BSES

Technical Specification of

LT Power Cable(Single & Multi-Core)

Specification no – BSES-TS-01-LTPC-R0

Rev:		0
Date:		31 Mar 2022
Prepared by	Abhishek Vashistha	
	Rohit Patil	
Reviewed by	Puneet Duggal	
	Amit Tomar	31/03/2022
Approved by	Gaurav Sharma	
	K. Sheshadri	31/3/22

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1.0 SCOPE OF SUPPLY

The specification covers design, manufacture, shop testing, packing and delivery of 1100 Volts grade, Aluminium conductor XLPE insulated power cables.

2.0 CODES & STANDARDS

The cables shall be designed, manufactured and tested in Accordance with the following Indian & IEC standards.

2.1	IS- 7098 (Part-1)	Cross linked polyethylene insulated PVC sheathed cables for working voltages upto and including 1100V.
2.2	IS- 6474	Polyethylene insulation & sheath of electric cables.
2.3	IS- 5831	PVC insulation and sheath of electrical cables.
2.4	IS : 10810	Methods of tests for cables.
2.5	IS : 8130	Conductors for insulated electrical cables and flexible cords.
2.6	IS : 3975	Low carbon galvanized steel wires, formed wires and tapes for armouring of cables.
2.7	IS- 4026	Aluminum ingots, billets and wire bars (EC grade)
2.8	IS-5484	EC Grade aluminium rod produced by continuous casting and rolling
2.9	IS : 10418	Specification for drums for electric cables.
2.10	IS : 3961	Recommended current ratings for cables.
2.11	IS:1255	Installation and Maintenance of power cables upto and including 33 kV rating.
2.12	IS:4826	Specification for hot-dipped galvanized coatings on round steel wires
2.13	IS:1717	Metallic Materials – Wire – Simple torsion test
2.14	IEC 60228	Conductors of insulated cables. Guide to the dimensional limits of circular conductors.
2.15	IEC 60331	Fire resisting characteristics of electric cables.
2.16	IEC 60332 – 3	Tests on electric cables under fire conditions. Part 3: Tests on bunched wires or cables.
2.17	IEC 60502	Extruded solid dielectric insulated power cables for rated voltages from 1kV to 30 kV.
2.18	IEC 60754 – 1	Test on gases evolved during combustion of materials from cables. Part 1: Determination of the amount of halogen acid gas evolved during combustion of polymeric material taken from cables.
2.19	IEC 60811	Common test methods for insulating and sheathing materials of electric cables
2.20	IEC 60885	Electric test methods for electric cables
2.21	IEC 60304	Standard colours for insulation for low frequency cables and wires.
2.22	IEC 60227	PVC insulated cables of rated voltages up to and including 460/760 V.

2.23	IEC 1034	Measurement of smoke density of electric cables burning under defined conditions
2.24	ASTMD 2843	Standard Test Method for density of Smoke from the burning or decomposition of cables
2.25	ASTM 2863	Standard Test Method for measuring of minimum oxygen concentration
2.26	IEC 60754-1	Test on gases evolved during combustion of materials for cables. Part 1 – Determination of the Halogen Acid gas Content
2.27	IS 1554 part 1	Specification for PVC insulated (Heavy duty) Electric cable

3.0 CABLE DESIGN

Description of each item mentioned in the specification (the text, BOQ, GTP or any site specific requirement) shall be followed along with IS: 7098 – P1

<table>
<tr><td>3.1</td><td>Conductor</td><td>a) Electrolytic Grade Stranded Aluminium Conductor
b) Grade: H2 as per IS: 8130/1984
c) Class 2
d) Chemical Composition as per IS 4026
e) Shape& Size:
<table>
<tr><th>S. no.</th><th>Shape</th><th>Single core (sq.mm)</th><th>Multi core (sq.mm)</th></tr>
<tr><td>1</td><td>Compacted Circular</td><td>• 1cx25
• 1cx95
• 1cx300
• 1cx630
• 1cx1000</td><td>• 2cx10</td></tr>
<tr><td>2</td><td>Sector</td><td>---</td><td>• 2cx25
• 4cx25
• 4cx50
• 4Cx150
• 4Cx300
• 4Cx400</td></tr>
</table></td></tr>
<tr><td>3.2</td><td>Insulation</td><td>Extruded XLPE insulation as per IS : 7098 part-1</td></tr>
<tr><td>3.3</td><td>Core Identification</td><td>a) Single Core Cable – Natural
b) Two Core Cable – Red & Black
c) Four Core Cable – Red, Yellow, Blue and Black</td></tr>
<tr><td>3.4</td><td>Inner Sheath</td><td>a) For Single Core Cable – Inner Sheath Not Required
b) For 2 Core cable- Pressurized Extruded, Black PVC type ST-2 (IS 5831-1984)
c) For 4 core cable –Extruded Black PVC type ST-2 (IS 5831-1984)</td></tr>
<tr><td>3.5</td><td>Armour</td><td>a) For 2C X 10 mm^2 – Galvanized Steel round wire.
b) For all sizes above 10 mm^2-Galvanized Steel Strip
c) Armour not required for single core cables
d) Minimum area of coverage of armouring shall be 90%</td></tr>
</table>

