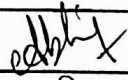


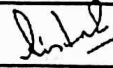
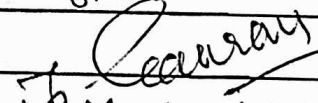
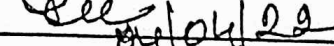




Technical Specification of
ACSR CONDUCTORS
(Insulated & Bare)

Specification no – BSES-TS-05-ACSR-R0

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TECHNICAL SPECIFICATION OF ACSR CONDUCTOR**1. SCOPE**

- 1.1 This specification covers the design, manufacture, testing at manufacturer's works, packing and delivery at site of the ACSR conductor along with necessary accessories.
- 1.2 The conductor and its accessories shall be complete with all fittings and components necessary for the effective working and efficient performance and satisfactory maintenance under the various operating conditions specified. All such parts shall be deemed to be included within the scope of supply where specifically included or not in this specification in the tender schedule. The successful bidder shall not be eligible for any extra charge for such accessories.
- 1.3 The specification includes both insulated & un-insulated ACSR conductor. Following table suggests requirement of conductors under insulated & un-insulated type as per tender enquiry

Conductor name	Zebra	Goat	Panther	Wolf	Dog	Rabbit	Squirrel
Insulated	X	X	X	X	√	√	√
Un-Insulated	√	√	√	√	√	√	√

2. CODES AND STANDARDS

- 2.1 All equipment and material shall be designed, manufactured and tested in accordance with the latest applicable Indian Standard, IEC standard and CBIP manuals enlisted in the appendix 1, except where modified and / or supplemented by this specification.
- 2.2 Equipment and material conforming to any other standard, which ensures equal or better quality, may be accepted. In such case copies of English version of the standard adopted shall be submitted by the vendor with the offer
- 2.3 The electrical installation shall meet the requirement of Indian Electricity Rules as amended up to date; relevant IS code of practice and Indian electricity act. In addition other rules & regulations applicable to the work shall be followed. In case of any discrepancy the most stringent & restrictive one shall be binding.
- 2.4 The equipment offered shall in general comply with the latest issues including amendments of the standards enlisted in the appendix 1 but not restricted to it.

3. DESIGN**3.1 General**

- All steel strands shall be smooth, uniform and free from all imperfections, such as spills and splits, die marks, scratches, abrasions and kinks after drawing and also after stranding.
- The finished material shall have minimum brittleness, as it will be subjected to appreciate vibration while in use.
- The steel strands shall be hot dip galvanized and shall have a maximum zinc coating of 240gms/sq.mm after stranding. The zinc coating shall be smooth, continuous of uniform thickness, free from imperfections and shall withstand three and a half dips after stranding in standard Price test.
- The steel wire rod shall be of such quality and purity that, when drawn to the size of the strands specified and coated with zinc, the finished strands shall be of uniform quality and have the same properties and characteristic as prescribed in relevant ASTM/IS/IEC standards.
- To avoid susceptibility towards wet storage stains (while rust), the finished material shall be provided with a protective coating of boiled linseed oil.
- The finished conductor shall have a smooth surface without any surface cuts, abrasions, scuff

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR

marks and shall be free from dirt, grit etc.

- The Steel wire shall be made from materials produced either by the acid or basic Open Hearth process or by electric process. No steel wire drawn from 'Bessemer processes shall be used. The steel wire shall not contain sulphur or phosphorous exceeding 0.5% and the total of sulphur and phosphorous shall not exceed 0.085%.
- The steel strands shall be performed and post formed in order to prevent spreading of strands in the event of cutting of composite core wire. Care shall be taken to avoid damages to galvanization during performing and post forming operations.

