring current upto 30 Amps shall be directly connected while those for measuring above 30 Amps shall be connected through suitable CTs. Ammeters shall be provided with selector switches.
- (r) Items inside the cabinet, made of organic material shall be coated with a fungus resistant varnish.

5.4.17 **INSULATING OIL:-**

- (a) The quality of the oil, supplied with the transformer shall conform to IEC 296 (Mineral oil class 1) and IS: 335 with latest amendment, if any. The percentage of Naphthenic content in the oil will be more than 40 percent and paraffinic content will be less than 56 percent. No oil shall be supplied or used at any stage of manufacture or test without a certificate, acceptable to the Purchaser that it has a PCB content of less than 2 mg/kg. No inhibitors shall be used in the oil. The oil samples will be drawn as follows:-
 - (i) Prior to filling.
 - (ii) Before and after heat run test.
 - (iii) Before energising.
 All tests as per relevant IEC & ISS shall be conducted on all samples.
- (b) Sufficient quantity of oil, necessary for first filling of all tanks, coolers and radiators at the proper level along with 10% extra oil for topping up shall be supplied in non-returnable containers, suitable for outdoor storage.
- (c) The supplier shall despatch the transformer, filled with oil or in an atmosphere of Nitrogen. In the former case, the Bidder shall take care of the weight limitation on transport and handling facility at site. In the latter case, necessary arrangement shall be

ensured by the supplier to take care of pressure drop of nitrogen during transit and storage till completion of oil filling during erection. A gas pressure testing valve with necessary pressure gauge and adapter valve shall be provided. **The transformer shall also be fitted with an impact recorder during transportation. This impact recorder is on returnable basis.**

- (d) The Bidders shall ensure that the oil supplied is in accordance with the latest editions of the following specifications with amendments, if any.

<u>Sl. No.</u>	<u>Characteristics</u>	<u>Requirement.</u>	<u>Method of Test.</u>
1.	Appearance	The oil shall be clear and transparent & free from suspended matter or sediments.	A representative sample of oil shall be examined in a 100mm thick layer at ambient temperature.
2.	Density at 27 deg.C (Max)	0.89 g/cu.cm.	IS: 1448
3.	Kinematic viscosity at 27 deg.C (max.)	27Cst.	IS: 1448
4.	Interfacial tension at 27 deg.C (min.)	0.04 N/m	IS: 6104
5.	Flashpoint penskey Marten (closed) (min.)	140 deg.C	IS: 1448
6.	Pour point (max.)	-6 deg.C	IS: 1448
7.	Neutralization value (max.) (Total acidity).	0.03 mg KOH/g	IS: 335
8.	Corrosive Sulphur (In terms of classification of copper strip)	Non-corrosive	IS: 335 (Appendix 'B')
9.	Electric strength (break down voltage) min.		
	a) New unfiltered oil.	30 KV (rms) if the above value is not attained, the oil shall be filtered)	IS: 6792.
	b) After treatment.	60 KV (rms)	
10.	Di-Electric dissipation factor (tan delta) at 90 deg.C (max.)	0.002	IS: 6262
11.	Specific resistance (resistivity)		
	a) at 90 deg.C (min.)	35 x 10 ¹² Ohm-cm.	IS: 6103
	b) at 27 deg.C (min.)	1500 x 10 ¹² Ohm-cm.	
12.	Oxidation stability.		
	a) Neutralization value after oxidation (max.)	0.4 mg KOH/g.	
	b) Total Sludge after oxidation (max.).	0.10% by weight.	
13.	Presence of Oxidationinhibitor	The oil shall not contain anti oxidant inhibitors.	IS: 335 (Appendix 'D')
14.	Water content (max.)	a) Untreated and unfiltered oil- 50 ppm. b) Before commissioning- 10 ppm.	IS: 2362
15.	Aging characteristics after 96 hrs. with catalyst (Copper)	As per AS TMD/934/IS: 12177	
	a) Resistivity.		

	i) 27 deg.C	2.5 x (10) ¹² Ohm-cm.	
	ii) 90 deg.C	0.2 x (10) ¹² Ohm-cm.	
	b) Tan delta at 90 deg.C	0.2 (max.).	
	c) Total acidity.	0.05 mg KOH/gm (max.)	
	d) Sludge content by weight.	0.05% (max.)	
16.	a) Napthenic content	More than 40%	Spectroscopic ethod
	b) Paraffinic content	Less than 56%	or any other prescribed method.

The Test certificates to conform the quality of the oil shall be submitted by the supplier. The purchaser at his discretion may depute his representative for witnessing the tests at the works of the supplier or its sub-vendor. The purchaser's representative may recommend for testing of sample oil at CPRI/ERDA including ensuring the percentage of naphthenic and paraffinic content in the offered oil. The cost for such testing shall be borne by the supplier. The purchaser at his discretion may also get the supplied oil, tested at Govt. approved laboratory for determination of quality, naphthenic and paraffinic contents as per specification.

5.4.18 **CLEANING, PAINTING AND TROPICALISATION:-**

- (a) All steel surfaces except galvanized surfaces or where otherwise specified, shall be shot blasted to remove all rust, scale and foreign matters from the surface. Oil, grease, dirt and swarf shall be thoroughly removed by emulsion cleaning. The surfaces shall then be chemically cleaned and surface treated by phosphating and dried in accordance with IS-6005 - "Code of practice for phosphating of iron and steel". Immediately after phosphating, the surfaces shall be given two coats of high quality zinc chromate primer.
- (b) The interior surfaces of mechanism chambers, boxes and kiosks, after preparation, cleaning and priming shall be painted with one coat of zinc chromate primer, one coat of phenolic based undercoating, followed by two coats of phenolic based finishing paint to white colour, followed by a final coat of anti-condensation white paint of a type and make to the approval of the Purchaser. A minimum overall paint film thickness of 200 microns shall be maintained throughout.
- (c) All steel work and metal work, after preparation and priming shall be painted with one coat zinc chromate primer, one coat of phenolic based under coating and two coats of micaceous iron oxide paint to an overall thickness of 200 microns to hard gloss finishing Light Grey Shade No. 697 of IS:5. Each successive coat of paint shall be of slightly different shade to enable inspection.

The finished surface shall present a pleasing appearance free from dents or unevenness surfaces.

- (d) It is the responsibility of the supplier to ensure that the quality of paints used shall withstand the tropical heat and extremes of weather conditions. The paint shall not peel-off, wrinkle, be removed by wind, storm and handling on site and the surface finish shall neither rust nor fade during the service life of the equipment.
- (e) After erection at site, the interior surfaces of mechanism chambers and kiosks shall be thoroughly examined and any deteriorated or mechanically damaged surfaces of such shall be made good to the full specification, described above.
- (f) After erection at site, all surfaces of steel works and metal works shall be thoroughly washed down and examined. Any deteriorated or otherwise faulty paint work shall be removed down to bare metal and made good to the full specification described above, then painted one further coat of phenolic based under coating and one coat phenolic based hard gloss finishing paint to provide an overall minimum paint film thickness of 200 microns.
- (g) All paint work shall be left clean and perfect on completion of the site works.

- (a) 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.
- (b) Except for small wiring, current carrying terminal bolts or studs for mechanical reasons shall not be less than 6 mm in diameter.
- (c) All nuts and pins shall be adequately locked.
- (d) 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
- (e) All bolts, nuts and washers, placed in outdoor positions shall be treated to prevent corrosion, by hot dip galvanizing. Bolts and Nuts below M12 (12mm.) size shall be of stainless steel. Appropriate precautions shall be taken to prevent electrolytic action between dissimilar metals
- (f) Where bolts are used on external horizontal surfaces and where water can collect, methods of preventing the ingress of moisture to the threads shall be provided.
- (g) 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 or nuts are placed so that they are inaccessible by means of ordinary spanners, special spanners shall be provided.
- (h) 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.
- (i) Taper washers shall be provided where necessary.
- (j) Protective washers of suitable material shall be provided front and back on the securing screws.

5.4.20. 1 (a) Cable box/sealing end shall be suitable for following types of cable.

- i) 415 Volt Power 1100 Volt grade PVC Insulated aluminum conductor cable with armour.
- ii) Control. 1100 Volt grade PVC insulated 7/0.737 mm stranded copper conductor cable with armour.
- b) Compression type cable connector shall be provided for termination of power and control cables.
- c) All controls, alarms, indicating and relaying devices, provided with the transformer shall be wired up to the terminal blocks inside the local control cabinets (both cooler and OLTC control cabinets)
- d) All devices and terminal blocks with the cooler control cabinet shall be clearly identified by symbols, corresponding to those used on applicable schematic or wiring diagrams.

Following cabling works are specifically excluded from the scope of the supplier. However, interconnection drawings for the same are to be submitted by the supplier

- Cabling between Remote OLTC panel to cooler control cabinet.
- Cabling between Remote OLTC panel to local OLTC cabinet.
- Cabling between Remote OLTC to supplier's panel.
- Cabling between cooler control cabinet to supplier's panel.
- Cabling between local OLTC cabinet to supplier's panel.

TS-E38

The following fittings shall be provided with each transformer, covered in this specification.

- (a) Conservator for main tank with oil filling hole and cap, vacuum application valve, vacuum equalizing valve, isolating valves, drain valve, shut off valve, magnetic oil level gauge with low level alarm contacts, dehydrating breather, with oil seal.
- (b) Conservator for OLTC with drain valve, surge relay (oil flow operated), vacuum application valve, vacuum equalizing valve, magnetic type oil level gauge with low level alarm contacts, oil-level indicator and silica gel breathers.
- (c) Oil preservation equipment.
- (d) Pressure relief device with alarm/trip contact.
- (e) (i) Buchholz relay, double float/read type with isolating valves on both sides, bleeding pipe with pet cock at the end to collect gases and alarm and trip contacts (Rating 1 Amp. 220V DC) test cock, gas collection box and gas check valve at ground level.
(ii) Separate Oil Surge relay with above features to be provided for OLTC chamber.
- (f) Air release plug.
- (g) Inspection openings and covers.
- (h) Bushing with metal parts and gaskets to suit the termination arrangement.
- (i) Winding temperature indicators for local and remote mounting. One RWTI with a four point selector switch shall be provided for three windings.
- (j) Top Oil temperature indicators with maximum pointer along with two sets of contactors.
- (k) Cover lifting eyes, transformer lifting lugs, jacking pads, towing holes and core and winding lifting lugs.
- (l) Protected type mercury or alcohol in glass thermometer.
- (m) Bottom and top filter valves with threaded male adoptors, bottom sampling valve and drain valve.
- (n) Rating and diagram plates on transformers and auxiliary apparatus.
- (o) Earthing terminals.
- (p) Flanged bi-directional wheels.
- (q) Cooler Control Cabinet with pad locks.
- (r) On load tap changing equipment and OLTC control cabinet with pad locks.
- (s) Drain valve plugs shall be provided in order that each section of pipe work can be drained independently.
- (t) Insulating Oil.
- (u) Terminal marking plate.
- (v) Jacking pads//lugs
- (w) Lifting bollards.
- (x) Haulage lugs.
- (y) Cover lifting lugs.
- (z) Valve schedule plate.
- (aa) Valves, as indicated at Cl.No.5.4.2 of this specification.
- (bb) Wiring up to marshalling box with PVC SWA PVC copper cables, 1100 volts grade.
- (cc) RTCC Panel
- (dd) Bushing Terminal Clamps & Connectors
- (ee) Valves, as indicated at Cl.No.5.4.2 of this Specification
- (ff) Wiring upto marshalling box with PVC SWA PVC copper cables, 1100Volts grade.

Note: - The fittings listed above are only indicative and any other fittings which generally are required for satisfactory operation of the above rated power transformers are deemed to be included.

5.4.22. LIMITS OF TEMPERATURE RISE:-

The temperature rise on any part of equipment shall not exceed the maximum temperature rise specified below under the conditions specified in test clauses. The permissible temperature rise indicated is for a maximum ambient temperature of 50 degree C. If the maximum ambient temperature rises, permissible values shall be reduced accordingly. For actual maximum temperature at the location of installation, refer perfect synopsis.

Sl. No.	Nature of the part or of the liquid.	Maximum value of:	
		Temperature.	Temperature rise at a maximum ambient air temp. not exceeding 50 degree C.
1	Contacts in air, silver-faced copper, copper alloy or aluminium alloy (see notes (i) & (ii).	95	40/45
	Bare copper or tinned aluminium alloy.	75	25
2	Contacts in oil:	90	40
	Silver-faced copper, copper alloy or aluminium alloy [see note-(i)].	80	30
3	Terminals to be connected to external conductors by screws or bolts silver faced (see note (iii)).	105	55
4	Metal parts acting as springs.	(See note iv).	(See note iv).
5	Metal parts in contact with insulation of the following classes:		
	Class Y : (for non-impregnated materials).	90	40
	Class A: (for materials immersed in oil or impregnated).	100	50
	Class E: in air	120	70
	In oil	100	50
	Class B: in air	130	80
	In oil	100	50
	Class F: in air	155	105
	In oil	100	50
	Enamel: oil base	100	50
	Synthetic, in air	120	70
	Synthetic, in oil	100	50
6	Any part of metal or of insulating material in contact with coil, except contacts.	100	50
7	Oil	90	40

- Notes: (i) When applying the temperature rise of 45° C, care should be taken to ensure that no damage is caused to the surrounding insulating materials.
- (ii) The quality of the silver facing shall be such that a layer of silver remains at the points of contact after the mechanical endurance test. Otherwise, the contacts shall be regarded as 'bare'.
- (iii) The values of temperature and temperature rise are valid whether or not the conductor connected to the terminals is silver-faced.

