

Terms and Conditions

1. Broad Scope

Wire Arc Additive Manufacturing (WAAM) of Haynes 230 coupons and plates

2. Detailed Scope

The detailed scope under the indent is tabulated below:

Sl. No.	Line Item/Activity
1	WAAM parameter development, engineering, trials and process establishment
2	WAAM printing of coupons (30*30*40mm) for property and microstructure evaluation
3	WAAM printing of plates (150*300*5mm) for property and microstructure evaluation
4	Wire cutting of WAAM printed coupons and plates (the coupon/plates delivered should have flat surfaces without waviness)
5	Non-Destructive Evaluation: Radiography and Die Penetrant on the WAAM printed plates and coupons
6	Procurement of WAAM feedstock and other consumables

2.1. Other Specifications

2.1.1. Haynes 230 Feedstock should be in line with AMS 5878C including its constituent chemistry.

2.1.2. Party shall supply the coupons and plates in road worthy containers suitable for transportation.

2.1.3. The containers shall either be packed with proper identification numbers.

2.1.4. The party should share the parameters used for realizing the coupons and plates.

2.2. Deliverables

Following are the deliverables to LPSCV as per the tender:

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Sl. No.	Item Deliverable	Qty. to be delivered
1	WAAM printing of coupons (30*30*40mm) for property and microstructure evaluation	2 Sets (one with different shielding gases and one with optimized shielding gas)
2	WAAM printing of plates (150*300*5mm) for property and microstructure evaluation	2 sets

Party should agree to print additional coupons (30*30*40) mm-5 Nos max if required at no extra cost considering the developmental nature of the activity.

Delivery schedule of the deliverables is tabulated below:

Sl. No.	Item Deliverable	Delivery Schedule
1	WAAM printing of coupons (30*30*40mm) for property and microstructure evaluation	1st Set: T+30 Days (T1) 2nd Set: T1+15 Days (T2)
2	WAAM printing of plates (150*300*5mm) for property and microstructure evaluation	1st Set: T2+30 Days (T3) 2nd Set: T3+15 Days

2.3. Acceptance

All the coupons and plates realized by the party should be acceptable in NDT as per Sl. 5 of table in Scope (Point 2)

2.4. Payment

Payment to the party shall be regulated as per the following table:

Line Item No.	Line Item/Activity	Payment clause
1	WAAM parameter development, engineering, trials and process establishment	Payable after delivery of 1 st set of coupons as per

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		Sl. No. 2
2	WAAM printing of coupons (30*30*40mm) for property and microstructure evaluation	Payable with each set of coupons delivered.
3	WAAM printing of plates (150*300*5mm) for property and microstructure evaluation	Payable with each set of plates delivered.
4	Wire cutting of WAAM printed coupons and plates (the coupon/plates delivered should have flat surfaces without waviness)	Payable after delivery of 2 nd set of plates as per Sl. No. 3
5	Non-Destructive Evaluation: Radiography and Die Penetrant on the WAAM printed plates and coupons	Payable after delivery of 1 st set of plates as per Sl. No. 3
6	Procurement of WAAM feedstock and other consumables	Payable after delivery of 1st set of plates as per Sl. No. 3

Payment shall be released against the invoices produced upon completion of above line items **based on certification from LPSC focal point.**