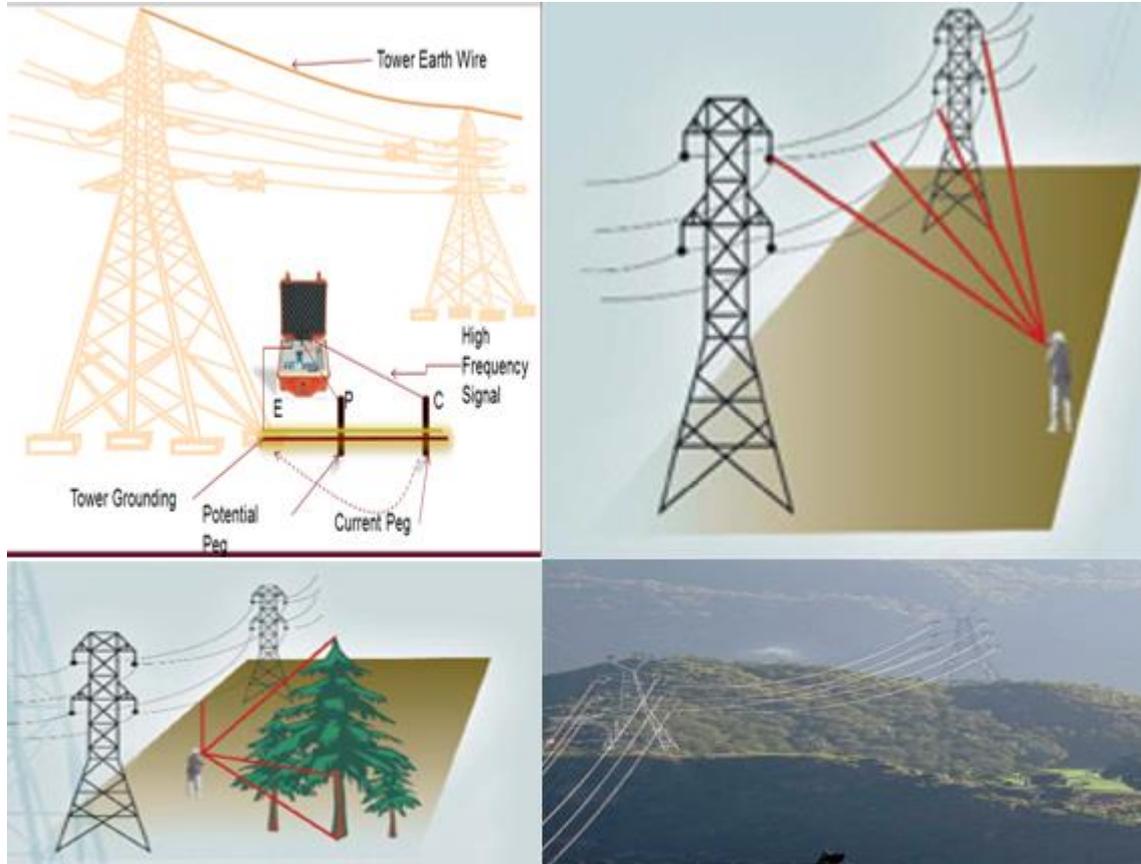


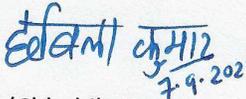
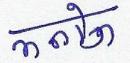
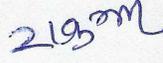
# PRE-COMMISSIONING PROCEDURES FOR TRANSMISSION LINE



CORPORATE ASSET MANAGEMENT  
POWER GRID CORPORATION OF INDIA LTD.

Sep '2021

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## ABBREVIATIONS

AC	Alternating Current
AM	Asset Management
CEA	Central electricity authority
CLR insulator	Composite Long Rod Insulator
CBIP	Central Board of Irrigation and Power
CERC	Central Electricity Regulatory Commission
CTUIL	Central Transmission Utility of India Limited
DC	Direct Current
D/C	Double Circuit
FS type Foundation	Fully submerged type foundation
GS	Ground Switch
IS	Indian standard
ICAO	International Civil aviation organization
MOEF	Ministry of Environment and Forest
M/C	Multi circuit
NTAMC	National Transmission Asset Management System
OPGW	Optical Fiber Ground wire
PTCC	Power and tele-communication coordination committee
ROW	Right of way
RTAMC	Regional Transmission Asset Management System
S/C	Single circuit

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## **1.0 INTRODUCTION**

This document includes overall procedure, safety rules, Statutory Requirements, dispatching procedure, switching sequences, inspection, testing & measurement, observations, acceptance criteria and documentation of test results for pre-commissioning procedures for transmission lines.

Different type of electrical clearances are tabulated as per CEA document (Measures relating to Safety and Electric Supply Regulations, 2010), CBIP manual for Transmission line in 2014, Forest conservation Act, 1980 & forest conservation Rules, 2003 & POWERGRID latest technical specifications for transmission lines. Different values indicated in this document is for reference purpose only; however, if there is any difference between the values indicated in this document & the values in the technical specifications/drawings; the values of technical specifications/drawings will prevail.

The detailed inspection and handing over documents are required to be checked for the entire length of transmission line before energization. Geo-tagged digital Photographs of all tower locations using high-resolution digital camera need to be handed over to taking over team and preserved as part of taking over record.

## **2.0 OVERALL PROCEDURE**

First, it is to be ascertained that the transmission line to be energized is ready for operation and has been properly handed over (released) in writing. This will include all safety aspects, Electrical inspector clearance, PTCC clearance, statutory clearance, regulation/ system operator requirement and final inspection, if any.

Instructions for the work and supervision are given by the test leader (Line in charge). However, regular operators will execute all switching and operational activities.

Line charging instructions received from Engineering department & CTUIL should be clearly understood by the Line in charge and doubts, if any, are to be got clarified prior to the energization of the line.

Once, the line is handed over for charging, no work shall be permitted without a valid work permit.

Engineering department & CTUIL recommendations, system operator/ regulation requirements are to be followed before putting the system into continuous operation.

## **3.0 SAFETY PROCEDURES**

Energization implies an abrupt and serious change of the working conditions in the line.

In order to avoid serious accidents, thorough information must be imparted to all personnel involved in the construction of transmission line. In-charge of the

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Transmission line must ensure that due publicity has been made to the public in all the villages/ areas along the line route cautioning them against climbing the towers etc. and that the line is proposed to be charged on notified date. It is also to be confirmed that all the agencies involved in construction activities shall not carry out any job on the said line without a valid work permit.

It shall be ensured that before charging all men, material, Tools & plants and any temporary earthing on any part of the entire length of line are removed.

It must be ensured that any power supply/ low voltage charging used as “anti-theft measure” must be disconnected and isolated to avoid accidental connection.

All equipment tests and pre-commissioning tests must have been completed, reconnected (in case cables were isolated for testing purpose) and documented as per prescribed format.

The system must be formally declared ready for Energization and handed over for operation in writing.

**4.0 STATUTORY REQUIREMENT**

**4.1** The concerned authorities shall be informed before commissioning the line and their approval shall be obtained in accordance with latest Central Electricity Authority (Measures relating to Safety and Electric Supply) Regulations.

**4.2** Before charging of the line, PTCC approval from concerned authority shall be obtained.

**5.0 INSPECTION**

Before the line is scheduled to be handed over for the pre-commissioning/ Energization, the same shall be inspected by representatives of POWERGRID and Construction Agency. Such inspection shall include:

- i) Right of way/ way leave/ electrical clearance
- ii) Jumper drops
- iii) Foundation and Revetments/ Protection Work
- iv) Tower and Tower accessories
- v) Earthing
- vi) Hardware fittings
- vii) Insulators
- viii) Conductors and Earth wire/OPGW
- ix) Accessories for conductor and Earth wires/OPGW
- x) Aviation Warning Signals (Lights/globules/painting)
- xi) Bird Diverter (if applicable)

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**5.1 RIGHT OF WAY / WAY LEAVE / ELECTRICAL CLEARANCE**

**5.1.1 Right of way/ Way leave clearance**

Maximum width of Right of way of transmission line in forest area and minimum electrical clearances between Conductor & trees shall be as per guidelines/clarifications issued by MOEF & climate changes in 2019 under Forest conservation Act,1980 & forest conservation rules,2003 for laying of transmission lines through forest area.

- (i) As per existing guidelines/clarifications issued by MOEF & climate changes in 2019 / POWERGRID specification, the maximum width of right of way for the transmission lines on forestland shall be as follows:

<b>Transmission Voltage (KV)</b>	<b>Width of Right of Way (in meter)</b>
66	18
132	27
220	35
+/-320 HVDC	44
400 S/C	52
400 D/C	46
765 S/C (Delta)	64
765 S/C (Horizontal)	85
765 D/C	67
+/-500 HVDC	52
+/-800 HVDC	69
1200 S/C	89

- (ii) Minimum electrical clearance between Conductor & Trees considering Maximum sag & swing of Conductor shall be as follows.

<b>Voltage (KV)</b>	<b>Minimum clearance between conductors and trees (in meter)</b>
66	3.4
132	4.0
220	4.6
400	5.5
765	9.0
+/-500 HVDC	7.4
+/-800 HVDC	10.7
1200	13

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**5.1.2 Electrical Clearance**

All statutory electrical clearance of transmission lines w.r.t. ground, building, Structures, Power line crossings, River crossing, Railway & Road crossings etc. as stipulated under latest version of Central Electricity Authority (Measures relating to Safety and Electric Supply) Regulations & POWERGRID specification shall be ensured.

**5.1.2.1 Minimum Ground clearance** shall be as per clause 58.0 of Central Electricity Authority (Measures relating to Safety and Electric Supply) Regulations, 2010 & POWERGRID specification under Sec-I & Sec-III of Vol-II.

The ground profile at the time of commissioning shall be checked with the profile approved at the time of check survey.

Sag in one of the span in each section shall be measured and it should be ensured that sag & tension of the section is in line with specification and sag & tension calculation chart approved by Engg.

Ground clearance of lowest conductors at critical points shall be checked in the field from any of the prevalent method and the values of ground clearance at these critical points including all power line, railway line and road crossings shall be recorded in the prescribed format.

In case of hilly Terrain and for building clearance, the side clearance from conductors and jumpers at critical points shall also be checked and recorded for all phases of conductor/ earth wire/ OPGW towards hill building side.

Transmission voltage (in kV)	66	132	220	± 320 HVDC	400	765	± 500 HVDC	± 800 HVDC	1200
Minimum Ground Clearance (in meter)	5.5	6.1	7.015	8.5	8.84	18	12.5	18	24

**5.1.2.2 Clearance of earth wire/OPGW with Top conductor at mid span to Top conductor**  
Availability of required vertical clearances (as per design & POWERGRID Specification) between conductor and earth wire/OPGW shall be ensured through random checking. Minimum clearances between conductor and earth wire/OPGW at mid-span shall be as indicated below:

Voltage (kV)	66	132	220	+/- 320 HVDC	400	+/- 500 HVDC	765	+/- 800 HVDC	1200
Minimum mid span clearance (in meter)	3	6.1	8.5	8.5	9	9	9	12(pole) 6.1(DMR)	18

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Record of such random checks shall be the part of pre-commissioning records.

**5.1.2.3 Clearance between line crossings each other**, the minimum clearances between the Power line crossing each other shall be as per clause no 69.0, part-III, Sec-4 of CEA's Regulations 2010 (Measures relating to Safety and Electric Supply) and POWERGRID specifications under sec-III, Vol-II

Where an overhead line crosses another overhead line, clearances shall be as under: -  
**(Minimum clearances in meters between AC lines crossing each other)**

Sl. No.	Nominal System Voltage (kV)	11-66	110-132	220	400	765	1200
1.	Low and Medium	2.44	3.05	4.58	5.49	7.94	10.44
2.	11-66	2.44	3.05	4.58	5.49	7.94	10.44
3.	110-132	3.05	3.05	4.58	5.49	7.94	10.44
4.	220	4.58	4.58	4.58	5.49	7.94	10.44
5.	400	5.49	5.49	5.49	5.49	7.94	10.44
6.	765	7.94	7.94	7.94	7.94	7.94	10.44
7.	1200	10.44	10.44	10.44	10.44	10.44	10.44

Where an overhead direct current (DC) line crosses another overhead line, clearances shall be as under: -

**Minimum clearances in meters between AC and DC lines crossing each other**

Sl. No.	System Voltage (AC/DC)	100 kV DC	200 kV DC	300 kV DC	400 kV DC	500 kV DC	600 kV DC	800 kV DC
1	Low and Medium AC	3.05	4.71	5.32	6.04	6.79	7.54	9.04
2	11-66 kV AC	3.05	4.71	5.32	6.04	6.79	7.54	9.04
3	110-132 kV AC	3.05	4.71	5.32	6.04	6.79	7.54	9.04
4	220 kV AC	4.58	4.71	5.32	6.04	6.79	7.54	9.04
5	200 kV DC	4.71	4.71	5.32	6.04	6.79	7.54	9.04
6	300 kV AC	5.32	5.32	5.32	6.04	6.79	7.54	9.04
7	400 kV AC	5.49	5.49	5.49	6.04	6.79	7.54	9.04
8	400 kV DC	6.04	6.04	6.04	6.04	6.79	7.54	9.04
9	500 kV DC	6.79	6.79	6.79	6.79	6.79	7.54	9.04
10	600 kV DC	7.54	7.54	7.54	7.54	7.54	7.54	9.04
11	765 kV AC	7.94	7.94	7.94	7.94	7.94	7.94	9.04
12	800 kV DC	9.04	9.04	9.04	9.04	9.04	9.04	9.04
13	1200 kV AC	10.44	10.44	10.44	10.44	10.44	10.44	10.44

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*Provided that no guarding are required when line of voltage exceeding 33 kV crosses over another line of 250 V and above voltage or a road or a tram subject to the condition that adequate clearances are provided between the lowest conductor of the line of voltage exceeding 33 kV and the top most conductor of the overhead line crossing underneath the line of voltage exceeding 33 kV and the clearances as stipulated in regulation 58 from the topmost surface of the road maintained*

**5.1.2.4 Electrical clearance from railway tracks** shall be as stipulated under Sec-III, Vol-II of Technical Specification of POWERGRID.

**(i) Vertical clearance for OHE (other than high rise OHE):**

Sl. No.	Transmission line voltage level	Minimum clearances from Rail Level
		New Power Line crossing or crossing planned for alteration
1	Above 66 kV & up to 132 kV	15.56 m
2	Above 132 kV & up to 220 kV	16.46 m
3	Above 220 kV & up to 400 kV	18.26 m
4	Above 400 kV & up to 500 kV	19.16 m
5	Above 500 kV & up to 800 kV	21.86 m

**(ii) Vertical clearance for high-rise OHE\*:**

Sl. No.	Transmission line voltage level	Minimum clearances from Rail Level
		New Power Line crossing or crossing planned for alteration
1	Above 66 kV & up to 132 kV	17.56 m
2	Above 132 kV & up to 220 kV	18.46 m
3	Above 220 kV & up to 400 kV	20.26 m
4	Above 400 kV & up to 500 kV	21.16 m
5	Above 500 kV & up to 800 kV	23.86 m

**(iii) Clearance between highest traction conductor & lowest crossing conductor**

Sl. No.	Transmission line voltage level	Minimum clearances from Rail Level
		New Power Line crossing or crossing planned for alteration
1	Above 66 kV & up to 132 kV	3.05
2	Above 132 kV & up to 220 kV	4.58
3	Above 220 kV & up to 400 kV	5.49
4	Above 400 kV & up to 500 kV	7.94
5	Above 500 kV & up to 800 kV	7.94

**\*Applicable only for electrification of routes where double stack container having maximum height of 6809 mm is plying**

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**5.1.2.5 Clearances from buildings of Lines**

Electrical clearances (Horizontal as well as vertical clearances) from building/structures shall be as per clause 61.0 of Central Electricity Authority (Measures relating to Safety and Electric Supply) Regulations, 2010.

- (1) An overhead line shall not cross over an existing building as far as possible and no building shall be constructed under an existing overhead line.
- (2) Where an overhead line of voltage, exceeding 650 V passes above or adjacent to any building or part of a building, it shall have on the basis of maximum sag a **vertical clearance above the highest part of the building** immediately under such line, of not less than clearance mentioned as per below table for respective voltage level

Voltage (kV)	66	132	220	400	765	1200
Minimum clearance (mm)	4000	4600	5500	7300	10600	14500

- (3) **The horizontal clearance** between the nearest conductor and any part of such building shall, on the basis of maximum deflection due to wind pressure, be not less than clearance mentioned as per below table for respective voltage level

Voltage (kV)	66	132	220	400	765	1200
Minimum clearance (mm)	2300	2900	3800	5600	8900	12800

**Note:** Clearance are calculated as per norms specified in clause no 61 of CEA safety regulation 2010

- (4) For High Voltage Direct Current (HVDC) systems, vertical clearance and horizontal clearance, on the basis of maximum deflection due to wind pressure, from buildings shall be maintained as below:

Sl. No	DC Voltage (kV)	Vertical Clearance (in mm)	Horizontal Clearance (in mm)
1.	100 kV	4600	2900
2.	200 kV	5800	4100
3.	300 kV	7000	5300
4.	400 kV	7900	6200
5.	500 kV	9100	7400
6.	600 kV	10300	8600
7.	800 kV	12400	10700

Vertical and horizontal clearances shall be as specified in schedule-X of **CEA safety regulation 2010**

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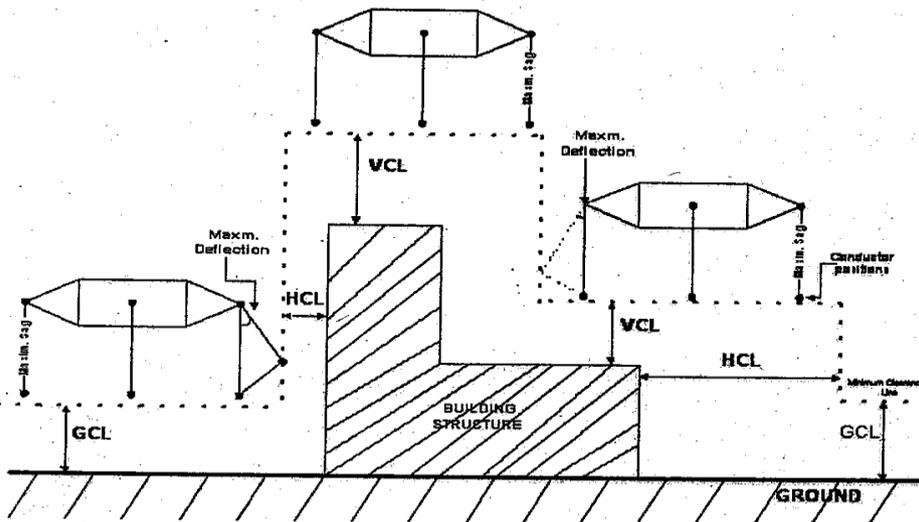
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Explanation: - For the purpose of this regulation the expression “building” shall be deemed to include any structure, whether permanent or temporary.

**Schedule-X**

**Ground, Vertical and Horizontal clearances**  
[See sub-regulation (6) of regulation 58, sub-regulation (5) of regulation (60) and sub-regulation (5) of regulation 61]



GCL: Clearances as per Regulation 59  
VCL: Clearances as per Regulation 60 & 61  
HCL: Clearances as per Regulation 60 & 61

**5.1.2.6 Minimum Clearance in air above ground and across road surface of Highways or roads for lowest conductor of an AC overhead lines, including service lines of nominal system voltage**

As per sub regulation (1) of regulation (58) of CEA draft safety regulation 2021

Nominal system Voltage(in kV)	Clearance above ground			Clearance between conductor & road surface across high way(in meter)
	Across street (in meter)	Along street (in meter)	Elsewhere) (in meter)	
66	6.5	6.1	5.5	11.6 or U/G cable
132	6.5	6.1	6.1	11.6
220	7.02	7.02	7.02	12.52
400	8.84	8.84	8.84	14.0
765	18*	18*	18*	18.8
1200	24*	24*	24*	30

*\*Higher clearance predominantly induction effects and time varying electric field (ICNIRP limit:10 kV/m for occupational exposure) at voltage exceeding 400 kV*

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**5.1.2.7 Minimum Clearance in air above ground and across road surface of Highways or roads for lowest conductor of an DC overhead lines,**

As per sub regulation (1) of regulation (58) of CEA draft safety regulation 2021

Nominal system Voltage (in kV)	Clearance above ground	Clearance between conductor & road surface across high way (in meter)
+/- 500 kV HVDC	12.5	17.25
+/- 800 kV HVDC	18	22.75

*Highway clearance required 4.75 meter higher than ground clearances (considering the vehicle height 4.75 meter as mentioned in the Indian road congress documents, 1983)*

**5.1.2.8 Power line/cable crossing with waterway:**

**Minimum Clearance of Power Conductor over the Highest Flood Level in case of navigable/non navigable rivers** (As per clause no 4.5.1 of CBIP manual on Transmission line, 2014)

**a) AC system**

AC Voltage Level in kV (Nominal voltage)	Minimum Clearance above H.F.L (mm)	
	Navigable River	Non-navigable river
66	19000	3650
110	19000	4300
132	19220	4300
220	20100	5100
400	21900	6400
765	25550	9400
1200	29900	11000

**b) DC system**

DC Voltage in kV	Minimum Clearance above H.F.L (mm)	
	Navigable River	Non-navigable river
+/- 500	24030	6750
+/- 800	27700	11000

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**FOUNDATION AND REVETMENTS/ PROTECTION WORK**

**5.2.1 FOUNDATION:**

There shall not be any damage/ uneven settlement of foundations. For this, tolerances in levels of all four stubs should not exceed the criteria provided in the Annexure - C of IS -5613 (Part -3/Section 2) latest revision.

It is to be ensured that back filling of foundation is properly done. Soil shall be filled over all legs up to ground level.

Extra surface earth after foundation back filling shall be removed from legs of the tower.

Any crack or break in chimney, if found, shall be repaired/rectified with approval of site In-charge.

**5.2.2 REVETMENTS / PROTECTION:**

Cracks/ damages to revetments shall be repaired/ rectified with approval of site In-charge.

Wherever revetments are provided, weep holes shall have slope such as to flush out the deposited water away from tower platform.

In case of hilly terrain, the benching area should be leveled properly. The area around tower shall have proper slope for drainage of rainwater.

**5.3 TOWER AND TOWER ACCESSORIES**

**5.3.1 Normal Tower**

After completion of a transmission line, all the towers shall be thoroughly checked before charging the line. Special attention shall be given to the following points:

Deformed/ Buckled/ Missing/ Rusted Members and Nuts and Bolts

It is to be ensured that no members are bent, deformed or rusted in towers and if so, the same shall be replaced.

If any member is found missing, a new member shall be fixed as per structural drawing of the Tower.

Nuts shall be sufficiently tightened for the required Torque. Minimum 2/ 3 complete threads shall be projected outside the nut. All bolts shall have their nuts facing outside of the tower for Horizontal connection and downwards for Vertical connections.

Bolts shall be punched as per the specification and nuts shall be properly tack welded. It shall be ensured that the circular length of each welding shall be at least 10 mm. Proper zinc rich paint (90% zinc content) shall be applied on welded portion.

It shall be ensured that all tower members are fixed and tightened properly. All extra blank holes on tower members are filled with correct size of nuts & bolts. Geotagged Digital Photographs (from different angles) of such conformance of all towers are to be handed over to taking over team and preserved with taking over

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records.

### **5.3.2 Special Towers**

In addition to the above checks for towers, ladders and platforms provided in special towers shall be properly tightened and no foreign material shall be left out on such platforms.

### **5.3.3 Earthing of Towers**

Ensure that proper earthing (Pipe type earthing in one of tower leg/ Counterpoise Earthing) of tower has been done and earthing strip is neither damaged nor broken and is properly fixed to the stub.

Ensure that Additional earthing is provided on every 7 to 8 kms distance at tension tower for direct earthing of both shield wires (Earth wire/ OPGW).

Ensure that Additional Rod type earthing is provided in one of foundation pit (Diagonally opposite to pipe type earthing) of all the transmission line towers in normal soil (i.e., Dry, Wet cultivated, Wet, PS, FS & Black cotton soil) in addition to pipe type earthing.

In case of counter poise earthing, it is to be ensured that earth wire is sufficiently buried in the ground to avoid digging out during cultivation. The length of counterpoise shall be as per technical specification. The same shall be laid uniformly and stacking/ coiling of counter poise wire is not allowed.

Before charging of the line, ensure that tower footing Impedance at each tower is below 10 ohms. If tower footing impedance of any tower (before stringing) has been recorded higher than 10 ohms, additional counterpoise type earthing/ Chemical earthing shall be provided to bring the tower footing impedance value below 10 ohms.

Earthing of special towers shall be verified as per approved drawings applicable for special towers/ special foundation.

### **5.3.4 Tower accessories**

All danger plates, number plates, circuit plates and phase plates shall be in position as per the specification and properly tightened.

All phase plates shall be fixed in correct phase sequence. Special care may be taken at transposition towers for indicating the correct phase sequence.

It shall be ensured that the anti-climbing device (ACD) is provided at the suitable height of tower. In case of barbed wire type ACD, barbed wire shall be tightly fixed.

It shall be ensured that the step bolts (for normal towers) are provided up to the peak of the tower. Any missing step bolts shall be replaced.

Fixing of bird-guards shall be ensured at all towers to prevent birds perching on suspension insulator strings.

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#### **5.4 HARDWARE FITTINGS**

Tightening of all bolts and nuts are to be checked up to specified torque. Check fixing of all security clips (W/R type clips).

Surface condition of corona control rings should be smooth. Distance/ alignment between tower side arcing horn (wherever applicable) and line side arcing horn/ corona control ring should be as per approved drawings.

Jumpers in the tension tower shall be properly bolted with the tension clamp and form a parabolic shape in order to achieve adequate clearance from steel super structure.

Provision of Suitable counter weight shall be ensured on Pilot string insulator (CLR type) as per approved drawings to restrain swing towards the tower.

Provision of Counter weight shall also be ensured on pilot insulator string (for both disc type/CLR pilot string) in case of transposition tower.

#### **5.5 INSULATORS**

All damaged/ broken porcelain/ glass insulator discs/ composite long rod/ porcelain long rod insulator units shall be replaced.

Unusual deflection in suspension strings, if observed, shall be rectified.

It is to be ensured before charging those insulators are clean. IR value of individual porcelain disc insulators shall be checked on random basis by 5/ 10 kV Insulation Tester and it shall not be less than 2000 Mega Ohm per disc.

#### **5.6 CONDUCTORS & EARTH WIRES/OPGW**

##### **5.6.1 Conductor**

Surface of the conductors shall be free from scratches/rubs.

Ensure that conductor strands are not cut and opened up. Wherever strands are found cut/ damaged/ scratched, they must be repaired with repair sleeves/ repair protective rods in case the no. of damaged strands are within specified limits (normally up to 1/6<sup>th</sup> nos of strands in the outer layer) for lines up to 220 kV and maximum 2 strands in case of 400 kV and higher voltage level.

##### **5.6.2 Earth wire/OPGW**

Ensure that strands of earth wire/OPGW have no cuts.

#### **5.7 ACCESSORIES FOR CONDUCTOR AND EARTH WIRES/OPGW**

##### **5.7.1 Joints**

All joints on conductor/ earth wires shall be away from the tower at a distance of at least 30 meters or as provided in the technical specification (TS).

Ensure that not more than one joint in a sub-conductor is provided in one span.

Ensure that no mid span joint is provided in major crossings like SH/NH/ Expressway, railway crossing, 132 kV & above voltage level power lines and major

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rivers etc. or as per the provision of technical specification.

Ensure that all mid span joints on conductors/ earth wire and repair sleeves of compression type are free from sharp edges, rust and dust. Wherever grease is specified the same shall be applied in the joints.

**5.7.2 Clamping**

Ensure that conductor is not over tightened in the suspension clamps.

**5.7.3 Spacers, vibration dampers and copper bonds**

Placement and number of spacers/ spacer-dampers on the bundle conductors on each phase shall be verified as per spacer/ spacer damper placement chart. Damaged/ missing spacers/ spacer-dampers shall be replaced and loose/ displaced spacers/ spacer-dampers shall be tightened/ relocated.

In case of tension towers, one additional spacer/ spacer damper shall be placed within 10 meters of dead-end clamp.

Spacing of Vibration dampers from the tower and spacing between damper to damper shall be verified as per the damper placement chart. All loose/ displaced VD shall be properly tightened/ relocated and missing VDs shall be provided.

It is to be ensured that no copper/ aluminum bond is loose/ missing.