- (iv) The temperature shall not reach a value where the elasticity of the material is impaired. For pure copper, this implies a temperature limit of 75°C.

5.4.23. MOTORS & MCBS:

- (a) All motors shall comply with IS: 325 and IEC 34 and dimensions with IEC-72. They shall be capable of operating continuously under actual service conditions without exceeding the specified temperature rises, determined by resistance, at any frequency between the voltage and frequency fluctuation, stated in this specification.
- (b) All miniature circuit breakers shall be provided with auxiliary contacts for remote indication of circuit breaker operation. Means shall be provided to prevent the miniature circuit breakers, being inadvertently switched to the 'OFF' Position. Miniature circuit breakers shall be mounted in such a manner so as to give easily visible indication of breaker position and shall be grouped and spaced according to their function in order to facilitate identification and easy replacement.

5.4.24. LIST OF MANDATORY SPARES FOR ENTIRE LOT OF TRANSFORMERS

The supplier shall provide the mandatory spares as detailed below.

Sl.No.	Description.	Quantity.
1	145kV HV Bushing with metal parts & gaskets	1 No
2	36kV LV Bushing with metal parts & gaskets	1 No
3	52kV HV Neutral Bushing with metal parts & gaskets	1 No
4	36kV LV Neutral Bushing with metal parts & gaskets	1 No
5	Winding Temperature indicators with contacts	1 set
6	Oil Temperature indicators with contacts	1 set
7	Pressure Relief Device	1 No
8	Magnetic oil level gauge with low oil level alarm contacts	1 No
9	Cooler fan with motor	1 No
10	Buchholz relay	1 No
11	Tap position Indicator	1 No

N.B.:-

- (a) The Supplier shall ensure that sufficient spare parts and consumable items are available for his own use during commissioning of the transformer. The spares, provided with the transformer shall not be used by the supplier without the written consent of the Purchaser and any spares, used during the commissioning of the transformer shall be replaced by the supplier at his own expense.
- (b) Spares shall be available during the life of the equipment and the Supplier shall give 12 months notice of his or any Sub-Suppliers, intention to cease manufacture of any component used in the equipment.
- (c) Any spare apparatus, parts and tools shall be subject to the same Specification, tests and conditions as similar material, supplied under this contract. They shall be strictly interchangeable and suitable for use in place of the corresponding parts, supplied with the transformer and must be suitably marked and numbered for identification and prepared for storage by greasing and painting to prevent deterioration.
- (d) All spare apparatus or materials, containing electrical insulation shall be packed and delivered in cases, suitable for storing such parts or material over a period of years without deterioration. Such cases shall have to be affixed to both the underside and top side of the lid a list detailing its contents. The case will remain as the property of the Purchaser.

5.5 **CENTRE OF GRAVITY:**

The center of gravity of assembled transformers shall be as low and as near the vertical center line as possible. The transformer shall be stable with and without oil. The location of the center of gravity, relative to track shall be clearly marked in the out line drawing, accompanying bid.

6.0 **INSPECTION AND TESTING:-**

6.1 **TESTING FACILITIES:-**

- 6.1.1 Bidders shall submit along with the bid, the details of testing facilities, available at their works for carrying out all the routine and type tests, as specified.
- 6.1.2 In case, the test facilities for any particular test are not available at the bidder's works, this shall be clearly brought out in the additional information schedule and proposed arrangement of carrying out that test shall be clearly indicated.
- 6.1.3 All the measuring systems, used for the tests have certified, traceable accuracy and are subjected to periodic calibration, according to the rules of 4.11 of ISO 9001[Ref-Cl.No.10 (Tests) of IEC-60076-1]
- 6.1.4 OPTCL at its discretion may use their own testing equipments or third party testing equipments such as Power Analyzer, Resistance meter etc during Routine test/Type test of the Transformers at the Bidder's Works. The test results of OPTCL/Third party instrument will be accepted for the purpose of the contract. During testing & inspection, of the Transformer, it shall be ensured to the Inspecting Officers that there must be direct connections from the secondary of the unit auxiliary testing transformer and from the secondaries of the testing instrument transformers to the power analyzer without any termination or any other parallel connection what so ever. The measuring instruments with connections should be positioned in such a manner that there shall be easy access to the above instruments / equipments at the time of testing by Inspecting Officers.

6.2 **GENERAL:-**

Inspection and testing shall be carried out on the transformer as detailed here and generally in accordance with IEC 76 and IS: 2026. The Purchaser shall have the right to reject a transformer, if test results do not comply with the standards/values, specified and informations/data, given in the schedules. For the purpose of determining when type tests are required, a transformer is considered to be representative of others only if it is fully identical in design, rating and construction.

Before and after acceptance testing, samples of oil shall be taken from the transformer and analysed for dissolved gases, using the procedures, specified in IEC Publications 567 and 599. Results of the analysis of gases, dissolved in the oil shall be immediately submitted to the Purchaser and included in the Acceptance Test Report. On completion of acceptance testing, the Supplier shall provide the Purchaser with seven copies of the complete test reports.

Full details of the proposed methods of testing including connection diagrams shall be submitted by the Supplier for approval at least one month before testing. All tests will be witnessed by the Purchaser.

The Purchaser shall have full access at all times to the works and all other places of manufacture of the transformers. The Supplier shall report to the Purchaser monthly or other period, as agreed between the two on manufacturing progress. The Supplier shall give the Purchaser on award of contract a complete manufacturing inspection program to allow the Purchaser, at its discretion, to inspect at all stages of transformer

manufacture.

6.3 **STAGE INSPECTION: -**

Stage inspection on core, windings, tank, OLTC and all other accessories etc. will be carried out by the Supplier in the presence of OPTCL's representative on free of cost to OPTCL before tanking of the core and windings. All the measurements will be taken on the above components, so as to ensure their compliance to the above Specification and the Guaranteed Technical Particulars. The possible routine tests like measurement of D.C. resistance, no load current and no load loss, determination of Knee Point Voltage, specific core loss, tank tests etc. will be conducted during stage inspection. For determination of number of turns in the windings, the manufacturer shall provide dummy core, so as to accommodate the LV winding and determining the ratio between the unknown No. of turns (winding) and known No. of turns, wrapped around the LV winding. The purchaser's representative at his discretion may choose small strips of core for testing at CPRI/ERDA. Also, a small piece of conductor for each type of winding and core material shall be made available to the purchaser's representative. Apart from the above, the purchaser at his discretion reserves the right to carry out the stage inspection at other stages also, for which advance intimation shall be given and all necessary co-operation shall be rendered by the manufacturer. The Supplier shall give at least two weeks notice in advance for deputing Inspecting Officer(s) to their works. Type Tests and routine tests on the transformer shall be conducted only if the stage inspection report and the pre-tanking tests are found to be in order as per this Specification.

6.4 **FINAL INSPECTION& TESTING:-**

Before offering for final inspection, type tests and routine tests, the Supplier shall furnish the factory test results (except dielectric tests) of the offered transformer(s) along with list of equipments/meters/instruments, to be used, during testing (both routine and type tests) as per Annex of this Specification along with calibration certificates of measuring instruments. The Purchaser may direct the Supplier for use of better equipments/meters during inspection/testing. The calibration of all the meters/instruments to be used during testing should have been done in Government approved laboratory. The Supplier shall give at least two weeks notice in advance for deputing Inspecting Officer(s) to their works.

6.4.1 **TYPE TESTS & SPECIAL TESTS:-**

The followings shall be regarded as type tests and shall be carried out in presence of Purchaser's representative on one unit out of the lot at the discretion of the purchaser. The charges for conducting each type test shall be quoted in the relevant price schedule.

(a) **Temperature Rise Test:-**

Test of temperature rise (IEC Publ. 76.2): This test shall be carried out on the tap giving the worst combination of loading on the transformer windings. The transformer shall be tested by feeding the tested losses or quoted losses, whichever is higher. The supplier, before carrying out such tests, shall submit detailed calculations, showing the alternatives possible on various taps and for the two different ratings (ONAN/ONAF) of the transformer and shall recommend the combination that results in highest temperature rise for the test. Temperature rise shall be measured at ONAN&ONAF ratings. Gas chromatographic analysis on oil shall be carried out before and after the temperature rise test and the results recorded in the test report. Sampling shall be in

accordance with IEC 60567. For evaluation of the gas analysis in temperature rise test, the procedure shall be as per IS: 9434 (based on IEC: 60567) and the results will be interpreted as per IS: 10593(based on IEC-60599). These results shall be treated as reference during future maintenance of Transformers. The calibration of OTI and WTI shall be done by transformer manufacturer and these calibrated OTI; WTI shall be used during testing of the transformer. The Sr.No.of WTI and OTI should be recorded during testing of the Transformer and only these OTI & WTI shall be supplied with the Transformer.

(b) **Measurement of Zero Sequence Impedance:-**

Measurement of open circuit and short circuit zero sequence impedances of the primary and secondary windings.

(c) **Auxiliary Power Consumption:-**

Measurement of power taken by fans.

(d) **Vacuum Test:-**

One transformer tank of each size shall be subject to full vacuum and tested at an internal pressure of 3.33 KN/Sq.m. (25 Torr) for one hour. The permanent deflection of plates after the vacuum has been released shall not exceed the values, specified below and the performance of the transformers shall not be affected in any way.

<u>Horizontal length of flat plate (mm.)</u>	<u>Permanent deflection (mm.)</u>
Upto and including 750	5.0
751 to 1250	6.5
1251 to 1750	8.0
1751 to 2000	9.5
2001 to 2250	11.0
2251 to 2500	12.5
2501 to 3000	16.0
Above 3000	19.0

The purchaser at his discretion may opt for vacuum test for the tanks of all the transformers, by paying extra cost to the supplier at their quoted price(s).

(e) **Pressure Test:-**

One transformer tank of each size together with its radiators, 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 35KN/Sq.m. whichever is lower. The applied pressure shall be measured at the base of the tank and maintained for one hour. The permanent deflection of flat plates after excess pressure has been released shall not exceed the values, specified in (d).

The purchaser at his discretion may opt for pressure test for the tanks of all the transformers, by paying extra cost to the supplier at their quoted price(s).

(f) **IP-55 Test:-**

One cooler control cabinet and OLTC cabinet for each type of transformer shall be tested for IP-55 protection in accordance with IS-2147/IEC-529.

(g) **Dynamic Short Circuit test:-** If desired by Purchaser, the 'Dynamic Short Circuit Test' shall be conducted at CPRI, Bangalore on any unit, randomly selected. The firm needs to quote price for above testing and transportation/other charges separately in the price bid. The firm will make all necessary arrangements for above Test.

N.B.: -1) The transformer offered or higher capacity (Both MVA & voltage rating) should have been tested as per the above type tests [6.4.1(a) to (f)] and chopped Lightning Impulse tests, as prescribed in this specification in presence of authorized representative(s) of Government Utilities. The bidder shall furnish four sets of such type & special test reports including Lightning Impulse Test Report (chopped Impulse) (indicating therein the type and design details) along-with the offer without which the tender may be rejected. These tests should have been conducted not before five years from the date of opening of bid.

2) Test reports towards all type tests as per IEC-214: 1976 and BS: 4571:1970 for the offered OLTC along with approved drawings to be submitted. Purchaser at his discretion may insist on repetition of some or all the applicable type tests as per above IEC & BS, at supplier's cost, if any discrepancy/deviation/deficiency is noticed in the type test reports.

6.4.2. **ROUTINE TESTS:-**

The followings shall be regarded as routine tests and shall be conducted on each transformer in the presence of purchaser's representative. No extra cost shall be paid for these tests.

- (a) **Measurement of winding resistance at all taps.**
- (b) **Voltage- ratio measurement and check of vector group.**
- (c) **Measurement of capacitance and dielectric dissipation factor of windings & bushings**(Before and after the series of dielectric tests). The capacitance test shall be carried out with the help of ampere turn bridge method on fully assembled transformer (filled with oil) to determine capacitance and tan delta between winding and earth as under:
 - i) HV winding with LV winding and tank earthed.
 - ii) LV winding with HV winding and tank earthed.
 - iii) HV and LV windings with tank earthed.
- (d) **Measurement of Insulation Resistance and Determination of Polarisation Index:** -This measurement shall be made with ten minute and one minute IR tests and should be repeated after all other tests.
- (e) **Impulse Test:**
 - (i) Full Wave Impulse Voltage withstand Test: - The test voltage shall be applied to each line. The applied voltage shall be the relevant lightning impulse voltage, specified in the schedule of requirements. This test shall be applied to each HV & LV Phase terminal.
 - (ii) Chopped wave impulse voltage withstand test: - The test voltage shall be applied to each line terminal. The applied voltage shall be 110% of the specified relevant lightning impulse voltage. This test shall be applied to each HV & LV Phase terminal.
 - (iii) An impulse test on transformer neutrals as per IEC-76-3 Clause 12.3.2 shall be carried out.
Tests (i) and (ii) shall be combined in a single sequence as follows for each line terminal:-

1. One reduced full impulse (calibration).
2. One 100% full impulse.
3. One or more reduced chopped impulse(s).
4. Two 100% chopped impulses.
5. Two 100% full impulses.