		e) The breaking load of armour joint shall not be less than 95% of that of armour wire / strip f) Zero negative tolerance for thickness of armour strip shall be as per IS:3975 g) Zinc rich paint shall be applied on strip/wire and its joint surface.
3.6	Outer Sheath	a) Extruded FRLS outer sheath of PVC (ST-2) shall be as per IS:5831 b) Colour : • For multi core cables-**Orange/Yellow as per tender requirement** • For single core cables **– Orange/Black as per tender requirement** c) FRLS Outer sheath of all the LT cables shall be UV resistant; as these cables are laid in air exposed to sun. Bidder to ensure the same for these requirements supported by required test. d) Shape of the cable over the outer sheath shall be circular, when manufactured/completed. e) The FRLS outer Sheath shall be embossed with following minimum text: i) The voltage designation ii) Type of construction /cable code (For e.g. A2XWY/A2XFY) iii) FRLS iv) Manufacture name/Trade mark v) Number of Cores and nominal cross section area of conductor vi) Name of buyer i.e BSES vii) Month & year of manufacturing viii) IS reference , i.e. IS:7098 ix) P.O No. and Date x) Font size shall be 5/5mm xi) ISI mark The embossing shall be progressive, automatic, in line and marking shall be legible and indelible. Following points shall be printed on every meter of cable i. Progressive (Sequential) length of cable at every meter, starting from zero for every drum. Colour filled in for the progressive marking, shall be with proper contrast in colouring. ii. Drum number marking on every meter of the cable length
3.7	Bending Radius	Bending Radius of cable shall comply to IS:1255
3.8	Sealing of cable end	Both ends of the cable shall be sealed by means of non-hygroscopic

		heat shrinkable PVC caps
3.9	FRLS Properties	Oxygen Index : Not less than 29% as per ASTM 2863
		Temperature Index : 250 Deg C at Oxygen Index 21 (when tested as per ASTM D 2863)
		Max Acid Gas Generation – Not more than 20% as per IEC -60754-1
		Light Transmission - Minimum 40% when tested as per ASTMD 2843 (Smoke Density rating shall be max 60%)
		Flammability Test – IEC 60332 part -1

4.0 CABLE DRUM

4.1	Reference Standard	Cable drum shall comply with IS: 10418.
4.2	Type of Drum	Wooden drums with anti termite treatment. (The drums shall be provided with M.S spindle plate and nut-bolts arrangement as per IS : 10418)
4.3	Drum Length & Tolerance	• For 2C X 10 mm^2 Cable - 1000+/-5% Mtr • For all Other cable sizes - 500 +/-5% Mtr
4.4	Overall Tolerance	-2 % for the total cable length for the entire order.
4.5	Short Length of Cable	a) Minimum acceptable length (Max. is 525 mtr) shall be 1 % of the total ordered qty. & no length shall be less than 250 mtr. Manufactures shall be taken prior approval from BSES Engineering for any short length supply. Short length will be accepted in last lot. b) Manufacture shall not be allowed to put two cable pieces of different short length in same cable drum
4.6	Preventive Measure for cable Drum	a) The surface of the drum and outer most cable layer shall be covered with water proof layer b) Ferrous part of wooden drum shall be treated with suitable rust preventive paint/coating to minimize rusting during storage.
4.7	Drum Identification Labels	a) Drum identification number b) Cable voltage grade c) Cable code (eg. A2XFY/A2XWY) d) Number of cores and cross sectional area e) Cable quantity i.e cable length (Meters) f) Purchase order number, date & SAP item code g) Total weight of cable and drum (kg) h) Manufacture's and Buyer's name i) Month & year of manufacturing j) Direction of rotation of drum; an arrow and suitable accompanying wording shall be marked on one end of the reel indicating the direction in which it should be rolled. k) Cable length final end-marking (i.e reading at the inner end

		and reading at the outer end, just before packing shall be marked on the drum.