3.2 MATERIALS

- The aluminium strands shall be hard drawn from electrolytic aluminum rods having a purity of not less than 99.5% and a copper content not exceeding 0.04%.
- The steel wire strands shall be drawn from high carbon steel wire rods produced by either the acid or basic open hearth process, the electric furnace process, or the basic oxygen process and shall conform to the following requirements as to the chemical composition:

Element	% composition
Carbon	0.50 to 0.85
Manganese	0.50 to 1.10
Phosphorus	Not more than 0.035
Sulphur	Not more than 0.045
Silicon	0.10 to 0.35

- The zinc used in galvanizing shall be electrolytic high grade zinc of 99.95% purity. It shall conform to and satisfy all the requirements of IS/IEC.

3.3 STANDARD LENGTH

- The standard length of the conductor shall be 3000 meters. A tolerance of +/-5% on the standard length offered by the Bidder shall be permitted. All lengths outside this limit of tolerance shall be treated as random lengths.
- Random lengths will be accepted provided no length is less than 70% of the standard length and the total quantity of such random length shall not be more than 10% of the total quantity ordered. When one number random length has been manufactured at any time, five (5) more individual lengths, each equivalent to the above random length with a tolerance of +/-5% shall also be manufactured and all the above six random lengths shall be dispatched in the same shipment. At any point, the cumulative quantity supplied including such random lengths shall not be more than 12.5% of the total cumulative quantity supplied including such random lengths. However, the last 20% of the quantity ordered shall be supplied only in standard lengths as specified.
- Bidder shall also indicate the maximum single length, above the standard length, he can manufacture in the guaranteed technical particulars of offer. This is required for special stretches like river crossing etc. The employer reserves the right to place orders for the above lengths on the same terms and conditions applicable for the standard lengths during the pendency of the Contract.

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR**3.4 JOINT IN WIRES****• Aluminium wires**

No joints shall be permitted in the individual wires in the outer most layer of the finished conductor. However, joints in the 12 wire and 18 wire inner layer of the conductor shall be allowed but these joints shall be made by cold pressure butt welding and shall be such that no such way joints are within 15 meters of each other in the complete stranded conductor. The joints shall withstand a stress of not less than the breaking strength of individual strand guaranteed.

• Steel Wires

There shall be no joint of any kind in the finished wire entering into manufacture of the non strand joint or strand splices in any length of the complete stranded steel core of the conductor.

3.5 INSULATON

S. No.	Particular	Data
1	Voltage Grade	1.1 kV
2	Insulation Material	XLPE
3	Nominal Thickness of Insulation	As per table 3 of IS 7098 P-1

4. QUALITY ASSURANCE

- 4.1 Vendor shall follow his standard procedures for quality assurance and control. These standard procedures including quality assurance plan shall be submitted to the purchaser for approval.
- 4.2 The procedures shall be in such a form as to clearly indicate the manufacturing sequence and major inspection points and to reference Bidder's test in inspection procedures.
- 4.3 Manufacturing and quality control procedures shall be available for audit to the Purchaser and / or its representatives at the place of manufacture.
- 4.4 The Purchaser and/or its representative reserves the right to inspect the equipment at the point of manufacture and witness factory and other such tests as may be necessary to ensure conformance to the specification.
- 4.5 The Purchaser and / or its representative shall inspect the Vendor facilities prior to award of contract.
- 4.6 The Purchaser and/or its representative may conduct surveillance of the Vendor facilities for compliance to his standard procedures of quality assurance and quality control while work is in progress.

5. INSPECTION AND TESTING**5.1 INSPECTION**

- The purchaser's representative shall at all times be entitled to have access to the works and all places where conductor shall be manufactured and shall have full facilities for unrestricted inspection of the manufacturer works, raw materials and process of manufacture for conducting necessary tests as detailed herein.
- The manufacturer shall keep the Employer informed in advance of the time of starting and of the progress of manufacture of conductor in its various stages so that arrangements can be made for inspection.
- No material shall be dispatched from its point of manufacture before it has been satisfactory inspected and tested, unless the inspection is waived off by the purchaser in writing. In the latter

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR

case also the conductor shall be dispatched only after satisfactory testing for all tests specified herein have been completed.