The sequence for test (iii) shall be as follows:-

1. One reduced full impulse at 50-75% of full level.

2. Three 100% full impulses.

In carrying out the above tests, the two extreme taps and another tap to be selected by the purchaser with each of the three phases, being tested on a different tap.

(f) **Separate source voltage withstand test/Applied Voltage test:-**

The test shall be conducted as per Cl. No- 10 of IEC-76-3; 2013 or its latest amendments. The applied voltage shall be the specified/relevant power frequency voltage.

(g) **Line terminal AC withstand voltage Test(LTAC):-**

The test shall be conducted as per Cl. No- 10 of IEC-76-3; 2013 or its latest amendments. The firm shall have to submit the over-potential diagram with details of calculation and explanation alongwith the offer for inspection.

(h) **Induced voltage Test with PD measurement(IVPD):-**

The test shall be conducted as per Cl. No- 10 of IEC-76-3; 2013 or its latest amendments. This test shall be carried out using a broad band instrument. The apparent charge (q) shall be in accordance with IEC 76-3.

(i) **Measurement of Impedance voltage on all taps.**

(j) **Measurement of the load loss at normal tap and extreme taps.** (To be carried out by three wattmeter method with low power factor wattmeter's at full rated current). The voltage, current, wattage, power factor and frequency meter reading in individual phases (u, v, w) shall be recorded during testing and shall be reflected in the test report.

(k) **Measurement of no load loss, no load current and determination of knee point voltage: -**

This test is to be carried out with three wattmeter method/Power Analyser by using low power factor wattmeters, three power factor meters, phase sequence meters, three low range ammeters and three each of average value and RMS value voltmeters. The test voltage from 10% voltage to 125% voltage shall be applied and currents, voltages (Average value and RMS value), wattmeters, power factor and frequency meter readings in all the three phases are to be recorded during the test. A saturation characteristic curve between the no load voltage (rms) vs. Measured current is to be plotted on the graph sheet, so as to determine the voltage at which increasing voltage by 10% (ten percent), the excitation current shall not increase by more than 50% (fifty percent). The knee point voltage as per specification will be complied if the excitation current at 121% of rated no load voltage shall not exceed by not more than 50% over the excitation current, obtained at 110% of the rated no load voltage. During the no load test, supplier's own generator set shall be used for feeding the above no load voltages at rated frequency. If the applied frequency is greater than the rated frequency, then proportionate voltage as per the rated frequency will be fed during the above no load test and following frequency correction formula along with the formula, stipulated at Clause No 16.5 of IS:2026 (Part-I) shall be used.

$$K = 0.5 [(f/f_1) + (f/f_1)^2]$$

Where f = rated frequency and f₁ = applied frequency.

For Example: - If measured loss = X Watts, correction factor due to R.M.S. and average

voltage as per ISS = K1 and frequency correction factor = K as per above formula, then corrected loss will be calculated as = measured loss • K1 • K.

If applied frequency is less than the rated frequency, no frequency correction formula will be applied. Rated voltage at that frequency will be fed during the no load test.

N.B.:- 1) If power analyser is to be used for determination of no load loss, no load current, Impedance Voltage, short circuit losses etc., its manual of operation, calibration certificate and the relevant standard for its use shall be produced prior to one month of test offer for studying its feasibility and reliability.

2) C.Ts. and P.Ts. of accuracy class 0.2 or better as per IS: 2705 are to be used during determination of no load losses and short circuit losses which involves financial implication. The calibration certificates of these C.Ts. & P.Ts. from independent Government approved laboratory shall be produced along with the traceability while offering for inspection. The accuracy class of reference standard C.T. & P.T. used for determination of the errors of the above C.Ts. & P.Ts. shall be 0.05 or better as per Clause No.2.9 of IS : 1248 (Part-9).

(l) **Measurement of Harmonic level** (1st to 24th Harmonic) in no-load current in all three phases at 90%, 100% and 110% of no-load voltage. The magnitudes of no load currents for all the three phases at the above excitation levels shall also be recorded and reflected in the test report for measurement of harmonic levels.

(m) **Measurement of capacitance and dielectric dissipation factor [Repeat © above).**

(n) **Measurement of polarisation Index (Repeat (d) above).**

(o) **Tests on no-load tap-changer (as per IS: 2026)**

(p) **Transformer noise measurement:-**

Noise level measurement in accordance with IEC Publication 551 using a precision sound level meter conforming to IEC Publication 651.

(q) **Auxiliary circuit tests:-**

All auxiliary circuits shall be subjected to application of 2KV (rms) withstand test voltage. Correct operation of all auxiliary control circuits will be tested.

(r) **Core earth test:-**

A test voltage of 2KV shall be applied between the core and the earthed structural steel work to prove that the core is earthed through the removable link, at one point only.

(s) **Oil BDV test.**

(t) **Measurement of Neutral current** during load loss test, which shall not be more than 2% of the rated current of the transformer.

(u) **Magnetic balance test.**

(v) **DGA test before and after all the tests.**

(w) **Oil Leakage test on transformer tank:-**

All tanks and oil-filled compartments shall be tested for oil tightness by completely filling with oil of viscosity, not greater than that of insulating oil, conforming to IS: 335 at the ambient temperature and as per this specification and applying a pressure, equal to the normal pressure plus 35KN/Sq.m., measured at the base of the tank. This pressure shall be maintained for a period of not less than 12 hours, during which time, no leakage shall occur. Bidder shall arrange for witnessing the leakage test of each tank.

(x) **Pressure Relief Device Test:-**

The pressure relief device of each size shall be subjected to increasing oil pressure. It shall operate before reaching the test pressure, specified at Cl.No.5.4.4 of this specification. The operating pressure shall be recorded. The device shall seal off after the excess pressure has been relieved. The following functional checks shall be conducted as acceptance tests on each of the pressure relief devices.

- i) Air- Pressure Test.
- ii) Liquid Pressure Test.
- iii) Leakage Test.
- iv) Contact Test.
- v) Di-electric Test.

(y) **Frequency Response Analysis (FRA) Test:-**

The supplier shall conduct the test at the time of final testing of the transformer and record the amplitude and phase shift results on CDS for subsequent analysis. The test shall also be carried out by the supplier before commissioning at site and compare this result with the results, obtained before dispatching the transformer and submit the report along with the above results in CDs for future analysis. Each transformer is subjected to FRA test and frequency responses, recorded as above and analysed in any of the following:-

- i) Shift in the response of the winding.
- ii) Differences between the responses of all the phases of the transformer.

(z) **Dew point measurement test before dispatching:-**

Positive Gas pressure is generally maintained at 0.175 Kg/m² during transportation and during storage. To ensure the same, dew point measurement shall also be carried out at site. The procedure and acceptance limits are as per CBIP Manual Pub. No.295 (2006) or latest.

Besides the above, the OLTC manufacturer shall conduct the following routine tests fully in compliance with IEC: 60214 on every unit, as given below, for which no extra cost will be payable by OPTCL.OPTCL will authorize its representative(s) for witnessing the said routine tests on any or some or all the OLTCs for the Transformers as per contract. It is the responsibility of the supplier to offer the OLTCs for following routine tests, to be conducted at the works of OLTC Manufacturer.

SL. No.	IEC reference	Test Description	Acceptance level
01.	60214 I. No.5.3.1	Mechanical Endurance Test	Minimum 1000 operations
02.	60214 Cl. No.5.3.2	Sequence Test	Switching operation with timing less than 50 m-secs.
03.	60214 Cl. No.5.3.4	Pressure Test	10PSI (0.7kg/sq.cm.) for 8hours at room Temperature.
04.	60214 Cl. No.5.3.4	Vacuum Test	Vacuum level, as guaranteed by manufacturer.
05	Special Test	Gas tightness Test,	Helium based or any other mutually agreed method.
06	60214 Cl. No.5.3.4	Auxiliary Circuits Insulation earth Test	Should withstand 2kV relative to earth for 1 Minute.
07	Special Test	Contact resistance	< 2 milli- Ohms.
08	Special Test	Physical & Dimensional	As per approved drawing.
TS-E38		Power Transformer 20 MVA, 132 /33 KV	Page 54 of 90

Checks.

All the relevant Test reports shall be submitted for OPTCL's approval.

N: B- The Purchaser reserves the right to have the tests carried out on the transformer(s) at his own cost in an independent Government approved laboratory to ensure that the Transformer complies with the requirements of this Specification.

6.4.3 CHALLENGE TEST :

6.4.3(a) Any participating bidder can challenge whether the supplier has supplied the transformer as per the purchase order / tender technical specification or not. Challenge testing can be done on any one transformer of a supplier, out of the ordered quantity, during guarantee period from the date of dispatch instruction but before commissioning at site.

6.4.3(b) The challenger shall have to make written request to the Senior General Manager(CPC) for challenge testing giving details of manufacturer, purchase order and rating of transformer supplied by the party challenged along with the following :

- i) Demand draft / Banker's cheque in favour of DDO, Head Quarter, OPTCL, Bhubaneswar amounting to Rs. 5,00,000/- (Rs. Five lacs only) towards challenge testing (non refundable).
- ii) Demand draft / Banker's cheque in favour of the party challenged amounting to rs. 1,00,000/- (Rs. One lac only) to meet their contingencies which shall be handed over to the party challenged at the time of sealing of the selected transformer for testing.
- iii) Confirmation of test date from the test lab (CPRI / ERDA). The test date shall not be later than 6 months from the date of submission of application for challenge testing. The test date at CPRI / ERDA is to be obtained by the challenger by deposit the required test charges.

6.4.3(c) All the expenses mentioned below during challenge testing shall be incurred by the challenger:

- i) Dismantling (if the transformer is already installed) and loading at site.
- ii) To & Fro transportation (including insurance) charges from site to testing platform and back to site (anywhere in ODISHA). The transformer lifted from site shall be fully insured against all the risk for the period starting from lifting of the transformer from the site till return back to site (anywhere in ODISHA) after testing.
- iii) Unloading and assembly at testing platform.
- iv) Dismantling after testing & loading from testing platform.
- v) Unloading at site.
- vi) Taxes, duties, levies, etc., during transportation of transformer from site to test lab & back to site, if any.
- vii) Re-installation charges of transformer at site, in case the selected transformer had already been installed.

viii) Testing fee / charges demanded by CPRI / ERDA.

All the arrangements in regards to above activities shall be exclusively made by the challenger.

6.4.3(d) The challenger shall intimate the proposed date of lifting of selected transformer to the Senior General Manager(CPC),OPTCL,Bhubaneswar,ODISHA at least, 15 days in advance, along with the following:

i) Bank guarantee, in acceptable form of an amount equivalent to F.O.R. Destination cost of the selected transformer including entry tax as per purchase order, in lieu of security of selected transformer for challenge testing. The Bank Guarantee shall be valid initially for one year.

ii) Insurance cover for full value of transformer against all the risk for the period starting from proposed date for lifting of the transformer from site till return back to site (anywhere in ODISHA) after testing.

Thereafter, permission for lifting of the transformer shall be granted to the challenger. The challenger shall also intimate the proposed date of lifting of selected transformer simultaneously to the party challenged.

6.4.3(e) The selected sample shall be lifted after sealing the same in the presence of authorized representative (s) of the challenger, the party challenged and OPTCL within 45 days prior to the date of proposed testing. If the party challenged fails to depute its representative to seal / witness the lifting of the proposed transformer on the intimated date, the transformer shall be lifted for testing without waiting for their representative for sealing / witness and the absence of their representative will be treated as their consent about sealing as well as challenge testing. The sealed transformer shall be transported to CPRI / ERDA for testing in order to proceed as per reserved testing schedule. Both party i.e. challenger, the party challenged may accompany the truck during transportation of selected sample from site to CPRI / ERDA and back.

6.4.3(f) The challenger, the party challenged and OPTCL shall witness the test. If any party i.e. challenger and / or the party challenged and / or OPTCL fails to attend / witness the testing, the sample shall be tested in their absence and all the parties have to accept the test results whatsoever.

6.4.3(g)The challenge testing would cover the following tests:-

a) Measurement of No load losses (including confirmation on requirement of minimum knee-point voltage as per OPTCL's Technical Specification).

b) Measurement of load losses at rated full (100%) load at principal tap duly converted to 75 deg.C winding temperature.

c) Temperature rise test.

All the tests shall be conducted in above mentioned sequence.