5.0 PACKING, SHIPPING, HANDLING & STORAGE

5.1	Shipping information Plan	The seller shall be give complete shipping information concerning the weight ,size of each package
5.2	Transit Damage	The seller shall be held responsible for all transit damage due to improper packing/inside cable damaged found in store/site
5.3	Cable Drum Handling	The drum shall be with M.S spindle plate(with nut –bolts) of adequate size to suit the spindle rod , normally required for handling the drums , according to expected weight of the cable drums as per IS:10418

6.0 QUALITY ASSURANCE, TESTING& INSPECTION

All the tests shall be carried out in accordance with IEC / IS standards.

6.1	Quality Assurance Plan	In event of order manufacturer has to submit the signed copy of QAP.
6.2	Inspection hold points	AS per approved QAP (QAP shall be approved at the time of GTP approval)
6.3	Routine Test	a) Measurement of Electrical Resistance b) HV test with power frequency AC voltage
6.4	Type Test	**For bid participation–** (a) Bidder must be submitted cable type tested report from CPRI/ERDA/NABL approved lab for the type, size & rating of similar or higher sizes of offered cable along with bid. **After award of P.O.-** (b) If a bidder has valid type test report from CPRI/ERDA lab for the type, size & rating of similar or higher sizes of offered cable (including FRLS)—No need to conduct fresh type test from CPRI/ERDA lab. (c) If a bidder has valid type test report from CPRI/ERDA lab for the type, size & rating of similar or higher sizes of offered cable (except FRLS)—Need to conduct only fresh type test of FRLS properties test from CPRI/ERDA/NABL lab(list of tests mentioned in clause 3.9)without any commercial implication to BSES. (d) If a bidder has valid type test report from NABL lab for the type, size & rating of similar or higher sizes of offered cable (including FRLS)—Need to conduct complete type test (including FRLS properties) from CPRI/ERDA lab without any

		commercial implication to BSES. (Type test shall not be more than 5 years old. If the type test report is more than 5 years old (max 10 years), it can be considered subject to no change in their design) (e) UV resistance test to be carried out on one sample from CPRI/ERDA/NABL Accredited Lab as per ASTM standard (sample shall meet minimum 80% retention in tensile strength and elongation after exposure of 21 days as per ASTM standard).
6.5	Acceptance Test (Shall be conducted as per Cl.15.2 of IS 7098 Part-1 & IS 1554 part 1 for each lot of cable)	a) For cable sizes up to 25 mm^2 – one sample for chemical composition and purity test of aluminium shall be conducted per300km of ordered quantity and multiple thereof. b) For cable sizes 50mm^2 – one sample for chemical composition and purity test of aluminium shall be conducted per 100km of ordered quantity and multiple thereof. c) For cable sizes above 50 mm^2 – one sample for chemical composition and purity test of aluminium shall be conducted upto 50km of ordered quantity and multiple thereof. d) Chemical composition and purity test of aluminium shall be conducted from the lot offered to BSES on each size involved in the purchase order. Test shall be carried out at NABL accredited third party lab without any price implication to BSES. e) The sample will be selected either during acceptance test or after receipt of cable in BSES Stores.
6.6	Inspection	a) The buyer reserves the right to witness all tests specified on completed cables b) The buyer reserves the right to inspect cables at the seller's works at any time prior to dispatch either in finished form or during manufacturing, to prove compliance with the specifications. c) In-process and final inspection call intimation shall be given in 10 days advance to purchaser/CES.
6.7	Test Certificates	Complete test certificates (routine & acceptance tests) need to be submitted along with the delivery of cables.

7.0 DOCUMENT SUBMISSION MATRIX

Document/Drawing submission shall be as per the matrix given below:

a. All documents/drawings shall be provided in soft copy only via mail or in returnable Pen drives
b. Language of the documents shall be English only.
c. Document check sheet compliance shall be the first sheet for each submission stage i.e. Technical bid, Drawing Approval, Pre Dispatch, Pre closure

d. No submission is acceptable without check list compliance.
e. Deficient/ improper or incomplete document/ drawing submission shall be liable for rejection.
f. Order of documents shall be strictly as per the check list.
g. Any document not included in the below table but necessary for detailed engineering shall be deemed to be included in bidder's scope