- The acceptance of any quantity of material shall in no way relieve the manufacturer of any of his responsibilities for meeting all requirements of the Specification and shall not prevent subsequent rejection if such material is later found to be defective.

5.2 TESTS

The following acceptance and routine tests and tests during manufacture shall be carried out on the conductor. For the purpose of this clause, the following shall apply

- Acceptance tests shall mean those tests which are to be carried out on samples taken from each lot offered for pre-dispatch inspection, for the purpose of acceptance of that lot.
- Routine tests shall mean those tests, which are to be carried out on each strand/spool/length of the conductor to check requirements which are likely to vary during production.
- Tests during manufacture shall mean those tests, which are to be carried out during the process of manufacture to ensure the desired quality of the end product.
- For all acceptance tests, the acceptance values shall be the values shall be the values guaranteed by the Bidder in the guaranteed technical particulars of his proposal or the acceptance value specified in this Specification, whichever is more stringent for that particular test.

5.3 TYPE TESTS

Supplier shall submit all Type test report with validity of 5 years, along with the bid. The entire test certificate as per relevant IS/IEC shall be submitted for purchaser review. In case type tests have not been conducted earlier the same has to be carried out without any cost implication to purchaser. Purchaser has the right of witnessing any of the tests for which the supplier has to give prior notice before the date of conducting such tests. The unit rates for each type of the tests to be carried out shall be indicated in the offer. Requirement of type test shall be as listed below. Type test charges shall not be included as part of main price to be indicated in the offer.

The following tests shall be performed on a typical length of conductor. The cost of these tests shall be quoted separately.

- a) Surface condition test
- b) Test for ultimate breaking load on stranded conductor
- c) Stress strain test
- d) Measurement of diameter of individual aluminium and steel wires.
- e) Measurement of lay ratio.
- f) Breaking load of individual wires
- g) Ductility test
- h) Wrapping test
- i) Resistance test and
- j) Galvanizing test

5.4 ACCEPTANCE TESTS

- a) Visual and dimensional check by drum
- b) Visual check for joints scratches etc and lengths of conductor by rewinding
- c) Dimensional check on steel and Aluminium strands

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR

- d) Galvanizing test on steel strands
- e) Torsion and elongation test on steel strands
- f) Check for lay ratio of various layers
- g) Breaking load test on steel and aluminium strands
- h) Wrap test on steel and aluminum strands
- i) DC resistance test on aluminium strands
- j) UTS Test on welded joint of strands
- k) Tensile test (For Aluminium)
- l) Test for thickness of insulation
- m) Tensile strength & elongation at break test for insulation
- n) High voltage test
- o) Insulation resistance (Volume resistivity) test

All above tests except (j-o) shall be carried out on aluminium and steel strands after stranding only.

5.5 ROUTINE TESTS

- a) Check to ensure that the joints are as per Specification.
- b) Check that there are no cuts, fins etc on the strands.
- c) Check that drums as per Specification.
- d) All acceptance test as mentioned above to be carried out on each coil

6. EMBOSSING & PRINTING

Following text shall be embossed on insulated conductor only

- a) BSES, PO No. & Date, Manufacturing month & year, Type of Conductor- one each meter length
- b) Printing of running meter No.- on each meter length- White colour

7. APPROVED VENDORS & SUPPLIERS OF RAW MATERIAL

S. No	Material	Approved Suppliers
1	Steel	TATA /SAIL
2	Aluminium	NALCO/BALCO/HINDALCO
3	Insulation	KLJ/KALPENA/DOW/HANWHA/BOREALIS

8. 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.