6.4.3(h)If all the test results conform to the specification, action shall be taken as detailed

below:

- a) The challenger will not be reimbursed the expenses incurred by him for challenge testing of the transformer.
- b) Since the challenge testing may take about 8 month's period for which the transformer may not be in operation. In such case, the actual performance guarantee of the transformer will be available for lesser period than prescribed performance period i.e. 36 months from the date of receipt or 30 months from the date of commissioning whichever is earlier, as per contract. Therefore, after expiry of contractual performance guarantee period of the transformer, the party challenged (Transformer manufacturer) shall have to further guarantee the transformer equivalent to the period starting from the date of application for challenge testing till return back to site after testing. For this, the party challenged shall have to furnish bank guarantee equivalent to 10% of the cost of transformer towards performance for the period as stated above.
- c) The Bank Guarantee, equivalent to the cost of transformer furnished in lieu to security, will be released on receipt of certificate by the consignee / site in- charge regarding receipt of the transformer complete with all fittings and accessories anywhere in Rajasthan to the challenger after recovery of re-installation charges etc, if any.

6.4.3(i) If any of the test results does not conform to the specification, action shall be taken as detailed below:

- a) The party challenged shall be declared as unsuccessful manufacturer and would be debarred from participating in all future tenders of power transformers for the period of 5 years. Further, the order for balance quantity under that particular order shall be cancelled.
- b) The party challenged shall have to reimburse all the expenses as detailed at Clause No. 6.4.3(c) incurred by the challenger on challenge testing directly to the challenger on furnishing requisite documents towards the expenses incurred. The party challenged shall also have to reimburse Rs. 5,00,000/- (Rs. five lakh only) to the challenger which had been incurred by the challenger as detailed at Clause No. 3.40.2 above.
- c) If the losses are found beyond guaranteed value then the penalty towards excess losses shall be recovered at twice the rate prescribed at Clause No. 5.2.2 of Specification for each supplied transformers in this order.
- d) If the transformer does not conform to the specification in temperature rise test, penalty @ 5% of F.O.R. Destination cost (including entry tax) of all the transformers supplied in that particular order till date shall be recovered.
- e) Any type of recoveries arising out due to challenge testing shall be recovered from the financial hold of the party challenged available with the OPTCL in any form in any order placed by the OPTCL.
- f) The Bank Guarantee(s) of the party challenged available with the Nigam against the purchase order shall be released after successful completion of performance guarantee period (including extended period as at Clause No. 3.40.8(b)) and recovery of all dues including the charges due to be reimbursed to the challenger.

6.4.4 **TESTS ON SITE:-**

The following site tests shall be performed on all units:-

- (a) General mechanical checks.
- (b) Core and winding insulation tests (Earth fault check on arrival at site).
- (c) Ratio and HV magnetisation current tests.
- (d) Vector group check.
- (e) Motors - Overload protection tests.
- (f) Motor pumps and motor/fans - Direction of rotation check for correct flow.
- (g) Buchholz device tests.
- (h) Silicagel breather check.
- (i) Temperature instrument calibration and tests.
- (j) Operational tests on tap change equipment.
- (k) Electric strength tests on insulating oil.
- (l) Bushing tests.
- (m) Impedance voltage at highest, rated and lowest voltage taps.
- (n) Zero sequence impedance at rated voltage tap.
- (o) DC resistance at all voltage taps.
- (p) Correct operation of all C.Ts
- (q) On-load tests.

7.0 **TEST REPORTS:-**

- (a) Six (6) sets of certified test reports and oscillograms shall be submitted for approval prior to the despatch of the equipment. The equipment shall be despatched only when all the required type and routine tests have been carried out and test reports have been approved by the Purchaser.
- (b) Each test report shall contain the following informations:-
 - (i) Complete identification, date, including serial number of the transformer.
 - (ii) Method of application, where applied, duration and interpretation of test results for each test.
- (c) Four (4) copies of the test reports for the tests carried out on the ancillary apparatus be furnished to the Purchaser for approval prior to despatch.
- (d) All auxiliary equipments/accessories shall be tested as per the relevant standards for the tests, as mentioned in this Specification. Test Certificates for the same shall be submitted to the Purchaser in four copies for scrutiny and record.

8.0 **LIST OF TRANSFORMER ACCESSORIES AND TEST CERTIFICATES REQUIRED FOR THEM:-**

Before offering for stage inspection of the Transformer, the supplier shall have to furnish the test certificates for the Transformer accessories, as enumerated below, wherever required.

<u>Sl. No.</u>	<u>Accessory</u>	<u>Ref. Standard</u>	<u>Test Certificates required.</u>
1.	Condenser Bushing	IS-2099	1. Appearance, construction and dimensional check. 2. Test for leakage of internal filling at a pressure of 1.Kg/Cm ² for 12h. 3. Insulation resistance measurement with 2 KV megger. 4. Dry power frequency voltage withstand test.

			<ul style="list-style-type: none"> 5. Dry power frequency voltage withstand test for test tap insulation. 6. Partial discharge measurement upto 1.5UN/ 1.732KV 7. Measurement of tan delta and capacitance.
2.	Bushings.	IS-2099	<ul style="list-style-type: none"> 1. Appearance, construction and dimensional check. 2. Insulation resistance measurement with 2 KV megger. 3. Dry power frequency voltage withstand test.
3.	OLTC	IS-8468	<ul style="list-style-type: none"> 1. Oil tightness test for the diverter switch oil chamber at an oil pressure of 0.5 Kg/Cm² at 100 degree C for 1 h. 2. Mechanical operation test. 3. Operation sequence measurement. 4. Insulation resistance measurement using 2 KV Megger. 5. Power frequency voltage withstand test on diverter switch to earth and between even and odd contacts. 6. Power frequency voltage withstand test on tap selector between maximum and minimum taps, between phases and supporting frames, between phases. 7. Operation test of complete tap changer. 8. Operation and dielectric test of driving mechanism.
4	Winding temperature indicator.		<ul style="list-style-type: none"> 1 Calibration test. 2 Dielectric test at 2 KV for one minute. 3 Accuracy test for indication and switch setting scales. 4 Test for adjustability of switch setting. 5 Test for switch rating. 6 Measurement of temperature rise with respect to the heater coil current.
5	Oil temperature indicator.		<ul style="list-style-type: none"> 1 Calibration test. 2 Dielectric test of 2 KV for one minute. 3 Accuracy test for indication and switch setting scales. 4 Test for adjustability of switch setting. 5 Test for switch rating.
6	Pressure Relief Valve.		<ul style="list-style-type: none"> 1 Functional test with compressed air to check bursting, pressure indication, flag operation and switch operation. 2 Dielectric tests at 2 KV for one minute. 3 Switch contact testing at 5A, 240V AC.
7	Cooling fan.	IS: 2312	<ul style="list-style-type: none"> 1. Insulation resistance measurement. 2. Dielectric test at 2 KV between winding and body for 1 minute. 3. Operation check. 4. Appearance, construction and Dimensional check.
8	Buchholz ` Relay.	IS-3637	<ul style="list-style-type: none"> 1. Leak test with transformer oil at a pressure of 3 Kg. /Cm² for 30 minutes at ambient temperature

			for relay casing.
			2. Insulation resistance measurement with 500 V Megger.
			3. Dielectric test at 2 KV for 1 minute.
			4. Elements' test at 1.75 Kg/ Cm ² for 15 minute using transformer oil at ambient temperature.
			5. Loss of oil and surge test.
			6. Gas volume test.
			7. Mechanical strength test.
			8. Velocity calibration test.
9.	Oil level Indicators.		9. Appearance, construction and dimensional check. 1 Test for oil levels. 2 Switch operations for low level alarm. 3 Switch contact test at 5A, 240V, A.C. 4 Dielectric tests at 2 KV for 1 minute.
10	Pressed Steel Radiators.		5 Appearance, construction and dimensional check. 1. Air pressure test at 2 Kg/ Cm ² under water for 15 minutes. 2. Appearance, construction and dimensional check.
11	OLTC Control Cubicle/cooler control cubicle.		1 Appearance, construction and Dimensional check. 2. Electrical operation. 3. Insulation resistance measurement using 500 V megger at ambient temperature. 4. Dielectric test at 2 KV for 1 minute.
12	Current transformer.	IS-2705	1. Appearance, construction and dimensional check. 2. Polarity check. 3. Measurement of insulation resistance. 4. High voltage power frequency test. 5. Determination of ratio error and phase angle of measuring and protection CTS. 6. Determination of turns ratio error for PS Class CTS. 7. Inter-turn insulation withstand test. 8. Excitation current characteristic test. 9. Secondary winding resistance measurement. 10. Knee-point voltage measurement for PS Class CT.

9.0 INSPECTION:-

9.1 GENERAL:-

- (i) The purchaser shall have access at all times to the works and all other places of manufacture where the transformer is being manufactured and the supplier shall provide all facilities for unrestricted inspection of the supplier's works, raw materials, manufacture of all the accessories and for conducting necessary tests, as detailed herein.
- (ii) The supplier shall keep the purchaser informed in advance of the time of starting and of the progress of the manufacture of the equipment in its various stages so that arrangements could be made for inspection.

- (iii) No material shall be despatched from its point of manufacture unless the material has been satisfactorily inspected and tested.
- (iv) The acceptance of the equipment shall in no way relieve the supplier of his responsibility for meeting all the requirements of this specification and shall not prevent subsequent rejection of such equipment, if found to be defective later.

9.2 **INSPECTION PROGRAMME:-**

- (a) The supplier shall chalk out a detailed inspection and testing programme for manufacturing activities for the various components. An indicative programme of inspection as envisaged by the purchase is given below. This is not however intended to form a comprehensive programme, as it is supplier's responsibility to draw up and carry out such a programme, duly approved by the Purchaser. Stage inspection on core and winding will be carried out before tanking of core. For this, the supplier shall give at least two weeks notice in advance. **The purchaser reserves the right to carry out the stage inspection, final inspection & testing by a third party.**
- (b) Additional tests, if required, are deemed to be included in the scope of work.
- (c) Stages of inspection and purchaser's participation would be defined and tied up at the time of award of contract within 15 days of issue of the Purchase order.
- (d) The supplier shall arrange all his tests in such a fashion that the inspection and testing shall not exceed 5 (five) days for the above transformer.
- (e) On site testing, if any discrepancies will occur, the supplier will be asked immediately for its rectification and the supplier shall depute his representative for rectification without any delay.
- (f) At the time of final inspection, the supplier shall identify each & every item/accessories of the particular Transformer under testing. Unless all items are identified, the manufactures will not be treated as complete. Serial No. of bushings, Tap-changer, WTI, OTI and other details shall be entered into the Test reports to ensure that these items are not being applied to the subsequent Transformer units while testing. Various tests as per the specification shall be performed in the presence of OPTCL Engineers or when the inspection waiver has been given, in such a case, the testing as per the specification shall be done at the manufacturers works and same should be confirmed by documentary evidence by way of Test Certificate, which shall be got approved by OPTCL.
- (h) In case, for any reason(s), inspection is not completed or the equipment is not found to be complete with all accessories as per confirmation, given with the inspection call, the purchaser reserves the right to recover the complete cost of deputation of inspection team to the works of the manufacturer.
- (i) The supplier shall submit the test certificates of the bought-out items and Raw materials at the time of the routine testing of the fully assembled equipments.
- (j) It may be noted that "No change in any accessory or associated equipment after passing all the tests successfully shall be allowed and if this is subsequently detected, it shall be binding on the supplier to replace with the same item with which the initial tests were conducted at his works, failing which the entire test shall become null & void. The purchaser at his discretion may consider for rejection of the units, thus supplied. The

entire cost for replacement of such rejected units, thus supplied and for repeating acceptance tests shall be borne by the suppliers.

9.2.1 **TANK AND CONSERVATOR:-**

- (a) Certification of chemical analysis and material test of plates.
- (b) Welder's qualification and welding procedure.
- (c) Testing of electrodes for quality of base materials and coatings.
- (d) Inspection of major weld preparation.
- (e) Crack detection of major strength weld seams by dye penetration test.
- (f) Measurement of film thickness of:
 - (i) Oil insoluble varnish.
 - (ii) Zinc chromate paint.
 - (iii) Finished coat.
- (g) Check correct dimensions between wheels, demonstrate turning of wheels through 90 degree and further dimensional check.
- (h) Check for physical properties of materials for lifting lugs, jacking pads etc. All load bearing welds including lifting lug welds shall be subjected to N.D.T.
- (i) Leakage test of the conservator.
- (j) Certification of all test results.

9.2.2 **CORE:**

- (a) Sample testing of core material for checking specific loss, bend properties, magnetisation characteristics and thickness.
- (b) Check on quality of varnish, if used on the stampings.
 - (i) Measurement of thickness and hardness of varnish on stamping.
 - (ii) Solvent resistance test to check that varnish does not react in hot oil.
 - (iii) Check overall quality of varnish by sampling to ensure uniform shining colour, no bare spot, no over-burnt varnish layer and no bubbles on varnished surface.
- (c) Check on the amount of burrs.
- (d) Bow-check on stampings.
- (e) Check for overlapping of stampings, corners of the sheets are to be apart.
- (f) Visual and dimensional check during assembly stage.
- (g) Check for interlaminar insulation between core sections, before and after pressing.
- (h) Check on completed core for measurement of iron loss, determination of knee point voltage and check for any hot spot by exciting the core so as to induce the designed value of the flux density in the core.
- (i) Visual and dimensional checks for straightness and roundness of core, thickness of limbs and suitability of clamps.
- (j) High voltage test (2 KV for one minute) between core, its bolts and clamps.
- (k) Certification of all test result.