**5.7.4 Jumpers**

Verify Jumper drop (i.e., distance between cross-arm and null point of jumper) as per drawing. All jumpers shall be checked for proper tightening and missing bolts. In case, jumpers (Conductor/ Earth wire) are found loose, it shall be tightened properly before line charging.

Geotagged Digital Photographs of such conformance for all jumper connections are to be handed over to taking over team and photographs are to be preserved by taking over team for record.

Jumper drop need to be measured for all tension tower locations and to be handed over to RHQ-AM. RHQ-AM will cross check 5% of measurement value on sample basis. If any abnormality is found in readings, additional 5% sample checking to be done. The sample checking process to be repeated till all abnormality related to jumper drop are resolved.

<b>Transmission voltage kV)</b>	<b>66</b>	<b>132</b>	<b>220</b>	<b>400</b>	<b>765</b>	<b>± 500 HVDC</b>	<b>± 800 HVDC</b>
<b>Jumper Drop (In meter)</b>	<b>1.3</b>	1.8	2.4	3.6	6.1	4	7.8(Pole) 2.6(DMR)

**5.7.5 Foreign material**

Ensure that all foreign materials like ropes, dead bird, fallen tree branches; bird nests etc. on conductors, earth wires/OPGW, jumper, insulator string, cross arms are removed.

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**5.7.6 Others**

It shall be ensured that all temporary/ local earthing, guys, T & P (Tools and Plants), foreign material, Pilot rope used in OPGW stringing and other loose material, which were used during stringing/ tower erection, have been removed.

If, there is any change in the ground profile before commissioning of line from the approved profile, the extra earth/ obstruction/ temporary sheds/ any other construction shall be removed.

**5.8 AVIATION WARNING OBSTRUCTION SIGNALS (LIGHTS/ GLOBULES/ PAINTING)**

It shall be ensured that following measures have been taken in the line/ Towers falling within obstruction zone of civil aviation and defense establishments as per IS-5613(latest revision), ICAO Guidelines and POWERGRID specification.

**5.8.1 Day markers**

**5.8.1.1 Structure marking:** The structure portion excluding cross arms above 45-meter height shall be painted in alternate bands of international orange and white color as per IS-5613(latest revision) & ICAO Guidelines.

**5.8.1.2** Line markers may be provided as per the technical specification.

**5.8.2 Night markers**

It shall be ensured that proper aviation lights at the peak level/ at specified heights of towers have been provided along with Solar panels/ Battery banks/ Control cubicles and other accessories as per specification. The functioning of lights with simulation shall be checked/ verified.

**5.9 BIRD DIVERTERS**

Bird diverters shall be placed in identified stretches as per conditions stipulated by forest authority to avoid the chance of collision of birds with transmission line.

**6.0 TESTING AND MEASUREMENT**

**6.1 Tower footing Impedance Measurement**

Tower footing impedance measurement is to be carried out using tower footing impedance tester. The value of impedance should be below 10 ohms. If impedance value is higher than 10 ohms, additional counterpoise type earthing/ chemical earthing shall be provided to bring the tower footing impedance value below 10 ohms. These measurements may preferably be carried out during dry climate.

Tower footing impedance need to be measured for all tower location and the values need to be recorded for future reference and document will be handed over to RHQ-AM. RHQ-AM will carry out impedance measurement at 5% locations on sample basis. Corrective action will be taken if impedance values are higher than 10 ohms.

**6.2** Before commissioning of the lines following tests may be carried out:

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**6.2.1 Conductor Continuity test:**

**6.2.1.1** Objective of this test is to verify that each conductor of the overhead line is properly connected.

A simple method of continuity test is illustrated below. Once the insulation test is completed and the results confirm no short circuit, carryout the following testing using 5kV/ 10 kV Insulation Tester

<b>Sending End</b>	<b>Receiving End</b>	<b>Results (Ohms)</b>
CLOSE R- Ph ground switch OPEN Y- Ph ground switch OPEN B- Ph ground switch	Test IR for R-Ph	Zero/ Low
	Test IR for Y-Ph	High
	Test IR for B-Ph	High
OPEN R- Ph ground switch CLOSE Y- Ph ground switch OPEN B- Ph ground switch	Test IR for R-Ph	High
	Test IR for Y-Ph	Zero/ Low
	Test IR for B-Ph	High
OPEN R- Ph ground switch OPEN Y- Ph ground switch CLOSE B- Ph ground switch	Test IR for R-Ph	High
	Test IR for Y-Ph	High
	Test IR for B-Ph	Zero/ Low

*(All Ground Switch in open condition)*

If the above test results are satisfactory, it confirms the continuity of the line.

**6.2.1.2** The continuity Test of the line with proper phase indication or phase marking can be checked by continuity test as described below:

<b>Sending End</b>	<b>Receiving End IR value in between</b>	<b>Results (Ohms)</b>
Connect R & Y phase. B-phase & all GS open	R & Y Phase	Zero Or Low
	Y & B Phase	High
	B & R Phase	High
Connect R & B phase. Y-phase & all GS open	R & Y Phase	High
	Y & B Phase	High
	B & R Phase	Zero Or Low
Connect Y & B phase R-phase & all GS open	R & Y Phase	High
	Y & B Phase	Zero Or Low
	B & R Phase	High

If the test results are satisfactory, it confirms that marking of the phases are in order.

**6.2.2 Insulation Resistance Test of Line**

This test may be carried out using 5 kV or 10 kV Insulation Tester preferably power driven to ascertain the insulation condition of the line. If, 5 kV Insulation Tester is used for insulation resistance measurement, it shall be ensured that the induced voltage (CVT reading) is less than the instrument withstanding capacity to avoid the possibility of damage of instrument.

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**6.2.3 Transmission Line parameters (Z1, Z0, Zn) measurement**

The Transmission line parameters measurement to be done by Substation commissioning team and the measured line parameters need to be incorporated in the relay setting. This is to improve the accuracy of fault locators and the distance relays.

**6.2.4 Offline Signature Analysis**

Offline signature shall be taken before commissioning to ensure healthiness of transmission line before charging. If any abnormality is found in signature, same need to be analyzed and defects must be attended before line charging. This will be preserved for future reference if any.

**6.2.5 Phase Sequence checking/validation (After energization)**

Once, the line is charged from one end, without closing the Breaker at the other end, the Phase sequence is to be checked from the CVT output using Phase Sequence Meter. If other charged feeders are available, Phase sequence to be RECHECKED by the measurement of secondary voltage of both the Feeders (New line & available charged line).

Let the secondary Voltage of CVT is 110 volts (Phase to Phase) for both the Circuit. In case of correct Phase sequence the voltage reading shall be as follows:

<b>New Circuit</b>	<b>Old Circuit</b>	<b>Voltage (in Volts)</b>
R – Phase	R – Phase	0
R – Phase	Y – Phase	110
R – Phase	B – Phase	110
Y- Phase	R – Phase	110
Y- Phase	Y – Phase	0
Y- Phase	B – Phase	110
B- Phase	R – Phase	110
B- Phase	Y – Phase	110
B- Phase	B – Phase	0

In case the results are not matching the phase sequence is to be re-checked and reconfirmed before closing the breaker.

**7.0 PROTECTIVE SYSTEM**

Before energization, it must be ascertained that all protective systems for the line to be energized are operative.

This includes confirmation that the protections have been properly tested and tests have been documented as per Pre-Commissioning Procedure laid down by the utility for S/S Bay Equipment.

It also includes verification by inspection or otherwise, if necessary, by repetition of

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trip test, that the protections are actually functionally enabled. This verification serves to prevent that energization takes place of a line where a protection has been disabled for test or other reason.

#### **8.0 DISPATCH PROCEDURES**

All operational activities (switching etc.) must be coordinated and communicated with the system dispatcher i.e. NTAMC/ RTAMC/ RLDC/ NLDC. In this respect, the general procedures already established by POWERGRID, Regulator and System Operator will be followed.

#### **9.0 SWITCHING PROCEDURES**

For each activity, the instructions to the operators and the communications to the dispatchers will be made in writing or by confirmed telephone messages. The switching procedures first to be properly documented step by step and understood by everybody involved in the switching operation prior to the energization. Any clarification required in the procedures must be resolved. The format established by the utility for switching orders and operational data logging shall be followed. Each and every activity must be listed and described, so that complete information is available for detailed investigation, if required in future.

#### **10.0 HANDING OVER**

The transmission line shall be inspected prior to Energization and a formal handing over document to be jointly signed by the representative of SUPPLIER (if available), ERECTION AGENCY and POWERGRID. However, all contractual taking over has to be resolved separately as per the terms and conditions of the contract. Handing over shall be limited to the completion of Erection and ready for Energization.

The relevant format No AM/COMM/LINE/1a & AM/COMM/LINE/1b which are in part-B of document for handing over is also a part of documentation

Any outstanding points or remaining activities are to be listed and signed jointly by the representatives of POWERGRID and ERECTION agency as per the Format No: AM/COMM/LINE/2 of part-B of this document. These documents are also to be retained at line office with a copy to regional office. The remaining activities outstanding points are classified in the following category.

Details of the SECTIONS:

- A. List of outstanding activities remaining in any part of the line
- B. A list of temporary arrangements introduced.
- C. Check list of records properly documented, completed and signed as per Format No: AM/COMM/LINE/1 of part-B of this document
- D. Original tracing of Profile, Route Alignment, Tower Design, Structural Drawings, Bill of Materials, Shop Drawings, stringing charts (initial and final as applicable) etc. of all towers/ line submitted to POWERGRID.

After resolving the above-mentioned outstanding activities or with only minor remaining points which do not influence on charging of line, handing over of the

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transmission line shall be accepted by the pre-commissioning team. Handing over of transmission line for Energization with or without remaining activities shall be made by the line in-charge to the commissioning in charge in writing as per the Format No. AM/COMM/LINE/3 of part-B of this document

Shortcomings noticed during inspection, "List of outstanding activities" shall be recorded as per Format No: AM/COMM/LINE/2 of part-B of this document and a copy of the shortcomings noticed is to be given to the responsible parties like SUPPLIER(s) and ERECTION AGENCY etc. for corrective action to be taken on a time bound schedule.

**11.0 ENERGIZATION**

Execution of the energization is simply the last event in the switching sequence, switching of the close control button for the relevant circuit breaker.

**12.0 OBSERVATIONS AND DURATION**

Visual and audible inspection (look and listen) of the associated equipment and reading of permanent instruments will be made.

The system shall be kept charged for the duration prescribed as per CERC regulation. During this time, continuous monitoring and inspection will be maintained in control room, auxiliary systems areas and switchyards.

This will include frequent, scheduled inspection of all equipment and reading of all permanent instruments, recorders and surge arrester counters, especially system parameters as per standard procedures adopted by POWERGRID.

**13 .0 DE-ENERGIZATION**

Instructions about de-energization will be given only if, this is part of the test otherwise de-energization will be considered part of regular operation.

**14.0 ACCEPTANCE CRITERIA**

Neither insulation breakdown nor protective system actions must occur. No irregular equipment behavior noise, vibration, high temperature is permitted.

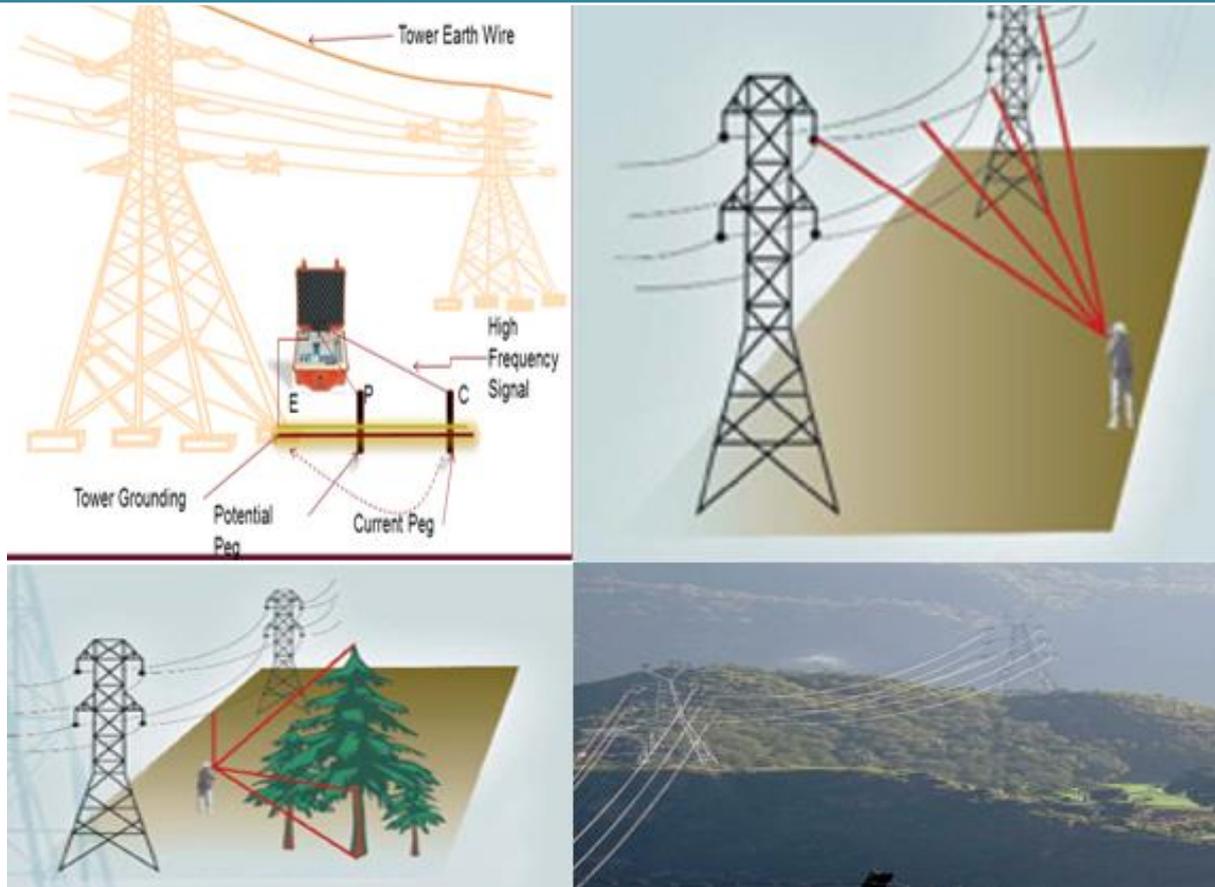
Corona discharges may not be "unreasonable". Local discharges that may be attributable to sharp points, shall be carefully located and recorded. After termination of Energization, the equipment shall be closely inspected and the points rounded or covered.

No unscheduled changes of system or of equipment are permitted during the 8-hour energized condition.

**15.0 DOCUMENTATION**

Switching and operational activities will be recorded in regular manner in the operator's log. Similarly, all readings of permanent instruments are also to be recorded. Copies of this log notes on special observations from inspections and other measurements will constitute the test records.

# PRE-COMMISSIONING FORMATS FOR TRANSMISSION LINE



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**Sep '2021**

**PRE COMMISSIONING FORMATS  
FOR TRANSMISSION LINES**

Earlier Doc. No. D-2-01-70-01-02  
Present Doc. No. D-2-01-70-01-03-part B

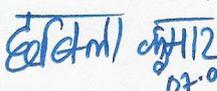
Rev.	Dept.	Date	Signature	Signature
00	CC(OS)	30/11/1995	Sd/-	Sd/-
01	CC(OS)	28/06/2004	Sd/-	Sd/-
02	CC(AM)	15/12/2014	Sd/-	Sd/-
03	CC(AM)	07/09/2021		

**Proposed by**

**Reviewed by**

**Recommended by**

**Approved by**



(Chhabila Kumar  
Sahoo)  
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CM (AM)



(Manoj Kumar  
Singh)  
GM (AM)



(Adish Kumar Gupta)  
CGM (AM)



(A P Gangadharan )  
ED (AM)

Sl. No.	Chapter	Revision	Action
1	All	01	Replace All
2	All	02	Replace All
3	All	03	Replace All

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3	Checklist for inspection at each tower location (FORMAT NO: AM/COMM/LINE/1b)	6
4	Inspection Record Prior to handing over the Line for energization (FORMAT NO: AM/COMM/LINE/2)	17
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6	Commissioning Format (including all electrical test) FORMAT NO: AM/COMM/LINE/4	20

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**ABBREVIATIONS**

AC	Alternating Current
AM	Asset Management
CC	Corporate Centre
CEA	Central electricity authority
CLR insulator	Composite Long Rod Insulator
CTUIL	Central Transmission Utility of India Limited
CVT	Capacitive Voltage Transformer
DC	Direct Current
D/C	Double circuit
FR type Foundation	Fissured rock type foundation
FS type Foundation	Fully submerged type foundation
GS	Ground Switch
HR type Foundation	Hard Rock type foundation
HVDC	High voltage Direct Current
ICT	Inter Connecting Transformer
IS	Indian standard
MOEF	Ministry of Environment and Forest
M/C	Multi circuit
NH	National Highway
NTAMC	National Transmission Asset Management System
OPGW	Optical Fiber Ground wire
PS type Foundation	Partially submerged type foundation
PTCC	Power and tele-communication coordination committee
PTW	Permit to work
ROW	Right of way
S/C	Single circuit
WBC type Foundation	Wet black cotton type foundation

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**Introduction:**

The document consists of 4 formats.

**Format 1:** This format is divided into two parts. Part 1 covers the general information of Line, in part2 details inspection checklist need to be filled against each tower location.

**Format 2:** In this format list of pending works in the line, list of temporary arrangement used during line construction, removal of any antitheft measure used before energization of line will be filled and same will be verified in handing over format (**Format 3**)

**Format 3:** In this format handing over of the records related to statutory clearance documents, **Format -1** and **Format-2** will be done by construction team to the commissioning team and same will be recorded in this format with acceptance of energization of line by the commissioning in charge. The pending work (minor nature type) which will not potentially affect the charging of line will be listed in the format.

**Format 4:** Carrying out Electrical tests before energization of Line and recording of all electrical parameter such as voltage, current, active Power, reactive power, phase sequence etc. after energization of the line need to be done as per this format and record will be kept for future use.

Table for different type of clearances have given before each format for user reference purpose based on the present version of technical specification of POWERGRID.

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**FORMAT NO: AM/COMM/LINE/1a**

Name of line	No of Circuit	Date of Energization

**GENERAL DATA AND INFORMATION (for Line)**

I	Region Name									
II	TL Office Name									
III	Type Of Conductor	Dog	Panther	Zebra	Moose	Snow Bird	AL 59	Bersimis	Lapwing	Others
IV	No of conductors in bundle	Single	Twin	Triple	Quad	Hexa	Octa	Others		
V	Voltage rating(kV)	66	132	220	+/-320	400	+/-500	+/- 800	765	1200
VI	Type of circuit	S/C		D/C		S/C on D/C Tower		M/C		
VII	Length of Line( in kms) <b>for the jurisdiction</b>									
VIII	Total Nos. of Towers <b>(in the jurisdiction)</b>									
a.	Total no of suspension towers									
b.	Total no of tension towers									

**Note:** Every row fields are independent and the verifying officer will tick the field as applicable for each location in other type of conductor HTLS or any other type to be mentioned

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**IX CROSSING DETAILS**

**a) River crossing**

Span(Loc A-Loc B)	River(Name)	Whether River is navigable or not

**b) Railway crossing**

Span(Loc A-Loc B)	Name of Railway line

**c) NH crossing**

Span(Loc A-Loc B)	Name of NH

**d) Power line crossing**

Span (Loc A- Loc B)	Name of Power Line	Voltage rating of line (in kV)

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**FORMAT NO: AM/COMM/LINE/1b**

**GERERAL DATA AND INFORMATION (To be furnished against each Location)**

<b>Tower Location No:</b>												
I	<b>Insulator Type</b>	Porcelain	CLR	Glass	Porcelain Rod	Long	Mixed					
II	<b>Tower type details</b>											
	<b>Tower type (For S/C)</b>	A	B	B1	B2	C	C1	C2	D	D45	D60	
	<b>Tower type (For D/C)</b>	DA	DB	DB1	DB2	DC	DC1	DC2	DD	DD45	DD60	
	<b>Angle of Deviation of Tower</b>	0-2	2-15	2-7	7-15	15-30	15-22	22-30	30-60	30-45	45-60	
	<b>Tower type (For M/C) with angle of deviation</b>	QA (0-2)	QB (2-15)			QC (15-30)			QD (30-60)			
III	<b>Normal Extn. (Meters)</b>	+3		+6		+9		+18		+25		+30
IV	<b>Other Leg/Body Extn. (Meters)</b>	+1.5		+3.0		+4.5		+6.0		+7.5		+9.0
		-1.5		-3.0		-4.5		-6.0				
V	<b>Tower Foundation Type</b>	Dry	Sandy Dry	Wet	Wet cultivated	PS	FS	WBC FR	FR	HR	PILE	
VI	<b>Is the location Vulnerable</b>	Yes					No					

**Note:** Every row fields are independent and the verifying officer will tick the field as applicable for each location

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**VII DETAILED CHECK LIST (To be furnished against locations)**

**Tower location No:**

SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
1	<b>Foundation</b>			
a	Check any damage/ uneven settlement of foundation			
b	Check back filling of foundation is properly filled up to the ground level of all legs			
c	Check surface earth/ concrete after foundation casting is removed from platform of the tower			
d	Check crack or damage to chimney			
e	Check crack or damage to retaining wall/ revetment and proper weep holes are provided for flushing water			
f	Check that all foundation chimneys are covered with soil and compacted specially in hilly terrain and river/ nalas banks up to ground level			
g	Check cliff-in foundation levels are within limit			
h	Check the back to back, diagonal and level of all four stubs (to be measured at stub top level). <b>Refer format-A for filling.</b>			
2	<b>Tower</b>			
a	Check for deformed/ rusted or damaged tower members			
b	Check for missing/hanging/bent tower members			
c	Check for missing bolts & nuts			
d	Check for tightening of all bolts & nuts			
e	Check for any missing joint plates			
f	Check for punching, tack welding (at least 10 mm circular length) and zinc coating of bolts & nuts			
g	Check filling of extra holes in tower members with bolts & nuts			
h	Check verticality of tower			

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SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
i	Check that no tower leg is suspected to be in sinking land or soil erosion field of river bank, if so, proper adequate protection has been provided			
J	Check fixing & visibility of all tower accessories namely danger/ number/ circuit/ phase plate/ step bolts and anti-climbing device (ACD)			
k	Check correct sequence of fixing of phase/ circuit plate at transposition towers			
l	Check that Fixing of bird-guards is done for all suspension towers to prevent birds perching			
m	Geotagged digital photographs (from different angles) of all towers to be taken and preserved.			
3	<b>Removal of T&amp;P and foreign materials</b>			
a	Check temporary Earthing/ Guys used during stringing and jumpering are removed			
b	Check all foreign materials on tower e.g., discharge rod, wire/ropes, kite, bird nests and any other T&P etc. left over on tower/ cross arm are removed			
c	Check that all the insulator discs/ Long rod insulator units are free from any damage			
d	Check for unusual deflection in suspension strings and if found, should be rectified			
e	Check proper aviation warning signals on towers above 45 meter height			
f	Check that red & white paints have been applied on towers which fall in aviation route			
4	<b>Hardware fittings</b>			
a	Check that proper fixing of hardware fittings like corona control ring/ grading ring/ arcing horns/ etc. are provided as per the approved drawing/ specification			
b	Check the condition of cotter pins and ensure that proper size cotter pins have provided as per the approved drawing.			
c	Check that all insulators are thoroughly clean			

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SL NO	DESCRIPTION	STATUS		REMARKS
		YES	NO	Record Deficiencies If Any
5	<b>Conductor and its accessories</b>			
a	Check that the conductors/ sub-conductors are free from scratches/ rubs			
b	Check that all joints on conductor/ earth wire/OPGW are away from the tower as per the specified distance (at least 30 meters) and joints are as per the approved drawings/ specification			
c	Check that not more than one joint in a sub conductor is provided in one span.			
d	Check that no mid span joints or repair sleeves are provided in major crossings for highway, Railway and major rivers.			
e	Check that all mid span joints on conductors/ Earth wire/OPGW and repair sleeves of compression type are free from sharp edges rust and dust			
f	Check that conductor is properly clipped in the suspension clamp			
g	Check that armor rods are provided on suspension towers			
h	Check that spacers/ spacer dampers are provided between sub conductors on each phase as per approved spacer placement chart/ specification			
i	Check that in case of tension towers, one additional spacer/ spacer damper is placed within 10 meter of dead end clamp.			
j	Check that all the spacers/ spacer-dampers are properly tightened and free from any external damage.			
k	Check that spacing of vibration dampers from the tower and spacing between damper to damper where two vibration dampers provided are properly fixed and tightened as per the damper placement chart/ specification			
l	Check that all the jumpers are properly fixed and torque tightened as per the approved drawing/ specification			

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DOCUMENT NAME: PRE-COMMISSIONING FORMATS FOR TRANSMISSION LINES

SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
m	Check that on conductors/ earth wires/OPGW hardware fittings are free from all foreign material like dead bird/ fallen tree/ bird nests etc.			
n	Check that suitable counter weight is provided on Pilot string insulator (CLR type) as per approved drawings			
o	Check that Counter weight is provided for pilot insulator string in case of transposition tower (for both disc type/CLR type string)			
p	Geotagged digital Photographs indicating all jumper bolts are provided and properly tightened for at least 10% jumper connections are taken on random basis and preserved			
6	<b>Different type of Clearances</b>			
a	Check that right of way is not obstructed by any building/hut etc. The vertical clearance and horizontal clearance need to be maintained (if present/applicable) <b>(Refer Table-1 and 2 )</b>			
b	Check that minimum clearance with trees is maintained if Trees are present in the corridor <b>(Refer Table-3)</b>			
c	Check that mid span clearance between top conductor and earth wire/ OPGW is adequate <b>(Refer Table-4)</b>			
d	Check that clearance between lowest conductor and ground is more than the required minimum ground clearance <b>(Refer Table-5)</b>			
e	Check that Jumper drop (i.e. distance between cross-arm and null point of jumper) as per design/drawing. All jumpers shall be checked for proper tightening. <b>(Refer Table-6)</b>			
f	Check that minimum clearance at Power line crossing is maintained. (if applicable) <b>(Refer Table-7)</b>			

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SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
g	Check that minimum clearance at railway track crossing is maintained (if applicable). <b>(Refer Table-8)</b>			
h	Check that minimum clearance at NH crossing is maintained. <b>(Refer Table-9)</b>			
i	Check that minimum clearance at River crossing is maintained (if applicable). <b>(Refer Table-10)</b>			
j	Measure the sag in one of the span in each section and check that sag and tension of the section is in line with specification and sag & tension calculation chart is approved by Engg. <b>Refer Format-B for measurement of Sag</b>			
7	<b>Tower footing impedance</b>			
a	Tower footing impedance needs to be measured at each location and it is to be ensured that impedance value is less than 10 ohms <b>Refer Format-C for measurement of Tower footing impedance</b>			
b	Physically check that earthing is at healthy condition (i.e. not damaged/not loose/not open )			
	10% checking			

**Format-A for checking Back to Back measurement of stub**

	As per drawing	Measured value	Deviation
Leg A-Leg B			
Leg B-Leg C			
Leg C-Leg D			
Leg D-Leg A			
Leg A-Leg C			
Leg B-Leg D			

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**Table-1: Clearance for right of way at different voltage level**

<b>Transmission voltage (kV)</b>	66	132	220	± 320 HVDC	400 (S/C)	400 (D/C)	± 500 HVDC	± 800 HVDC	765(S/C) *(H/D type)	765 (D/C)	1200 (S/C)
<b>ROW width (Meters)</b>	18	27	35	44	52	46	52	69	85/ 64	67	89

\* H-Horizontal configuration  
D-Delta configuration  
Formats for record

Location No	
ROW width (Meters)	

**Table-2: Clearances from buildings of Lines**

**a) Vertical clearance**

<b>Voltage (kV)</b>	66	132	220	400	765	1200
<b>Minimum clearance (mm)</b>	4000	4600	5500	7300	10600	14500

**b) The horizontal clearance**

<b>Voltage (kV)</b>	66	132	220	400	765	1200
<b>Minimum clearance (mm)</b>	2300	2900	3800	5600	8900	12800

**Note:** Clearance are calculated as per norms specified in clause no 61 of CEA safety regulation 2010

**c) Clearance for DC line**

Sl. No	DC Voltage (kV)	Vertical Clearance (in mm)	Horizontal Clearance (in mm)
1.	100 kV	4600	2900
2.	200 kV	5800	4100
3.	300 kV	7000	5300
4.	400 kV	7900	6200
5.	500 kV	9100	7400
6.	600 kV	10300	8600
7.	800 kV	12400	10700