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR

- 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 ACSR Conductor	Required	Required	
4	Dimensional drawing of drum	Required	Required	
5	Type test reports of offered type and rating of ACSR conductor	Required	Required	
6	BIS certificate	Required		
7	Complete cable catalogue	Required		
8	Make of Raw Materials	Required	Required	
09	Inspection test reports and Routine Test Certificates carried out in manufacturer's works			Required
10	Test certificates of all raw materials			Required
11	Calibration test reports of instruments			Required

9. ANNEXURE - I**CONDUCTOR DATA SHEET**

S.N.	Particulars	Conductor Details						
1	Conductor Name	Zebra	Goat	Panther	Wolf	Dog	Rabbit	Squirrel
2	Stranding and wire diameter	54/3.18 mm Al. + 7/3.18 mm Steel	30/3.71 mm Al. + 7/3.71 mm Steel	30/3.0 mm Al. + 7/3.0 mm Steel	30/2.59 mm Al. + 7/2.59 mm Steel	6/4.72 mm Al. + 7/1.57 mm Steel	6/3.35 mm Al. + 1/3.35 mm Steel	6/2.11 mm Al + 1/2.11 mm Steel
3	Number of strands							
3a	Core	1	1	1	1	1	1	1
3b	1 st layer	6	6	6	6	6	6	6
3c	2 nd Layer	12	12	12	12	6	--	--
3d	3 rd layer	18	18	18	18	--	--	--
3e	4 th Layer	24	--	--	--	--	--	--
4	Sectional	428.9 Sq.	324.30	212.10	158.10	105.00	52.88 Sq.	20.98 Sq.

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR

	Area of Aluminum	mm	Sq. mm	Sq. mm	Sq. mm	Sq. mm	mm	mm
5	Total Sectional Area	484.5 Sq. mm.	400.00 Sq. mm	261.50 Sq. mm	194.90 Sq. mm	118.50 Sq. mm	61.70 Sq. mm	24.48 Sq. mm
6	Overall Diameter	28.62 mm	25.97 mm	21.00 mm	18.13 mm	14.15 mm	10.05 mm	6.33 mm
7	Approx. Weight							
7a	Aluminum	1186 kg/Km	878 kg/Km	587 kg/Km	428 kg/Km	287 kg/Km	145 kg/Km	58 kg/Km
7b	Steel	435 kg/Km	610 kg/Km	387 kg/Km	298 kg/Km	107 kg/Km	69 kg/Km	27 kg/Km
7c	Total	1621 kg/Km	1488 kg/Km	974 kg/Km	726 kg/Km	394 kg/Km	214 kg/Km	85 kg/Km
8	Calculated DC resistance at 20°C	0.06868 Ohm/Km	0.09106 Ohm/Km	0.13900 Ohm/Km	0.18710 Ohm/Km	0.27920 Ohm/Km	0.55240 Ohm/Km	1.39400 Ohm/Km
9	Minimum UTS	130.32 KN	137.00 KN	89.67 KN	67.34 KN	32.41 KN	18.25 KN	7.61 KN

Lay Ratio of Aluminum Conductors, Steel Reinforced

S. No.	Conductor	No. of wire		Ratio of Aluminum Wire Diameter to Steel wire Diameter	Lay ratio to Steel core (6 wire ratio)		Lay ratio for Aluminum wire					
							Outermost Layer		Layer immediately beneath Outermost Layer		Innermost Layer of conductors with 3 Aluminum wire Layers	
		Aluminum	Steel		Min	Max	Min	Max	Min	Max	Min	Max
1	Zebra	6	1		-	-	10	14	-	-	-	-
		6	7		13	28	10	14	-	-	-	-
		30	7		13	28	10	14	10	16	-	-
		42	7		13	28	10	14	10	16	10	17
		54	7		13	28	10	14	10	16	10	17

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Diameter of Aluminum & Steel Strands