S No.	Detail of Document	Bid	Approval	Pre Dispatch
1	Guaranteed Technical Particulars (GTP)	Required	Required	
2	Deviation Sheet, if any	Required	Required	
3	Detailed cross sectional drawing of cable	Required	Required	
4	Dimensional drawing of cable drum	Required	Required	
4	Type test reports of offered type and rating of cable	Required	Required	
5	BIS certificate	Required		
6	Complete cable catalogue	Required		
7	Make of Raw Materials	Required	Required	
8	Cable de-rating factors	Required	Required	
9	Armour coverage calculation		Required	
10	Inspection test reports and Routine Test Certificates carried out in manufacturer's works			Required
12	Test certificates of all raw materials			Required
13	Calibration test reports of instruments			Required

8.0 PROGRESS REPORTING

8.1	Outline Document	To be submitted for purchaser approval for outline of Production-inspection, testing-inspection, packing, dispatch, documentation programme.
8.2	Detailed Progress Report	To be submitted to purchaser once a month containing a) Progress on material procurement b) Progress on fabrication (As applicable) c) Progress on assembly (As applicable) d) Progress on internal stage inspection e) Reason for any delay in total programme f) Details of test failures if any in manufacturing stages. g) Progress on final box up constraints/forward path.

9.0 DEVIATION

a) Deviations from this specification shall be listed separately by bidder clause wise (format given below) along with optional offer and has to submit the list along with bid/quotation. BSES will review the deviations and if BSES is agreed with the deviation, seller has to take written confirmation from BSES on deviation during tender evaluation.
b) In the absence of any separate list of deviations from the bidders with bid as well as written confirmation from BSES on deviations, it will be assumed by the Buyer that the Seller complies with the Specification fully.
c) Any deviations mentioned in any other submitted bid documents (i.e.in filled GTP, Catalog, BSES old approval, buyer's/seller's standards etc) by seller without separate deviation sheets will not consider as a deviation from this tech spec at any stage of contract.

Deviation sheet format

Sl. No.	Document Name	Clause No.	Deviation	Reason	Merit to BSES

10.0 Annexure -A

GUARANTEED TECHNICAL PARTICULARS (Multi-core)

(Standard Cable sizes are 2cx10, 2cx25, 4cx25, 4cx50, 4C X 95, 4cx150, 4cx300, 4cx400)

For each size /rating separate GTP need to be furnished

Sr. No.	Description	Buyer's Requirement	Seller's data
	Manufacture Contact Person & Number		
	Purchase Req. No.	……..	
	Guarantee Period: (Min)	60 Months (from date of commissioning) / 66 months (from date of receipt at purchaser's store) whichever is earlier	
	Applicable IS / IEC Standard followed by vendor	As mentioned in the clause no – 2.0	
1	Make	…	
2	Type (as required by purchaser)		
A	For 2CX10Sqmm	A2XWY	
B	For Sizes above 10 mm^2	A2XFY	
3	Voltage Grade (kV)	1.1	
4	Maximum Conductor temperature		
A	Continuous	90°C	
B	Short time	250°C	
5	Conductor		
A	Material and Grade	As per Cl.3.1	
B	Make of Al	Ref Annexure D	
C	Size (mm^2)	…… mm^2	
D	Min no. of wires in each conductor (Nos.)	As per Manufacturer Standard	
E	Min Dia. of wires in each conductor before compaction (mm)	As per Manufacturer Standard	

Sr. No.	Description	Buyer's Requirement	Seller's data
F	Shape of Conductor	As per Cl.3.1 (e)	
G	Diameter over conductor (mm)	……	
H	Maximum Conductor resistance at 20 ° C(Ohm/Km)	As per Table 2 of IS 8130	
6	Insulation		
A	Insulation Material	As per Cl. 3.2	
B	Nominal thickness (mm)	As per Table 3 of IS 7098 Part-1	
C	Diameter over Insulation (mm) Approx.	……	
D	Make of insulation compound	Ref: Annexure D	
7	Inner Sheath		
A	Material and Type	As per Cl. 3.4	
B	Minimum thickness	As per Table 5 of IS 7098 Part-1	
C	Approx. dia. Over sheath (mm)	……	
8	Galvanized Steel Armour	as per purchaser's site - specific condition	
A	Material		
a)	For 2CX10 mm^2	G.I. Wire	
(i)	Wire Dia. (mm)	1.4+/-0.040	
(ii)	No. of wires	As per Manufacturer Standard	
b)	For sizes above 10 mm^2	G.I. Strip	
(i)	Strip size (Width and Thickness)	4x0.8 (Zero negative tolerance for thickness)	
(ii)	No. of Strips	As per Manufacturer Standard	
B	Area covered by Armour	Min 90% and calculations shall be strictly as per Annexure-D	
C	Dia. over Armour – Approx.(mm)	……	