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**Formats for record (if applicable)**

Building /Structure	HCL	VCL
<b>Clearance from building</b>		

Table will be repeated for more than structure present

**Table-3 : Minimum electrical clearance between Conductor & Trees**

<b>Voltage (KV)</b>	<b>Minimum clearance between conductors and trees (in meter)</b>
66	3.4
132	4.0
220	4.6
400	5.5
765	9.0
+/-500 HVDC	7.4
+/-800 HVDC	10.7
1200	13

**Formats for record (if applicable)**

Tree	
<b>Clearance from line</b>	

Table repeated for more than one tree in corridor

**Table-4: Minimum clearance for top conductor and Earth wire at mid-span**

<b>Voltage (kV)</b>	<b>66</b>	<b>132</b>	<b>220</b>	<b>± 320 HVDC</b>	<b>400</b>	<b>765</b>	<b>± 500 HVDC</b>	<b>± 800 HVDC</b>	<b>1200</b>
Minimum mid span clearance (mm)	3000	6100	8500	9000	9000	9000	8500	12000(pole) 6100(DMR)	18000

**Formats for record**

Location	
Mid span Clearance value	

Table will be repeated if more than circuit is present in the line

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**Table-5: Minimum ground clearance for different voltage level**

Transmission voltage kV)	66	132	220	± 320 HVDC	400	765	± 500 HVDC	± 800 HVDC	1200
Minimum Ground Clearance (mm)	5500	6100	7015	8500	8840	18000	12500	18000	24000

**Formats for record**

Location	
Minimum Ground Clearance (mm)	

Table will be repeated if more than circuit is present in the line

**Table-6: Table for Jumper Drop**

Transmission voltage kV)	66	132	220	400	765	± 500 HVDC	± 800 HVDC
Jumper Drop (in meter)	1.3	1.8	2.4	3.6	6.1	4	7.8(pole) 2.6(DMR)

\*values to be confirmed with respective drawings

**Formats for record**

Span (Tower location nos.)	Jumper drop for Circuit-I		
	R	Y	B

Table will be repeated for other circuit too in case of D/C or M/C

**Table 7: Measurement of minimum clearance when line is crossing another Power line**

SI No	Nominal System Voltage ( in kV)	132	220	400	+/- 500 HVDC	765 kV	+/- 800 kV HVDC	1200
1.	132KV	3050	4580	5490	6860	7940	9040	1044
2.	220KV	4580	4580	5490	6860	7940	9040	1044
3.	400KV	5490	5490	5490	6860	7940	9040	1044
4.	+/- 500 kV HVDC	6860	6860	6860	6860	7940	9040	1044
5.	765 kV	7940	7940	7940	7940	7940	9040	1044
6.	+/- 800 kV HVDC	9040	9040	9040	9040	9040	9040	1044

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7.	<b>1200 kV</b>	1044	1044	1044	1044	1044	1044	1044
----	----------------	------	------	------	------	------	------	------

**Formats for record (if applicable)**

Span (Tower location nos.)	Crossing Power line details (Name & voltage)	Clearance (mm)

**Table 8: Measurement of minimum clearance when line is crossing Railway track**

**(i) Vertical clearance for OHE (other than high rise OHE):**

Sl. No.	Transmission line voltage level	Minimum clearances from Rail Level
		New Power Line crossing or crossing planned for alteration
1	Above 66 kV & up to 132 kV	15.56 m
2	Above 132 kV & up to 220 kV	16.46 m
3	Above 220 kV & up to 400 kV	18.26 m
4	Above 400 kV & up to 500 kV	19.16 m
5	Above 500 kV & up to 800 kV	21.86 m

**(ii) Vertical clearance for high rise OHE\*:**

Sl. No.	Transmission line voltage level	Minimum clearances from Rail Level
		New Power Line crossing or crossing planned for alteration
1	Above 66 kV & up to 132 kV	17.56 m
2	Above 132 kV & up to 220 kV	18.46 m
3	Above 220 kV & up to 400 kV	20.26 m
4	Above 400 kV & up to 500 kV	21.16 m
5	Above 500 kV & up to 800 kV	23.86 m

\* Applicable only for electrification of routes where double stack container having maximum height of 6809 mm is plying

**(iii) Minimum Clearances between Highest Traction Conductor & Lowest Crossing conductors**

Sl. No.	Transmission line voltage level	Minimum clearances from Rail Level
		New Power Line crossing or crossing planned for alteration
1	Above 66 kV & up to 132 kV	3.05
2	Above 132 kV & up to 220 kV	4.58
3	Above 220 kV & up to 400 kV	5.49
4	Above 400 kV & up to 500 kV	7.94

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5	Above 500 kV & up to 800 kV	7.94
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Notwithstanding the above, Minimum clearance for railway crossings shall be as per Indian Railway Schedule of dimensions(BG) Revised 2004 as amended from time to time.

**Formats for record (if applicable)**

Span (Tower location nos.)	Railway track details (Name & voltage)	Vertical clearance for OHE	Vertical clearance for high rise OHE	Minimum Clearances between Highest Traction Conductor & Lowest Crossing conductors

Note: Minimum clearance when power line crossing railway track:

**Table-9: Minimum Clearance in air above ground and across road surface of Highways or roads for lowest conductor of overhead lines**

**A) AC system**

Nominal system Voltage(in kV)	Clearance above ground			Clearance between conductor & road surface across high way(in meter)
	Across street (in meter)	Along street (in meter)	Elsewhere) (in meter)	
66	6.5	6.1	5.5	11.6 or U/G cable
132	6.5	6.1	6.1	11.6
220	7.02	7.02	7.02	12.52
400	8.84	8.84	8.84	14.0
765	18*	18*	18*	18.8
1200	24*	24*	24*	30

**B) DC system**

Nominal system Voltage(in kV)	Clearance above ground	Clearance between conductor & road surface across high way(in meter)
+/- 500 kV HVDC	12.5	17.25
+/- 800 kV HVDC	18	22.75

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**Formats for record (if applicable)**

Span (Tower location nos.)	Name of NH	Clearances	
		Clearance above Ground	Clearance between conductor & road surface across high way(in meter)

**Table-10: Minimum Clearance of Power Conductor over the Highest Flood Level in case of navigable/non navigable rivers**

**AC system**

AC Voltage Level in kV (Nominal voltage)	Minimum Clearance above H.F.L (mm)	
	Navigable River	Non-navigable river
66	19000	3650
110	19000	4300
132	19220	4300
220	20100	5100
400	21900	6400
765	25550	9400
1200	29900	11000

**DC system**

DC Voltage in kV	Minimum Clearance above H.F.L (mm)	
	Navigable River	Non-navigable river
+/- 500	24030	6750
+/- 800	27700	11000

**Formats for record (if applicable)**

Span (Tower location nos.)	Name of river (navigable/non- navigable)	Clearances	
		Clearance above Ground	Clearance between conductor & road surface across high way(in meter)

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**Format-B for measurement of sag in one of the span in each section (as applicable)**

Section (Loc A To Loc B)	Span (Loc C To Loc D)	Measured sag(in meter)

**Note:** Measurement to be repeated for each phases and circuits

**Format-C for measurement of Tower footing impedance**

Location No.	Leg No	R( in $\Omega$ )	Rc ( in $\Omega$ )	C (in nF)	L (in $\mu$ H)	Z ( in $\Omega$ )
	Leg-A					
	Leg-B					
	Leg-C					
	Leg-D					

(Note: The value should not be more than 10 ohms)

The above inspection and measurements are carried out in the location mentioned above and the remaining activities, temporary arrangements etc. are documented in format no: **AM/COMM/LINE/2**

	Erection Agency Representative	Supplier Agency Representative	Project Execution (POWERGRID)
<b>Signature</b>			
<b>Date</b>			
<b>Name</b>			
<b>Organization</b>			

**Note:**

- This format is to be filled for each tower location.
- This format is to be kept at group head quarter with a copy to regional head quarter
- This format to be signed not below the level of engineer and important locations like river crossing, railway crossing, National Highway, power line crossing etc. are to be countersigned by minimum Manager for POWERGRID and in-charge of the working agency

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DOCUMENT NO: D-2-01-70-01-03-Part B  
DOCUMENT NAME: PRE-COMMISSIONING FORMATS FOR TRANSMISSION LINES

**FORMAT NO: AM/COMM/LINE/2**

NAME OF LINE	CIRCUIT	DATE OF ENERGISATION

**INSPECTION RECORD PRIOR TO HANDING OVER FOR ENERGIZATION**

**LIST OF REMAINING ACTIVITIES**

**LIST OF TEMPORARY ARRANGEMENTS**

Region:		Location		Observation		Completion		Inspection		
Section A/B/C	Sl. No.	Tower No.	From	To	Date	Sign	Date	Sign	Date	Sign
			Description of remaining activities/ Temporary arrangements							

	Erection Agency representative	Erection (POWERGRID)	Line In-charge (POWERGRID)
Signature			
Date			
Name			
Organization			

**Details of sections is to be furnished in this format:**

- a. Outstanding activities remaining in any part of the line
- b. A list of temporary arrangements introduced.
- c. Checklist records properly completed and signed as per format **AM/COMM/ LINE/ 1**
- d. Original tracing of Profile, Route alignment, Tower Design, Structural Drawings, Bill of material, Shop drawings, Stringing Charts indicating initial and final sag etc. of all towers submitted to POWERGRID.

**Note:** This document is to be retained at Group head S/S or TLM office with a copy RHQ

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DOCUMENT NO: D-2-01-70-01-03-Part B

DOCUMENT NAME: PRE-COMMISSIONING FORMATS FOR TRANSMISSION LINES

**FORMAT NO: AM/COMM/LINE/3**

NAME OF LINE	CIRCUIT	DATE OF ENERGISATION

**HANDING OVER RECORD FOR ENERGIZATION**

**A. GENERAL DATA AND INFORMATION:**

REGION	Office	TYPE OF TOWERS		S/C	D/C	M/C
VOLTAGE RATING	KV	Tower locations	From		To	
Total no. of towers		Total length			Kms.	

**Details:**

SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
1	Check list of entire section of the line along with towers and accessories under this Division have carried out and documented in the format no: <b>AM/COMM/LINE/1</b>			
2	Inspection has been carried out in all towers and the outstanding issues along with temporary arrangements are documented in the format no: <b>AM/COMM/LINE/ 2</b>			
3	No. of remaining activities/ points are listed at <b>clause-B</b> in this format these are minor in nature and do not stop charging the line			
4	All Electrical and Ground clearances are as per the Approved drawings issued from CC/ Engg. Dept have been checked and no deviation has been noted.			
5	All man and material and temporary antitheft electrical connection, if any, have been removed from all the locations under this Division .			
6	All electrical clearance has been received from CEA electrical inspector for charging of the line vide order no: Dated: <b>(copy enclosed)</b>			

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SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
7	PTCC clearance has been received from CEA's PTCC Directorate for charging of the line vide order no: Dated: <b>(copy enclosed)</b>			
8	All statutory rules and regulations pertaining to line charging has been carried out and Nothing is pending			
9	All working agencies involved In construction/ erection of this Line are intimated regarding charging of this line and further work, if any, are to be carried out only after availing the Permit to Work (PTW) from the Concerned sub-station operating staff			

**B. HANDING OVER CHECK POINTS**(Minor nature)

SECTION	Points according to format no: AM/COMM/LINE/1 ( Nos of remaining activities)	Points completed and confirmed		Points accepted	
		Date	Sign	Date	Sign
A					
SECTION	Points according to format no: AM/COMM/LINE/1 ( Nos of remaining activities)	Points completed and confirmed		Points accepted	
		Date	Sign	Date	Sign
B					
C					
D					

The above line is handed over for Energization with/ without remaining activities

	Handed over by	Accepted for Energization
Signature		
Date		
Name		
Designation	Line In-charge	Commissioning In-charge

Note: For details of section, please refer pre commissioning doc no : D-2-01-70-01-02, format no  
**AM/COMM/LINE/ 2**

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DOCUMENT NAME: PRE-COMMISSIONING FORMATS FOR TRANSMISSION LINES

**FORMAT NO: AM/COMM/LINE/4**

NAME OF LINE	CIRCUIT	DATE OF ENERGISATION

**COMMISSIONING FORMAT**

**A. GENERAL DATA AND INFORMATION:**

REGION	Office	TYPE OF TOWERS	S/C	D/C	M/C
VOLTAGE RATING	KV	Tower locations	From	To	
Total no. of towers		Total length		Kms.	

Details:

SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
1	The entire section of the line handed over for energization as per POWERGRID format no: AM/COMM/LINE/3 on Dated:			
2	No. of remaining activities/ points are listed as per format no: AM/COMM/LINE/2 on and these are minor in nature and do not stop charging the line			
3	All the equipments involved in charging of the line are tested and documented as per the pre-commissioning formats of bay equipment			
4	Pre - commissioning tests of bay/ feeder as per approved document has been completed and test results are documented			
5	In case, reactor provided in this line, all tests are carried out as per prescribed format and all test results are documented			
6	All electrical clearance has been received from CEA electrical inspector for charging of the line vide order no: dated: (copy to be enclosed)			

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SL NO	DESCRIPTION	STATUS		REMARKS Record Deficiencies If Any
		YES	NO	
7	All man and material and temporary antitheft electrical connection, if any, removed from all the locations			
8	All electrical clearance has been received from CEA electrical inspector for charging of the line terminating feeder vide order no : dated:			
9	PTCC clearance has been received from CEA's PTCC Directorate for charging of the line vide order no: Dated:			
10	All statutory rules and regulations pertaining to line charging has been carried out and nothing is pending			
11	All working agencies involved in construction/ erection of this line and sub-station Equipments are intimated regarding charging of this line & bay and further work, if any, are to be carried out only after availing the permit to work (PTW) from the concerned sub-station operating staff			
12	All the protections are checked and put into service as per standard format no: and documented			

**B. MEASUREMENT INSULATION RESISTANCE FOR LINE (using 5 kV/ 10 kV motorized Insulation Tester):**

BETWEEN	MEASURED VALUE IN M - OHM	REMARK	CONDITION
R-PHASE & GROUND			All ground switches at other end are opened. Min. value should be approx. 150 Mega ohm (value may change with weather condition)
Y-PHASE & GROUND			
B-PHASE & GROUND			
R-PHASE & Y-PHASE			
Y-PHASE & B-PHASE			
B-PHASE & R-PHASE			

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**C. CONTINUITY TEST OF THE LINE**

**a. For phase marking confirmation**

Sending end Conditions	Receiving end Insulation Resistance between	Measured value In ohms	Remarks
CLOSE R - Phase GS & OPEN Y - Phase GS & OPEN B - Phase GS	R – Phase & Ground		Low
	Y – Phase & Ground		High
	B – Phase & Ground		High
OPEN R - Phase GS CLOSE Y - Phase GS OPEN B - Phase GS:	R – Phase & Ground		High
	Y – Phase & Ground		Low
	B – Phase & Ground		High
OPEN R - Phase GS OPEN Y - Phase GS CLOSE B - Phase GS	R – Phase & Ground		High
	Y – Phase & Ground		High
	B – Phase & Ground		Low
CONNECT R & Y Phase E, all GS open	R & Y-phase		Low
	Y & B-phase		High
	B & R-phase		High
Connect R & B Phase, all GS open	R & Y-phase		High
	Y & B-phase		High
	B & R-phase		Low
Connect Y & B Phase, all GS open	R & Y-phase		High
	Y & B-phase		Low
	B & R-phase		High

Note:

- If the test values are as per the remarks, phase marking at both ends are correct.
- This test is to be done if the IR value do not show short circuit of the line with ground or between phases in IR measurement

**D. Verification/validation of phase sequence**

After closing the breaker from one end only the line can be charged.

- a Check the phase sequence by the phase sequence meter by connecting at the secondary of the CVT

OK	Not OK
----	--------

- b Check the phase sequence by the help of multi-meter in case of a charged sub-station at the secondary of the CVT (old & new) in the control panel as per the

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measurement indicated below:

Sl. No.	Voltage measurement between		Measured voltage (volts)	Remarks
	New circuit	Charged old circuit		
1	R-phase	R-phase		In case of correct phase sequence, the voltage measured between R & R phase, Y & Y phase, B & B phase of old charged line and newly charged circuit will be zero or very small and all other measurements will show full line CVT phase to phase secondary voltage
2	R-phase	Y-phase		
3	R-phase	B-phase		
4	Y-phase	R-phase		
5	Y-phase	Y-phase		
6	Y-phase	B-phase		
7	B-phase	R-phase		
8	B-phase	Y-phase		
9	B-phase	B-phase		

**F CHARGING INSTRUCTION**

Once the correct phase sequence is established, the charging instruction received from CC-Engg. & CTUIL to be followed and properly documented regarding status of various parameters with other lines and generators ( **if any** )

Charging instruction no:

Dated: (Copy enclosed)

i. Charging details:

Date:

Time:

ii Pre-charging conditions for sending end

a. Voltage  kV

b. Generator Details:

Unit No	Capacity	MW Generated	MVAR Generated	Remarks
1				
2				
3				

c. Lines Connected:

Sl. No.	Name of line	MW	MVAR	Line Reactor	
				In service	Capacity
1					
2					
3					

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**d. No. and rating of ICTs connected**

Sl. No.	Rating		MW	Tertiary reactor MVAR
	Voltage	MVA		
1.				
2.				
3.				
4.				

**e. Status of Bus Reactor, if any**

Sl. No.	Rating	Status of charging/Healthiness

**iii On charging condition**

Details	Sending end	Receiving end
Voltage		N/A
MVAR		N/A
Open end voltage	N/A	

**iv Post charging condition**

Details	Sending end	Receiving end
Voltage		
MW		
MVAR		

The line has been/ not has been successfully test charged with or without following operational constraints:

- 1.
- 2.
- 3.

<b>Signature</b>					
<b>Name</b>					
<b>Designation</b>					
<b>Organization</b>				<b>POWERGRID</b>	<b>POWERGRID</b>
<b>Agency</b>	<b>Line Erection</b>	<b>S/S Erection</b>	<b>Line Supplier</b>	<b>Line In-Charge</b>	<b>S/S In-Charge</b>

## Standard Manufacturing Quality Plan

For

### Galvanized Tower Structures/Parts

(MQP no. CC/QA&I/MQP/Standard/Tower Parts Rev 06)

Valid from 16-10-2024 to 15-10-2027

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Instructions for Code Allocation



Code 1	Indicate place where testing is planned to be performed i.e. Inspection location A At Equipment Manufacturer's works (Transmission Line Tower Manufacturer) B At Component Manufacturer's works (Re-Roller/Plate Manufacturer) C At Authorised Distributor's works D At Independent Lab E At Turn Key Contractor's location F Not specified	Code 2	Indicate who has to perform the tests i.e. Testing Agency J The Equipment Manufacturer K The Component Manufacturer L The Third Party M The Turnkey Contractor
Code 3	Indicate who shall witness the tests i.e. Witnessing Agency P Component Manufacturer Q Component Manufacturer and Equipment Manufacturer R Component Manufacturer, Equipment Manufacturer and Contractor S Equipment Manufacturer T Equipment Manufacturer and Contractor U Equipment Manufacturer and/or Contractor and POWERGRID V Third Party	Code 4	Review of Test Reports/Certificates W By Equipment Manufacturer during raw material / bought out component inspection X By Contractor during product / process inspection Y By POWERGRID during product / process inspection Z By Contractor and / or POWERGRID during product / process inspection
Code 5	Whether specific approval of sub-vendor / component make is envisaged? E Envisaged N Not Envisaged	Code 6	Whether test records required to be submitted after final inspection for issuance of CIP/MICC Y Yes N No

**Notes:**

1	The MQP should be read in conjunction with POWERGRID specification and shall deem to include additional tests, if any required as per the contract.
2	POWERGRID specification shall include provisions of letter of Award, POWERGRID approved drawings / Technical Data Sheet / BOM / Test Schedule / Test Procedure applicable to the specific contract.
3	In case of any contradiction between MQP and POWERGRID Technical specification/Approved Drawing, the Technical specifications/Approved Drawing of respective project shall have precedence over this MQP.
4	It is the responsibility of the manufacturer to ensure that this document is readily available at their works as well as at the works of their sub vendors in order to avoid any delay at the time of inspection.
5	For the steel sections procured from approved re-rollers of POWERGRID the POWERGRID approved SMQP for re-roller shall be adhered to.
6	All bought out components /fasteners to be procured from POWERGRID approved manufacturers as per their standard/respective manufacturing quality plan approved by POWERGRID/relevant IS and CIP clearance to be obtained.
7	Valid calibration certificates of various testing and measuring instrument / equipments from Labs, accredited as per ISO/IEC -17025 which operates in accordance with the requirements of ISO/IEC 17011 having full membership & MRA of ILAC/APLAC, shall be maintained.
8	In case of any test being carried out at the third party lab, the same should be accredited as per ISO/IEC -17025 which operates in accordance with the requirements of ISO/IEC 17011 having full membership & MRA of ILAC/APLAC
9	The manufacturer shall maintain the proper co-relation of test certificates from raw material stage to finished product stage and the records should be available during inspection by POWERGRID. In absence of proper correlation of test certificates of Raw Material, actual testing to be done during Final Inspection.
10	The manufacturer should progressively align their Quality system and sub-vendors Quality system to the requirements of ISO 9000 series Quality standards and in due course of time should get their quality system certified to ISO 9001.
11	All bent pieces shall be checked at the process of bending by a bend gauge made as per bend ratio/degree shown in the sketch of the item / mark no. On the stand, one piece is thoroughly checked with bend gauge and all other pieces are checked by comparison method and pieces are cleared for further process. If the holes are to be made near the bend line, the same shall be done after bending.
12	The sample pieces consumed in a testing shall be replenished by the manufacturer at the time of dispatch. If the offered material meets the quality requirements, CIP/MICC shall be issued for total quantity offered without deducting the weight of materials consumed in testing.
13	Grades of steel used as well as the relevant standards it is conforming to, shall be as per the approved Drawings/ BOM for the specific contract and the same shall be indicated in the offer list at the time of inspection.
14	Steel plates below 6mm size used for packing plates/packing washers, produced as per IS: 1079 (Grade-0) are also acceptable. However, if below 6mm size plate are used as load bearing plates viz gusset plates, joint splices etc. the same shall conform to IS : 2062 or equivalent standard. Flats of equivalent grade meeting mechanical strength/ metallurgical properties may also be used in place of plates for packing plates/ packing washers.
15	Dispatch of the inspected Tower Structures shall be done with each tower/ panel wise bundling in order to ensure availability of complete Tower parts without missing of any member at site.
16	Pieces of light sections to be wire bundled and those of heavy sections to be supplied loose. Stacking to have proper ventilation and kept inclined. Damage to galvanization coating to be avoided while handling. The manufacturer to ensure sequential supplies and other details as per POWERGRID Technical Specification
17	In case Tower parts are to be used at sub zero temperature, Impact testing at -20° C shall be carried out during final inspection in line with IS/ POWERGRID TS.

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18	Welding procedure and Welder's performance qualification shall be done in line with approved Guideline (attached herewith), in case welding is involved at any stage of fabrication/erection.	
19	All Welding procedures, qualification of welders, operators and procedures, electrodes, preheat, notch toughness and minimum yield of the electrodes needs to be ensured in conformance with the requirements of the latest revision of American Welding Society Structural Welding Code (ANSI/AWS D1.1) or other equivalent National/International standards. Preheating shall be done according to the ANSI/AWS code or the steel producers' recommendations or both.	
20	All relevant standards shall be read along with the latest amendments.	
21	POWERGRID may review the effective implementation of the process during the product inspection/process inspection. In case of any violation in process or process parameters are observed, the reason along with corrective & preventive measure shall be conveyed to POWERGRID.	
22	Any addition /change in new vendor/design/process shall be submitted for review by POWERGRID and necessary change in MQP may be requested, if necessary.	
23	If any activity (for which manufacturer is already approved) is being outsourced due to some exigencies/ unforeseen circumstances, then prior approval from POWERGRID needs to be taken.	
24	If the manufacturer does not have facility for any process, then the same shall be carried out at POWERGRID approved sources/as per the prior approval of POWERGRID. All the tests/checks against this outsourced process shall remain the same as indicated against respective process and the applicable codes shall be A/B, J/K, S/P,W/Z, -,N.	
25	Inspection of angle sections at black stage for galvanised tower structures/parts, irrespective of specific contract can be followed as detailed hereunder:	
25.1	The manufacturer may raise inspection call for angle section at black stage at re-roller's work against any one of the ongoing Contract.	
25.2	The manufacturer may fabricate the raw material, cleared under CAT –A CIP for a particular contractor, for any of its POWERGRID projects under execution.	
25.3	The manufacturer will maintain a separate register indicating splitting and swapping of material between different projects awarded to same contractor, which can be reviewed by POWERGRID inspection engineer. Separate register for each Contractor is to be maintained if the manufacturer is executing jobs for different contractor.	
25.4	The manufacturer as a contractor on whom POWERGRID has placed the contract, shall be allowed to split and swap material in black stage only, amongst its different ongoing contracts with POWERGRID, without any obligation to POWERGRID.	
25.5	The final inspection after fabrication and galvanizing, however, will continue to be contract wise and CIPs will be issued for each contract only.	
26	In case of any failure of samples during mechanical or chemical testing, retesting shall be carried out to nullify any possibility of error during sample preparation or testing. While selecting samples for retesting, one sample shall be taken from the very same section of Tower structure from which the original test sample was taken and another sample shall be selected from any other member (section of same size) in the offered lot. The lot of this particular section size shall be considered acceptable only if both the samples selected for retesting are conforming to acceptance parameters against the test performed. Else, following action shall also be taken .	
a)	<b>For Individual Calls:</b> Any sample(s) out of the selected samples (as per sampling plan) fails in mechanical or chemical testing.	Material corresponding to the failed section(s) shall be <b>rejected</b> . Further, samples of the section(s), from which samples were not selected earlier for testing, shall also be taken for testing.
b)	<b>Combined Calls</b> Any sample(s) out of selected samples for testing (after calls combination) fails in mechanical or chemical testing.	Material corresponding to the failed section(s) against all the inspection calls combined shall be <b>rejected</b> . Further, samples of the section(s), from which samples were not selected earlier for testing, shall also be taken for testing.
27	The manufacturer shall strip off galvanizing of rejected material before re-galvanizing in case the rejection is due to galvanizing defects.	
28	The manufacturer shall dispose off entire section rejected in physical testing by gas cutting or by machine cutting from any end of rejected mark number.	
29	Combined sampling shall be carried out based on the request of contractor/ sub-vendor ( TLT manufacturer), an undertaking/ letter (format attached) in this regard shall be taken from the contractor / sub-vendor (TLT Manufacturer).	