9.2.3 **INSULATING MATERIAL.**

- (a) Sampling check for physical properties of materials.
- (b) Check for dielectric strength.
- (c) Visual and dimensional check.
- (d) Check for the reaction of hot oil on insulating materials.
- (e) Dimensional stability test at high temperature for insulating material.
- (f) Tracking resistance test on insulating materials.
- (g) Certification of all tests results.

9.2.4 **WINDING:**

- (a) Sample check on winding conductor for mechanical properties and electrical conductivity.
- (b) Check insulating distance between high voltage connection, cables and earth and other live parts.
- (c) Check insulating distance between low voltage connection and earth and other parts.
- (d) Check for proper cleanliness and absence of dust.
- (e) Visual dimensional checks on conductor for scratches, dent marks etc.
- (f) Sample check on insulating paper for PH value, electric strength.
- (g) Check for the bonding of insulating paper on the conductor.
- (h) Check for absence of short circuit between parallel strands.
- (i) Check for brazed joints wherever applicable.
- (j) Measurement of voltage ratio to be carried out when core/yoke is completely restacked and all connections are ready.
- (k) Certification of all test results.

9.2.5 **CHECKS BEFORE DRYING PROCESS:**

- (a) Check condition of insulation on the conductor and between the windings.
- (b) Check insulating distances between high voltage connections, cables and earth and other live parts.
- (c) Check insulating distances between the low voltage connection and earth and other parts.
- (d) Insulation test of core earthing. Insulation of the core shall be tested at 2 KV/min. between core to clamp plates and core bolts.
- (e) Check for proper cleanliness and absence of dust etc.
- (f) Certification of all test results.

9.2.6 **CHECKS DURING DRYING PROCESS:**

- (a) Measurement and recording of temperature, vacuum and drying time during vacuum treatment.
- (b) Check for completeness of drying by measuring IR value and TAN DELTA. Polarisation index of the winding i.e., ratio of IR value taken at 10 minutes to 1 minute shall be taken.
- (c) Certification of all test results.

9.2.7 **ASSEMBLED TRANSFORMER:**

- (a) Check completed transformer against approved out line drawings, provision for all fittings finish level etc.
- (b) Jack test with oil on the assembled transformers.
- (c) DP test shall be carried out after jacking test.

9.2.8 **OIL:**

Site test shall be performed on oil samples before and after filling in the transformer. Oil parameters shall conform to relevant IEC & IS prior to filling at site and oil samples taken from the tank top, bottom and cooling system after filling shall possess characteristics as per above standards. The supplier shall warrant that oil furnished is in accordance with the relevant clause of this specification. The purchaser at his discretion may send oil sample(s) to Govt. approved laboratory for determination of quality of oil including confirmation on percentages of naphthenic and paraffinic content, as specified at Cl. No.5.4.17 (a) of this Specification.

9.2.9 The makes of all major bought out items shall be subject to purchaser's approval. The

supplier shall also prepare comprehensive inspection and testing programme for all bought-out/sub-contracted items and shall submit the same to the purchaser for approval. Such programme shall include the following components.

- (a) Buchholz Relay.
- (b) Axles and wheels.
- (c) Winding temperature indicators for local and remote mounting.
- (d) Oil temperature indicators.
- (e) Bushings.
- (f) Neutral current transformers.
- (g) Cooler control cabinet.
- (h) Cooling equipments.
- (i) Fans/Air blowers.
- (j) Tap changing switch.
- (k) Terminal connectors.
- (l) Transformer oil

9.3 **PRE-SHIPMENT CHECK AT SUPPLIER'S WORKS:**

- (a) Check for proper packing and preservation of accessories like radiators, Bushings, explosion vent, dehydrating breather, rollers, Buchholz relay, fans, control cubicle, connecting pipes, conservator etc.
- (b) Check for proper provision of bracing to arrest the movement of core and winding assembly inside the tank.
- (c) Gas tightness test to conform tightness.
- (d) Deviation of leakage rate and ensure adequate reserve gas capacity.

9.4 **RECOMMENDED COMMISSIONING CHECKS:**

- (a) Check the colour of sillicagel breather.
- (b) Check the oil level in the breather housing, conservator tanks, cooling system, condenser bushing etc.
- (c) Check the bushing for conformity of connection to the lines etc. and tan delta test for bushings at 10 KV (min.)
- (d) Check for correct operation of all protection and alarm.
 - (i) Buchholz Relay.
 - (ii) Excessive winding temperature.
 - (iii) Excessive oil temperature.
 - (iv) Low oil flow.
 - (v) Low oil level indication.
 - (vi) Fan and pump failure protection.
- (e) Check for the adequate protection of the electric circuit supplying the accessories.
- (f) Check resistance of all windings on all the taps.
- (g) Insulation resistance measurement of:
 - (i) Control wiring.
 - (ii) Tap changer motor and control.
 - (iii) Cooling system motor and control.
 - (iv) Main windings.
 - (h) Check for cleanliness of the transformer and the surroundings.
- (i) Continuously observe the transformer operation at no load for 24 hours.
- (j) Gradually put the transformer on load, check and measure increase in temperature in relation to the load and check the operation with respect to temperature rise, noise level etc.

- (k) Phase sequence and vector group test.
- (l) Ratio tests on all taps.
- (m) Magnetising current test.
- (n) Tan delta measurement of windings.

10.0 QUALITY ASSURANCE PLAN:

The Bidder shall invariably furnish following information alongwith his offer, failing which the offer shall be liable for rejection.

- (i) 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 material in presence of Bidder's representative, copies of test certification.
- (ii) Information and copies of test certificates as in (i) above in respect of bought out items.
- (iii) List of manufacturing facilities available.
- (iv) Level of automation achieved and list of areas where manual processing exists.
- (v) List of areas in manufacturing process, where stage inspections are normally carried out for quality control and details of such tests and inspection.
- (vi) Special features provided in the equipment to make it maintenance free.
- (vii) List of testing equipments available with the Bidder for final testing of equipment specified and test plant limitation, if any, vis-à-vis the type, special, acceptance and routine tests specified in the relevant standards. These limitations shall be very clearly brought out in 'Schedule of Deviations'.

10.1 The supplier shall within 30 days of placement of order, submit the following informations to the purchaser.

- (i) Name of the raw materials as well as bought- out accessories and the names of sub-suppliers selected from those furnished along-with the offer.
- (ii) Type test certificates of the raw material and bought out accessories.
- (iii) Quality Assurance Plan (QAP) with hold points for purchaser's inspection. The QAP and hold points shall be discussed between the purchaser and the supplier before the QAP is finalised. The QAP shall include all the quality checks as stipulated in this specification.

10.2 The supplier shall submit the routine test certificates of bought out items and raw material at the time of routine testing of the fully assembled transformer.

11.0 DOCUMENTATION:

11.1 All drawings shall conform to relevant International Standards Organisation (ISO) specification. All drawing shall be in ink and suitable for micro filming. All dimensions and data shall be in S.I.Units. . **All the drawings are to be submitted in AutoCAD format in addition to hard copy in PDF format.**

11.2 The Bidder shall furnish along-with the bid dimensional drawings of transformer and all other accessories. These drawing shall include the following informations.

- (a) Dimensions.
- (b) Tolerances on dimensions.
- (c) Material designation used for different components with reference to standards.
- (d) Fabrication details such as welds, finishes and coatings.
- (e) Catalogue or part members for each component and the total assembly with bill of materials.
- (f) Identification marking.

(g) Weight of individual components and total assembled weight.

11.3

11.3.1 The supplier shall, within 15 (fifteen) days of placement of order submit four sets of final version of all the following drawings/ documents for purchaser's approval. All Drawings and Designs in complete shape (not in a piece-meal manner) as per the specification and without any deviation should be submitted within 15 (Fifteen) days of placement of Purchase Order. The Design Engineer(s) of the firm should be present in the office of the Sr. G.M (CPC) to complete the Design Review and Drawing Approval as soon as possible

- a) Out line dimensional drawings of transformer and accessories.
- b) Table of fittings for OGA.
- c) Combined Rating and Diagram plate.
- d) HV Bushing.
- e) LV Bushing.
- f) Neutral Bushings.
- g) Twin Bi-directional Roller.
- i) Valve schedule plate
- j) Foundation plan along with weights of foundations.
- k) Oil filling Instruction plate.
- l) Schematic control and wiring diagram for all auxiliary equipments including OLTC cooler control etc.
- m) GA of Marshalling Kiosk.
- n) General Arrangement of RTCC panel.
- o) Assembly of core with details of stacks dimensions and weights etc.
- p) Details of winding arrangement, conductor cross-section & weights etc.
- q) CT rating plate.
- r) Schematic diagram showing the flow of oil in the cooling system as well as each limb and winding Longitudinal and cross-sectional view showing the duct sizes, cooling pipes etc. for the transformer/ heat exchanger, drawn to scale shall be furnished.
- s) Inter connection-cabling diagram between transformer and all panels.
- t) Constructional details and sectional views of on-Load Tap Changer.
- u) Complete bill of materials.
- v) Detailed dimensions, assembly and description of auxiliaries.
- w) Constructional details of tank including material, dimensions thickness, reinforcing members, used, if any.
- x) Galvanising and painting procedure.
- y) Factory Test procedures, lay-out of testing equipments/circuits and Test schedules for tests.
- z) Commissioning test procedure and report.
- aa) Operation and Maintenance Manual.
- bb) QAP during manufacturing and during erection of the transformer.
- cc) Any other drawings(s) as required by the purchaser.

The purchaser shall communicate his comments/ approval on the drawings/documents to the supplier within reasonable period. The supplier shall, if necessary, modify the drawings and resubmit four copies of the modified drawings for purchaser's approval within one week from the date of comments. After receipt of purchaser's approval the bidder shall, within one week, submit 15 prints and one good quality reproducible of the approved drawings for purchaser's use.

11.3.2 DESIGN REVIEW:-

- 11.3.2.1 The Transformers shall be designed, manufactured and tested in accordance with the best International Engineering Practices under strict Quality Control to meet the requirements, stipulated in the Technical specification. Adequate safety margin with respect to thermal, mechanical, di-electric, electrical stresses and electrical clearances shall be maintained during design, selection of raw materials, manufacturing process etc. so that the Transformer provides long life with least maintenance.
- 11.3.2.2 The design review will commence after placement of award with successful Bidder and shall be finalized before final drawing approval. The supplier shall depute their design engineer(s) to OPTCL for design review and finalisation of drawings. However, the entire responsibility of design shall rest with the manufacturer.
- 11.3.2.3 The representative of the purchaser may visit to the manufacturer's works to inspect design, manufacturing and testing facilities.
- 11.3.2.4 The design review shall be conducted generally following the "Guidelines for conducting design reviews, prepared by CIGRE SC12 working Group 12.22.
- 11.3.2.5 The manufacturer shall provide all necessary informations and calculations during design review to demonstrate that the Transformer meets the requirements for short circuit strength and durability. The latest recommendations of IEC and CIGRE SC12 shall be applied for short circuit withstand evaluation.
- 11.3.2.6 The manufacturer will be required to demonstrate the use of adequate safety margin for thermal, mechanical, dielectric and vibration etc. to take into account the uncertainties of his design and manufacturing processes.
- 11.3.2.7 The scope of such a design review shall at least include the followings:-
- i) Core design
 - ii) Winding, tapping and Insulation design
 - iii) Short-circuit withstand capability
 - iv) Electrical clearances between windings to core(both axially and radially) between windings, outer windings to tank etc.
 - v) Thermal design including areas, prone to hot spots including thermal modeling for placement of the Optic Fiber Temperature Sensors.
 - vi) Cooler design
 - vii) Over-load capacity
 - viii) Over-fluxing
 - ix) Magnetising Inrush current
 - x) Eddy current losses
 - xi) Seismic design
 - xii) Insulation co-ordination
 - xiii) Tank & Accessories
 - xiv) Bushings & barrier design
 - xv) Tap-changer
 - xvi) Protective devices
 - xvii) Fans & radiators
 - xviii) Oil & oil preservation system
 - xix) Corrosion protection
 - xx) Electrical and physical interfaces with sub-station
 - xxi) Earthing
 - xxii) Processing and assembly

- xxiii) Testing capabilities
- xxiv) Inspection and Test plan
- xxv) Transport and storage
- xxvi) Sensitivity of design to specified parameters
- xxvii) Accoustic noise
- xxviii) Spares, inter-changeability and standardization
- xxix) Maintainability
- xxx) Any other design aspect, as deemed necessary

11.4 The supplier shall also furnish two copies of bound manuals for each transformer covering erection, commissioning, operation and maintenance instructions and all relevant informations and drawings pertaining to the main equipment as well as auxiliary devices. Marked erection drawings shall identify the component parts of the equipment as shipped to enable purchaser to carry out erection with his own personnel. Each manual shall also contain one set of all the approved drawings, type test reports as well as acceptance reports of the corresponding consignment despatched.

