



BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPPALLI – 620014, TAMILNADU
VALVES SUBCONTRACTING DEPARTMENT

EXPRESSION OF INTEREST (EOI)

(Ref No: BHEL/TRY/VSC/EOI/FH/001) Dated: 24.07.2026

FOR

“STELLITE WELDING, INCONEL BUTTERING AND MACHINING OF
VALVE COMPONENTS”

Issued by:

Valves Subcontracting Department, Bharat Heavy Electricals Limited, Trichy,
Tamilnadu-620014, INDIA

Registered office

Bharat Heavy Electricals Limited, having registered office at BHEL House, Siri Fort New Delhi-
110049 (Hereinafter referred to as 'BHEL')



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INTRODUCTION

This Expression of Interest (EOI) invites response from Vendors located within 400 km radius from Tiruchirappalli, who are capable of carrying out Stellite Welding/Hard facing using the TIG process, Inconel buttering using SMAW process followed by heat treatment and further machining of welded components in accordance with BHEL's technical requirements.

The required raw material and Stellite/inconel electrodes will be supplied by BHEL.

For more details, kindly refer attached **Annexure A**.

INSTRUCTION TO APPLICANTS

Prospective Partner / Respondent may submit their application by submission of **Annexure B** (along with supporting documents with respect to monthly capacity and experience to the following contact detail via E-mail / Speed Post:

Mr. Prajeesh B / Manager / Valves Sub Contracting

Ground Floor, Building No. 24, Valves Subcontracting Department

HPBP | BHEL | Tiruchirappalli – 620 014

Ph. No: 0431 – 257 6731

Email: prajeesh@bhel.in | paramananda@bhel.in |

The details submitted by the applicant(s) shall be complete in all respects and BHEL may seek clarifications/additional information as considered necessary.

Last Date for submission of EOI: 30-August-2026



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Annexure – A

BHEL, Tiruchirappalli invites Expression of Interest (EOI) from Vendors for Stellite Welding/Hard facing using the TIG process, Inconel buttering using SMAW process followed by heat treatment and further machining of welded components. The vendor is expected to weld and manufacture the following valve components.

Valve Components		
Component Name	Material Specification	Quantity
FH Body	A105,F22,F316,F91, F92	30,000
FH Disc	A276-410, SA182-F316, OHTARON, F91, F92	30,000
FM Disc	A276-410, SA182-F316	40,000
FM Seat Ring	A276-410, SA182-F316	30,000
TOA Disc	F22	1,200
TOA Seat Ring	A105,F22	600
TOA Bonnet	A105,F22	1,200
OFE Gate	AISI 410, 4130, 1040	10,000
OFE Seat Ring	AISI 410, 4130, 1040	20,000
SV Seat bushing	Inconel-617	100

Major Process Involved:

- Weld Preparation and rough Machining of components
- Hard facing of components using the TIG Welding process with stellite electrodes
- Inconel weld buttering of components using SMAW process with Inconel electrodes
- Stellite/Inconel electrodes and raw material shall be supplied by BHEL
- Post Weld Heat Treatment shall be carried out as per the BHEL approved Procedure
- Finish Machining as per BHEL Drawing and technical requirements

Brief Scope of Work:

- Being a special process approval for the vendor's WPS and PQR needs to be approved from BHEL



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- Collection of raw material and stellite/inconel electrode from BHEL Tiruchirapalli and dispatch of finished material to BHEL Tiruchirapalli will be in vendors' scope
- Weld Preparation of components as per BHEL drawing
- Welding and heat treatment as per approved WPS
- Finish Machining and Inspection of components as per BHEL Drawing and technical requirements

Eligibility Criteria:

- Vendor should be located within 400 km radius from Tiruchirapalli
- Vendor should have in house facility for doing the Stellite Hard facing/ Inconel buttering and heat treatment
- IBR certified welder should be employed to carry out the welding operation
- Machining of components may be outsourced with prior approval
- Calibrated furnace to be used for post weld heat treatment.

For any clarifications, kindly contact:

Mr. Prajeesh B / Manager / Valves Sub Contracting

Ground Floor, Building No. 24, Valves Subcontracting Department

HPBP | BHEL | Tiruchirappalli – 620 014

Ph. No: 0431 – 257 6731

Email: prajeesh@bhel.in



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Annexure – B (Details Required from Vendor)

Sl No	Details	Suppliers Response																						
1	Name of the Firm / Company																							
2	Registered Works Address:																							
3	PAN of the Firm / Company																							
4	Year of commencement of Business																							
5	MSME Category (Tick the applicable one)	Micro / Small / Medium / Non-MSME																						
6	Approx. Land area of Works Address (in acres)																							
7	Approximate Sales made in the last year (Rs. Lakhs)																							
8	Profit Before Tax (PBT) (in Rs. Lakhs)																							
9	Certification available (tick the applicable one)	ISO 9001 / ISO 14001 / ISO 45001																						
10	Details of Contact Person	Name: Designation: Mobile No.: E- Mail:																						
11	Type of Ownership (Tick the applicable one)	Proprietorship / Partnership / Limited																						
12	Vendors IBR Approval	Available / Not Available																						
13	Past experience details in Stellite Welding/ Inconel Buttering																							
14	Furnace capacity with Calibration Details																							
15	Existing Availability of WPS (Yes/No)	<table border="1"> <tbody> <tr><td>A105</td><td></td></tr> <tr><td>F22</td><td></td></tr> <tr><td>F316</td><td></td></tr> <tr><td>F91</td><td></td></tr> <tr><td>F92</td><td></td></tr> <tr><td>A276-410</td><td></td></tr> <tr><td>OHTARON</td><td></td></tr> <tr><td>Inconel 617</td><td></td></tr> <tr><td>AISI 410</td><td></td></tr> <tr><td>AISI 4130</td><td></td></tr> <tr><td>AISI 1040</td><td></td></tr> </tbody> </table>	A105		F22		F316		F91		F92		A276-410		OHTARON		Inconel 617		AISI 410		AISI 4130		AISI 1040	
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16	If already Registered with any other BHEL units	BHEL Unit Name: Supplier Code: Approved Product(s):
17	Any Feedback / Suggestion	
18	Any Deviation from above requirement	