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SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes						Remarks
							1	2	3	4	5	6	
1	<b>RAW MATERIAL</b>												
1.1	<b>STRUCTURAL STEEL (ANGLE SECTIONS, PLATES)</b>												
1.1.1	Steel Plates and Angle sections shall be procured from POWERGRID approved Sources. For angle sections procured from approved re-rollers, specific manufacturer approval of POWERGRID for size and Grade of Angle sections shall be ensured along with CIP against every lot at re-roller's works. The acceptance norms shall be as per relevant standards indicated in TS/approved drawing/BOM. However, if different grade is mentioned in the Technical Specifications/approved drawings, acceptance norms shall be as per the relevant standards.												
1.1.2	<b>Mechanical Properties</b>												
1.1.2.1	Yield Stress	Mechanical	Plant Standard of Transmission Line Tower Structure Manufacturer	IS: 2062/Relevant Standard as mentioned in POWERGRID TS	IS: 2062/Relevant Standard as mentioned in POWERGRID TS	Plant Record	A	J	S	W/Z		Y	
1.1.2.2	Ultimate Tensile Strength	Mechanical				Plant Record	A	J	S	W/Z		Y	
1.1.2.3	Percentage Elongation at 5.65√Area	Mechanical				Plant Record	A	J	S	W/Z		Y	
1.1.2.4	Bend Test	Mechanical				Plant Record	A	J	S	W/Z		Y	
1.1.2.5	Impact Test (if applicable)	Mechanical				Plant Record/Third Party Lab	A/D	J/L	S/N	W/Z		Y	
1.1.3	<b>Chemical properties</b>												
1.1.3.1	Chemical Analysis	Chemical	Plant Standard of Transmission Line Tower Structure Manufacturer	As per Chemistry enclosed at Annexure-I for each source/Relevant standards indicated in POWERGRID TS	As per Chemistry enclosed at Annexure-I for each source/Relevant standards indicated in POWERGRID TS	Plant Record/Third Party Lab	A/D	J/L	S/N	W/Z		Y	
1.1.4	<b>Visual Inspection</b>												
1.1.4.1	Visual	Visual	Plant Standard of Transmission Line Tower Structure Manufacturer	Relevant Standard as mentioned in POWERGRID TS	Material to be free from surface defects like laminations, rough/jagged and imperfect edges, cracks, rounded apex, deep roll marks, pipy and any harmful defects	Plant Record	A	J	S	W/Z		Y	

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SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes						Remarks
1.1.5	<b>Dimensional Inspection</b>												
1.1.5.1	<b>Angle Sections</b>												
1.1.5.1.1	Tolerances For Leg Length of Angles Equal / Un Equal	Measurement	Plant Standard of Transmission Line Tower Manufacturer	IS 1852/ IS 808/ POWERGRID Spec	As per relevant IS standards	Plant Record	A	J	S	W/Z		Y	
1.1.5.1.2	Out of Square ness	Measurement		IS 1852/ POWERGRID Spec		Plant Record	A	J	S	W/Z		Y	
1.1.5.1.3	Camber	Measurement		IS 1852/ POWERGRID Spec		Plant Record	A	J	S	W/Z		Y	
1.1.5.1.4	Root radius	Measurement		IS 808		Plant Record	A	J	S	W/Z		Y	
1.1.5.1.5	Weight Tolerance For Angle Sections	Unit Weight Test		IS 1852/ IS 808		Plant Record	A	J	S	W/Z		Y	
1.1.5.2	<b>Plates</b>												
1.1.5.2.1	Weight Tolerances	Unit Weight Test	Plant Standard of Transmission Line Tower Manufacturer	IS 1852 / IS 1730	As per relevant IS standards	Plant Record	A	J	S	W/Z		Y	
1.1.5.2.2	Thickness Tolerance	Measurement		IS 2062 / IS 1730 / IS 1852		Plant Record	A	J	S	W/Z		Y	
1.2	<b>Zinc (To be procured from POWERGRID approved sources or Imported LME registered source)</b>												
1.2.1	Chemical Composition	Chemical	Every Consignment	IS 209/IS 13229	IS 209/IS 13229	Zinc Manufacturer TC	B	K	P	W		N	
			One sample for 100MT or Part thereof	IS 209/IS 13229	IS 209/IS 13229	TPL Reports	D	L	V	W		N	
			One sample of molten zinc taken from bath per quarter	IS 209/IS 13229	Min Zinc purity 98.5%	TPL Reports	D	L	V	W		N	


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SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes										
								Remarks									
2	<b>IN-PROCESS INSPECTION</b>																
2.1	<b>Fabrication of Tower Parts</b>																
2.1.1	Cropping (Cutting)	Dimensional	1 <sup>st</sup> Piece and every 50th Piece		Length Tolerance : $\pm 2$ mm, The cut surface to be clean, reasonable square & free from distortion.	Plant Record	A	J	S	Z						N	
2.1.2	Stamping	Visual	1 <sup>st</sup> Piece and every 50th Piece		Letter size as per POWERGRID Tech. Specn. / TPL norms	Plant Record	A	J	S	Z						N	
2.1.3	Punching / Drilling	Dimensional	1 <sup>st</sup> Piece and every 50th Piece		Holes for bolts shall be drilled or punched with a jig but drilled holes shall be preferred. The punching may be adopted for thickness up to 12 mm. Tolerances regarding punch holes should be as follows:	Plant Record	A	J	S	Z						N	
2.1.4	Edge Security	Dimensional	1 <sup>st</sup> Piece and every 50th Piece	IS 802 Part II/ IS 7215/ POWERGRID approved Drwg., Shop Sketches		Plant Record	A	J	S	Z						N	
2.1.4.1	For 13.5 mm dia Hole				Sheared 20mm Min. Rolloed 16mm Min.												
2.1.4.2	For 17.5 mm dia Hole				Sheared 23mm Min. Rolloed 20mm Min.												
2.1.4.3	For 21.5 mm dia Hole				Sheared 28mm Min. Rolloed 25mm Min.												
2.1.4.4	For 25 mm & 25.5 mm dia Hole				As per approved drawing												
2.1.5	Drilling & Punching Hole To Hole Distance		1 <sup>st</sup> Piece and every 50th Piece		Tolerance cumulative and between consecutive hole shall be within $\pm 2$ mm and $\pm 1$ mm respectively	Plant Record	A	J	S	Z						N	
2.1.6	Notching Flange Cut Corner Cut Bevel Cut		1 <sup>st</sup> Piece and every 50th Piece		+ 5mm on specified length of cut, operationally shearing up to 12 mm thick & by gas cutting for material above 12 mm thick	Plant Record	A	J	S	Z						N	

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							A	J	S	Z		N	
2.1.7	Heel Cutting	Dimensional	1 <sup>st</sup> Piece and every 50th Piece	POWERGRID Approved Drwgs./ Shop Sketches	for members > 12mm thick - gas cutting may be adopted followed By grinding/Machine cutting; Tolerance on heel cutting length: +10mm	Plant Record	A	J	S	Z		N	
2.1.8	Bending		100% Pieces	IS 802( Part II)/ IS 7215/ POWERGRID Approved Drawing / Shop Sketches	(1) HT Sections / Plates - All Sections & all plates to be hot bent.  (2) MS Section- i) Cold – Section upto 75X75X6 - Angle Upto 10° ii) Cold – Section upto 100X100X8 – Angle Upto 5° iii) Hot - Section above 75X75X6 – Angle Above 10° iv) Hot - Section above 100X100X8 – Angle Above 5°	Plant Record	A	J	S	Z		N	
2.1.9	Welding												
2.1.9.1	(a) WPS Approval (Welding procedure specification) (b) PQR/WQR Approval (Procedure /Welder qualification record)			As per POWERGRID Technical specn./approved Drg./POWERGRID approved Welding procedure & Welder's qualification		Plant Record	A	J	S	Y		N	WPS and Welder's qualification shall be done in line with Welder's Qualification Guideline
2.1.9.2	Dye-Penetration Test	Visual	Random Basis	As per POWERGRID Technical specn./approved Drg./POWERGRID approved Welding procedure & Welder's qualification		Plant Record	A	J	U	Y		N	CIP
2.1.9.3	Dimensional & visual for welded tower parts	Dimensional	Random Basis	As per POWERGRID Technical specn./approved Drg./POWERGRID approved Welding procedure & Welder's qualification		Plant Record	A	J	U	Y		N	CIP
2.1.10	Final Inspection of Fabricated Parts		Random Basis	All parameters from 2.1.1 to 2.1.13 above are checked and record maintained before releasing the material for galvanizing.		Plant Record	A	J	S	Z		N	



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							A	J	S	Z		N	
2.1.11	<b>Foundation Bolts</b>	Physical	1st piece & every 50th piece	IS 802/POWERGRID Technical spec./Approved drawing		Plant Record	A	J	S	Z		N	
2.1.11.1	Cutting & Shearing												
2.1.11.2	Chamfering												
2.1.11.3	Threading												
<b>2.2</b>	<b>Galvanizing</b>												
2.2.1	Degreasing	Chemical	One sample daily	IS 2629	Manufacturer's plant standard/Relevant IS	Plant Record	A	J	S	Z		N	
2.2.2	Pickling	Chemical	One sample daily	IS 2629	Manufacturer's plant standard/Relevant IS Iron contents 100 to 120 gram/litre. Max	Plant Record	A	J	S	Z		N	
2.2.3	Rinsing	Chemical	One sample daily	IS 2629	Manufacturer's plant standard/IS	Plant Record	A	J	S	Z		N	
2.2.4	Pre Fluxing	Chemical	One sample daily	IS 2629	IS 2629	Plant Record	A	J	S	Z		N	
2.2.5	Pre-heating	Measurement	One Check per day	IS 2629	IS 2629	Plant Record	A	J	S	Z		N	
2.2.6	Dipping After drying is over the material is dipped in molten zinc. Following parameters are controlled												
2.2.6.1	Zinc bath temperature Recording is done by graphical manner or sensors with digital display		Hourly Check	IS 2629	450+/-10° C	Plant Record	A	J	S	Z		N	
2.2.6.2	Immersion & Withdrawal time. Degree of immersion and withdrawal time is decided based on thickness and length of material		Hourly Check	IS 2629	IS 2629	Plant Record	A	J	S	Z		N	


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							A	J	S	Z		N	
2.2.7	Quenching in Running Water: After dipping the material is quenched in running water			IS 2629	IS 2629	Plant Record	A	J	S	Z		N	
2.2.8	Dichromating : After quenching, material is dipped in sodium dichromatic solution to avoid the white rust.(Proprietary Chemicals.)		One Sample daily	IS 2629	IS 2629	Plant Record	A	J	S	Z		N	
<b>2.3</b>	<b>Galvanizing Check</b>												
2.3.1	Visual Checking	Visual	100%	IS 2629	Surface to be free from defects like bare / black spots, (except when small and suitable for patching) heavy ash & flux inclusions, lumps, pimples, runs etc	Plant Record	A	J	S	Z		N	*For marine mentioned in BPS, Coating Thickness shall be $\geq 5\text{mm}=127$ micron, $<5\text{mm}$ & plate= $87$ micron *For marine, $\geq 5\text{mm}=900\text{gm/ m}^2$ , $<5\text{mm}$ & plate= $610$ gm/ $\text{m}^2$
2.3.2	Thickness of Zinc coating	Measurement	8 samples/shift	IS 4759	The minimum average zinc coating for all section shall be 87 microns for thickness $\geq 5$ mm & 65 microns for thickness $< 5\text{mm}$ and for plates	Plant Record	A	J	S	Z		N	
2.3.3	Weight of Zinc Coating	Measurement	3 samples/shift	IS 4759 / IS 6745	(a) For thickness below 5mm, but not less then 2 mm and for plates- Average Mass of Coating - $460\text{gm/m}^2$ (b) For thickness 5mm & above – Average Mass of Coating - $610$ gm/ $\text{m}^2$	Plant Record	A	J	S	Z		N	
2.3.4	Uniformity of Zinc coating	Measurement	3 samples/shift	IS 2633	Material to withstand 4 dips of one minute each without showing signs of copper deposits	Plant Record	A	J	S	Z		N	
2.3.5	Adhesion Tests of Zinc coating	Pivoted Hammer Test	3 samples/shift	IS 2629	No removal or lifting of coating in areas between hammer impressions	Plant Record	A	J	S	Z		N	


  
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							A	J	U	Z		Y	
<b>3</b>	<b>FINAL INSPECTION AND TESTING (Inspection Engineer to ensure/check compliance of Notes/general requirements mentioned in this MQP)</b>												
3.1	Visual and Dimensional Inspection: For Fabrication (as per approved Drawing) & Galvanizing	Visual & Measurement	a. For Angles/Plates etc. which have been procured with CIP (in line with MQP): Total nos. of samples shall be calculated (A) based on One sample/50	Please refer Sr. No 2.1.1 to 2.1.9 /POWERGRID approved drawing	Please refer Sr. No 2.1.1 to 2.1.9 /POWERGRID approved drawing	Test Report	A	J	U	Z		Y	CIP
3.2	Mechanical Properties		MT/Section/Source (Re-roller/Manufacturer). <b>Only 25% of "A" shall be randomly selected for testing.</b>										
3.2.1	Yield Stress Test	Mechanical	b. For Angles/Plates etc. which have been procured without CIP (in line with MQP) Total nos. of samples shall be calculated (B1) & (B2) based on One sample/50 MT/ Section / Source (Re-roller/ Manufacturer) for MS (B1) and HT (B2) items respectively and following sampling plan for inspection shall be adhered:	Please Refer (for test values) Sr. No. 1.2.1 to 1.2.5	Please Refer (for test values) Sr. No. 1.2.1 to 1.2.5	Test Report	A	J	U	Z		Y	
3.2.2	Ultimate Tensile Strength	Mechanical	<b>MS Items: 25% of B1</b> <b>HT Items: 50% of B2</b>				A	J	U	Z		Y	
3.2.3	Percentage Elongation at $5.65\sqrt{\text{Area}}$	Mechanical	c. Sampling plan for testing for new vendors (initially for a period of one year and subsequently as indicated in their MQP approval extension letter) and in cases, where material has been procured from traders (after approval from POWERGRID):				A	J	U	Z		Y	
3.2.4	Bend Test	Mechanical	One sample for				A	J	U	Z		Y	
3.2.5	Impact Test (if applicable)	Mechanical	Every 50 MT/ section/Lot or part thereof for each source (re-roller/manufacturer)				A/D	J/L	U/V	Z		Y	
3.3	Chemical Properties	Chemical	100% samples selected for testing as per above sampling plan	IS: 2062/Grade as mentioned in POWERGRID TS	IS: 2062/Grade as mentioned in POWERGRID TS	Test Report/ Third party Lab report	A/D	J/L	U/S	Z		Y	CIP


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 SMQP FOR Transmission Line Tower

SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes						Remarks
							A	J	U	Z		Y	
3.4	Galvanizing Tests												
3.4.1	Thickness of Zinc Coating (Galvanizing coating check by Elcometer)	Chemical	100% samples selected for testing as per above sampling plan	IS 2629/IS 4759/IS 6745/IS 2633/	Please refer SI. No. 2.3	Test Report	A	J	U	Z		Y	CIP
3.4.2	Weight of Zinc Coating	Chemical											
3.4.3	Uniformity of Zinc Coating	Chemical											
3.4.4	Adhesion Test of Zinc Coating	Chemical											
3.5	<b>For Foundation Bolt</b>												
3.5.1	Dimensional test	Measurement	Sampling as per IS 1367/2500	POWERGRID Drawing	POWERGRID Drawing	Test Report	A	J	U	Z		Y	CIP
3.5.2	Mechanical Test UTS, Yield & Elongation	Mechanical	2 samples lot	As per IS 2062/SAE 1018	As per IS 2062/SAE 1018	Test Report	A	J	U	Z		Y	
3.5.3	Chemical Test	Spectro Analysis	2 samples lot	As per IS 2062/SAE 1018	Chemistry needs to be comparable with raw material supplier TC	Test Report	A	J	U	Z		Y	
3.5.4	Impact Test (if applicable)	Mechanical	One sample per section per lot for each source	IS 2062 Grade E250, POWERGRID Tech. Specn.	IS 2062 Grade E250, POWERGRID Tech. Specn.	Test Report	A/D	J/L	U/V	Z		Y	
3.6	Packing, Storing, Bundling and Handling		100%		IS802/POWERGRID specn./Packing list to be submitted along with dispatch documents	Manufacturer's Log Book/Format No							Tower wise bundling shall be carried out. Pieces of lighter sections shall be wire bundled and heavy sections shall be supplied loose. Stacking shall have proper ventilation and be kept inclined. Damage to galvanization coating shall be avoided while handling. Sequential supplies and other details as per POWERGRID technical specification shall be ensured.


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SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes	Remarks
<b>ANNEXURE-I</b> Agreed Chemical Composition of Billets / Blooms for POWERGRID Projects								
<b>Rashtriya Ispat Nigam Ltd (RINL):</b>			<b>SAIL (IISCO)</b>			<b>SAIL (BSP)</b>		
Grade	C18HMn-For HT (E350) with V	C18HMn-For HT (E350) with Ti	C20 MMn-For MS (E250)	SAIL Tower Grade VI For HT (E350)	C20 MMn-For MS (E250)	SAIL Tower Grade VI For HT (E350)	C20 MMn-For MS (E250)	
C	0.15-0.20	0.15-0.20	0.17-0.23	0.15-0.22	0.16-0.25	0.15-0.22	0.16-0.25	
Mn	1.1-1.4	1.1-1.4	0.6-0.1	1.15-1.6	0.6-1.05	1.25-1.6 /	0.6-1.05	
Si	0.1-0.35	0.1-0.35	0.1-0.35	0.10-0.35	0.15-0.30	0.15-0.30	0.1 (Max)	
P (Max)	0.04	0.04	0.04	0.045	0.047	0.047	0.047	
S (Max)	0.04	0.04	0.04	0.045	0.047	0.047	0.047	
Cr (Max)	0.08	0.08	0.08	0.1	0.2	0.2	0.2	
Ni (Max)	0.03	0.03	0.03	0.05	0.05	0.05	0.05	
Cu (Max)	0.03	0.03	0.03	0.07	0.1	0.1	0.1	
Mo (Max)	0.005	0.005	0.005	0.05	0.05	0.05	0.05	
V (Min)	0.03			0.025	As per test certificate	0.025 / 0.03*	As per test certificate	
V (Max)	0.08	0.01	0.01					
Nb (Min)				0.015		0.015		
Nb (Max)								
Ti (Min)		0.028						
Ti (Max)	0.01	0.05	0.01					
Al (min)	0.015 for SMS -1 Heats			0.015				
Al (max)	0.04 for SMS -2 Heats							
CE (Min)			0.28		0.28	0.36	0.28	
CE (Max)	0.45	0.45	0.42	0.45	0.42	0.45	0.42	
S+P (Max)				0.09	0.09	0.09	0.09	
N (Max)								
B (Max)	0.004	0.004	0.004	0.005	0.005	0.005	0.005	
Sn (Max)								
Remarks	Variation in Min/Max Limit: C=0.02, Mn=0.03, P=0.005, S=0.005			Si - Traces - 0.35 for Al killed Steel, V=0.025 Min or Nb=0.015 (if added alone), V+Nb+Ti = 0.25 Max, Al=0.015 for Al Killed heats.		Mn 1.25 -1.60 for blooms size 350x150mm; V=0.025 Min for Billets and Blooms up to 150 mm and 0.03 for Blooms of 160 mm and above; Nb=0.015 (if added alone), Al=0.015 for Al Killed heats.		

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SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes	Remarks
	<b>SAIL (DSP)</b>		<b>Electrosteel Steels Ltd</b>		<b>Jindal Steel &amp; Power Ltd (Raigarh &amp; Angul)</b>			
<b>Grade</b>	SAIL Tower Grade VI For HT (E350)	C20 MMn-For MS (E250)	C18HMn-For HT (E350)	C20 MMn-For MS (E250)	C18 HMn-HT (E350)	C20 MMn-For MS (E250)	C18 MMn-For MS (E250)	
<b>C</b>	0.15-0.22	0.16-0.25	0.15-0.22	0.17-0.25	0.15-0.20	0.17-0.23	0.15-0.21	
<b>Mn</b>	1.25-1.6 /	0.6-1.05	1.20-1.50	0.6-1.00	1.20-1.50	0.60-1.00	0.60-1.00	
<b>Si</b>	0.15-0.30	0.15-0.30	0.10-0.35	0.10-0.35	0.15-0.30	0.10-0.40	0.10-0.40	
<b>P (Max)</b>	0.047	0.047	0.045	0.045	0.03	0.04	0.04	
<b>S (Max)</b>	0.047	0.047	0.045	0.045	0.03	0.04	0.04	
<b>Cr (Max)</b>	0.2	0.2	0.08	0.08	0.07	0.07	0.07	
<b>Ni (Max)</b>	0.05	0.05	0.03	0.03	0.07	0.07	0.07	
<b>Cu (Max)</b>	0.1	0.1	0.03	0.03	0.1	0.1	0.1	
<b>Mo (Max)</b>	0.05	0.05	0.005	0.005	0.07	0.07	0.07	
<b>V (Min)</b>	0.025 / 0.03*	As per test certificate	0.03		0.03			
<b>V (Max)</b>			0.06	0.005				
<b>Nb (Min)</b>	0.015				0.015			
<b>Nb (Max)</b>								
<b>Ti (Min)</b>								
<b>Ti (Max)</b>								
<b>Al (min)</b>					0.015	0.01	0.01	
<b>Al (max)</b>								
<b>CE (Min)</b>	0.36*/0.38	0.28	0.36	0.28				
<b>CE (Max)</b>	0.45	0.42	0.45	0.42	0.45	0.42	0.42	
<b>S+P (Max)</b>	0.09	0.09						
<b>N (Max)</b>								
<b>B (Max)</b>	0.005	0.005	0.004	0.004				
<b>Sn (Max)</b>								
<b>Remarks</b>	* 0.36 for 125x125 mm Billets Mn 1.25 -1.60 for blooms size 350x150mm; V=0.025 Min for Billets and Blooms up to 150 mm and 0.03 for Blooms of 160 mm and above; Nb=0.015 (if added alone), Al=0.015 for Al Killed heats.			Variation in Min Limit: C=0.02, Mn=0.03, P=0.005, S=0.005, Nb when added alone V+Nb+Ti<=0.25				

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SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes	
								Remarks
<b>JSW Steel Ltd</b>				<b>Jayaswal Neco Industries Ltd</b>				
Grade	C18 HMn-HT (E350)	C20 MMn-For MS (E250)	C18 MMn-For MS (E250)	C18 /C20 HMn- HT (E350)	C18 MMn MS (E250)	C20 MMn- MS (E250)		
C	0.15-0.21	0.17-0.23	0.15-0.21	0.15-0.20	0.15-0.20	0.17-0.23		
Mn	1.20-1.50	0.60-1.00	0.60-1.00	1.2-1.50	0.6-1.00	0.6-1.00		
Si	0.10-0.35	0.10-0.35	0.10-0.35	0.15-0.35	0.15-0.35	0.15-0.35		
P (Max)	0.04	0.04	0.04	0.035	0.035	0.035		
S (Max)	0.03	0.04	0.04	0.035	0.035	0.035		
Cr (Max)	0.07	0.07	0.07	0.05	0.05	0.05		
Ni (Max)	0.07	0.07	0.07	0.05	0.05	0.05		
Cu (Max)	0.1	0.1	0.1	0.1	0.1	0.1		
Mo (Max)	0.07	0.07	0.07	0.05	0.05	0.05		
V (Min)	0.025			0.03				
V (Max)								
Nb (Min)	0.015*							
Nb (Max)								
Ti (Min)								
Ti (Max)								
Al (min)	0.015	0.01	0.01	0.015	0.01	0.01		
Al (max)	0.06			0.035	0.035	0.035		
CE (Min)				0.38				
CE (Max)	0.45	0.42	0.42	0.42	0.41	0.41		
S+P (Max)								
N (Max)								
B (Max)								
Sn (Max)				0.1	0.1	0.1		
Remarks	Total Microalloying (Ti+Nb+V) <= 0.20 * Nb=0.015 (Min) if added alone			Variation in Min/Max Limit: C=0.02, Mn=0.05				


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SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes	
								Remarks
			<b>Tata Steel, Kalinganagar (For Plates)</b>		<b>Electrotherm India Pvt Ltd</b>			
<b>Grade</b>	C18 HMn- HT (E350)		C18MMn-For MS (E250)	C18 HMn-HT (E350)	C20 MMn-For MS (E250)	C18 MMn-For MS (E250)		
<b>C</b>	0.12-0.18		0.15-0.20	0.15-0.21	0.17-0.23	0.15-0.21		
<b>Mn</b>	1.05-1.45		0.6-1.0	1.20-1.50	0.60-1.00	0.60-1.00		
<b>Si</b>	0.14-0.25		0.15-0.30	0.10-0.35	0.10-0.35	0.10-0.35		
<b>P (Max)</b>	0.030		0.035	0.04	0.04	0.04		
<b>S (Max)</b>	0.020		0.035	0.04	0.04	0.04		
<b>Cr (Max)</b>	0.1		0.05	0.1	0.1	0.1		
<b>Ni (Max)</b>	0.1		0.05	0.07	0.07	0.07		
<b>Cu (Max)</b>	0.1		0.05	0.1	0.07	0.07		
<b>Mo (Max)</b>	0.1		0.05	0.07				
<b>V (Min)</b>				0.025				
<b>V (Max)</b>				0.05				
<b>Nb (Min)</b>				0.015				
<b>Nb (Max)</b>	0.15							
<b>Ti (Min)</b>								
<b>Ti (Max)</b>	0.1		0.01					
<b>Al (min)</b>	0.02			0.015	0.02	0.02		
<b>Al (max)</b>			0.025					
<b>CE (Min)</b>								
<b>CE (Max)</b>	0.45		0.39	0.47	0.42	0.42		
<b>S+P (Max)</b>								
<b>N (Max)</b>	0.012							
<b>B (Max)</b>	0.0005							
<b>Sn (Max)</b>								
<b>Remarks</b>	Total Microalloying (Ti+Nb+V) = 0.025 (Min) and 0.25 (Max)			Nb = 0.015 Min if added alone Ti+Nb+V <= 0.20				

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**BAKSHI** BAKSHI

SI No.	Components/Operations & Description of Test	Type of check	Quantum of check/ Sampling with basis	Reference document for testing	Acceptance norms	Form of record	Applicable Codes	
								Remarks
<b>Bhushan Steel Ltd</b>								
Grade	C18 HMn-HT (E350)	C20 MMn-For MS (E250)						
C	0.15-0.21	0.17-0.23						
Mn	1.20-1.60	0.60-1.00						
Si	0.35	0.35						
P (Max)	0.04	0.04						
S (Max)	0.04	0.04						
Cr (Max)	0.12	0.12						
Ni (Max)								
Cu (Max)								
Mo (Max)	0.07							
V (Min)	0.03							
V (Max)								
Nb (Min)								
Nb (Max)								
Ti (Min)								
Ti (Max)								
Al (min)	0.01	0.01						
Al (max)								
CE (Min)								
CE (Max)	0.45	0.42						
S+P (Max)								
N (Max)								
B (Max)								
Sn (Max)								
Remarks	Ti+Nb+V <= 0.20							

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BAKSHI

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BAKSHI

Request Letter

On Official Letter Head

To

RIO Incharge, -----

POWERGRID

Sir,

We (Name of the Manufacturer)..... are offering material for inspection vide following Inspection Call nos:

1. ....,
2. ....
3. ....
4. ....
5. ....

As the material is of the same design and specification, We want to offer this material for inspection in single lot. We understand that in case of failure of any section(s) , the material corresponding to the failed section(s) in all the above-mentioned inspection calls shall be rejected.

Thanking you.

Yours sincerely,

(Seal & Signature of the Quality In-charge)

**ROHITAV**  
**BAKSHI**

Digitally  
signed by  
**ROHITAV**  
**BAKSHI**



## Guidelines for welder/brazer Qualification by POWERGRID

Revised guidelines for welder/ brazer qualification /certification are as follows:

1. The welder/brazer shall be qualified as per provision in ASME Section-IX/ AWS D1.1.
2. The manufacturer shall engage a certified third-party agency for WPS and witness the welding process in line with the approved WPS (Welding Procedure Specification) for qualification of welder.
3. The third-party agency must be a Type-A inspection body accredited as per ISO/IEC 17020:2012 from an IAF member body which is signatory to their Multilateral Recognition Arrangement (MLA) for the certification bodies as a requirement and having scope of accreditation-IAF scope 17 (i.e. as per ASME section IX & AWS D1.1).
4. As per Clause QW-322 of ASME Sec-IX:2019, the performance qualification of the welder shall remain valid, provided that not more than 6 months have passed since the qualified welding process was last used. Hence, the manufacturer shall re-validate their qualification at every two years interval, as per the existing practice followed by POWERGRID.
5. The validity of the welders approved by POWERGRID shall remain valid and existing POWERGRID certified welders will continue to be considered approved. After expiry of their approval or for new welder qualification, the certification shall be done by certified third party agency as per above mentioned procedure.
6. POWERGRID QA&I dept shall review the welder certification during product and process inspection.
7. POWERGRID reserves the right to carry out welder qualification as per earlier practice as and when required (i.e. *Welding brazing procedure is approved by POWERGRID and Welders/ Brazers are qualified based on witnessing of welding/ brazing work by POWERGRID representative*)

The above guidelines shall be implemented with immediate effect.

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ANURAG  
KRISHAN  
ARORA

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by ANURAG  
KRISHAN  
ARORA

# **SECTION-IVE**

## **EMPLOYER DESIGN FOUNDATIONS**

**(Applicable for Transmission Lines  
wherein Foundation Design is in  
Employer's scope)**

TECHNICAL SPECIFICATIONS

SECTION-IV E

EMPLOYER DESIGN FOUNDATIONS

Revision History

Revision No.	Date	Clause Ref	Description
Rev-0	June'2021		First Release
Rev-1	Sept'2021		First Revision
Rev-2	Jan'2022		Second Revision
Rev-3	Oct'2022		Third Revision
Rev-4	Mar'2023		Fourth Revision
Rev-5	Dec'2023		Fifth Revision
Rev-6	Jan'2025		Sixth Revision
Rev-7	May'2025		Seventh Revision

TECHNICAL SPECIFICATIONS

SECTION-IV E

EMPLOYER DESIGN FOUNDATIONS

CONTENTS

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1.2	Type of Foundations	1
1.3	Classifications of Foundations	1
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1.5	Soil Investigation	4
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1.7	Construction of Tower Foundation, Stub Setting and Earthing	6
1.8	Unit Rates and Measurement for Foundation	8
1.9	Setting of Stubs	9
1.10	Mixing, Placing and Compacting of Concrete	10
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1.12	Backfilling and Removal of Stub Templates	12
1.13	Benching	13
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## TECHNICAL SPECIFICATIONS

### SECTION- IV E

#### EMPLOYER DESIGN FOUNDATIONS

##### 1.1 Foundations

Foundation includes supply of all labour, tools & machineries, materials such as cement, sand, coarse aggregates and reinforcement steel and all associated activities, such as, excavation, concreting and back filling etc.