11.5 The manufacturing of the equipment shall be strictly in accordance with this Specification, approved drawings and no deviation shall be permitted without the written approval of the purchaser. All manufacturing and fabrication work in connection the equipment prior to the approval of the drawings shall be at the supplier's risk.

However, approval of the drawings by the purchaser shall not relieve the supplier of his responsibility and liability for ensuring correctness and correct interpretation of the latest revision of applicable standards, rules and codes of practices. The Transformer shall conform in all respects to high standards of engineering, design, workmanship and latest revisions of relevant standards at the time of ordering and the purchaser shall have the power to reject any material, which in his judgement is not in full accordance therewith.

11.5.1 TEST REPORTS:

- (i) Two copies of type test reports shall be furnished to the purchaser. One copy will be returned duly certified by the purchaser to the supplier.
- (ii) Four copies of routine test reports shall be furnished to the purchaser. One copy will be returned duly certified by the purchaser and only thereafter shall the materials be despatched.
- (iii) All records of routine test reports shall be maintained by the supplier at his works for periodic inspection by the purchaser.
- (iv) All test reports for tests conducted during manufacture shall be maintained by the supplier. These shall be produced for verification as and when requested for by the purchaser.

12.0 TRANSPORTATION, PACKING AND FORWARDING:-

12.1 The supplier shall dispatch the transformer, filled with oil or in an atmosphere of nitrogen or dry air at positive pressure. In the former case, the supplier shall take care of the weight limitation on transport and handling facility at site. In the latter case, necessary arrangement shall be ensured by the supplier to take care of pressure drop of nitrogen or dry air during transit and at site of installation. The nitrogen or dry air cylinder, provided to maintain positive pressure can be taken back by the supplier after

oil filling. A gas pressure-testing valve with necessary pressure gauge and adapter valve shall be provided. **Transformer shall also be fitted with at least one “Electronic Impact Recorder” (on returnable basis) during transportation to measure the magnitude and duration of the impact in all three directions.** The acceptance criteria and limits of impact in all three directions, which can be withstood by the equipment during transportation and handling, shall be submitted by the supplier during detailed engineering. The recording shall commence in the factory before dispatch and must continue till the unit is received/installed at destination sub-station. The data of electronic impact recorder(s) shall be downloaded at site and a soft copy of it shall be handed over to Engineer-in-charge. Further, within three weeks, the supplier shall communicate the interpretation of the data.

- 12.2 The equipment shall be suitable for vertical/horizontal transport as the case may be and suitable to withstand handling during transport and outdoor storage during transit. The supplier shall be responsible for any damage to the equipment during transit, due to improper and inadequate handling during transfer, loading and unloading. The easily damageable material shall be carefully packed and marked with the appropriate caution symbol. Whenever necessary, proper arrangement for lifting, such as lifting hooks etc. shall be provided. Any material found short inside the packing cases shall be supplied by supplier without any extra cost.
- 12.3 Each consignment shall be accompanied by a detailed packing list containing the following informations:-
- (a) Name of the consignee.
 - (b) Details of consignment.
 - (c) Destination.
 - (d) Total weight of consignment.
 - (e) Sign showing upper/lower side of the crate.
 - (f) Handling and unpacking instructions.
 - (g) Bill of materials indicating contents of each package.
 - (h) Two sets of approved copies of drawings, instruction and commissioning manuals, approved test certificates and certificates of bought out items, approved copies of guarantee certificate.
- 12.4 The supplier shall ensure that the packing and bill of materials are approved by the purchaser before despatch.

13.0 SUPERVISION OF ERECTION, TESTING AND COMMISSIONING (ET&C):

The erection, testing and commissioning of the transformers shall be supervised by trained personnel (Engineer) of the supplier. The Engineer shall direct the sequence of ET& C. The Engineer shall correct in the field, any errors or omissions on the part of the supplier, in order to make the equipment and material properly perform in accordance with the intent of this specification. The Engineer shall also instruct the plant operators in the operation and maintenance of the commissioned equipment. The supplier shall be responsible for any damage to the equipment, on commissioning the same, if such damage results from faulty or improper ET&C procedure. Purchaser shall provide adequate number of skilled/semi-skilled workers as well as all ordinary tools and equipment and cranes required for equipment erection, at his own expenses. Apart from the above, the purchaser shall not be responsible for any other expenses such as Engineer's salary, insurance against personal injuries to the Engineer etc. Special tools, if required for erection and commissioning, shall be arranged by the supplier at his cost

and on commissioning, these shall be supplied to the purchaser, free of cost for future use. The supervision of erection, testing and commissioning charges will be borne by the Purchaser as per tender price schedule.

14.0 QUANTITY AND DELIVERY REQUIREMENTS:

- (i) This is set out in Annexure -I of this Specification. The firm will submit a 'PERT CHART', indicating the manufacturing, inspection, testing and delivery schedule in details immediately after receipt of the Purchase Order.
- (ii) The scope of supply shall also include supply of 2.5% extra quantity of bolts, nuts, washers, split pins, cotter pins and such other small loose items, free of cost in addition to the materials/equipments as spelt out in this specification.

15.0 Values quoted in the G.T.P. and in details of loss calculations shall not differ. In case if it differs, then values quoted in the G.T.P. will be taken as final for all purposes.

16.0 METHOD OF TECHNICAL EVALUATION:

Bids will be evaluated in the following manner.

- (a) To check the flux density at the rated voltage i.e., 132KV/33KV rated frequency i.e., 50 Hz and maximum stacking factor as 0.97.
- (b) To check the data furnished in the GTP as correct as per the Technical Specification. If on calculation, GTP data will be different from the calculated data, then the bid will not be considered or owner may take any other decision. GTP furnished in incomplete shape will not be considered for evaluation.
- (c) If HI-B grade sheet steel for core material has not been quoted and specific loss and B-H curve for the said material alongwith the materials name and test report has not been furnished, the bid will be rejected. Details of HIB core particulars like length, Breadth, thickness of each stack alongwith core dia., L.V., & H.V. No of turns and lamination thickness, weight of core shall be submitted alongwith the bid failing which tender will be liable for rejection.
- (d) Bid will be rejected, if firm will not accept all the specified Technical terms and conditions.
- (e) Bid will be rejected if Maximum Flux Density and Core weight calculation (As per Annex-II) and details of Loss calculations (As per Annex-III) will not be found to be in order and if there is any ambiguity/discrepancy, noticed in the above calculations.
- (f) The Bidder shall submit alongwith the bid the graph depicting the saturation characteristic curve between the no load voltage (RMS) vs.-measured excitation current starting from 10% of rated no load voltage to 125% of the same, failing which the tender is liable for rejection. The knee point voltage shall have to satisfy the specified value as per the criteria stipulated at Clause No.4 (18) of this Specification.

Bidders are required to be careful in choosing the maximum flux density, best possible core materials (HIB or better) and type of corner joints of the core etc.so as to quote the practicable no-load current at different percentages of rated no-load voltage as per given GTP format and submit a linear graph along with the tender, confirming to achieve the specified minimum knee point voltage i.e.110% of the rated voltage during no-load test as per the method, stipulated at CL.No.6.4.2 (k) of this Technical Specification, which will be confirmed through testing both during stage inspection and final inspection.

ANNEXURE-I

MAXIMUM FLUX DENSITY, CORE WEIGHT & NO LOAD LOSS CALCULATION FOR 20 MVA, 132/33 KV POWER TRANSFORMER [To be filled in by the Bidder]

Name of the bidder: -

Address:-

Type and Grade of Core: -

Thickness [in mm]:-

<u>Step No</u>	<u>Width of steps [mm]</u>	<u>Stack thickness [mm]</u>	<u>Gross Iron area [mm²]</u>
----------------	----------------------------	-----------------------------	---

1

2

3

4

5

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15 to

$E = 4.44 \times f \times B_{max} \times A_i \times N$

Where E = L.V. winding rated voltage / phase = 33000 volts.

f = Rated frequency = 50 HZ. , B_{max} = Maximum flux density in Tesla.

1) Flux Density Calculation	
Gross iron area in sq.m =	
Stacking factor =	
A_i (Net iron area in sq.m) = Gross iron area in sq.m x stacking factor =	
N = Number of L.V. winding turns/phase=	
B_{max} (At rated voltage & frequency)= $E / (4.44 \times f \times A_i \times N)$ =	
B_{max} [at Maximum System voltage (145 KV/36 KV) and minimum system frequency (48.5 HZ)]	

2) Core weight Calculation	
Core dia [in mm] =	
Window height [in mm] =	
Limb center [in mm] =	
W =Weight of core = [3 x window height + 4 x limb centre + 2 x max. width] x Net iron area x	

Density of core =	
-------------------	--

3) No load loss_Calculation	
Core loss in watt/kg. from graph for grade/type of core material and selected Flux density=	
Building factor=	
Calculated No-load loss in watts =core weight x watts/kg. x Building factor=	
Guaranteed No-load loss in watts =	

- NB: - 1. Specific loss vs. flux density graph for the type of core lamination to be used has to be furnished.
2. VA/Kg. Vs flux density graph for the core lamination to be used has to be furnished.
3. Any other factor assumed for above calculation to be explained with reasons.

Place
Date

Bidder's name:
Signature, designation, seal

NB- The Bidders are required to up load this calculation sheet duly filling the required data, in PDF format.

ANNEXURE-II

DETAILS OF LOSS CALCULATIONS FOR 20 MVA,132/33 KV POWER

TRANSFORMER

[To be filled in by the Bidder]

20MVA, 132/33KV

1. Name of the Firm
2. Flux density as adopted for offered transformer design, at
 - i (145)/36 KV and 48.5 Hz [Tesla]
 - ii (132)/33 KV & 50.0Hz [Tesla]
3.
 - i Core weight in Kg.
 - ii Gross core area [mm²]
 - iii. Stacking factor.
 - iv. Net core iron area [mm²] [ii x iii]
4. [a] Specific losses [W/Kg.]
 - i At designed flux density corresponding to (145)/36 KV and 48.5 HZ.
 - ii At designed flux density corresponding to (132)/33 KV and 50Hz.[b] Volt ampere/Kg
 - (i) At designed flux density corresponding to (145)/36 KV and 48.5 Hz
 - (ii) At designed flux density corresponding to (132)/33 KV and 50 Hz.
5. Calculated/guaranteed iron loss in KW at:-
 - i Rated voltage and rated frequency
 - ii Maximum system voltage and lowest system frequency
5. Current density [A/Sq. mm] at normal tap for
 - i HV
 - ii Regulating
 - iii LV
6. Conductor size [in mm²]
 - a HV
 - i Bare
 - ii Insulated
 - iii No of conductors in parallel
 - b Regulating winding
 - i Bare
 - ii Insulated
 - iii No of conductors in parallel
 - c L.V. winding
 - i. Bare
 - ii. Insulated.
 - iii. No. of conductors in parallel.
- 8 Total Bare copper conductor area(A) (Sq.mm.)

	i	HV			
	ii	LV			
	iii	Regulating			
9.	No. of turns/phase(N) at	Highest tap	Lowest tap	Normal tap	
	i	HV			
	ii	Regulating			
	iii	LV			
10.	Internal Diameter(in mm.)				
	i	HV			
	ii	Regulating			
	iii	LV			
11.	Outside Diameter(in mm.)				
	i	HV			
	ii	Regulating			
	iii	LV			
12.	Mean Diameter(Dm) (in mm.)				
	i	HV			
	ii	Regulating			
	iii	LV			
13.	Length of copper conductor(L) =Pie x Dm xN	Highest tap	Lowest tap	Normal tap	
	i	HV			
	ii	Regulating			
	iii	LV			
14.	Per-phase resistance of winding (in ohms) at 75 deg.C= $\frac{0.0211 \times L}{A}$	Highest tap	Lowest tap	Normal tap	
	i	HV			
	ii	Regulating			
	iii	LV			
15.	I ² R loss for winding at 75 ⁰ C				
	i.	At normal tap position (in KW)			
	ii.	At maximum tap position (in KW)			
	iii	At minimum tap position (in KW)			
16.	I ² R loss at 75 ⁰ C towards connecting leads for windings, bushings, OLTC etc.				
	i.	At normal tap position (in KW)			
	ii.	At maximum tap position (in KW)			
	iii	At minimum tap position (in KW)			
17.	Eddy current losses in winding (in KW) at 75 deg.C				
	i.	At normal tap position.			
	ii.	At maximum tap position.			
	iii.	At minimum. tap position.			
18.	Stray losses in tank & other parts of transformer (in KW) at 75 deg.C				
	i.	At normal tap position.			
	ii.	At maximum tap position.			
	iii.	At minimum. tap position.			
19.	Calculated guaranteed Load losses (in KW) at 75 deg. C [15 + 16 + 17 + 18]				
	i.	At normal tap position.			
	ii.	At maximum tap position.			