Sr. No.	Description	Buyer's Requirement	Seller's data
9	Outer Sheath (FRLS)		
A	Material and Type	As per Cl. 3.6	
B	Minimum Thickness	As per Table 8 of IS 7098 Part-1	
C	Colour	Orange	
D	Embossing Details	As per Cl.3.6 (e)	
10	Approx. overall dia. (mm)	……	
11	Overall order tolerance	- 2 % for the total cable length for the entire order	
12	Cable Drum		
A	Type of Drum	Wooden	
B	Drum Length & tolerance	As per Spec. Cl. 4.3 & 4.4	
C	Marking on Drum	As per Spec. Cl. 4.7	
D	Drums provide with MS Spindle plate & nut bolts arrangement (as per IS:10418)	Required	
13	End Cap	Required	
14	Weights	……	
a)	Net Weight of cable (Kg/Km.) – Approx		
b)	Weight of empty drum	Kg	
c)	Weight of cable with drum	Kg	
15	Continuous current rating for standard I.S condition laid direct		
a)	In ground 30° C	Amps	
b)	In duct 30° C	Amps	
c)	In Air 40° C	Amps	
16	Short circuit current for 1 sec of Conductor (kAmp)	……	
17	Electrical Parameters at Maximum operating temperature:		
A	AC Resistance	Ohm/Km	

Sr. No.	Description	Buyer's Requirement	Seller's data
B	Reactance at 50 C/s	Ohm/Km	
C	Impedance	Ohm/Km	
D	Capacitance	Micro farad / Km	
18	Recommended minimum bending radius	..... x O/D	
19	De-rating factor for following Ambient temperature in	Ground / Air	
a)	At 30° C		
b)	At 35° C		
c)	At 40° C		
d)	At 45° C		
e)	At 50° C		
20	Group factor for following Nos. of cables laid	Touching / Trefoil	
a)	3 Nos.		
b)	4 Nos.		
c)	5 Nos.		
d)	6 Nos.		
21	Process of Cross linking of Polyethylene	Dry/ Sioplas Cure	
22	Type test	Is copy of latest valid TTR for respective Sizes enclosed? Yes /No	
23	FRLS Properties	As per IS 1554, Part-1	
	Oxygen Index	As per IS 1554, Part	
	Temperature Index	As per IS 1554, Part	
	Max Acid Gas Generation	As per IS 1554, Part	
	Light Transmission / Smoke Density	As per IS 1554, Part	

11.0 ANNEXTURE- B

GUARANTEED TECHNICAL PARTICULARS (Single Core)
(Separate GTP needs to be furnished for 25, 95, 300, 500, 630 & 1000 mm^2 cables)

S.No.	Description	Buyer's Requirement	Seller's data
	Manufacture Contact Person & Number		
	Purchase Req. No.	……..	
	Guarantee Period: (Min)	60 Months (from date of commissioning) / 66 months (from date of receipt at purchaser's store) whichever is earlier	
	Applicable IS / IEC Standard followed by Vendor	As mentioned in the clause no-2.0	
1	Make	……	
2	Type	A2XY (Un-armoured)	
3	Voltage Grade (kV)	1.1kV	
4	Maximum Conductor temperature		
A	Continuous	90°C	
B	Short time	250°C	
5	Conductor		
A	Material and Grade	As per Cl. 3.1	
B	Size (mm^2)	.....mm^2	
C	Min no. of wires in each conductor (Nos.)	As per Manufacturer Standard	
D	Min Dia. of wires in each conductor before compaction (mm)	As per Manufacturer Standard	
E	Shape of conductor	Compacted Circular	
F	Diameter over conductor (mm)	……	
G	Maximum Conductor resistance at 20 ° C(Ohm/Km)	As per Table 2 of IS 8130	
H	Make of Al	Ref Annexure D	
6	Insulation	As per Table 3 of IS7098 Part-1	
A	Insulation Material	As per Cl. 3.2	