##### 1.2 Type of Foundations

The foundation shall generally be of open cast type. Plain Cement Concrete/ Reinforced Cement Concrete footing shall be used for all type of normal towers. All the four footings of the tower and their extensions shall be similar for a particular location, except where soil condition and or water table are different at different legs. The total depth of foundation, below ground level shall be upto 3.5 meters. Further for dry type of foundation, total depth shall be upto 4.0m depending on economy and feasibility of construction at site with compatible stub. For Hard Rock type and also where specific site conditions/ properties demand foundation of different depths (lower or higher), the same shall be adopted. Minimum reinforcement as 0.12% of cross section area shall be provided in raft/ block of hard rock foundation. The raft/ block shall also satisfy the design criteria as per IS 456.

For tower type DN/DDN/QDN as mentioned in clause section 1.2.2 IVA)/special river crossing/Anchor tower, maximum depth of foundation shall be up to 5.0 meters from ground level (while taking proper safety precaution during excavation in line with IS 3764) depending on economy and feasibility of construction at site with compatible stub.

##### 1.3 Classifications of Foundations:

The foundation designs shall depend upon the type of soil, sub soil water level and the presence of surface water which have been classified as follows (except pile foundations which is described in relevant section of this specification).

##### 1.3.1 Normal Dry

To be used for locations where normal dry cohesive or non-cohesive soils are met. Foundations in areas where surface water encountered from rain runoff shall also be classified as normal dry.

##### 1.3.2 Sandy Dry Soil

To be used for locations where cohesion less pure sand or sand with clay content less than 10% met in dry condition. If the clay content is more than 10% met in dry condition, the foundation shall be classified as Normal Dry.

**1.3.3 Wet**

To be used for locations where sub-soil water table is met between 1.5 meters from ground level and the depth of foundation below the ground level.

**1.3.4 Wet Cultivated**

To be used for locations where there is no sub-soil water within the foundation depth but which are in surface water for long period with water penetration not exceeding one meter below the ground level e.g. paddy fields/ cultivated field. However, if water penetration due to surface water is more than one meter below ground level, the adoption of suitable foundation shall be decided by site-in-charge in consultation with Corporate engineering Department

**1.3.5 Partially Submerged**

To be used at locations where sub-soil water table is met between 0.75 meter and 1.5 meter below the ground level.

**1.3.6 Fully Submerged**

To be used at locations where sub-soil water table is met at less than 0.75 meter below the ground level.

**1.3.7 Black Cotton Soil**

To be used at locations where soil is clay type, not necessarily black in colour, which shrinks when dry and swells when wet, resulting in differential movement. For designing foundations, for such locations, the soil is considered submerged in nature.

**1.3.8 Fissured Rock**

To be used at locations where decomposed or fissured rock, hard gravel, kankar, limestone, laterite or any other soil of similar nature is met. Under cut type foundation is to be used for fissured rock locations.

In case of fissured rock locations, where water table is met at 1.5M or more below ground level, wet fissured rock foundations shall be adopted. Where fissured rock is encountered with subsoil water table less than 1.5 meter below ground level,

submerged fissured rock foundations shall be adopted. In case of dry locations dry fissured rock foundations shall be adopted.

#### 1.3.9 **Hard Rock**

The locations where chiseling, drilling and blasting is required for excavation for monolithic rock for a particular leg/ tower, Hard rock type foundations are to be used. For these locations rock anchoring is to be provided to resist uplift forces.

1.3.10 The sub-soil water table is not constant and its level changes during different seasons due to various factors. In case during soil investigation/ trial pit or during excavation, if wet soil/ fissures rock is encountered within the foundation depth, it is to be considered that water table has been encountered (considering that water table had reached that level sometime in past) and accordingly type of foundation shall be classified.

1.3.11 Where soil is of composite in nature, classification of foundation shall be according to the type of soil predominant in the foundation pit.

1.3.12 The foundation classification at any particular location shall be based on the type of soil (clay/ sandy/ silt/ fissured rock etc.) and water table, presence of surface water, etc. at the location. However, in case of locations which are in vicinity of rivers, depending upon case to case, type of foundation is to be decided considering other aspects also e.g. in case RL (reduced level) of a location in comparison to the HFL is lower and there is possibility of submergence at the time of floods due to absence of river bunds/ protection etc., FS type foundation with suitable raised chimney is to be adopted. Further in case there is a possibility of change in river course, considering the nature and turbulence of probable water flow and subsequent scouring of soil, pile type or special foundation may be considered for these locations.

### 1.4 **Design of Foundations**

1.4.1 Design of foundations as classified under *Clause 1.3* for all towers and towers with extensions shall be developed by the Employer based on the standard soil properties. The indicative shape of foundation is also enclosed in this specification.

1.4.2 In case of normal foundation, minimum clearance between chimney concrete level and ground level shall be 225 mm. Based on specific site condition to avoid rusting of stubs, foundation with 500 mm clearance between concrete level and ground level may be used on case to case basis as may decide by Site-In-charge.

1.4.3 Depending on the site conditions other types of foundations shall also be designed and provided by the Employer suitable for Intermediate conditions under the

above classifications to affect more economy or to suit specific site conditions encountered.

The proposal for these types of foundations shall be submitted by the Contractor based on the detailed soil investigation and duly recommended by Engineer-in-charge.

1.4.4 The construction drawings/ working drawings of all type of foundations classified as in **Clause 1.3** shall be provided to the contractor progressively during execution stage. The drawings for other foundations designed for specific site conditions shall be provided based on actual site requirements only.

1.4.5 The special foundations like pile foundations and combined raft foundation if required shall also be designed by the Employer based on detailed soil investigation report. The working drawing of these foundations shall be provided by the Employer to the Contractor during execution stage based on requirements. For detailed specification for pile foundations relevant section of this specification shall apply.

1.4.6 The provisional quantities of excavation, concreting and reinforcement steel required for the project are furnished in the BPS.

## 1.5 Soil Investigation

The Contractor may be required to undertake soil investigation as per clause 4.0 of Section-III at some tower locations as required by the Employer. The bearing capacity of soil is to be derived from both shear and settlement criteria. The total permissible settlement of soil may be considered as 50 mm in case of suspension towers and 40 mm in case of tension towers for determining bearing capacity of soil from settlement criteria. The provisional numbers of soil testing locations are furnished in BPS. However, contractor shall take reference to the soil investigations wherever already carried out by the Employer.

## 1.6 Properties of Concrete

### 1.6.1 For open cast type foundation

The cement concrete used for the foundations shall generally be of grade M20 having 1:1.5:3 nominal volumetric mix ratio with 20 mm coarse aggregate graded downward for chimney portion and pyramid or slab portion. All the properties of concrete regarding its strength under compression, tension, shear, punching and bending etc. as well as workmanship will conform to IS 456.

Weigh batching in place of volumetric batching (1:1.5:3) as an alternative may be adopted. Further, use of self loaders viz Ajax Fiori / small portable weigh batcher may be permitted for batching and mixing of concrete, subjected to compliance of following: -

(i) Weight of cement, sand and aggregate equivalent to that of nominal mix of proportion 1:1.5:3 by volume basis shall be calculated. For finalisation of weight,

average of 5 samples of cement, sand and aggregates shall be taken from measurement boxes. The volumetric conversions to the weight shall be noted and the same conversion shall be applied to the entire location.

- (ii) For every change in source of sand/ aggregates, the weights shall be recorded.
- (iii) The minimum cement content shall remain same i.e. 400 kg/m<sup>3</sup>.
- (iv) Calibration certificate of self-loader/concrete producing equipment shall be checked before start of concreting works. The accuracy of the measuring equipment shall be within +/- 2% of the quantity of cement and within +/-3% of the quantity of aggregate.
- (v) Preferably, print out of each load indicating weight of all the constituent's material i.e. Cement, Fine Aggregate, Coarse Aggregate, Water, Admixture (if any) is to be ensured or proper records shall be maintained to ensure weight of constituents materials.
- (vi) Necessary modification in weight of fine aggregate due to bulkage may be taken care in weigh batching. Water cement ratio due to moisture content shall be suitably adjusted.
- (vii) Concreting using RMC (Ready Mix Concrete) may also be carried out with weight ratio to be calculated as per S.No. (i) above.

1.6.2.1 The Quantity of minimum cement to be used per unit quantity of consumption for different mix (nominal mix) of concrete should be as follows:

Sl. No.	Description	Unit	Quantity of Minimum cement to be used per Unit quantity of work (in kg)
1.	1:1.5:3 nominal mix concrete	cum	400
2.	1:2:4 nominal mix concrete	cum	320
3.	1:3:6 nominal mix concrete	cum	220
4.	Random Rubble Masonry with 1:6 cement mortar	cum	83

In this regard utilisation record is to be maintained at site.

1.6.2.2 Alternatively, ready-mix concrete from batching plant as per IS 4925 can also be used with no extra payment and without any recovery. However, cement content shall be as per IS 456, unless otherwise specified herein. The ready-mix concrete shall conform to IS 4926. The selection and use of Materials for the ready-mix concrete shall be in accordance with IS 456. The concrete shall be of M25 grade design mix as per IS 456. The transport of concrete and transportation time shall be as per IS 4926.

1.6.2.3 Ready-mix concrete of M25 grade design mix as per IS 456, shall be used for foundations of railway crossing locations.

1.6.2.4 Use of small batching machines/ self-loading mixers may be allowed after verification of cement consumption and mix by Employer site-in-charge. The equipment shall have facility of checking the proportion of ingredients of concrete being made. The records of mix shall be maintained at site. The calibration of equipment shall be done at regular intervals.

1.6.2.5 Ready mix concrete of M25 grade shall be designed as per IS 456. However, minimum cement content shall not be less than 330 kg/m<sup>3</sup>.

1.6.3 Cement used shall be ordinary Portland Cement, unless mentioned otherwise, conforming to the latest Indian Standard Code IS 269.

Alternatively, other varieties of cement other than ordinary Portland Cement such as Portland Pozzolana Cement conforming to IS 1489 (latest edition) or Portland Slag Cement conforming to IS 455 (Latest edition) can also be used. The Contractor shall submit the manufacturer's certificate, for each consignment of cement procured, to the Employer. However, Employer reserves the right to direct the Contractor to conduct tests for each batch/ lot of cement used by the Contractor and Contractor will conduct those tests free of cost at the laboratory so directed by the Employer. The Contractor shall also have no claim towards suspension of work due to time taken in conducting tests in the laboratory. Changing of brand or type of cement within the same structure shall not be permitted without the prior approval of the Employer. Sulphate Resistant Cement shall be used if Sulphate content is more than the limits specified in IS 456, as per Geotechnical investigation report.

Ordinary Portland Cement (OPC) and Portland Pozzolana Cement (PPC) or Portland Slag Cement are Technically Equivalent and there would not be any financial implication/ or recovery to be borne by Employer/ Contractor. However, the minimum cement content shall be as per above table for nominal mix concrete.

1.6.4 Coarse and fine aggregates shall conform to IS 383.

1.6.5 The water used for mixing concrete shall be fresh, clean and free from oil, acids & alkalis, organic materials or other deleterious substances.

1.6.6 Reinforcement shall conform to IS 1786 for high strength steel bars (Fe 500/ Fe500D/ Fe 550 / Fe 550D). If mentioned in BPS, epoxy coated reinforcement conforming to IS 13620 shall be used. Thermo Mechanically Treated (TMT) bars (equivalent grade) in place of cold twisted bars are also accepted. Hard drawn steel wire shall conform to IS 432. All reinforcement shall be clean and free from loose mill scales, dust, loose rust and coats of paint, oil or other coatings, which may destroy or reduce bond. Contractor shall supply, fabricate and place reinforcement to shapes and dimensions as indicated or as required to carry out the intent of approved foundation drawings and Specifications. The contractor

may also use pre-fabricated/ assembled reinforcement cage conforming to shape, dimension, size as per approved foundation drawing. Spacers, chairs, stays, hangers, overlaps/couplers, and annealed steel wire for binding etc. as may be necessary, should be used for proper completion of the foundation job as per requirement. Spacers or chairs should be placed at a maximum spacing of 1m and closer spacing shall be provided wherever necessary.

1.6.7 Use of crushed stone in place of natural sand, in case of non-availability or restriction by local authority, may be allowed by Employer site-in-charge subject to sieve analysis meeting acceptance criteria as per relevant IS and complying of other requirement as per standard field quality plan.

1.6.8 For foundation in coastal areas or creek or aggressive soil areas or under marine environment, if mentioned in BPS, Ready Mix Concrete of M30 Grade shall be used to avoid use of locally available saline water. However, design mix concrete of M30 Grade conforming to IS 456 with potable water can be used at locations where transportation of ready-mix concrete is not feasible. Minimum cement content in any case shall not be less than 330kg/m<sup>3</sup>. Plain concrete/lean concrete shall of grade M20 nominal mix 1:1.5:3. The surface of the reinforcement steel shall be treated with epoxy-based coating to enhance corrosion performance of foundation. Use of epoxy coated reinforcement in foundation shall be as per IS 13620. In addition, 02 (two) numbers of coats of bituminous painting of minimum 5 sq. m/litre per coat shall be applied on all the exposed faces of the foundation (i.e. pedestal & base slab). Double coat of total 20 mm thick cement plaster shall be provided on all exposed concrete surface as well upto 300 mm below ground level to give protection to concrete surface from environmental and saline effect. Before coping of chimney top portion, three coats of anti-corrosive paint of minimum 30-35 microns dry film thickness each shall be applied on the stub in the 50 mm coping portion as well as upto 350mm above CL portion. Cost of the above shall be deemed to be included in the unit rate of M30 concrete.

Corrosion resistant steel (CRS) of grade Fe500 / Fe 500D / Fe 550 / Fe 550D conforming to IS 1786 may be adopted as an alternative to epoxy coated reinforcement for foundation in coastal areas or creek or aggressive soil areas or under marine environment.

In case of foundation in coastal areas or creek or aggressive soil areas or under marine environment, Portland Pozzolana Cement (PPC) or Portland Slag Cement shall be used .

## **1.7 Construction of Tower Foundation, Stub Setting and Earthing**

### **1.7.1 Excavation**

- 1.7.1.1 The excavation work for foundations shall be taken up by the contractor progressively stretch wise/ section wise after obtaining approval from Employer for the proposed stretch wise/ section wise tower schedule, profile etc. as per detailed survey along the approved route alignment.
- 1.7.1.2 Except as specifically otherwise provided, all excavation for footings shall be made to the lines and grades of the foundations. The excavation wall shall be vertical and the pit dimensions shall be based on an assumed clearance of 150 mm on all sides of the foundation pad. For footings with undercut, care shall be taken to carry out excavation as per drawing without any side clearance. For Fissured rock foundations, undercut as shown in the drawing is required and shall be provided accordingly. In cases where undercutting portion is excavated beyond stipulated dimension, the extended undercut portion shall be filled with additional concrete and reinforcement shall be extended into the undercut portion considering margin for concrete cover. However, payment of concrete & reinforcement shall be limited to design volumes of excavation, concrete, reinforcement etc. All excavation shall be protected so as to maintain a clean sub grade and provide worker safety until the footing is placed, wherever the soil is loose or collapsible or in case of water in excavated pit, using timbering, shoring, shuttering, dewatering arrangements etc. as approved by the Employer/ Site-In-Charge. Contractor shall especially avoid disturbing the bearing surface of the pad. Any sand, mud, silt or other undesirable materials which may accumulate in the excavated pit or borehole shall be removed by Contractor before placing concrete.
- 1.7.1.3 Keeping in view of safety aspect, in case any sloped/ stepped/ ramp excavation for easy movement of man and material in excavation pit is required the same shall be done by the contractor. No Extra payment shall be admissible to the Contractor for the same.
- 1.7.1.4 The soil to be excavated for tower foundations shall be classified as follows depending upon the physical state of the soil at the time of excavation irrespective of the type of foundation installed.
- a) **Dry Soil**
- Soil removable either manually, by means of a spade and shovel or mechanically by poclains, excavators etc.
- Excavation done in dry soil for sandy dry, wet, partially submerged, fully submerged and wet black cotton type of foundations shall also be covered under this.
- b) **Wet Soil**
- During excavation, if wet soil is encountered within the foundation depth, the type of soil shall be considered as Wet irrespective of whether pumping/

bailing out of water is required or not. The excavation done in wet soil in case of wet, wet cultivated, partially submerged, fully submerged and wet black cotton type of foundation shall also be covered under this.

c) **Dry Fissured Rock**

Limestone, laterite, hard conglomerate or other soft or fissured rock in dry condition which can be quarried or split with crowbars, wedges, pickaxes etc. However, if required, light blasting may be resorted to for loosening the material but this will not in any way entitle the material to be classified as hard rock.

d) **Wet Fissured Rock**

Above fissured rock, when encountered with subsoil water within the range of foundation depth or land where pumping or bailing out of water is required, shall be treated as wet fissured rock.

e) **Hard Rock**

Any rock excavation, other than specified under fissured rock above, for which blasting, drilling, chiseling is required. The unit rate quoted for hard rock excavation shall be inclusive of all costs for such drilling (including drilling required for anchoring), chiseling and blasting, etc.

1.7.1.5 No extra payment shall be admitted for the removal of fallen earth into a pit or borehole once excavated.

1.7.1.6 Where rock is encountered, the holes for tower footings shall preferably be drilled. Blasting where resorted to as an economy measure, shall be done with utmost care to minimise fracturing rock and using extra concrete for filling the blasted area. All necessary precautions for handling and use of blasting materials shall be taken. In case where drilling is done, the stubs may be shortened suitably with the approval of the Employer.

In cases where unnecessarily large quantities are excavated/ blasted for fissured rock/ hard rock, resulting in placement of large volumes of concrete, payment of concrete shall be limited to design volumes of excavation, concreting, reinforcement etc.

In cases where unnecessarily excavation is done beyond foundation depth for normal foundation other than Hard rock, the same shall be filled with additional Plain cement concrete (PCC) corresponding to a 1:3:6 nominal mix without any additional financial implication to Employer. However minimum thickness of PCC above founding level as shown in the construction drawing of foundation shall be provided.

1.7.1.7 The Contractor shall arrange and supply requisite blasting material, and be responsible for its storage and use, without any extra cost to the Employer.

1.7.1.8 Indian Standard IS 3764 shall be followed regarding safety of excavation work.

## **1.8 Unit Rates and Measurement for Foundation**

1.8.1 The indicative shape of foundations is enclosed in this Specification. The bidder is required to quote the unit rates for different foundation activity namely, excavation for different types of soils, concreting, supply and placement of reinforcement steel and stub setting in the BPS.

1.8.2 The unit rates of excavation for each type of soil shall include excavation along with all associated activities like shoring, shuttering, dewatering till completion of foundation work stock piling, dressing, back filling of foundations after concreting with excavated/ borrowed earth (irrespective of lead) and consolidation of earth, carriage of surplus earth to the suitable point of disposal as required by the Employer or any other activity required for to completion of foundation work in all respect.

The measurement for excavation shall be made on the basis of design excavation volume arrived at considering dimension of pit leaving 150 mm gap around (except for undercut foundations) the base pad or actually excavated whichever is less and the unit rate of this item as indicated in in the Contract. The payment for excavation shall be made as per actual type of soil encountered at the time of excavation, but the total payment for excavation portion shall not exceed the amount as payable for excavation considering the soil type same as that of foundation classification. The decision of the Employer shall be final and binding with respect to classification of soil and foundations.

1.8.3 Form boxes shall be used for casting of foundations (except under cut portion of foundation). The unit rate of concreting shall include the cost of supply, fabrication and placement of form boxes, cement, water, coarse and fine aggregates mixing and placing of concrete, curing of concrete and any other activities related/ required for completion of concreting works of foundation. The payment for this item shall be made as per the actual volumes of concreting completed but limited to design volume based on unit rates indicated in the Contract.

1.8.4 The unit rate of 'Reinforcement Steel' shall include supply and placement of reinforcement steel, stirrups, wire for binding the reinforcement, chairs, bolsters and spacers etc. as required to complete the foundation work. The payment of reinforcement steel shall be made based on the working drawing. In case of actual unit weight of the reinforced steel is found less than standard unit weight, but within acceptable tolerance variation as per applicable standard, the same shall be accepted without any compensation/ deduction. However, if unit weight is found to be beyond the negative (-ve) tolerance limits specified in IS, the material shall be rejected. Wastage overlaps, couplers (if provided), spacer bars, chairs,

stays, hangers and annealed steel wire etc. shall not be measured for the payment and cost of these items shall be deemed to be included in the rates for reinforcement.

No payment shall be made on account of overlaps for joining the reinforcement in any type of foundations except for Pile & Combined Raft Foundation.

## 1.9 Setting of Stubs

1.9.1 The stubs shall be set correctly and precisely in accordance with approved method at the exact location, alignment and levels with the help of stub setting templates and leveling instruments. Minimum clearance between chimney concrete level and ground level shall be ensured as per foundation drawing. Stubs setting shall be done in the presence of Employer's representative available at site where required and for which adequate advance intimation shall be given to Employer by Contractor. Tolerances as per provisions of IS 5613 shall be allowed for stub setting.

1.9.2 Setting of stub at each location shall be approved by Employer.

1.9.3 Individual Leg stub setting template may also be used by the contractor with prior approval from Employer Site-In-Charge. An indicative drawing for individual leg stub setting template is attached with the specification. Proper care shall be taken by the contractor for accurate setting & alignment of stub levels

1.9.4 Alternatively, props may be used with complete accuracy and high skilled supervision. No recovery shall be made on account of using Props for stub setting.

### 1.9.5 Stub Setting Templates/ Props

1.9.5.1 Stub setting templates shall be arranged by the Contractor at his own cost for all heights of towers. Stub templates shall be of adjustable type. The Contractor shall also arrange for props for setting of stubs at specific locations. Stub templates/ props should be painted.

1.9.5.2 The Contractor shall deploy sufficient number of templates/ props for timely completion of the line without any extra cost to Employer.

1.9.5.3 However, the number of templates to be deployed shall depend upon type of terrain condition, number of types of towers etc. Hence, the quantity of template to be deployed for timely completion of the line shall be finalized in consultation with Site-In-Charge without any extra cost to the Employer.

The number of sets of props (if permitted) to be arranged, will depend as per actual site condition and completion schedule of line.

1.9.5.4 One set of each type of stub setting template/ props (if used) shall be supplied to the Employer, on completion of the project, at no extra cost to Employer.

## 1.10 Mixing, Placing and Compacting of Concrete

1.10.1 The concrete shall be mixed in the mechanical mixer. However, in case of difficult terrain, hand mixing may be permitted at the discretion of the Employer. The water for mixing concrete shall be fresh, clean and free from oil, acids and alkalis. Saltish or blackish water shall not be used.

Alternatively, Ready Mix concrete from batching plant as per IS 4925 can also be used with no extra payment and without any recovery. However, cement content shall be as per IS 456, unless otherwise specified herein. The ready-mix concrete shall conform to IS 4926. The selection and use of Materials for the ready-mix concrete shall be in accordance with IS 456. The concrete shall be of M25 grade design mix as per IS 456. The transport of concrete and transportation time shall be as per IS 4926. Record of delivery ticket information as per Annexure-G of IS 4926 has to be maintained.

1.10.2 Mixing shall be continued until there is uniform distribution of material and mix is uniform in colour and consistency, but in no case the mixing be carried out for less than two minutes. Normal mixing shall be done close to the foundation but exceptionally, in difficult terrain, the concrete may be mixed at the nearest convenient place. The concrete shall be transported from the place of mixing to the place of final deposit as rapidly as practicable by methods which shall prevent the segregation or loss of any ingredient. The concrete shall be placed and compacted before setting commences.

1.10.3 To avoid the possibility of reinforcement rods being exposed due to unevenness of the bottom of the excavated pit, a pad of lean concrete 50 mm thick and corresponding to a 1:3:6 nominal mix shall be provided at the bottom of the pad. The coarse aggregate shall be of 20mm size and shall conform to IS 383.

1.10.4 Form boxes shall be used for casting all types of foundations except at an undercut interface for which the adjoining subsurface material shall provide adequate support. Form boxes shall conform to the shape, lines & dimensions of the foundation drawing and shall be constructed so as to be rigid during the placing and compacting of concrete. Contractor shall ensure that Form boxes are in good condition. Repeated use & maintenance of form box shall be as per IS 456 & IS 14687.

1.10.5 The concrete shall be laid down in 150mm layers and consolidated well, so that the cement cream works, up to the top and no honey-combing occurs in the concrete. A mechanical vibrator shall be employed for compacting the concrete. However Monolithic casting of foundation must be carried out. However, in case of unavoidable circumstances, a key construction joint can be provided at the chimney-pad interface subject to approval of the Employer or as directed by the Engineer-in-charge. Number of such joints shall be kept minimum. Joints shall be kept as straight as possible & such construction joints should comply with IS 456. There shall not be any construction joint near stub & cleat portion of frustum.

However, nothing extra shall be paid to the Contractor for providing such construction joints. For raised chimney, joint in concrete shall be of 3 m in chimney portion if casting of full chimney is not possible in one stretch.

- 1.10.6 After concreting the chimney portion to the required height, in the top 50 mm portion between CL & GL coping shall be done after erection of tower and the top surface should be finished smooth with a slight slope towards the outer edge for draining rain water.

Further, in case of Wet, Wet cultivated, PS, FS & WBC foundation before coping of chimney top portion, three coats of anti-corrosive paint (As recommended by paint manufacture for structural steel application) of minimum 30-35 microns dry film thickness each shall be applied on the stub in the 50 mm coping portion as well as upto 350 mm above CL portion. Cost of supply and application of anti-corrosive paint shall be deemed to be included in the unit rate of concreting.

- 1.10.7 Wet locations shall be kept completely dewatered, both during and 24 hours after placing the concrete, without disturbance of the concrete.

- 1.10.8 If minor defects in concrete surface is found after the form work has been removed, the damage shall be repaired with a rich cement sand mortar to the satisfaction of the Employer before the foundation is back filled.

#### 1.11 **Curing**

The concrete shall be cured by maintaining the concrete wet for a period of at least 10 days after placing. Once the concrete has set for 24 hours the pit may be backfilled with selected moistened soil and well consolidated in layers thereafter both the backfill earth and exposed chimney shall be kept wet for the remainder of the prescribed 10 days. The exposed concrete chimney shall also be kept wet by wrapping gunny bags around it and wetting the bags continuously during the initial 10 days period.

Alternatively, membrane curing may also be carried over all exposed surface of concrete in line with IS 456

#### 1.12 **Backfilling and Removal of Stub Templates**

- 1.12.1 After opening of formwork and removal of shoring, shuttering etc., backfilling shall be done with the excavated soil, unless it consists of large boulders/ stones, in which case the boulders/ stones shall be broken to a maximum size of 80 mm or disposed-off. At locations, where borrowed earth is required for backfilling, Contractor shall bear the cost of the borrowed earth irrespective of leads & lift.

- 1.12.2 The backfilling materials shall be clean and free from organic or other foreign materials. The earth shall be deposited in various layers, levelled, wetted if necessary and shall be fully compacted. All excavated earth shall be placed over the filled in pit to allow further settlement, if any, by gravity.

1.12.3 The backfilling and grading shall be carried to an elevation of about 75 mm above the finished ground level to drain out water. After backfilling 50 mm high, earthen embankment (band) will be made along the sides of excavation pits and sufficient water will be poured in the backfilling earth for at least 24 hours. After the pits have been backfilled to full depth the stub template can be removed.

### 1.13 **Benching**

When the line passes through hilly/ undulated terrain, levelling the ground may be required for casting of tower footings. All such activities shall be termed benching and shall include cutting of excess earth and removing the same to a suitable point of disposal as required by Employer. Benching in sandy soil shall be payable only when it requires cutting of excess soil by any excavator or JCB. Benching shall not be payable in case benching is done in moving sand dunes. Benching shall be resorted to only after approval from Employer. Volume of the earth to be cut shall be measured before cutting and approved by Employer for payment purposes. Further, to minimise benching, unequal leg extensions/ raised chimney shall be considered and provided if found economical. The proposal shall be submitted by the Contractor with detailed justification to the Employer.