- iii. At minimum. tap position.
 - 20. Guaranteed Cooler Losses{ in KW}
 - 21. Computed/guaranteed total loss in KW at rated voltage and rated frequency
[Copper loss + cooler loss + Iron loss]
 - i At normal tap position
 - ii At maximum tap position
 - iii At minimum tap position
 - 22. Copper Weight ($L \times A \times 8.89 \times 10^{-3}$)
 - i HV
 - ii Regulating
 - iii LV
 - iv For Tap connections, star connection and any other [please specify]
 - v Total copper weight [i]+[ii]+[iii]+[iv]
- NB: - 1 Approximate values in weight and losses etc. are not allowed.
 2 Tolerance of + 5% in weights may be quoted without any approximation

Place:

Date

Bidder's name:

Signature, designation, seal

NB- The Bidders are required to up load this calculation sheet duly filling the required data, in PDF format.

ANNEXURE-III

GUARANTEED TECHNICAL PARTICULARS

[TO BE FILLED IN BY THE BIDDER, IN EXCEL FORMAT OF THE TECHNO COMMERCIAL BID SHEET]

Sl. No	<u>Description</u>	<u>20MVA, 132/33KV</u>
1	Name of the Manufacturer	
2	Installation [indoor/outdoor]	
3	Reference standards	
4	Continuous Ratings	
	a	Type of cooling
	b	Rating [MVA]
	i	With ONAN cooling
	ii	With ONAF cooling
	c	Rated voltage
	i	HV [KV rms.]
	ii	LV [KV-rms.]
	d	Highest system voltage
	i	HV [KV rms.]
	ii	LV [KV-rms.]
	e	Rated frequency with $\pm\%$ variation
	f	Number of phases
	g	Current at rated full load and on
		Principal tap
	i	HV [Amps]
	ii	LV [Amps]
5	Connections	
		HV
		LV
6	Connection symbol and vector group	
7	Temperature rise	
	a	Temperature rise of oil above ambient temperature [by Thermometer]
	i	At full ONAN rating [°C]
	ii	At full ONAF rating [°C]
	b	Temperature rise of windings above ambient temperature [By resistance method]
	i	At full ONAN rating [°C]
	ii	At full ONAF rating [°C]
	c.	Temperature gradients between windings & oil.
	d.	Limit of Hot spot temperature for which the Transformer is designed [°C]
	e.	Period of operation of transformer at full load without calculated winding hot spot

		Temperature exceeding 140°C and with		
	i	50% Coolers		
	ii	100% Coolers		
8		Type of ON load tap changing switch		
9		Tapping on windings for		
	i	Constant flux/variable flux/combined Regulation.		
	ii	Tapping provided at		
	iii	Number of steps		
	iv	Range of tapping for variation [+ percent to- Percent]		
10	i	No load loss at rated voltage and frequency at Principal tap [KW]		
	ii	No load loss at the voltage corresponding to Highest tap [KW]		
11		Load loss at rated output, rated frequency, corrected for 75 °C winding temperature at: -	<u>ONAN</u>	<u>ONAF</u>
	i	Principal tap [In KW]		
	ii	Highest tap [In KW]		
	iii	Lowest tap [In KW]		
12		Auxiliary losses at rated output, normal ratio, rated voltage, rated frequency and ambient Temperature [KW]		
13		Total losses at normal ratio inclusive of auxiliary equipment losses [KW]		
14		Positive sequence impedance on rated MVA base at rated current and frequency at 75°C Winding temperature at		
	i	Principal tap [%]		
	ii	Highest tap [%]		
	iii	Lowest tap [%]		
15		Zero sequence impedance at reference Temperature of 75°C at principal tap [%]		
16		% reactance at rated MVA base at rated Current and rated frequency at		
	i	Principal tap [%]		
	ii	Highest tap [%]		
	iii	Lowest tap [%]		
17		% resistance at rated MVA base at rated current and rated frequency at		
	i	Principal tap [%]		
	ii	Highest tap [%]		
	iii	Lowest tap [%]		
18		% Impedance at rated MVA base at rated Current and rated frequency at		
	i	Principal tap [%]		
	ii	Highest tap [%]		
	iii	Lowest tap [%]		
19	a.	Polarisation index i.e. ratio of Megger values		

		at 600 secs to 60 secs, (H.V. to E, L.V. to E, H.V. to L.V.		
	b.	Regulation at full load and 75°C winding Temperature expressed as a percentage of normal voltage		
	i	At unity power factor [%]		
	ii	At 0.8 power factor [lagging][%]		
20		Efficiency at 75°C winding temperature as derived from guaranteed loss figures and at	Unity power factor	0.8 Power factor
	a	At full load [%]		
	b	At ¾ load [%]		
	c	At ½ load [%]		
21	i	Maximum efficiency [%]		
	ii	Load at which maximum efficiency occurs[% of full load]		
22		Time in minutes for which the transformer can be run at full load without exceeding the maximum permissible temperature at reference ambient temperature when supply to: -		
	i	Fans are cut off		
23		Short time thermal rating of		
	i	HV winding in KA and duration in seconds		
	ii	LV winding in KA and duration in seconds		
24		Permissible over loading: -		
	a	HV winding		
	b	LV winding		
25		Terminal arrangement		
	a	High voltage [HV]		
	b	Low voltage (LV)		
	c	Neutral		
26		Insulating and cooling medium		
27	[A]	Test voltage	<u>HV</u>	<u>LV</u> <u>HVN</u> <u>LVN</u>
	i.	Lightning impulse withstand test voltage [KVP]		
	ii	Power frequency withstand test voltage [dry and wet][for 1 minute] [KV-rms.]		
28		Partial discharge level as per relevant up-to-date IEC		
29		Noise level when energized at normal voltage, frequency without load and with all cooling fans in running condition.		
30		External short circuit withstand capacity [MVA] and duration [seconds]		
31		Over-fluxing withstand capability of the Transformer		
32		DETAILS OF CORE		
	a	Type of core construction		
	b	Type of corner joints of the core		
	c.	Flux density as adopted for offered transformer design at		
	i	Rated voltage [132/33 KV] & rated frequency 50 Hz][in Tesla]		
	ii	Highest system voltage [145/36 KV] and		

- lowest system frequency [48.5Hz.][In Tesla]
- d **No load current, no load loss and no load power factor at normal ratio and frequency**
[Amp/KW/p.f.] [With reference to 33KV side]
- i 10 percent of rated voltage
 - ii 25percent of rated voltage
 - iii 50 percent of rated voltage
 - iv 85 percent of rated voltage
 - v 100 percent of rated voltage
 - vi 105percent of rated voltage
 - vii 110 percent of rated voltage
 - viii 112.5 percent of rated voltage
 - ix 115 percent of rated voltage
 - x 120 percent of rated voltage
 - xi 121 percent of rated voltage
 - xii 125 percent of rated voltage
- e **Core laminations:-**
- i Make & type[HIB/Laser grade] of core Material
 - ii BIS Grade of core laminations
 - iii Thickness of core lamination [mm]
 - iv Specific loss [watt/Kg.] at Design Flux Density at rated voltage & rated frequency
 - v Specific loss [watt/Kg.] at Design Flux Density at highest system voltage & lowest system frequency
 - vi Whether specific core loss graph [flux density vs. watt/Kg.submitted
 - vii VA/Kg at Design Flux Density at rated voltage & rated frequency
 - viii VA/Kg at Design Flux Density at 110% of rated voltage & rated frequency
 - ix. VA/Kg at Design Flux Density at 121% of rated voltage & rated frequency
 - x VA/Kg. at Design Flux Density and at highest system voltage & lowest system frequency
 - xi Whether VA/Kg. Vs. flux density graph submitted.
 - xii Insulation of core laminations
- f **CORE ASSEMBLY:-**
- i Core diameter [mm]
 - ii Core window height [mm]
 - iii Core leg centre [mm]
 - iv Gross core cross-sectional area [m²]
 - v Whether details of core widths, stacks and Calculation furnished as per enclosed annexure
 - vi Distance between centres [mm]
 - vii Total height of core [mm]
 - viii core belting
 - 1) Details of core belting.
 - 2) Material, grade & type.
 - 3) Width.
 - 4) Thickness.
 - 5) Fixing method.
 - ix Details of top end frame.

	x	Details of Bottom end frame.		
	xi	Details of clamp plate [Material, thickness, Insulation]		
	xii	Core stacking factor		
	xiii	Net core area Sq. m.		
	xiv	Total core weight [kg]		
	xv	Building Factor		
	xvi	Core loss basing on core loss graph at operating Flux density [rated voltage and rated Frequency] [kw]		
	xvii	Margin towards corner joints, cross fluxing etc. [kw]		
	xviii	Total core loss at rated voltage and rated Frequency [xvi+xvii] [kw]		
	xix	Dielectric loss at rated voltage and rated Frequency [KW]		
	xx	No load loss at rated voltage and rated Frequency [xviii+xix] [KW]		
	g	Describe location/method of core grounding		
	h	Details of oil ducts in core		
	i	Peak value of magnetising Inrush current (% of HV rated current).		
33		<u>DETAILS OF WINDINGS.</u>	HV	LV
	a	Type of winding		
	b	Material of the winding conductor.		
	c	Maximum current density of windings [At rated current] [Normal Tap] and Conductor area	Conductor/ Current area [cm ²] density [A/cm ²]	
	i	HV		
	ii	Regulating		
	iii	L.V.		
	d	Whether HV windings are interleaved.		
	e	Whether windings are pre-shrunk?		
	f	Whether adjustable coil clamps are provided for H.V. and L.V. windings?		
	g	Whether steel rings are used for the windings? If so, whether these are split?		
	h	Whether electrostatic shields are provided to obtain uniform voltage distribution in the Windings?		
	i	Winding Insulation	Type & class.	Graded or ungraded
	ii	H.V. & Regulating		
	iii	LV		
	j	Insulating material used for		
	i	H.V. & Regulating winding.		
	ii	L.V Winding		
	iii	For core bolts washers and end plates.		
	iv	Tapping connection.		
	k	Insulating material used between		
	i	H.V. and L.V. winding		

- ii H.V. and Regulating winding.
- iii Core and L.V winding.
- iv H.V. to H.V.winding [between phases]
- I** Type of axial coil supports.
 - i H.V. winding
 - ii LV winding
 - iii Regulating winding
- m** Type of radial coil supports
 - i HV winding
 - ii Regulating winding
 - iii LV winding
- n** Maximum allowable torque on coil clamping bolts HV Regulating LV
- o** Bare conductor size (mm).
- p** Insulated conductor size (mm).
- q** No. of conductors in parallel (Nos.).
- r** No. of turns/phase
- s** No. of discs/phase
- t** No. of turns/disc
- u** Gap between discs. (mm).
- v** Inside diameter (mm).
- w** Outside diameter (mm).
- x** Axial height after shrinkage (mm).
- y** D.C.RESISTANCE
 - i L.V winding at 75 ° C (Ohms).
 - ii HV winding and Regulating winding at normal tap at 75° C (Ohms).
 - iii HV winding and Regulating winding at highest tap at 75° C (Ohms).
 - iv HV winding and regulating winding at lowest tap. (Ohms).
- Z** I^2R loss for winding at 75⁰C
 - i. At normal tap position (in KW)
 - ii. At maximum tap position (in KW)
 - iii. At minimum tap position (in KW)
- aa.** I^2R loss at 75⁰C towards connecting leads for windings, bushings, OLTC etc.
 - i. At normal tap position (in KW)
 - ii. At maximum tap position (in KW)
 - iii. At minimum tap position (in KW)
- bb.** Eddy current losses in winding (in KW) at 75 deg.C
 - i. At normal tap position.
 - ii. At maximum tap position.
 - iii. At minimum. tap position.
- cc.** Stray losses in tank & other parts of transformer (in KW) at 75 deg.C
 - i. At normal tap position.
 - ii. At maximum tap position.
 - iii. At minimum. tap position.
- dd.** Any special measures taken to reduce eddy current losses and stray losses, mention in details.
- ee.** Load losses at 75°C [I^2R + stray].