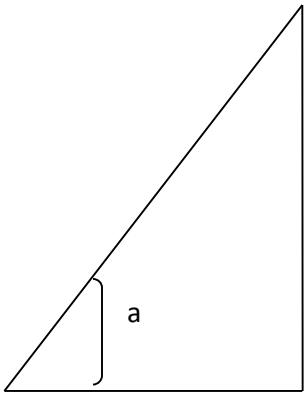
S.No.	Description	Buyer's Requirement	Seller's data
B	Nominal thickness (mm)		
(i)	For 1Cx300 mm^2	1.8 mm	
(ii)	For 1Cx500 mm^2	2.2 mm	
(iii)	For 1Cx630 mm^2	2.4 mm	
iv)	For 1Cx1000 mm^2	2.8 mm	
C	Diameter over Insulation (mm) Approx.	……	
D	Make of insulation compound	Ref: Annexure D	
7	Inner Sheath	Not applicable	
8	Armour	Not applicable	
9	FRLS Outer Sheath		
A	Material and Type	As per Cl. 3.6	
B	Minimum Thickness	As per Table 8 of IS 7098 Part-1	
C	Colour	Orange	
D	Embossing Details	As per Cl.3.6 (e)	
10	Approx. overall dia. (mm)	……	
11	Overall order tolerance	-2 % for the total cable length for the entire order	
12	Cable Drum		
A	Type of Drum	Wooden	
B	Drum Length & tolerance	As per Spec. Cl. 4.3 & 4.4	
C	Marking on Drum	As per Spec. Cl. 4.7	
D	Drums provide with MS Spindle plate & nut bolts arrangement (as per IS:10418)	Required	
13	End Cap	Required	
14	Weights	……	
a)	Net Weight of cable (Kg/Km.) – Approx		
b)	Weight of empty drum	Kg	

S.No.	Description	Buyer's Requirement	Seller's data
c)	Weight of cable with drum	Kg	
15	Continuous current rating for standard I.S condition laid direct		
a)	In ground 30° C	Amps	
b)	In duct 30° C	Amps	
c)	In Air 40° C	Amps	
16	Short circuit current for 1 sec of Conductor (kAmp)	……	
17	Electrical Parameters at Maximum operating temperature:		
A	AC Resistance	Ohm/Km	
B	Reactance at 50 C/s	Ohm/Km	
C	Impedance	Ohm/Km	
D	Capacitance	Micro farad / Km	
18	Recommended minimum bending radius	……. x O/D	
19	Derating factor for following Ambient temperature in	Ground / Air	
a)	At 30° C		
b)	At 35° C		
c)	At 40° C		
d)	At 45° C		
e)	At 50° C		
20	Group factor for following Nos. of cables laid	Touching / Trefoil	
a)	3 Nos.		
b)	4 Nos.		
c)	5 Nos.		
d)	6 Nos.		
21	Process of Cross linking of Polyethylene	Dry/ Sioplas Cure	
22	Type test	Is copy of latest valid TTR for respective Sizes enclosed?	

S.No.	Description	Buyer's Requirement	Seller's data
		Yes /No	
23	FRLS Properties		
	Oxygen Index	As per IS 1554, Part	
	Temperature Index	As per IS 1554, Part	
	Max Acid Gas Generation	As per IS 1554, Part	
	Light Transmission / Smoke Density	As per IS 1554, Part	

12.0 ANNEXTURE – C

ARMOUR COVERAGE PERCENTAGE



Percent coverage = $\frac{N \times d}{W} \times 100$

Where,
N = number of parallel wires / Strips
d = diameter of wire / width of formed wires
W = π x D x Cos a,
D = diameter under armour
a = angle between armouring wire / formed wires and axis of cable
tan a = π x D/C, and
C = lay length of armouring wires / formed wires.

Min 90% armour coverage shall be provided both in case of wires and strips.

The gap between armour wires / formed wires shall not exceed one armour wire / Formed wire space and there shall be no cross over / over-riding of armour wire / Formed wire so, the minimum area of coverage of armouring shall be 90%.

13.0 ANNEXTURE – D

LIST OF SUB-VENDORS

Sr. No.	Description of Material	Sub-Vendors
1	E.C Grade Aluminium Rod	Bharat Aluminium Co. Ltd. (BALCO) Hindustan Aluminium Co. Ltd. (HINDALCO) National Aluminium Co. Ltd. (NALCO)
2	XLPE Compound	Kkalpana Industries Ltd. KLJ Polymers and Chemicals Ltd. Dow Chemical, U.S.A Borealis, Sweden Hanwha, Seoul, South Korea
3	PVC Compound	Kkalpana Industries Ltd. KLJ Polymers and Chemicals Ltd. Universal SCJ Plastic Sriram Polytech Shri Ram Vinyl, Kota
4	GI Strip	Tata Balaji Systematic Mica Wires Pvt Ltd. Bansal Industries