### 1.14 **Protection of Tower and Tower Footing**

1.14.1 Tower shall be spotted such that the quantities of revetment are optimum. For tower locations in undulated terrain such as hill/ mountain slopes, options like use of unequal leg extensions for towers, unequal chimney extensions etc. shall be explored by the contractor for optimizing the need for revetment & benching.

1.14.2 The work shall include all necessary stone revetments, concreting and earth filling above ground level, the clearing from site of all surplus excavated soil, special measures for protection of foundation close to or in nalas, river bank / bed, undulated terrain, protection of uphill/ downhill slopes required for protection of tower etc., including suitable revetment or galvanised wire netting and meshing packed with boulders. The top cover of stone revetment shall be sealed with 1:2:4 nominal mix concrete. Contractor shall recommend protection at such locations wherever required. Details of protection of tower/ tower footing are given in drawing enclosed with these specifications for reference purpose only.

1.14.3 Tower footings shall generally be backfilled using soil excavated at site unless unsuitable for backfilling. In the latter case, backfilling shall be done with borrowed earth of suitable quality irrespective of leads and lift. The unit rate for backfilling quoted in BPS shall include the required lead and consolidation and leveling of earth after backfilling.

1.14.4 The provisional quantities for protection work of foundations are furnished in BPS. The unit rates shall also be applicable for any quantity variations during execution. The same unit rates shall hold good for protection work carried out on down hills or up hills slopes applicable for the tower locations.

- 1.14.5 The unit rate for random rubble masonry revetment quoted in price schedule shall also include excavation & (1:5) random masonry. For payment purposes the volume of random rubble masonry revetment shall be measured from bottom of RRM to bottom of M15 sealing and paid at the unit rates indicated in the Contract.
- No extra payment shall be made for allied works such as excavation for revetment, packed stone at head of weep holes etc. However, no deduction shall be made for the volume enclosed by weep holes.
- 1.14.6 For some of the locations in nalas, river bed or undulated terrain etc., boulders of minimum. 150mm size bounded and packed in galvanised wire net/ mesh of 8 SWG wire and 10000 square mm (maximum) mesh are to be provided. These stones shall be provided in crates size of 2.0 m x 2.0 m or as deemed suitable for a particular location. Measurement shall be taken in cubic meters and 15% deduction will be made for void from cage/ stack measurements.
- 1.15 After completion of foundation, stub levels, back to back dimensions, diagonal dimensions etc. shall be measured jointly by the Engineer of Contractor and Employer before taking up erection of tower and same shall be recorded for future reference. In case of any deviations beyond permissible limits as per IS 5613, the foundation shall be rectified or re-casted by the contractor at his own cost.

# SECTION-IVF

## MONOPOLE STRUCTURE, FOUNDATION AND ERECTION

**TECHNICAL SPECIFICATIONS**

**SECTION-IVF**

**CONTRACTOR DESIGN FOUNDATIONS**

**Revision History**

<b>Revision No.</b>	<b>Date</b>	<b>Clause Ref</b>	<b>Description</b>
Rev-0	Feb'2022		First Release
Rev-1	Oct'2022		First Revision
Rev-2	March'2023		Second Revision

**TECHNICAL SPECIFICATIONS**

**SECTION-IVF**

**MONOPOLE STRUCTURE, FOUNDATION AND ERECTION**

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## TECHNICAL SPECIFICATIONS

### SECTION- IVF

#### MONOPOLE STRUCTURE, FOUNDATION AND ERECTION

#### 1.0 Transmission Line Mono Pole structure

#### 1.1 General Description of Transmission Line Mono Pole structure

1.1.1 The general description of monopoles applicable for the package and technical particulars thereof are indicated in **Section-IA** of this Specification. Outline diagram of monopole structures are enclosed with the specifications.

#### 1.1.2 Extensions

1.1.2.1 Mono pole structures shall be designed so as to be suitable for adding 3M, 6M, 9M extensions for maintaining adequate ground clearances without reducing the specified factor of safety in any manner. Also tapering ratio of these extension shall be kept same as that of tested pole and the design factor of safety of non-tested extension shall not be less than the factor of safety of tested pole in any case.

1.1.2.2 For +18/25m and higher extensions for 765kV S/C, 400kV Multi-circuit (Twin-Twin) & 400kV D/C (Quad/Triple/Twin), Bidders may offer pole structures as Single/ Twin poles. These structures may be either designed and tested for Reliability level prescribed for the particular voltage level as per the provisions regarding testing of poles specified herein or the same shall be designed for Reliability level-3, if not tested.

#### 1.1.3 Spans

#### 1.1.3.1 Normal Span

The Design Span or Normal ruling span for the monopole structure shall be as under:

Voltage level and Configuration Transmission Line	Normal design span (m)
765kV S/C, 400 kV D/C(Quad), 400 kV D/C(Triple) and M/C(Twin-Twin)	150m
400kV D/C (Twin) & 400 kV S/C	200m
220 kV and 132 kV	250m

### 1.1.3.2 Wind Span

The wind span is the sum of two half spans adjacent to the support under consideration. For normal horizontal spans this equals to normal ruling span.

### 1.1.3.3 Weight Span

The weight span is the horizontal distance between the lowest points of the conductors on the two spans adjacent to a monopole structure. For design of structures, maximum weight span limits given in table below shall be considered:

Sl. no.	Pole Type	Normal Condition		Broken wire condition	
		Maximum (m)	Minimum (m)	Maximum (m)	Minimum (m)
<b>A)</b>	<b>765kV S/C, 400 kV D/C(Quad), 400 kV D/C(Triple) and 400kV M/C(Twin-Twin)</b>				
i)	PA	225	100	135	50
ii)	PB	225	0	135	(-)100
iii)	PC	225	0	135	(-)100
iv)	PD	225	0	135	(-)100
v)	Dead End condition for PD	112	0	22	0
vi)	Dead End with Slack Span condition for PD	225	0	135	(-)100
<b>B)</b>	<b>400kV D/C (Twin) &amp; 400 kV S/C</b>				
i)	PA	300	100	180	50
ii)	PB	300	0	180	(-)200
iii)	PC	300	0	180	(-)200
iv)	PD	300	0	180	(-)200
v)	Dead End condition for PD	150	0	30	0
vi)	Dead End with Slack Span condition for PD	262	0	172	(-)200
<b>C)</b>	<b>220 kV and 132 kV</b>				
i)	PA	375	125	225	75
ii)	PB	375	0	225	(-)200
iii)	PC	375	0	225	(-)200
iv)	PD	375	0	225	(-)200
v)	Dead End condition for PD	187	0	40	0
vi)	Dead End with Slack Span condition for PD	300	0	210	(-)200

#### 1.1.4 Electrical Clearances

##### 1.1.4.1 Ground Clearance

The minimum ground clearance from the bottom conductor at maximum sag conditions i.e. at max. operating temperature and still air shall be as indicated in **Section-1A** of TS.

##### 1.1.4.2 Live Metal Clearance

The minimum live metal clearance to be provided between the live parts and steel work of pole structure shall be as given in the table below:

###### A) For 765kV S/C transmission line:

Wind pressure Condition	Minimum electrical clearance
<b>A. For "I" Suspension Insulator Strings</b>	
1. 0° Swing	5600 mm
2. 25° Swing	4400 mm
3. 55° Swing	1300 mm
<b>B. For Jumpers in tension insulator strings (with or without Pilot)</b>	
1. 0° Swing	5600 mm
2. 25° Swing	4400 mm
3. 55° Swing	1300 mm

Not more than one pilot insulator string is to be used for PD pole only.

###### B) For 400kV transmission line:

Wind pressure Condition	Minimum electrical clearance
<b>A. For Single Suspension Insulator Strings</b>	
1. 0° Swing	3050 mm
2. 22° Swing	3050 mm
3. 44° Swing	1860 mm
<b>B. For Jumpers in tension insulator strings</b>	
1. 0° Swing	3050 mm
2. 25° Swing	3050 mm
3. 40° Swing	1860 mm
<b>C. For Pilot insulator strings</b>	
1. 0° Swing	3050 mm

2. 15° Swing	3050 mm
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Not more than one pilot insulator string is to be used for PD pole only.

**C) For 220kV transmission line:**

Wind pressure Condition	Minimum electrical clearance
<b>A. For “I” Suspension Insulator Strings</b>	
1. 0° Swing	2130 mm
2. 15° Swing	1980 mm
3. 30° Swing	1830 mm
4. 45° Swing	1675 mm
<b>B. For Jumpers in tension insulator strings</b>	
<b>Without Pilot</b>	
1. Swing angle 0°	2130 mm
2. Swing angle 10°	2130 mm
3. Swing angle 20°	1675 mm
<b>With Pilot</b>	
1. Swing angle 0°	2130 mm
2. Swing angle 10°	2130 mm
3. Swing angle 15°	1980 mm

Not more than one pilot insulator string is to be used for PD pole only.

**D) For 132kV transmission line:**

Wind pressure Condition	Minimum electrical clearance
<b>A. For “I” Suspension Insulator Strings</b>	
1. Swing angle (15°)	1530 mm
2. Swing angle (30°)	1370 mm
3. Swing angle (45°)	1220 mm
4. Swing angle (60°)	1070 mm
<b>B. For Jumpers in tension insulator strings (without Pilot)</b>	
1. Swing angle (0°)	1530 mm
2. Swing angle (10°)	1530 mm
3. Swing angle (20°)	1070 mm

4. Swing angle (30°)

1070 mm

Pilot (s) is not to be considered for Jumper Swing

- 1.1.4.3 Bidder shall adopt same cross arm design where jumper is projecting outside of cross-arm for tension monopole structure.
- 1.1.4.4 For computing the live metal clearances, the dimensions of insulator strings as indicated in technical specifications shall be considered. The design of the monopole structure shall be such that it should satisfy all the above conditions when clearances are measured from any live point of the strings.
- 1.1.4.5 Cross arm projections for Dead end monopole structures shall be fixed in such a way that it can accommodate a condition of 150 deviation of conductors towards monopole structure at both Left and Right-side cross arms on slack span side and 0-15 degrees deviation on line side.
- 1.1.4.6 For Dead End Tower design conditions, following wind span is to be considered:

#### Wind Span for Dead End

Tower Type	Normal Condition	Broken wire condition
<b>765kV S/C, 400 kV D/C(Quad), 400 kV D/C(Triple) and 400kV M/C(Twin-Twin)</b>		
Dead End	75	15
Dead End with Slack Span	150	90
<b>400 kV D/C (Twin) &amp; 400kV S/C</b>		
Dead End	100	20
Dead End with Slack Span	175	115
<b>220kV &amp; 132kV</b>		
Dead End	125	25
Dead End with Slack Span	200	140

#### 1.1.4.7 **Angle of Shielding**

The angle of shielding is defined as the angle formed by the line joining the centre lines of the earthwire/ OPGW and outer power conductor, in still air, at monopole structure supports, to the vertical line through the centre line of the earthwire/ OPGW Bidders shall design the pole in such a way that the angle of shielding does not exceed the value given in the table below. For estimating the minimum angle of protection, the drop of earth wire suspension clamp along with shackle shall be taken as 150 mm.

Sl. No.	Voltage Level of Transmission Line	Angle of Shielding
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A)	765 kV S/C and 400 kV line	20 <sup>0</sup>
B)	220 kV and 132 kV line	30 <sup>0</sup>

#### 1.1.4.8 Mid Span Clearance

The minimum vertical mid span clearance between the earthwire and the nearest power conductor shall not be less than the value given below, which shall mean the vertical clearance between earthwire and the nearest conductor under all temperatures and still air condition in the normal ruling span. Further, the tensions of the earthwire/ OPGW and power conductor shall be so co-ordinate that the sag of earthwire/ OPGW shall be at least 10% less than that of power conductors under all temperature loading conditions: -

Sl. No.	Voltage Level of Transmission Line	Mid Span Clearance
A)	400 kV and 765 kV	9000 mm
B)	220 kV	8500 mm
C)	132 kV	6100 mm

#### 1.1.4.9 Phase to Phase Spacing

The phase to phase spacing for conductors shall be not less than 15000 mm for 765 kV & 8000 mm for 400 kV vertically. For 220 kV & 132 kV, required vertical phase to phase spacing shall be governed by the pole design as well as minimum live metal clearances under different insulator swing angles.

### 1.2 Design of Monopole structures

The following clauses specify the minimum requirements for design of monopole structures:

#### 1.2.1 Design Criteria

- a) The monopole structure shall be designed to meet design requirements & design criteria stipulated in IS 802:2015, ASCE Manuals and reports on Engineering practice No. 72 and ASCE-48-11 "Design of Steel Transmission Pole Structures", & CBIP Manual as applicable except otherwise specified in this specification. Wind Zone to be considered for the design of pole structure shall be as per **Section-1A** of the TS.
- b) Terrain category shall be considered as 2, unless otherwise mentioned in Section-1A.

- c) Under broken wire condition, pole shall be designed considering transverse load based on maximum angle of deviation and longitudinal load based on minimum angle of deviation mentioned in Section-IA of Technical specifications.
- d) For poles in coastal areas (wherever mentioned in BPS), an additional factor viz.  $K_4 = 1.3$  shall be considered for design of poles to take care of cyclonic wind conditions.
- e) Reliability level shall be considered as 1 for 132kV, 220kV & 400 kV (twin bundle conductor) and 2 for triple & quadruple circuit poles and poles with more than two sub-conductors per phase upto 400 kV & 765 kV poles.
- f) For 765kV S/C, 400kV Multi-circuit (Twin-Twin) & 400kV D/C (Quad/Triple), bidders may offer PD type pole structures as Twin poles. These structures may be either designed and tested for Reliability level prescribed for the particular voltage level or the same shall be designed for Reliability level-3, if not tested.
- g) Contractor shall offer pole/ foundation design considering the type of conductor, being supplied by them under the package and the conductor, earthwire & OPGW properties as per those mentioned in the respective sections.
- h) Deflection Criteria: 5% of height of pole @ultimate load condition and 2% of the height of pole @ everyday loading condition.

### 1.2.2 Design Temperatures

The following temperature range for the conductors and ground wires shall be adopted for transmission line design:

- i) Minimum Temperature: Minimum Ambient Temperature as per Section IA
- ii) Every day temperature : 32<sup>0</sup>C
- iii) Max. temperature of
  - a) Conductor (ACSR/ Al59/AAAC) : 85<sup>0</sup>C
  - b) Conductor (HTLS) : Refer TS for HTLS conductor
  - c) Earthwire exposed to sun : 53<sup>0</sup>C

### 1.2.3 Conductor and Earthwire/ OPGW Configuration

For single circuit poles, three phases shall be in vertical delta/vertical formation. Double circuit pole structures shall be in vertical formation. For voltage levels up to 220 kV Cross-arms of conductor phases coming over one another shall be suitably staggered as per IS 5613(Part-2/Section- 1) stipulations.

### 1.2.4 Maximum Tension

Maximum tension shall be based on either

- a) at Minimum temperature with 36% full wind pressure or
- b) at 32<sup>o</sup> C with full wind pressure whichever is more stringent

Sag tensions calculations are to be carried out by the contractor considering conductor & earthwire/ OPGW parameters & specified conditions and spans. As per Clause 15 of IS 802:2015 the initial tension at 32<sup>o</sup>C and without wind shall not exceed 25% for below 400kV voltage levels and 22% for 400kv & above voltage levels of the ultimate tensile strength for the conductor and 20% of the ultimate tensile strength for the earthwire/ OPGW.

For normal poles, the value of final unloaded tension of conductor at everyday temperature considered for Pole Design under Safety Condition and Anti-cascading condition, shall not be less than 25% of the ultimate tensile strength of conductors for below 400kV voltage level transmission lines and not less than 22% of the ultimate tensile strength of conductors for 400 kV and higher voltage lines.

At ruling span, the final unloaded tension of conductor at everyday temperature of upper phase shall not be less than that of conductor in lower phase so as to maintain the phase-to-phase spacing.

As per Clause 12.1.2.1 (b) (2) of IS 802:2015, Under security condition for tension and dead-end poles, the transverse loads due to line deviation shall be the component of 100 percent mechanical tension of conductor and ground wire/ OPGW corresponding to 100% of design wind pressure at everyday temperature or 36% design wind pressure at minimum temperature after accounting for drag coefficient and gust response factor. Drag coefficient for wind on the pole body shall be as per following table: -

Member Shape	Drag Coefficient
16-sided Polygonal	0.9
12-sided Polygonal	1.0
8-sided Polygonal	1.4
6-sided Polygonal	1.4

Square, Rectangle 16-sided Polygonal

2.0

The cross section and polygon of the structure shall be so selected that it offers optimum weight of the structure using specified materials and also ease of fabrication and erection. For cross arms also, Polygonal Sections shall be used.

#### 1.2.5 Loading Conditions

The Contractor shall calculate loads at structure, conductor & earthwire/ OPGW points under different loading conditions viz. Reliability Conditions (Normal Condition), Security Conditions (Broken Wire Condition), Safety Conditions, Anti-cascading condition etc. as per IS 802:2015 considering various combinations of design temperatures, wind loads and prepare loading trees/ diagrams/ charts. The loading trees/ diagrams/ charts shall be submitted to Employer for approval. The monopole structure designs shall be developed by the contractor as per the approved loading trees/charts/ diagram.

#### 1.2.6 Design and Drawings

1.2.6.1 The following design calculation and drawings are required to be furnished to the Employer:

a) Alongwith Bid:

Detailed design calculations and drawings for PA+0 & PD+0 type pole structure along with foundation.

b) After award of the Contract:

The Contractor shall submit detailed design of monopole structures with all extensions along with foundation design/drawings of all type of monopole structures for soil type as per site requirement. The monopole structure design shall be submitted along with the stress diagram/ computer output together with sample calculations etc., Anchor Bolt templates and loading/ rigging arrangement of monopole structure testing (if applicable) to enable the Employer to make a preliminary check regarding structural stability of monopole structure before fabrication

1.2.6.2 After design and testing (if applicable) of monopole structures and subsequent approval of design, drawings and bill of materials, the Contractor shall furnish further copies to the Employer for necessary distribution:

a) Detailed design calculation and drawing for monopole structures and foundations.

- b) Detailed structural drawings indicating section size, length of members, sizes of plates along with hole to hole distance & joint details etc.
- c) Bill of materials, indicating cutting and bending details against each member.
- d) Shop drawings showing all details relevant to fabrication.
- e) All the drawings for the monopole structure accessories.

1.2.6.3 All the drawings shall have a proper name plate clearly displaying the name of EMPLOYER on right hand bottom corner. The exact format of the nameplate shall be handed over to the successful bidder for incorporation of the same on all the drawings. Also, all the drawings shall carry the following statement and shall be displayed conspicuously on the drawing:

**WARNING:** THIS IS PROPRIETARY ITEM AND DESIGN RIGHT IS STRICTLY RESERVED WITH POWERGRID. UNDER NO CIRCUMSTANCES THIS DRAWING SHALL BE USED BY ANYBODY WITHOUT PRIOR PERMISSION FROM THE EMPLOYER/OWNER IN WRITING.

1.2.6.4 The Contractor is required to submit four copies of the drawings for Employer's approval. While submitting the structural drawings, bill of materials, shop drawings and any other drawings pertaining to the subject transmission line, the Contractor shall clearly indicate on each drawing POWERGRID Specification No., Name of the specific Transmission line and project, letter reference no. and date on which the submission are made. The same practice is also to be followed while submitting distribution copies.

1.2.6.5 The monopole structure accessories drawings like Number plate, Danger plate, phase plate, Circuit Plate, Step Bolt, Anti-climbing device, pole plate and Earthing Arrangement Bird Guard, D-shackle etc. shall be prepared by the Contractor and shall be submitted to the Employer, in for approval.

1.2.6.6 The drawings submitted by the Contractor shall be approved/ commented by the Employer as the case may be within fifteen (15) days of receipt of drawings in his office. If the designs/ drawings are commented by the Employer, the Contractor shall submit revised design/ drawings duly incorporating all comments within fifteen (15) days of date of issue of comments. The Contractor shall submit 15 copies of all monopole structure drawings, BOM etc. for further distribution by the Employer.

1.2.6.7 Other than the items indicated above, some other drawings and documents, such as BOM, Shop drawings, structural drawings for monopole structures/ extensions, which are required for the project, shall also be developed by the Contractor. However, no extra cost on this account shall be payable to the Contractor.

### 1.3 **Materials**

### 1.3.1 Monopole structure Steel Sections

Steel of tested quality of conformity with IS 2062:2011 are to be used in monopole structures. Not more than two grades of steel shall be permitted for use. The quality of steel shall be BR/BO. The Contractor can use other equivalent grade of steel plates conforming to latest International Standards. However, use of steel grade having designated yield strength more than that of IS:2062 grade E450 BR/ EN 10025 grade S450 JO/ ASTM 572 grade 65 (designated yield strength 450 MPa) is not permitted, unless otherwise indicated in this specification.

Steel plates below 6mm size exclusively used for packing plates/ packing washers produced as per IS 1079 (Grade-0) are also acceptable. However, if below 6mm size plate are used as load bearing plates viz gusset plates, joint splices etc. the same shall conform to IS 2062 or equivalent standard meeting mechanical strength/metallurgical properties corresponding to selected grade. Flats of equivalent grade, meeting mechanical strength/ metallurgical properties, may also be used in place of plates for packing plates/ packing washers.

SAILMA 350HI grade plate can also be accepted in place of HT plates (EN 10025 grade S355 JR/JO/ IS 2062:2011, grade E350, as applicable) provided SAILMA 350HI grade plate meet all the mechanical properties of plate as per EN 10025 grade S355 JR/JO (designated yield strength 355 MPa)/ IS 2062: 2011, grade E350.

During execution of the project, if any particular section/grade is not available, the same shall be substituted by higher section/grade. Any cost on account of the same shall be borne by the Contractor. However, design approval for such substitution shall be obtained from the Employer before any substitution and records of such substitutions shall be maintained by the Contractor.

### 1.3.2 Fasteners: Bolts, Nuts and Washers

1.3.2.1 All hexagonal bolts and nuts shall conform to IS 12427. They shall have hexagonal head and **nuts**, the heads being forged out of the solid, truly concentric, and square with the shank, which must be perfectly straight.

All bolts and nuts shall be galvanized as per IS 1367 (Part-13)/ IS 2629.

1.3.2.2 The bolt shall be of 16/24/30/36 mm diameter and of property class 5.6 or 8.8 as specified in IS 1367 (Part-III) and matching nut of property class as specified in IS 1367 (Part-VI).

1.3.2.3 Bolts up to M16 and having length up to 10 times the diameter of the bolt should be manufactured by cold forging and thread rolling process to obtain good and reliable mechanical properties and effective dimensional control. The shear strength of bolts shall be as per applicable standard. Bolts should be provided with washer face in accordance with IS 1363 (Part-I) to ensure proper bearing.

- 1.3.2.4 Nuts for hexagonal bolts should be double chamfered as per the requirement of IS 1363 (Part-III). It should be ensured by the manufacturer that nuts should not be over tapped beyond 0.4mm oversize on effective diameter for size up to M16.
- 1.3.2.5 Fully threaded bolts shall not be used. The length of bolts shall be such that the threaded portion will not extend into the place of contact of the members.
- 1.3.2.6 All bolts shall be threaded to take the full depth of the nuts and threaded for enough to permit firm gripping of the members, but not further. It shall be ensured that the threaded portion of each bolt protrudes not less than 3mm and not more than 8mm when fully tightened. All nuts shall fit tight to the point where the shank of the bolt connects to the head.
- 1.3.2.7 Flat and tapered washers shall be provided wherever necessary. Spring washers shall be provided for insertion under all nuts. These washers shall be steel electro-galvanised, positive lock type and 3.5mm in thickness for 16mm dia bolt and 4.5mm for 24mm bolt.
- 1.3.2.8 To avoid bending stress in bolts or to reduce it to minimum, no bolt shall connect aggregate thickness of members more than three (3) times its diameter.
- 1.3.2.9 The bolt positions in assembled pole structures shall be as per structural drawing.
- 1.3.2.10 Bolts at the joints shall be so staggered that nuts shall be tightened with spanners without fouling.
- 1.3.2.11 To ensure effective in-process Quality control it is desirable that the manufacturer should have in house testing facility for all tests like weight of zinc coating, shear strength and other tests etc. The manufacturer should also have proper Quality Assurance System which should be in line with the requirement of this specification and IS 9001 series Quality System Standard.

### 1.3.3 Anchor bolts

Anchor bolts shall generally conform to IS 5624. The size, grade & numbers of anchor bolts and its thread and nuts selection should be compatible with the required strength as per design.

### 1.4 Pole structure Accessories

Arrangement shall be provided for fixing of all pole structure accessories to the pole structure at a height between 2.5 meters and 3.5 meters above the ground level.

#### 1.4.1 Step Bolts & Ladders

Each monopole structure shall be provided with step bolts as per drawing enclosed in the section of drawing. The step bolts conforming to IS:10238 of not less than 16mm diameter and 175mm long shall be provided, spaced not more than 450mm apart and extending from 2.5 meters above the ground level to the top of the pole structure. However, the head diameter shall be 35mm as indicated in the enclosed drawing. The step bolt shall be fixed on two sides of polygon of the monopole structures in alternate step arrangement. Each step bolt shall be provided with two nuts on one end to fasten the bolt securely to the monopole structure and button head at the other end to prevent the feet from slipping away. The step bolts shall be capable of withstanding a vertical load not less than 1.5 KN. As an alternate to step bolts, ladders of suitable design may also be provided by the contractor. For horizontal access on cross arms, suitable designed hooks shall also be provided. Detailing for providing step bolts/ hooks/ ladders etc. shall be done so that all parts of monopole structures are accessible and installation & maintenance of insulators, hardware assemblies, conductors etc. is possible.

#### 1.4.2 Insulator Strings and Earth wire Clamps Attachments

- a) For the attachment of suspension Insulator string, if required a suitable dimensioned swinging hanger on the monopole structure shall be provided so as to obtain specified clearances under respective swinging condition of the strings. The hanger, extensions links, D-shackles etc. as required shall be of same rating/strength as that of corresponding rating/ Ultimate tensile Strength of Insulator string. The design and supply of hanger, D-shackles, strain plate, extension link etc. are also in the scope of Contractor.
- b) At tension monopole structures, strain plates of suitable dimensions under each cross-arm tip, shall be provided for taking the hooks or D-shackles of the tension insulator strings. Full details of the attachments shall be provided by the contractor. To achieve requisite clearances, if the design calls for providing extra D-shackles, link plate etc. before connecting the insulator string the

same shall be supplied by the Contractor. These items shall be of same rating/strength as that of as that of corresponding rating/ Ultimate tensile Strength of Insulator string.

- c) D shackles, if required for attachment of Insulator strings, shall be supplied by the contractor from the identified and approved sub-vendor / supplier of Hardware fittings.

#### 1.4.3 **Earth wire/ OPGW Clamps Attachments**

For Suspension and tension clamp for attachment of earthwire/ OPGW wherever required, the Contractor shall supply U-bolts, D-Shackles etc. for attachment of clamp to the monopole structure. These items shall be of same rating/ strength as that of corresponding rating/ Ultimate tensile Strength of earthwire suspension/tension clamp.

#### 1.4.4 **Anti Climbing Device**

Barbed wire type anti climbing device, shall be provided and installed by the Contractor for all monopole structures. The barbed wire shall conform to IS 278 (size designation A1). The barbed wires shall be given chromating dip as per procedure laid down in IS:1340

#### 1.4.5 **Danger, Number, Circuit and Phase plate**

Danger Plates, Circuit plates, Phase Plates and Number plates shall be provided and installed by the Contractor. These Danger/ Number/Phase/ Circuit Plate shall be as per the drawings enclosed in the section of drawing. The contractor shall submit distribution copies of the same endorsing the package details (i.e. line name, LOA No. etc.) and installed by the Contractor.

- a) Each monopole structure shall be fitted with a danger plate, number plate, circuit plate and two sets of phase plates for double circuit monopole structure.
- b) The letters, figures and the conventional skull and bones of danger plates shall conform to IS 2551 and shall be in a signal red on the front of the plate.
- c) The corners of the danger, number and circuit plates shall be rounded off to remove sharp edges.
- d) The letters of number and circuit plates shall be red enameled with white enameled background.