- i. Normal tap position [KW].
- ii. Highest tap position [KW].
- iii. Lowest tap position [KW].
- ff. Details of special arrangement provided to improve surge voltage distribution in the windings
- gg. Tandelta(Power factor) of Winding(Max.) at measured temperature

34 BUSHINGS.

HV LV HV Neutral LV Neutral

- a Make and type
- i Rated voltage class [KV-rms.]
- ii Rated current [Amps.]
- b. Lightning Impulse withstand test voltage [1.2/50 microsecond][KVP]
- c Switching surge withstand test voltage [KVP]
- d Power frequency withstand test voltage
 - i Wet for 1 minute [KV-rms]
 - ii Dry for 1 minute [KV-rms]
- e. Power frequency visible corona discharge Voltage [KV-rms.]
- f Partial discharge level [PC]
- g Minimum creepage distance in mm
- h Minimum creepage distance in mm [protected]
- i Whether test-tap is provided?
- j Quantity and grade of oil in bushing and Specification of oil used [Kg.]
- k Weight of assembled bushing [Kg.]
- l Minimum clearance height for removal of Bushing [mm]
- m Under oil flashover or puncture impulse voltage [KVP]
- n. Under oil flashover or puncture power frequency Voltage (KV-rms).
- o. Phase to earth clearance in air of live parts at the top of bushings.
- p. Maximum tan delta value at measured temperature

35 Minimum clearance [mm]

Between
Windings

Phase to
ground

(A) Out of Oil

HV
LV

(B) In Oil

- (i) LV to Core
- (ii) LV to top yoke
- (iii) LV to bottom yoke
- (iv) LV to HV (radially)
- (v) HV to Regulating (radially)
- (vi) HV to top yoke
- (vii) HV to bottom yoke

- (viii)Regulating to top yoke
- (xii)Regulating to bottom yoke
- (xiii)Reg. winding to Reg. winding

- (xiv)Regulating winding to tank
 - (a)Length wise
 - (b)Breadth wise
 - (c)Width wise

N:B- Winding Arrangement-CORE-LV-HV-REGULATING

36 Weight [Tolerance + 5%]

[Approximate value is not allowed]

- a Core [Kg.]
- b Core with clamping [Kg.]
- c H.V. winding insulated conductor [Kg.]
- d L.V. winding insulated Conductor [Kg.]
- e Regulating winding insulated conductor [Kg.]
- f Coils with insulation [Kg.]
- g Core and winding [Kg]
- i Oil required for first filling [Liter/Kg.]
- j Tank and fittings with accessories [Kg.]
- k Untanking weight [Kg.]
- l Total weight with oil and fittings along with accessories [Kg.]

37 DETAILS OF TANK

- a Material for Transformer tank
- b Type of tank
- c Thickness of sheet
[No approximate value to be mentioned]
- i Sides [mm]
- ii Bottom [mm]
- iii Cover [mm]
- iv Radiators [mm]
- d Inside dimensions of main tank
[No approximation in dimensions to be used]
- i Length [mm]
- ii Breadth [mm]
- iii Height [mm]
- e Outside dimensions of main tank
[No approximation in dimensions to be used]
- i Length [mm]
- ii Breadth [mm]
- iii Height [mm]
- f. Thickness of spray galvanisation of tank bottom.
- g. Vacuum recommended for hot oil circulation [torr]
- h. Vacuum to be maintained during oil filling in Transformer tank [torr]
- i. Vacuum to which the tank can be subjected

- without distortion [torr]
 - j. No. of bi-directional wheels provided
 - k. Track gauge required for the wheels
 - i Transverse axis
 - ii Longitudinal axis
 - k Type and make of pressure relief device and minimum pressure at which it operates [Kpa]
- 38-A CONSERVATOR**
- a Total volume [Liters]
 - b Volume between the highest and lowest visible Oil levels [Litres]
 - c Power required by heaters [If provided][KW]
 - d Conservator sheet thickness (mm.)
- 38-B DETAILS OF AIRCELL OF CONSERVATOR**
- a Make
 - b Type
 - c Capacity
 - d Size
- 39 OIL QUALITY**
- a Governing standard
 - b Density in gms/cu-cm
 - c Kinematics viscosity in CST
 - d Inter facial tension at 27°C in N/m
 - e Flash point in °C
 - f Pour point in °C
 - g Acidity [neutralization value] in mg of KOH/gm
 - h Corrosive sulfur in %
 - i Electric strength [Breakdown voltage]
 - i As received [KV-rms.]
 - ii After treatment [KV-rms.]
 - j Dielectric dissipation factor [Tan-delta] at 90°C
 - k Saponification value in mg of KOH/gm
 - l Water content in ppm
 - m Specific resistance
 - i At 90°C [ohm-cm]
 - ii At 27 °C [ohm-cm]
 - n N- dm analysis CA%
CM%
CP%
 - o Oxidation stability
 - i Neutralization value after oxidation
 - ii Total sludge after oxidation
 - p Characteristic of oil after ageing test as per ASTM-D-1934
 - i Specific resistance at 27°C [ohm-cms]

	90°C [ohm-cms]		
	ii Tan delta		
	iii Sludge content		
	iv Neutralization number		
	v Percentage of Napthenic content		
	vi Percentage of paraffinic content		
	vii Details of oil preserving equipment offered		
40	<u>RADIATORS</u>		
	a Overall dimensions lxbxh [mm]		
	b Total weight with oil [Kg.]		
	c Total weight without oil [Kg.]		
	d Thickness of radiator tube [mm]		
	e Types of mounting		
	f Vacuum withstand capability		
	g Total radiating surface in sq.m		
	h Type and make of material used for the radiators		
	i Total number of radiators/Banks for Transformer and dimensions of tubes.		
	j. Thickness of hot dip galvanization of radiators.		
41	<u>COOLING EQUIPMENT</u>	Fan motor	
	A Make and type		
	b No. of connected units		
	c No. of stand -by units		
	d Rated power input		
	e Capacity [cu-m/min. or] [liters/min]		
	f Rated voltage [volts]		
	g Locked rotor current [Amps.]		
	h Efficiency of motor at full load [%]		
	i Temperature rise of motor at full load [°C]		
	j BHP of driven equipment		
	k Temperature range over which control is adjustable [°C]		
	l Whether the fans are suitable for continuous operation at 85 % of their rated Voltage.		
	m Estimated time constant in hours for		
	i Natural cooling		
	ii Forced air cooling		
42	<u>GAS AND OIL OPERATED RELAY</u>		
	a Make		
	b Type		
	c Size		
	d Whether supervisory alarm and trip contacts provided and their sizes and Nos.		
43	<u>TEMPERATURE INDICATORS</u>	Oil Temp.	Winding Temp.
		Indicator	Indicator
	a Make and type		
	b Permissible setting ranges for alarm and trip		
	c Number of contacts		

- d Current rating of each contact
 - e Whether supervisory alarm contacts provided?
 - f Size [lxbxd]
 - g Nos.
 - h Ratio and type of CT used for winding
- Temperature indicators.
- 44 **APPROXIMATE OVERALL DIMENSIONS
OF TRANSFORMER INCLUDING
COOLING SYSTEM, TAP CHANGING
GEAR ETC.**
- a Length [mm]
 - b Breadth [mm]
 - c Height [mm]
- 45 a Minimum clearance height for lifting core and
Winding from tank [mm]
- b Minimum clearance height for lifting tank cover
[mm]
- 46 **SHIPPING DETAILS**
- a Approximate weight of heaviest package [Kg.]
 - b Approximate dimensions of largest
Package [Kg.]
- 47 Transformers will be transported with oil/gas.
- 48 Size of rail recommended for the track.
- 49 Details of Neutral Current Transformers
- a Quantity
 - b Type and voltage class
 - c No. of cores
 - d Ratio
 - e VA burden
 - f Accuracy class
 - g Minimum knee point voltage [volts]
 - h Maximum magnetization current at minimum
Knee point voltage [mA]
 - i Maximum secondary winding resistance at
75°C [ohms]
- 50 **MARSHALLING KIOSK**
- a Make and type
 - b Details of apparatus proposed to be housed in the
Kiosk
- 51 Details of anti-earthquake device provided, if any
- 52 Separate conservator and Buchholz relay provided
- 53 **TAP CHANGING EQUIPMENT**
[These details refer to the basic rating of O.L.
T.C. as guaranteed by OLTC manufacturers]
- a Make
 - b Type
 - c Power flow [Uni.-directional/bi -
directional/restricted bi-directional]
 - d Rated voltage to earth [KV]
 - e Rated current [Amps.]

	f	Step voltage [volts]
	g	Number of steps
	h	Control - manual/local-electrical/remote-electrical
	i	Voltage control [Automatic/Non -automatic]
	j	Line drop compensation provided/not provided
	k	Parallel operation
	l	protective devices
	m	Auxiliary supply details
	n	Time for complete tap change [one step][Sec.]
	o	Diverter selector switch transient time [cycles]
	p	Value of short circuit current [Amps][minimum] along with duration
	q	Maximum impulse withstand test voltage with 1.2/50 microseconds full wave between switch Assembly and ground [KVP]
	r	Maximum power frequency test voltage between Switch assembly and earth [KV-rms]
	s	Maximum impulse withstand test voltage with 1.2/50 microseconds across the tapping range [KVP]
	t	Approximate overall dimensions of tap changer [WxBxD] in mm.
	u	Approximate overall weight [Kg.]
	v	Approximate mass of oil [Kg.]
	w	Particulars of the OLTC control panel for installation in control room
54		DRIVING MECHANISM BOX
	a	Make and type
	b	Details of apparatus proposed to be housed in the box
55		Types of terminal connectors and drawing No
	a	HV
	b	LV
56		Details of painting, galvanization conforms to this Specification [Yes/No]
57		Type of oil level indicator and whether Supervisory alarm contact for low oil level provided [Yes/No]
58		Type and size of thermostat to be used
59		No. of breathers provided [Nos.]
60		Type of dehydrating agent used for breathers
61		Valve sizes and numbers
	a	Drain valves- mm-Nos.
	b	Filter valves- mm-Nos.
	c	Sampling valves- mm-Nos.
	d	Radiator valves- mm-Nos.
	e	Other valves- mm-Nos.
62.	a)	Type and make of PRV.
	b)	No. of each type of devices per transformer

- c) Min. pressure at which device operates.
- 63 Please enclose the list of accessories and fittings, being provided on transformer. Please confirm, these are as stipulated in the tender.
- 64 Whether the transformer, covered is fully type tested and if so, whether copies of type test certificates, enclosed with the tender.
- 65 Whether tenderer can supply transformer, wound on vertical coil winding machine. Preference shall be given to the tenderer who will ensure supply of transformer wound on vertical winding machines.
- 66 In case Sl.No.65 is not confirmed, what are the additional pre-cautions, which shall be taken by the tenderer to justify that the coil, wound on horizontal machine shall be equivalent in all respects to that which are wound on vertical winding machine.
- 67 What are the arrangements, available for jointing the Winding. Preference shall be given to the tenderer using high-frequency brazing machines. In case other jointing techniques are used; adequacy of the same is to be recorded. Please note that bolted joints in the winding are not acceptable. This should be confirmed here.
- 68 Please confirm that you will guarantee maximum Impedance variation between phases within the limit of 2% only.
- 69 a) Please confirm that the transformer shall be dried by vapour-phase drying method. Please specify level of dryness.
- b) In case, other methods of drying are used, the level of dryness, so achieved should be identical to that by VPD. Adequacy of such system should be justified.
- 70 Please confirm whether the In-House facilities for all routine tests as per this Tender Specification are available with the tenderer and the tenderer shall agree to conduct these tests on the transformer in the event of order.

71. Whether the Tenderer has got In-House core-cutting facility for cutting core materials for the transformer ratings as offered. (YES/NO)

72 If 'YES', following informations/confirmations are required: -

- a. Name of the manufacturer of HIB Grade core material from whom core materials will be directly imported or through their accredited marketing organization of repute. If to be imported through the accredited Marketing Organisation, Please state the name of such Marketing Organisation and please enclose the relevant documents with the Tender Offer regarding accreditation of the said Marketing Organisation by the manufacturer of the HIB core material.
- b. Grade, Trade Name and Thickness of the core material, to be imported
- c. Whether agreed for witnessing of core materials by OPTCL's representative(s)

- d. Whether, the Bidder has past experience towards direct import of core materials. If 'YES', the copies of recent past Import documents to be furnished with the Tender Offer (Please state, whether the said import documents are enclosed with the Tender Offer)
- e. Whether, the Bidder has got In-House CNC Machine facility for cutting of core materials
- f. Whether the Bidder is agreed to follow the procedures, as stipulated at Cl.No.5.4.8 (o), (p) &(q) of this Technical Specification, as applicable for those, who have got In-House core-cutting facility

73 If the Bidder has no In-House core-cutting facility, the following informations/confirmations are required: -

- a. Name of the core manufacturer of core materials from whom core materials will be directly imported or through their accredited marketing organization of repute. If to be imported through the accredited Marketing Organisation, Please state the name of such Marketing Organisation and please enclose the relevant documents with the Tender Offer regarding accreditation of the said Marketing Organisation by the manufacturer of the HIB core material.
- b. Grade, Trade Name and Thickness of the core material, to be imported
- c. Name of the core-cutting vendor and whether the said vendor has got In-House CNC Machine facility for cutting of core materials and whether the said vendor has been accredited by ISO
- d. Whether, the Bidder has past experience towards direct import of core materials. If 'YES', the copies of recent past Import documents to be furnished with the Tender Offer (Please state, whether the said import documents are enclosed with the Tender Offer)
- e. Whether the Bidder is agreed to follow the procedures, as stipulated at Cl.No.5.4.8 (o), (p) &(q)(1), (2), (3), (4), (5),(6) & (7) of this Technical Specification, as applicable for those, who have got no In-House core-cutting facility.

74. Please confirm that the facility for partial discharge test is available with the tenderer and the tenderer shall agree to conduct This test on transformer in the event of order.

Place
Date

Bidder's name:
Signature, Designation, Seal