S. No.	Conductor Name	Aluminum			Steel		
		Nominal	Maximum	Minimum	Nominal	Maximum	Minimum
1	Zebra	3.18	3.21	3.15	3.18	3.24	3.12
2	Goat	3.71	3.74	3.68	3.71	3.76	3.65
3	Panther	3.00	3.03	2.97	3.00	2.94	2.06
4	Wolf	2.59	2.62	2.56	2.59	2.64	2.54
5	Dog	4.72			1.57		
6	Rabbit	3.35	3.32	3.38	3.35	3.42	3.28
7	Squirrel	2.11	2.13	2.9	2.11	2.15	2.07

10. ANNEXURE - II

VENDOR DATA (GURANTEED TECHNICAL PARTICULARS)(SEPARATE DATA SHEET SHALL BE SUBMITTED FOR EACH TYPE OF CONDUCTOR)

SI.NO.	DESCRIPTION	BSES Requirement	PARTICULARS
1	Name of the material offered	XLPE Insulated ACSR Conductor	
2	Maker's Name	Required	
3	Address and Phone No.		
4	Reference Standards	IS-398Pt-1, IS 1778 , IS 7098	
5	No.of strands/diameter of Galvanised steel wire/Al strand	Required	
6	Apporx.Dia over covered conductor		
7	Minimum Ultimate Tensile Strength of Conductor	18.25	
8	Direction Of Lay	Successive layers shall have opposite directions of lay outermost layer being Right Handed	
9	Lay ratio of Aluminum wire		
10	Continuous max. current rating of ACSR Conductor in still air at an ambient temperature at 45 Deg C	Required	
11	Temperature rise for the above current	Required	
12	Short Circuit current rating of ACSR Conductor for 1sec	Required	
13	Module of elasticity of complete	79	

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR

	Conductor		
14	Coefficient of linear expansion of complete conductor	19.1x10 ⁶	
15	Cross sectional area	Required	
16	Nominal aluminium area	Required	
16.1	Conductivity and Grade of Al	61% EC Grade	
16.2	% Composition of steel wire	As Per spec	
17	Chemical composition certificate from NABL approved lab	Required	
18	Minimum breaking load		
18.1	Aluminum strand (After Stranding)	Required	
18.2	Galvanised steel wire (After Stranding)	Required	
19	Total Conductor	Required	
20	Max.Working tension of conductor	75% of UTS	
21	Resistance of Al conductor at 20Deg C(Max)	Required	
22	Weight		
22.1	Aluminium strand	Required	
22.2	Steel Strand	Required	
22.3	Conductor without insulation	Required	
22.4	Conductor with insulation	Required	
23	Purity of AL.rod in %age	Required	
24	Zinc coating on steel wire		
24.1	Grade of Zinc	Electrolytic High Grade Zinc not less Than 99.95% purity as per IS209-1992	
24.2	Min wt of Zinc Coating	Required	
24.3	No.& duration of dips of Zinc coating (Before Stranding)	Required	
25	Type of Insulation	XLPE Type as per IS 7098	
25.1	Nominal thickness of XLPE insulation	1.6	
25.2	Min thickness of XLPE insulation	1.5	
25.3	Color of XLPE insulation	Black	
25.4	Tensile strength of Insulation (Min)	12.5	
25.5	Percentage elongation at break of Insulation(Min)	200	
25.6	Insulation resistance test (Volume resistivity) Min	1x10 ¹⁴ at 27deg C 1x10 ¹² at 90deg C	

TECHNICAL SPECIFICATION OF ACSR CONDUCTOR

26	Chemical composition test certificate of XLPE insulation material	Required, shall be weather proof and have property of protection against ultraviolet light having 2.5% black carbon content	
27	Drum	Required	
27.1	Ref IS	IS-1778-1980	
27.2	Gross weight of drum including weight of Conductor	Required	
27.3	Standard length of each piece of Conductor	3Km	
27.4	Non standard length	length	
28	Order quantity tolerance	(+/-)2%	Yes/No
29	Embossing	Name of manufacturer, Manufacture year, Manufacturing month, Type of conductor, BSES, P.o no & date	