#### 1.4.6 **Bird Guard**

To prevent birds perching immediately above the suspension insulator strings (I type) and fouling the same with dropping, suitable bird guards shall be provided

on all suspension poles. In case of I string Bird Guard as per IS 5613 shall be provided at cross arm tips. Suitable provision of cleat/ plate to be provided on all Suspension poles facilitating installation of bird guard after stringing.

#### 1.4.7 **Aviation Requirements**

1.4.7.1 Painting of monopole structures above the height of 45 m shall be carried out by the contractor conforming to IS 5613. The cost of painting shall be deemed to be included in the cost of monopole structures and no separate payment shall be made in this regard.

#### 1.5 **Monopole Structure Fabrication**

The Monopole Structure along with cross arms, earthwire peaks, base plate and joints shall be fabricated by the Contractor as per the design prepared by the contractor and approved by the Employer. The fabrication of Monopole structure shall be in conformity with the following:

1.5.1 Except where hereinafter modified, details of fabrication shall conform to industry practices and relevant standards.

1.5.2 Joints shall be so designed and fabricated that eccentricity is avoided as far as possible. Connections by means of slip joints only are acceptable. Minimum overlap shall be as applicable ASCE standard.

1.5.3 The cross arms shall be connected to the monopole by means of suitable flanges welded on the body and cross arms.

1.5.4 The Monopole structures shall be accurately fabricated to connect together easily at Site without any undue strain on the structure.

1.5.5 No sharp/rough edges shall be permitted in the entire structure.

1.5.6 On slip-in joints, diameter of the inner and outer part of the monopole shall be controlled to ensure smooth assembly of the monopole structure and its correct height after erection.

1.5.7 The structure shall be designed so that all parts shall be accessible for inspection and cleaning. Drain holes shall be provided at all points where pockets of depression are likely to hold water. The top end of the monopole, earthwire peaks and cross arms shall be suitably sealed with cover plate welded to the structure.

1.5.8 The length of any individual segment shall be such that it can be easily transported and erected. All similar parts shall be made strictly inter-changeable. Pole segments, as far as possible, shall be fabricated in single piece. Higher diameter

pole segments may be fabricated in two or more parts and kept minimum. The maximum permissible parts shall be as per follows:

Sr no	Maximum Outer diameter (D) of pole segment (mm)	Max permissible no of fabricated parts per pole segment/seams
1	$D < 600$	1
2	$600 \leq D < 1200$	2
3	$1200 \leq D < 1800$	3
4	$D \geq 1800$	4

1.5.9 Suitable provisions shall be kept in the design and detailing of monopole structures for easy erection at site using conventional as well as mechanized methods.

1.5.10 Design and detailing for providing step bolts/hooks/ladders etc. shall be done so that on provision of these, all parts of monopole structures are accessible and installation & maintenance of insulators, hardware assemblies, conductors etc. is possible. Design detailing for provision of other accessories viz. Anti-climbing device, Danger plate, Number, Phase plate etc. shall also be done.

1.5.11 **Material Cutting, Forming & Bending**

1.5.11.1 The required material cutting, forming and bending operations shall be carried out generally in accordance with the relevant sections of ASCE Manuals and reports on Engineering practice No.72 and ASCE-48-11 "Design of Steel transmission Pole Structures".

1.5.11.2 Before any cutting work is started, all steel plates shall be carefully straightened and trued by pressure and not by hammering. They shall again be trued after cutting & welding etc.

1.5.12 **Drilling and Punching**

1.5.12.1 Holes for bolts shall be drilled or punched with a jig but drilled holes shall be preferred. The tolerances regarding punch holes are as follows:

- a) Holes must be perfectly circular and no tolerance in this respect is permissible.
- b) The maximum allowable difference in diameter of the holes on the two sides of plates or angle is 0.8 mm i.e. the allowable taper in a punched hole should not exceed 0.8mm on diameter.

c) Holes must be square with the plates or angles and have their walls parallel.

1.5.12.2 All burrs left by drills or punch shall be removed completely. When the monopole structure members are in position, the holes shall be truly opposite to each other. Drilling or reaming to enlarge holes shall not be permitted.

### 1.5.13 **Welding**

1.5.13.1 All welding shall be in accordance with the latest revision of American Welding Society Structural Welding Code (ANSI/AWS D1.1) or other equivalent National/ International standards. Welding terms and symbols should comply with the AWS definitions and symbols.

1.5.13.2 Care should be exercised with respect to welding procedures, qualification of welders, operators and procedures, electrodes, preheat, notch toughness and minimum yield of the electrodes to ensure conformance with the requirements of the ANSI/AWS D1.1 code. Preheating shall be done according to the ANSI/AWS code or the steel producers' recommendations, or both. These details shall be included in MQP (Manufacturing Quality Plan) to be prepared and submitted by the Contractor.

### 1.5.14 **Erection mark**

1.5.14.1 Each individual member shall have erection mark conforming to the component number given to it in the fabrication drawings. The mark numbers shall be marked with marking dies of 16mm size before galvanizing and shall be legible after galvanizing.

1.5.14.2 Erection Mark shall be A-BB-CC-DDD

A = Employer's code assigned to the Contractors- Alphabet

BB = Contractor's Mark-Numerical

CC = Pole structure Type Alphabet.

DDD = Number mark to be assigned by Contractor - Numerical.

Erection mark for high tensile steel members shall be prefixed by the letter "H"

## 1.6 **Quantities and weights**

1.6.1 The provisional quantities required (including provisional spare monopole structure quantity) are mentioned in the respective Schedules of BPS. Final quantities shall be determined after completion and approval of the detailed route survey. The final quantities of monopole structure including spare monopole structures shall be confirmed by the Employer/ Site-in-charge based on

the requirement of quantities of various monopole structures after completion of detailed survey.

- 1.6.2 The Employer reserves the right to order the final quantities including required quantities of spares for which the rates quoted in the Bid shall be valid. Regarding quantity variation, the provisions of relevant clauses of SCC shall apply.
- 1.6.3 Though fully galvanised monopole structure parts are to be supplied, the weight of monopole structure shall mean the weight of monopole structure calculated by using the black sectional (i.e. ungalvanised) weight of steel members of the size indicated in the approved fabrication drawings and bill of materials, without taking into consideration the reduction in weights due to holes, notches and bevel cuts etc. but taking into consideration the weight of the D shackles, hangers, strain plates, pack plates, gusset plates, extension link/ plates and pack washers etc. The weight of strain plates, pack plates, extension link and gusset plates shall mean the weight of its circumscribing rectangle, without taking into consideration the reductions in weight due to holes, notches etc. The weight of D-shackles, hangers and pack washers shall be net actual weight taking into consideration reduction due to holes. For bolts and nuts along with spring washers and step bolts, the weight per monopole structure shall be calculated from the bolt schedule applicable to each type of monopole structures and body extensions as approved by the Employer. The rate quoted by the bidder for monopole structure/ monopole structure parts supply, is deemed to be inclusive of galvanising charges including the cost of zinc.
- 1.6.4 The contractor is permitted to get inspected and supply upto 2.5% extra fasteners to take care of losses during erection. No payment shall be admissible for these extra supplies.
- 1.6.5 Payment of the monopole structures shall be made on per structure basis as per the unit rates in the contract irrespective of any change in weight of structure estimated by the bidder at the time of the bidding vis-à-vis weight of structure as per actual tested and approved design.
- 1.6.6 Design of Pole structure extensions, which are not specified in the Final BPS of the Contract Agreement, but required during execution of the project and authorised by the Employer, shall have to be carried out by the Contractor. No additional payment on account of Design charges shall be payable.

The payment for pole structure extensions, not specified in BPS, shall be on pro-rata basis derived from the rates indicated in price schedule of Contract Agreement and final approved weight of the corresponding standard (+0m) pole.

## 1.7 Galvanizing

### 1.7.1 Fabricated Monopole structure Parts

The monopole structure parts and pack washers shall be hot dip galvanized. The galvanization shall be done as per requirements of IS 4759 after all fabrication work is completed. The contractor shall also take guidelines from the recommended practices for hot dip galvanizing laid down in IS 2629 while deciding and implementing galvanizing procedure. The mandatory requirements, however, are specified herein.

Unless otherwise specified, the fabricated monopole structure parts shall have a minimum overall Zinc coating of 610 gm per sqm of surface area except for plates & sections below 5mm which shall have Zinc coating of 460 gm per sqm of surface area. The average zinc coating for all sections and plates 5 mm & above shall be maintained as 87 microns and that for plates & sections below 5 mm shall be maintained as 65 microns.

The zinc coating shall be adherent, reasonably uniform, smooth, continuous and free from imperfections such as black/ bare spots, ash rust strains, bulky white deposits/ wet storage strains and blisters.

The surface preparation for fabricated monopole structure parts for hot dip galvanizing shall be carried out as indicated herein below:

- (i) **Degreasing & Cleaning of Surface:** Degreasing and cleaning of surface, wherever required, shall be carried out in accordance with clause 4.1 of IS 2629-1985. After degreasing the article shall be thoroughly rinsed. However, if acidic degreasers are used rinsing is not required.
- (ii) **Pickling:** Pickling shall be done using either hydrochloric or sulphuric acid as recommended at clause 4.3 of IS 2629:1985. The actual concentration of the acids and the time duration of immersion shall be determined by the Contractor depending on the nature of material to be pickled. Suitable inhibitors shall also be used with the acids to avoid over pickling. The acid concentration, inhibitors used, and maximum allowable iron content shall form part of plant standard to be formulated and submitted to employer along with Quality Assurance Program.
- (iii) **Rinsing:** After pickling, the material shall be rinsed, preferably in running water to remove acid traces, iron particles or any other impurities from the surface. Two rinse tanks are preferable, with water cascading from the second tank to the first to ensure thorough cleaning. Wherever single tank is employed, the water shall be periodically changed to avoid acid contamination, and removal of other residue from the tank.

- (iv) Fluxing: The rinsed article shall be dipped in a solution of Zinc ammonium chloride. The concentration and temperature of the flux solution shall be standardized by the contractor depending on the article to be galvanized and individual circumstances. These shall form part of plant standard to be formulated and submitted to employer along with Quality Assurance Program. The specific gravity of the flux solution shall be periodically monitored and controlled by adding required quantity of flux crystals to compensate for drag-out losses. Free acid content of the flux solution also shall be periodically checked and when it is more than two (2) grams of free acid per litre of the solution, it shall be neutralized. Alternatively, Ph value should be monitored periodically and maintained between 5.0 to 5.5.
- (v) Drying: When dry galvanizing is adopted the article shall be thoroughly dried after fluxing. For the purpose of drying, the contractor may use hot plate, air oven or any other proven method ensuring complete drying of the article after fluxing and prior to dipping in the molten zinc bath. The drying process shall be such that the article shall not attain a temperature at which the flux shall get decomposed. The article thus dried shall be galvanized before the flux coating picks up moisture from the atmosphere or the flux layer gets damaged or removed from the surface. The drying procedure, time duration, temperature limits, time lag between fluxing, drying, galvanizing etc shall form part of plant standard to be formulated and submitted to employer along with Quality Assurance Program.
- (vi) Quality of Zinc: Any one or combination of the grades of zinc specified in IS 209 or IS 13229 or other comparable international standard shall be used for galvanizing. The contractor shall declare the grade(s) of zinc proposed to be used by them for galvanizing. The molten metal in the zinc bath shall contain minimum 98.5 % zinc by mass. It shall be periodically measured and recorded. Zinc aluminum alloy shall be added as per IS 2629.
- (vii) Dipping Process: The temperature of the galvanizing bath shall be continuously monitored and controlled. The working temperature of the galvanizing bath shall be maintained at  $450 \pm 10^0$  C. The article should be immersed in the bath as rapidly as possible without compromising on safety aspects. The galvanizing bath temperature, immersion angle & time, time duration of immersion, rate of withdrawal etc. shall be monitored and controlled depending upon the size, shape, thickness and chemical composition of the article such that the mass of zinc coating and its uniformity meets the specified requirements and the galvanized surface is free from imperfections and galvanizing defects.
- (viii) Post Treatment: The article shall be quenched in water. The quench water is to be changed/ drained periodically to prevent corrosive salts from accumulating in it. If water quenching is not done then necessary cooling

arrangements should be made. The galvanized articles shall be dipped in chromating solution containing sodium dichromate and sulphuric acid or chromic acid base additive at a predetermined concentration and kept at room temperature to retard white rust attack. The temperature of the chromate solution shall not exceed 65<sup>0</sup> C. The articles shall not be stacked immediately after quenching and dichromating. It shall be ensured that the articles are dry before any further handling operation.

- (ix) Storing, Packing and Handling: In order to prevent white rust formation sufficient care should be exercised while storing handling and transporting galvanized products. The articles shall be stored in an adequately ventilated area. The articles shall be stored with spacers in between them and kept at an inclination to facilitate easy drainage of any water collected on the articles. Similar care is to be taken while transporting and storing the articles at site.

The Contractor shall prepare a detailed galvanizing procedure including Flow Chart with control parameters and all plant standards as required above and submit to POWERGRID for approval as part of Quality Assurance Plan.

In case of restriction due to the size of hot dip galvanising bath, pole segments having outer diameter more than 1m and upto 2.5m may be galvanized in two halves and then seamlessly welded. For pole segments having outer diameter more than 2.5m galvanizing shall be carried out in maximum four parts, and then seamlessly welded. After seamless welding of above parts, surface of the welded portion shall be cleansed and prepared. These welded portions shall be galvanized by metallizing using molten zinc technique. For metallizing, the process as per ANSI/AWS WCZ/D19.0-72 or other National/ International standard/Guidelines shall be followed. The thickness of zinc coating by metallizing shall not be less than the minimum specified for hot dip galvanizing.

#### 1.7.2 Fasteners

For fasteners, the galvanizing shall conform to IS 1367(Part-13). The galvanizing shall be done with centrifuging arrangement after all mechanical operations are completed. The nuts, may however be tapped (threaded) or rerun after galvanizing and the threads oiled. The threads of bolts & nuts shall have a neat fit and shall be such that they can be turned with finger throughout the length of the threads of bolts and they shall be capable of developing full strength of bolts. Spring washers shall be electro galvanized as per Grade-IV of IS 1573.

#### 1.8 Earthing

Each monopole structure shall be earthed. The monopole structure footing resistance shall not exceed 10 ohms. The Contractor shall measure the monopole structure footing resistance (TFR) of each monopole structure during dry weather after it has been erected and before the stringing of the earth wire. Pipe type earthing and counter poise type earthing shall be done as required in accordance with the following standards:

IS 3043 Code of practice for Earthing

IS 5613 Code of practice for Design, Installation and maintenance (Part-II/Section-2) of overhead power lines

1.8.1 The drawings for pipe & counterpoise type earthing are enclosed with these specifications.

1.8.2 For counterpoise type earthing, the earthing will vary depending on soil resistivity. For soil resistivity less than 1500 ohms-meter, earthing shall be established by providing 4 lengths of 30 m counterpoise wire. Otherwise, for soil resistivity greater than 1500 ohms meter earthing shall be established by providing 4 length of 70 m counterpoise wire.

1.8.3 The provisional quantities for pipe type earthing and counterpoise earthing are indicated in the BPS. The bidders are required to quote unit rates for the same in appropriate schedule of BPS. The quoted price shall include fabrication, supply and installation of earthing material including supply of coke, salt etc. In case of counterpoise type earthing, the unit rates shall correspond to 120/ 280 meters of counterpoise wire per monopole structure.

## 1.9 Testing of pole structure

### 1.9.1 General

1.9.1.1 Bidder shall offer single circuit/ double circuit pole structures which have already been designed & proto type tested conforming to minimum specified requirement stipulated in this specification. In case of non-availability of tested design of pole structures with the Contractor, design, optimization and prototype testing of that type of pole structures shall be required to be carried out by the Contractor at their own cost.

For design of other pole structures with extensions, the factor of safety in the design shall not be less than the factor of safety considered in the design of above proto tested pole structures.

1.9.1.2 The pole structures shall be proto type tested with the extension mentioned in the following table by the contractor at any testing station having facilities to test the structures. The proto type pole structures after inspection by employer shall be transported to the test bed by the Contractor. Testing of pole structure shall

generally conform to IS 802 (Part-III). The employer shall depute their representative at their own expense to witness the tests. The responsibility for design and successful proto type testing shall solely lie with the Contractor. At the time of proto-assembly and/ or proto testing, if any modification is required to be carried out, the same shall be carried out by the Contractor without financial implication to employer. These modifications, if any, shall also be incorporated on the fabrication shop drawings and/ or on the structural drawings.

Sl. no.	Voltage Level of Transmission Line	Extension
1	765kV S/C	Normal pole
2	400kv D/C (Quad)	
3	400kv D/C (Triple)	
4	400kV M/C (Twin-Twin)	
5	400kV D/C (Twin), 400kv S/C	Normal Pole+9m
6	220kV	
7	132kV	

1.9.1.3 A galvanized A galvanized pole structure of each type complete with specified extension shall be subjected to design and destruction tests by first applying test loads in a manner as approved by the Employer. The pole structure shall withstand these tests without showing any sign of failure or permanent distortion in any part. Thereafter, the pole structure shall be subjected to destruction by increasing the loads further in an approved manner . The pole structure shall be tested specified loading conditions as approved by employer. The Contractor shall submit to the Employer, for approval, the detailed programme and proposal for testing the pole structures showing the methods of carrying out the tests and manner of applying the loads. After the Employer has approved the test procedures and programmes the Contractors will intimate the Employer about carrying out the tests at least 30 days in advance of the scheduled date of tests during which the Employer will arrange to depute his representative to be present at the time of carrying out the tests. Six copies of the test reports shall be submitted. The Contractor shall submit one set of shop drawings alongwith the bill of materials at the time of prototype pole structure testing for checking the pole structure material. Further, at the time of submission of test report, the contractor has to submit the final drawings, shop drawings and Bill of materials for Employer’s reference and record.

1.9.1.4 In case of premature failure, the pole structure shall be retested and steel already used in the earlier test shall not be used again. However, in case of minor failures, the contractor can replace the members with higher section and carry out the testing. The Contractor shall provide facilities to the Employer or their representatives for inspection of materials during manufacturing stage and also during testing of the same. In case of any premature failure even during waiting period, the pole structure is to be retested with rectified members. However, if

the failures are major in nature and considerable portion of pole structure is to be re-erected, in such cases all the tests which has been carried out earlier are required to be re-conducted again in compliance with Specification.

- 1.9.1.5 No part of any pole structure subject to test shall be allowed to be used on the line.
- 1.9.1.6 The Contractor shall ensure that the specification of materials and workmanship of all pole structures actually supplied conform strictly to the pole structures which have successfully under gone the tests. In case any deviation is detected, the Contractor shall replace such defective pole structures free of cost to the Employer. All expenditure incurred in erection, to and fro transportation and any other expenditure or losses incurred by Employer on this account shall be full borne by the Contractor. No extension in delivery time shall be allowed on this account.
- 1.9.1.7 Each type of pole structure to be tested shall be a full-scale prototype galvanized pole structure and shall be erected vertically on rigid foundation. The pole structure erected on test bed shall not be out of plumb by more than 1 in 360.
- 1.9.1.8 All the measuring instruments shall be calibrated in systematic/ approved manner with the help of standard weight/ device. Calibration shall be done before commencing the test of each pole structure upto the maximum anticipated loads to be applied during testing.
- 1.9.1.9 The tension pole structure is to be tested with strain plate as per approved design/ drawings.
- 1.9.1.10 The sequence of testing shall be decided by the Employer at the time of approving the rigging chart/ test data sheet.
- 1.9.1.11 The Employer may decide to carry out the tensile test, bend test etc. as per the relevant IS/ DIN on few members of the test pole structure after completion of the test or in case of any premature failure. The Contractor shall make suitable arrangement for the same without any extra cost to the Employer.
- 1.9.1.12 Prefix 'T' shall be marked on all members of test pole structure in addition to the Mark No. already provided.
- 1.9.2 **Method of Load Application**
- 1.9.2.1 Loads shall be applied according to the approved rigging arrangement through normal wire attachments angles on bent plates.

1.9.2.2 The various types of loads, transverse, vertical and longitudinal shall be applied in such a way that there is no impact loading on the pole structure due to jerks from the winches.

1.9.2.3 All the loads shall be measured through a suitable arrangement of strain devices or by using weights. Positioning of the strain devices shall be such that the effect of pulley friction is eliminated. In case the pulley friction cannot be avoided, the same will be measured by means of standards weights and accounted for in the test loads.

### 1.9.3 Pole structure Testing Procedure

The procedure for conducting the pole structure test shall be as follows:

#### 1.9.3.1 Bolt Slip & joint adjustment test

In a bolt slip test, the test loads shall be gradually applied up to the 50% of design loads under normal condition, kept constant for two (2) minutes at that loads and then released gradually.

For measurement of deflection the initial and final readings on the scales (in transverse & longitudinal directions) before application and after the release of Loads respectively shall be taken with the help of theodolite. The difference between readings gives the values of the bolt slip.

#### 1.9.3.2 Normal Broken Wire Load Tests

All the loads, for a particular load-combination test, shall be applied gradually upto the full design loads in the following steps and shall also be released in the similar manner:

25 percent,

50 percent,

75 per cent,

90 percent,

95 percent and

100 percent

#### 1.9.3.3 Observation Periods

Under normal and broken wire load tests, the pole structure shall be kept under observation for sign of any failure for two minutes (excluding the time of adjustment of loads) for all intermediate steps of loading upto and including 95 percent of full design loads.

For normal, as well as broken wire tests, the pole structure shall be kept under observation for five (5) minutes (excluding the time for adjustment of loads) after it is loaded upto 100 percent of full design loads.

While the loading operation are in progress, the pole structure shall be constantly watched, and if it shows any tendency of failure anywhere, the loading shall be immediately stopped, released and then entire pole structure shall be inspected. The reloading shall be started only after the corrective measures are taken.

Full design loads for five (5) minutes, with no visible local deformation after unloading (such as bowing, buckling etc.) and no breakage of elements or constitute parts. The structure shall be considered to be satisfactory, if it is able to support the specified.

Ovalization of holes and permanent deformation of bolts shall not be considered as failure.

Further, for pole the maximum deflection during testing shall not exceed 8% of the height of the pole being tested for test load cases.

#### 1.9.3.4 **Recording**

The deflections of the pole structure in transverse and longitudinal directions shall be recorded at each intermediate and final stage of normal load and broken wire load tests by means of a theodolite and graduated scale. The scale shall be of about one metre long with marking upto 5 mm accuracy.

#### 1.9.3.5 **Destruction Test**

The destruction test shall be carried out under normal condition or broken wire condition. Under which load condition the destruction test is to be carried out shall be intimated to the contractor at the time of approving rigging chart/ test data.

The procedure for application of load for normal/broken wire test shall also be applicable for destruction test. However, the load shall be increased in steps of five (5) per cent after the full design loads have been reached till the load value reaches as specified in approved rigging chart or Monopole fails (whichever is earlier).

### 1.10 **Standards**

1.10.1 The design, manufacturing, fabrication, galvanising, testing, erection procedure and materials used for manufacture and erection of monopole structures, design and construction of foundations shall conform to the following Indian Standards (IS)/ International Standards which shall mean latest revisions, with amendments/

changes adopted and published, unless specifically stated otherwise in the Specification. In the event of supply of material conforming to Standards other than specified, the Bidder shall confirm in his bid that these Standards are equivalent to those specified. In case of award, salient features of comparison between the Standards proposed by the Bidder and those specified in this document will be provided by the Contractor to establish their equivalence.

1.10.2 The material and services covered under these specifications shall be performed as per requirements of the relevant standard code referred hereinafter against each set of equipment and services. Other internationally acceptable standards which ensure equal or higher performance than those specified shall also be accepted.

<b>Sl. No.</b>	<b>Indian Standard</b>	<b>Title</b>	<b>International Standard</b>
1	IS 209:1992	Specification for Zinc	
2	IS 278:1991	Galvanised Steel Barbed wire	
3	IS 800:1991	Code of Practice for General Building Construction in Steel	
4(a)	IS 802(Part 1) Sec 1-2015 Sec 2-2015	Code of Practice for General Building Construction in Steel in Overhead Transmission Line Pole:  Materials, loads and Permissible Stress  Section-1: Materials and loads Section-2: Permissible stresses.	
4(b)	IS 802(Part 2): 1990	Code of Practice for use of structural steel in Overhead Transmission Line:  Fabrication, Galvanising, inspection & Packing	
4(c)	IS 802(Part 3): 1990	Code of Practice for use of structural steel in Overload Transmission Line:  Pole testing	
5	IS 808:1991	Dimensions for Hot Rolled Steel Beam, Column, Channel and Angle Sections.	

Sl. No.	Indian Standard	Title	International Standard
6	IS 875:1992	Code of Practice for Design Loads (other than Earthquakes) for Buildings and Structures.	
7	IS 1363:1990	Hexagon Nuts (size range M5 to M36)	
8	IS 1367:1992	Technical Supply Conditions for Threaded Steel/ Fasteners	
9	IS 1477:1990	Code of practice for Painting of Ferrous Metals in Buildings: Part-I: Pre-treatment Part-II: Painting.	
10	IS 1573:1991	Electro-Plated Coatings of Zinc on iron and Steel	
11	IS 1852:1993	Rolling and Cutting Tolerances of Hot Rolled Steel Products	
12	IS 1893:1991	Criteria for Earthquake Resistant Design of Structures	
13	IS 2016:1992	Plain Washers	
14	IS 2062:1992	Steel for general structural purposes	
15	IS 2074:1992	Ready Mixed Paint. Air Drying, Oxide. Zinc Chrome, Priming Specification.	
16	IS 2551:1990	Danger Notice Plates	
17	IS 2629:1990	Recommended Practice for Hot Dip Galvanising of iron and steel.	
18	IS 2633:1992	Method of Testing Uniformity of Coating of Zinc Coated Articles	
19	IS3043:1991	Code of Practice for Earthing	
20	IS 3063:1994	Single coil Rectangular section Spring Washers for Bolts, Nuts Screws	
21	IS 3757: 1992	High Strength Structural Bolts	

Sl. No.	Indian Standard	Title	International Standard
22	IS:4759-1990	Specification for Hot zinc coatings on structural steel and other Allied products	
23	IS 5369:1991	General Requirements for Plain Washers	
24	IS 5613:1993	Code of Practice for Design installation and Maintenance of Overhead Power Lines  Section-1: Design Part 2, Section-2: Installation and Maintenance	
25	IS 6610:1991	Specification for Heavy Washers for Steel structures	
26	IS 6623:1992	High Strength Structural Nuts	
27	IS 6639:1990	Hexagon Bolts for Steel Structure.	
28	IS 6745:1990	Method for Determination of weight of Zinc coated iron and Steel Articles.	
29	IS 8500:1992	Specification for Weldable Structural Steel (Medium & High Strength Qualities)	
30	IS 10238:1989	Step Bolts for Steel Structures	
31	IS 12427:1988	Bolts for Transmission Line Poles	
32	Publication No. 19(N)/700	Regulation for Electrical Crossing of Railway Tracks	
33		Design of Steel Transmission Pole Structures.	ASCE 48-11
34		Design of Steel Transmission Pole Structures.	ASCE Manuals and reports on Engineering practice No. 72

The standards mentioned above are available from

Reference Abbreviation	Name and Address
BIS/IS	Beureau Of Indian Standards. Manak Bhavan, 9, Bahadur Shah Zafar Marg, New Delhi - 110001 INDIA
ISO	International Organisation for Standardization. Danish Board of Standardization Danish Standardizing Sraat, Aurehoegvej-12 DK-2900, Heeleprup, DENMARK
CSA	Canadian Standard Association 178, Rexadale Boulevard, Rexdale (Ontario) Canada, M9W 1R3
DIN	Deutsches Institute fiir Normung, Burggrafenstrasse 4-10 Post Farh 1107 D-1000, Berlin 30 GERMANY
ASTM	American Society for testing and Material 1916 Race Street Philadelphia. PA 1903-1187 USA
Indian electricity Rules Regulation for electricity crossing of railway Tracks	Kitab Mahal Baba Kharak singh Marg New Delhi-110001 INDIA
ASCE	American Society of civil Engineers 345 East 47 <sup>th</sup> Street New York, NY 10017-2398 USA
IEEE	Institute of Electrical and Electronics Engineers 445 Hoes LanePiscataway, NJ  0085-1331, USA
IEC	International Electro technical Commission, Bureau Central de la Commission, electro Technique international, 1 Rue de verembe,



## 2.0 Foundations

### 2.1 General

2.1.1 The scope of work for foundation shall include soil investigation, design, supply of materials such as cement, sand aggregates, reinforcement steel as well as all items of work related to supply and installation of foundations such as form work, excavation, anchor bolt/ stub setting, concreting, placement of reinforcement, shoring, shuttering, dewatering, stock piling, dressing, curing, backfilling etc. and any activity related to completion of foundation work.

2.1.2 The contractor shall carry out geotechnical investigation at every pole location. The price of geotechnical investigation at pole location is deemed to be included in the lump sum quoted price of foundation in BPS.

2.1.3 The bidder is required to quote in the relevant schedules of Bid Proposal Sheets, the composite rate of foundation per monopole structure for the foundations listed in the Bill of quantities. The composite rate quoted shall deem to include the complete scope of work as indicated above.

2.1.4 For the foundation types/ classifications listed in Bill of Quantities, the respective composite rate only shall be payable to the contractor irrespective of change in approved design volumes/ quantities in comparison to the estimated volumes/ quantities furnished at the time of bidding.

2.1.5 Design and Casting of Foundations which are not specified in the Final BPS of the Contract Agreement, but required during execution of the project and authorised by the Employer, shall have to be carried out by the Contractor. No additional payment on account of Design charges shall be payable. Payment for execution of such foundations shall be made on mutually agreed rates to be derived on the basis of rates available in the Contract during execution stage.

### 2.2 Type of Foundations

The foundation shall generally be either pier type or pile or screw pile type for monopole structures. However, for 132kV and 220kV pole structure, open cast type foundation is also permitted. The payment of foundation shall be restricted to the lump sum quoted price of foundation in BPS, irrespective of the type of foundation

#### 2.2.1 Classifications of Open Cast Foundations

Classification of foundations and design of foundation depend upon the type of soil, sub- soil water level and the presence of surface water which have been classified as follows:

**2.2.1.1 Normal dry**

To be used for locations where normal dry cohesive or non-cohesive soils are met. Foundations in areas where surface water encountered from rain runoff shall also be classified as normal dry.

**2.2.1.2 Sandy Dry Soil**

To be used for locations where cohesion less pure sand or sand with clay content less than 10% met in dry condition. If the clay content is more than 10 % met in dry condition, the foundation shall be classified as Normal Dry.

**2.2.1.3 Wet**

To be used for locations where sub-soil water table is met between 1.5 meters from ground level and the depth of foundation below the ground level.

**2.2.1.4 Wet Cultivated**

To be used for locations where there is no sub-soil water within the foundation depth but which are in surface water for long period with water penetration not exceeding one meter below the ground level e.g. paddy fields/cultivated field. However, if water penetration due to surface water is more than one meter below ground level, the adoption of suitable foundation shall be decided by site In-charge in consultation with corporate engineering department.

**2.2.1.5 Partially Submerged**

To be used at locations where sub-soil water table is met between 0.75 meter and 1.5metre below the ground level.

**2.2.1.6 Fully Submerged**

To be used at locations where sub-soil water table is met at less than 0.75 meter below the ground level.

**2.2.1.7 Black Cotton Soil**

To be used at locations where soil is clayey type, not necessarily black in colour, which shrinks when dry and swells when wet, resulting in differential movement. For designing foundations, for such locations, the soil is considered submerged in nature.

#### 2.2.1.8 Fissured Rock

To be used at locations where decomposed or fissured rock, hard gravel, kankar, limestone, laterite or any other soil of similar nature is met. Under cut type foundation is to be used for fissured rock locations.

In case of fissured rock locations, where water table is met at 1.5M or more below ground level, wet fissured rock foundations shall be adopted. Where fissured rock is encountered with subsoil water table less than 1.5 meter below ground level, submerged fissured rock foundations shall be adopted. In case of dry locations dry fissured rock foundations shall be adopted.

#### 2.2.1.9 Hard Rock

The locations where chiseling, drilling and blasting is required for excavation for monolithic rock for a particular leg/ pole, Hard rock type foundations are to be used. For these locations rock anchoring is to be provided to resist uplift forces. For quoting prices of Hard Rock foundations, Rock level shall be assumed at 1.5 meters below the ground level. Due to change in Rock level, no extra payment shall be payable on account of increase in concrete volume, excavation volume and weight of reinforcement. Also, no recovery shall be made if the actual volume of concrete, excavation and weight of reinforcement are less than that quoted in Schedule of prices. However, for design purpose, Rock level shall be considered at ground level and no over burden soil weight shall be considered for resisting the uplift.

2.2.2 The sub-soil water table is not constant and its level changes during different seasons due to various factors. In case during soil investigation/ trial pit or during excavation, if wet soil/ fissures rock is encountered within the foundation depth, it is to be considered that water table has been encountered (considering that water table had reached that level sometime in past) and accordingly type of foundation shall be classified.

2.2.3 Where soil is of composite in nature, classification of foundation shall be according to the type of soil predominant in the foundation pit.

2.2.4 The foundation classification at any particular location shall be based on the type of soil (clay/ sandy/ silt/ fissured rock etc.) and water table, presence of surface water, etc. at the location. However, in case of locations which are in vicinity of rivers, depending upon case to case, type of foundation is to be decided considering other aspects also e.g. in case RL (reduced level) of a location in comparison to the HFL is lower and there is possibility of submergence at the time of floods due to absence of river bunds/ protection etc., FS type foundation with suitable raised chimney/ Pedestal/ pier is to be adopted. Further in case there is a possibility of change in river course, considering the nature and turbulence of

probable water flow and subsequent scouring of soil, pile type or special foundation may be considered for these locations.

## 2.2.5 Design Parameters for Open Cast Foundations

2.2.5.1 The foundation designs shall depend upon the type of soil, soil properties, sub soil water level. Design of foundations for all pole structures and pole structures with extensions shall be developed by the contractor based on the typical soil properties as indicated below in the table.

### Soil Properties for open Cast type foundation

Sl. No	Properties of Soil	Ultimate Bearing Capacity in KN/M <sup>2</sup> (Kg/M <sup>2</sup> )	Angle of Repose (Degree)
1	<b>For Normal Soil (UP, Uttarakhand, Haryana, Delhi, Bihar, Jharkhand, WB, MP, Chhattisgarh, Kerala, J&amp;K, Ladakh, Assam, Andhra Pradesh, Telangana, Tamil Nadu)</b>		
	Normal Dry Soil	268 (27350)	30
	Wet Soil Due to Presence of Subsoil/ Surface Water	134 (13675)/ 268(27350)	15
	Black cotton Soil Due to Presence of Subsoil/Surface water and dry condition	134 (13675)	0
	Sandy Soil	268 (27350)	20
2	<b>For Normal Soil (Rajasthan)</b>		
	Normal Dry Soil	268 (27350)	25
	Wet Soil Due to Presence of Subsoil/ Surface Water	134 (13675)/ 268(27350)	10
	Black cotton Soil Due to Presence of Subsoil/Surface water and dry condition	134 (13675)	0
	Sandy Soil	268 (27350)	20
3	<b>For Normal Soil (Maharashtra)</b>		
	Normal Dry Soil	490(50000)	30
	Wet Soil Due to Presence of Subsoil/ Surface Water	122.5 (12500)/ 490(50000)	10
	Black cotton Soil Due to Presence of Subsoil/ Surface Water and dry condition	122.5 (12500)	0
4	<b>For Normal Soil (Himachal Pradesh)</b>		
	Normal Dry Soil	196 (20000)	30
	Wet Soil Due to Presence of Subsoil/ Surface Water	98 (10000)/ 196 (20000)	15
	Black cotton Soil Due to Presence of Subsoil/ Surface Water and dry condition	98 (10000)	0
	Sandy Soil	196 (20000)	20

5	<b>For Normal Soil (Karnataka)</b>		
	Normal Dry Soil	214.5 (21870)	30
	Wet Soil Due to Presence of Subsoil/ Surface Water	107.2 (10935)/ 214.5 (21870)	15
	Black cotton Soil Due to Presence of Subsoil/ Surface Water and dry condition	107.2 (10935)	0
	Sandy Soil	214.5 (21870)	20
6	<b>For Normal Soil (Odisha)</b>		
	Normal Dry Soil	256.5 (26175)	30
	Wet Soil Due to Presence of Subsoil/ Surface Water	183.8 (18750)/ 256.5 (26175)	15
	Black cotton Soil Due to Presence of Subsoil/ Surface Water and dry condition	183.8 (18750)	0
	Sandy Soil	256.5 (26175)	20
7	<b>For Normal Soil (Punjab)</b>		
	Normal Dry Soil	264.6 (27000)	30
	Wet Soil Due to Presence of Subsoil/ Surface Water	132.3 (13500)/ 264.6 (27000)	15
	Black cotton Soil Due to Presence of Subsoil/ Surface Water and dry condition	132.3 (13500)	0
	Sandy Soil	264.6 (27000)	20
8	<b>For Normal Soil (Gujarat)</b>		
	Normal Dry Soil	268 (27350)	30
	Wet Soil Due to Presence of Subsoil/ Surface Water	134 (13675)/ 268(27350)	15
	Black cotton Soil Due to Presence of Subsoil/ Surface Water and dry condition	107.8 (11000)	0
	Sandy Soil	268 (27350)	20
9	Fissured Rock		
	a) Fissured rock in dry portion	613 (62500)	20
	b) Fissured rock in presence of water	613 (62500)	10
10	Hard Rock	1225.83 (125000)	
11	Weight of earth for normal soil and black cotton soil	UNIT	VALUE
	a) Dry	KN/M3 (Kg/M3)	14.12 (1440)
	b) In presence of Surface Water	KN/M3 (Kg/M3)	14.12 (1440)
	c) In presence of Subsoil Water	KN/M3 (Kg/M3)	9.22 (940)
	12	Weight of Fissured Rock	
	a) Dry	KN/M3 (Kg/M3)	14.12 (1440)

	b) In presence of Subsoil Water	KN/M3 (Kg/M3)	9.22 (940)
13	Ultimate bond between Steel & Rock for Hard Rock foundations	KN/M2 (Kg/M2)	0.147 (15)

2.2.5.2 Type of foundation to be adopted for a particular location shall be decided based on above foundation design parameters and geotechnical investigation. Further, in case the soil parameters as per the geotechnical report are inferior, the same shall be adopted for design of foundation. However, no extra payment shall be payable to contractor and the payment of foundation shall be restricted to the lump sum quoted price of foundation in BPS.

### 2.2.6 Loads on Foundations

2.2.6.1 The foundations shall be designed to withstand the specific loads of the superstructure and for the foundation reactions obtained from the structural stress analysis in conformity with the relevant factors of safety.

2.2.6.2 The reactions on the foundation shall be composed of the following type of loads for which these shall be required to be checked:

- a) Max. Tension or uplift loads.
- b) Max. Compression or down-thrust loads.
- c) Max. Horizontal shear or side thrust.
- d) Max. Bending moment/ Overturning moment

### 2.2.6.3 Overload factor for Foundation loads:

The overload factor for foundation loads shall be considered as 1.1 i.e. the reaction on the foundations shall be increased by 10 percent.

### 2.2.6.4 Stability analysis

In addition to the strength design, stability analysis of the foundation shall be done to check the possibility of failure by over-turning, uprooting, sliding and tilting of the foundation.

## 2.3 Design of Foundations

2.3.1 Structural design of foundation shall be done by limit state method as per IS-456: 2010.

2.3.2 Pier type foundation, proposed to be adopted by bidder, shall be designed & constructed as per IS-456, IS-491 and prudent utility practices and applicable

national/ international standards/ practices so as to withstand all loads/ reactions due to pole structures. The soil strength factor shall be considered as 0.7.

- 2.3.3 Design & Construction of Pile type foundation shall conform to IS 2911.
- 2.3.4 In case of Screw anchor type foundations, design shall be as per applicable international standards and prudent utility practices. Detailed design calculations shall be submitted by the Contractor for approval of the Employer.
- 2.3.5 The construction drawings/ working drawings along with design calculation of foundations shall be submitted by the contractor for approval before execution.

## 2.4 Properties of Concrete

### 2.4.1 For open cast type foundations:

The cement concrete used for the foundations shall generally be of grade of M20. All the properties of concrete regarding its strength under compression, tension, shear, punching and bending etc. as well as workmanship will conform to IS 456.

- 2.4.1.1 The Quantity of minimum cement to be used per unit quantity of consumption shall be 400 kg for 1:1.5:3 nominal mix concrete. In this regard utilization record is to be maintained at site.

Weigh batching in place of volumetric batching (1:1.5:3) as an alternative may be adopted. Further, use of self loaders viz Ajax Fiori / small portable weigh batcher may be permitted for batching and mixing of concrete, subjected to compliance of following: -

- (i) Weight of cement, sand and aggregate equivalent to that of nominal mix of proportion 1:1.5:3 by volume basis shall be calculated. For finalisation of weight, average of 5 samples of cement, sand and aggregates shall be taken from measurement boxes. The volumetric conversions to the weight shall be noted and the same conversion shall be applied to the entire location.
- (ii) For every change in source of sand/ aggregates, the weights shall be recorded.
- (iii) The minimum cement content shall remain same i.e. 400 kg/m<sup>3</sup>.
- (iv) Calibration certificate of self-loader/concrete producing equipment shall be checked before start of concreting works. The accuracy of the measuring equipment shall be within +/- 2% of the quantity of cement and within +/-3% of the quantity of aggregate.
- (v) Preferably, print out of each load indicating weight of all the constituent's material i.e. Cement, Fine Aggregate, Coarse Aggregate, Water, Admixture (If any) is to be ensured or proper records shall be maintained to ensure weight of constituents materials.
- (vi) Necessary modification in weight of fine aggregate due to bulkage may be taken care in weigh batching. Water cement ration due to moisture content shall be suitably adjusted.
- (vii) Concreting using RMC (Ready Mix Concrete) may also be carried out with weight ratio to be calculated as per S.No. (i) above.

- 2.4.1.2 Alternatively, Ready Mix concrete from batching plant as per IS 4925 can also be used with no extra payment and without any recovery. However, Cement content shall be as per IS 456. The ready-mix concrete shall conform to IS 4926. The selection and use of Materials for the ready-mix concrete shall be in accordance with IS:456. The concrete shall be of M25 grade design mix as per IS 456. However, minimum cement content shall not be less than 330 kg/m<sup>3</sup>. The transport of concrete and transportation time shall be as per IS 4926.
- 2.4.1.3 Use of small batching machines/ self-loading mixers may be allowed after verification of cement consumption and mix by Employer site in-charge. The equipment shall have facility of checking the proportion of ingredients of concrete being made. The records of mix shall be maintained at site. The calibration of equipment shall be done at regular intervals.
- 2.4.2 For Pier/ Pile type foundations:
- 2.4.2.1 Concrete for Pile/ Pier type foundation shall be M25 grade design mix as per IS 456 or readymade mix as specified in 2.4.1.2. However, minimum cement content shall not be less than 330 kg/m<sup>3</sup>.
- 2.4.3 The Cement used shall be ordinary Portland Cement, unless mentioned otherwise, conforming to the latest Indian Standard Code IS 269 or IS 8112 or IS 12269.

Alternatively, other varieties of cement other than ordinary Portland Cement such as Portland Pozzolana Cement conforming to IS 1489 (latest edition) or Portland Slag Cement conforming to IS 455 (Latest edition) can also be used. The Contractor shall submit the manufacturer's certificate, for each consignment of cement procured, to the Employer. However, Employer reserves the right to direct the Contractor to conduct tests for each batch/ lot of cement used by the Contractor and Contractor will conduct those tests free of cost at the laboratory so directed by the Employer. The Contractor shall also have no claim towards suspension of work due to time taken in conducting tests in the laboratory. Changing of brand or type of cement within the same structure shall not be permitted without the prior approval of the Employer. Sulphate Resistant Cement shall be used if Sulphate content is more than the limits specified in IS:456, as per Geotechnical investigation report.

Ordinary Portland Cement (OPC) and Portland Pozzolana Cement (PPC) or Portland Slag Cement are Technically Equivalent and there would not be any financial implication / or recovery to be borne by Employer / Contractor. However, the minimum cement content shall be as per above table for nominal mix concrete.

- 2.4.4 Coarse and fine aggregates shall conform to IS 383:2016.
- 2.4.5 The water used for mixing concrete shall be fresh, clean and free from oil, acids & alkalis, organic materials or other deleterious substances.
- 2.4.6 Reinforcement shall conform to IS 1786 for high strength steel bars (Fe 500/ Fe500D). If mentioned in BPS, epoxy coated reinforcement conforming to IS 13620 shall be used. Thermo Mechanically Treated (TMT) bars (equivalent grade) in place of cold twisted bars are also accepted. Hard drawn steel wire shall conform to IS 432. All reinforcement shall be clean and free from loose mill scales, dust, loose rust and coats of paint, oil or other coatings, which may destroy or reduce bond. Contractor shall supply, fabricate and place reinforcement to shapes and dimensions as indicated or as required to carry out the intent of approved foundation drawings and Specifications. The contractor may also use pre-fabricated/assembled reinforcement cage conforming to shape, dimension, size as per approved foundation drawing. Spacers, chairs, stays, hangers, overlaps and annealed steel wire for binding etc. as may be necessary, should be used for proper completion of the foundation job as per requirement. Spacers or chairs should be placed at a maximum spacing of 1m and closer spacing shall be provided wherever necessary.
- 2.4.7 Use of crushed stone in place of natural sand, in case of non-availability or restriction by local authority, may be allowed by Employer site in-charge subject to sieve analysis meeting acceptance criteria as per relevant IS and complying of other requirement as per standard field quality plan.
- 2.4.8 For foundation in coastal areas or creek or aggressive soil areas or under marine environment, if mentioned in BPS, Ready Mix Concrete of M30 Grade shall be used to avoid use of locally available saline water. However, design mix concrete of M30 Grade conforming to IS 456 with potable water can be used at locations where transportation of ready-mix concrete is not feasible. Minimum cement content in any case shall not be less than 330kg/m<sup>3</sup>. The surface of the reinforcement steel shall be treated with epoxy based coating to enhance corrosion performance of foundation. Use of epoxy coated reinforcement in foundation shall be as per IS 13620. In addition, 02 (two) numbers of coats of bituminous painting of minimum 1.6 kg/m<sup>2</sup> per coat shall be applied on all the exposed faces of the foundation (i.e. pedestal & base slab). Double coat 20 mm thick cement plaster shall be provided on all exposed concrete surface as well up to 300 mm below ground level to give protection to concrete surface from environmental and saline effect. Before coping of chimney top portion, three coats of anti-corrosive paint of minimum 30-35 microns dry film thickness each shall be applied on the stub in the 50 mm coping portion as well as up to 350mm above CL portion. Cost of the above shall be deemed to be included in the rates quoted.

## 2.5 Construction of Monopole structure Foundation,

The contractor shall submit detailed methodology for construction of foundation for monopole structures to Employer's site in-charge. The construction methodology shall conform to applicable standards and prudent utility practices and safety norms.

## 2.6 Setting of Anchor bolt

2.6.1 The anchor bolts shall be set correctly in accordance with approved method at the exact location & alignment and precisely at correct levels with the help of anchor bolt setting templates, if required, and leveling instrument. Anchor bolts shall be set in the presence of Employer's representative available at site and for which adequate advance intimation shall be given to the Employer by the Contractor.

2.6.2 Setting of anchor bolts at each location shall be approved by the Employer's representative

## 2.7 Mixing, Placing and Compacting of Concrete

2.7.1 The concrete shall be mixed in the mechanical mixer. However, in case of difficult terrain, hand mixing may be permitted at the discretion of the Employer. The water for mixing concrete shall be fresh, clean and free from oil, acids and alkalis. Saltish or blackish water shall not be used.

Alternatively, Ready Mix concrete from batching plant as per IS 4925 can also be used with no extra payment and without any recovery. However, Cement content shall be as per IS 456. The ready-mix concrete shall conform to IS 4926. The selection and use of Materials for the ready-mix concrete shall be in accordance with IS:456. The concrete shall be of M25 grade design mix as per IS:456. The transport of concrete and transportation time shall be as per IS 4926. Record of delivery ticket information as per Annexure-G of IS 4926 has to be maintained.

2.7.2 Mixing shall be continued until there is uniform distribution of material and mix is uniform in colour and consistency, but in no case the mixing be carried out for less than two minutes. Normal mixing shall be done close to the foundation but exceptionally, in difficult terrain, the concrete may be mixed at the nearest convenient place. The concrete shall be transported from the place of mixing to the place of final deposit as rapidly as practicable by methods which shall prevent the segregation or loss of any ingredient. The concrete shall be placed and compacted before setting commences.

2.7.3 If minor defects in concrete surface is found after the form work has been removed, the damage shall be repaired with a rich cement sand mortar to the satisfaction of the Employer before the foundation is back filled.

## 2.8 Curing

The concrete shall be cured by maintaining the concrete wet for a period of at least 10 days after placing. Once the concrete has set for 24 hours the pit may be backfilled with selected moistened soil. The exposed concrete shall also be kept wet by wrapping gunny bags around it and wetting the bags continuously during the initial 10 days period.

## 2.9 Benching

When the line passes through undulated terrain, levelling the ground may be required for casting of monopole structure foundations. All such activities shall be termed benching and shall include cutting of excess earth and removing the same to a suitable point of disposal as required by Employer. Benching shall be resorted to only after approval from Employer. Volume of the earth to be cut shall be measured before cutting and approved by Employer for payment purposes.

## 3.0 Monopole structure Erection

### 3.1 General

3.1.1 The scope of erection work shall include the cost of all labour, tools and plant such as mechanized rope way, wherever required, for hilly areas for transportation of materials and all other incidental expenses in connection with erection work.

3.1.2 The Contractor shall be responsible for transportation to site of all the materials to be supplied by the Contractor as well as proper storage and preservation of the same at his own cost, till such time the erected line is taken over by the Employer. Similarly, the Contractor shall be responsible for transportation, proper storage, safe custody, and loss or damage of all Employer's supplied items for incorporation in the lines and shall maintain and render proper account of all such materials at all times. The Contractor shall reimburse the cost of any of the materials lost or damaged during storage and erection over and above specified and permitted in the technical specifications.

3.1.3 Contractor shall set up required number of stores along the line and the exact location of such stores shall be discussed and agreed upon with the Employer. Employer during the kick off meeting at site supplied items shall be dispatched to the stores set up by the Contractor.

### 3.2 Treatment of Minor Damage

Minor defects in hot-dip galvanized members shall be repaired by applying zinc rich paint to the satisfaction of the Employer before erection.

### 3.3 Assembly

The Contractor shall give complete details of the erection procedures he proposes to follow.

3.3.1 The method for the erection of pole structures shall ensure the following:

- a) Straining of the members shall not be permitted for positioning. It may, however, be necessary to match hole positions at joints using tommy bars not more than 450mm in length
- b) The bolt positions in assembled pole structures shall be as per IS 5613 (Part II/Section 2);
- c) Pole structure shall be fitted with number, danger, Bird guard, circuit plate, pole plate and phase plates as well as anti-climbing device, as described;
- d) After complete erection of the pole structure, all blank holes, if any, are to be filled by bolts and nuts of correct size.
- e) The monopole structures shall not be out of vertical by more than 1 in 360 before stringing is carried out.

### **3.4 Tightening of Bolts and Nuts**

3.4.1 All nuts shall be tightened properly using correct size spanner and preferably using torque wrench. Before tightening, it will be verified that filler washers and plates are placed in relevant gap between members, bolts of proper size and length are inserted, and one spring washer is inserted under each nut. In case of step bolts, spring washers shall be placed under the outer nuts. The tightening shall progressively be carried out from the top downwards, care being taken that all bolts at every level are tightened simultaneously. The threads of bolts projecting outside the nuts shall be punched at their position on the diameter to ensure that the nuts are not loosened in course of time. If, during tightening, a nut is found to be slipping or running over the bolt threads, the bolt together with the nut shall be replaced.

3.4.2 The threads of all the bolts projected outside the nuts shall be welded at two diametrically opposite places; the circular length of each welding shall be at least 10 mm. The welding shall be provided from ground level up to waist level for pole structures subject to maximum 30 m height from ground level. After welding the surface of welding shall be cleaned, dried and made free of oil, grease and corrosion product and on this surface Zinc Rich Paint shall be applied by means of a brush according to the paint manufacturer's recommendations. Zinc Rich Paint, Pre-mixed type paint, based on organic/ inorganic binders specially formulated for steel surfaces may be used. The dried film of Zinc Rich Paint should contain a minimum of 92 percent Zinc Dust by mass. The cost of welding and paint including application of paint shall be deemed to be included in the erection price.

### **3.5 Final checking, Testing and Commissioning**

After completion of the works, final checking of the line shall be carried out by the Contractor to ensure that all foundation works and pole structure erection have been done strictly according to the specifications and as approved by the Employer. All the works shall be thoroughly inspected in order to ensure that:

- a) Sufficient backfilled earth covers each foundation pit and is adequately compacted;
- b) Concrete chimneys and their copings are in good condition and finely shaped.
- c) All pole structure members are used strictly according to final approved drawing and are free of any defect or damage whatsoever.
- d) All bolts are properly tightened, punched, tack welded and painted with zinc rich paint;
- e) All other requirements for completion of works such as fixing of danger plate, phase plate, number plate, anti-climbing device and aviation signal have been fulfilled.
- f) Wherever required, that proper revetment (erosion protection) is provided;
- g) The original tracings of profile and route alignment as well as monopole structure design, structural drawings, bill of material and shop drawings of all monopole structures are submitted to the *Employer* for reference and record.
- h) All monopole structures are properly grounded.

3.5.1 The contractor should also fulfill the requirements of pre-commissioning procedure as given in **Appendix-I of Section -IVC** to this Specification

#### 4.0 Field Quality Plan

The Contractor shall execute the work in accordance with the Field Quality Plan which is available on the POWERGRID Website 7 (seven) days prior to the actual date of bid opening. In this Standard Field Quality plan, the word “pole” as mentioned shall be treated as Mono Pole structures.

#### 5.0 Manufacturing Quality Plan

Manufacturing quality plan of monopole structure shall be submitted by the contractor to Employer’s QA&I department Monopole structure manufacturing shall be carried out in accordance with Manufacturing Quality plan approved by the employer prior to manufacturing of Monopole structures. In this Manufacturing Quality Plan, the word “pole” as mentioned shall be treated as Monopole structures.

# SECTION-V

## GALVANISED STEEL EARTHWIRE

TECHNICAL SPECIFICATIONS

SECTION-V

GALVANISED STEEL EARTHWIRE

Revision History

Revision No.	Date	Clause Ref	Description
Rev-0	June'2021		First Release
Rev-1	May'2024	Annexure-B	Second Release

**TECHNICAL SPECIFICATIONS**

**SECTION-V**

**GALVANISED STEEL EARTHWIRE**

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## TECHNICAL SPECIFICATIONS

### SECTION- V

#### GALVANISED STEEL EARTHWIRE

#### 1.0 Technical Description

#### 1.1 Details of Earth wire

1.1.1 The galvanised steel earth wire shall generally conform to IS12776 except where otherwise specified herein.

#### 1.1.2 Standard Technical Particulars

The standard Technical Particulars (STP) of Earthwire is enclosed at Annexure-B of this section. The values indicated in the STP are the minimum and/or maximum values required to be met by the supplier.

#### 1.2 Workmanship

1.2.1 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.

1.2.2 The finished material shall have minimum brittleness as it will be subjected to appreciable vibration while in use.

1.2.3 The steel strands shall be hot dip galvanized and shall have minimum Zinc coating after stranding, as stipulated in Standard Technical Particulars attached with. The zinc coating shall be smooth, continuous, of uniform thickness, free from imperfections. 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 characteristics as prescribed in STP.

1.2.4 The steel strands shall be pre-formed and post-formed in order to prevent spreading of strands while cutting of composite earth wire. Care shall be taken to avoid damage to galvanization during performing and post forming operation.

1.2.5 To avoid susceptibility towards wet storage stains (white rust), the finished material shall be provided with a protective coating of boiled linseed oil.

#### 1.3 Joints in Wires

There shall be no joint of any kind in the finished steel wire strand entering into the manufacture of the earth wire. There shall be no strand joints or strand splices in any length of the completed stranded earth wire.

#### 1.4 Tolerances

The manufacturing tolerance to the extent of the limits as stipulated in Standard Technical Particulars attached with this specification shall only be permitted in the diameter of the individual steel strands and lay length of the earth wire.

#### 1.5 Materials

##### 1.5.1 Steel

The steel wire strands shall be drawn from high carbon steel rods and the chemical composition shall conform to the requirements as stipulated in Standard Technical Particulars attached with.

##### 1.5.2 Zinc

The zinc used for galvanising shall be electrolytic High Grade Zinc and shall conform to the requirements of IS 209.

#### 1.6 Standard Length

1.6.1 The standard length of the earth wire shall be as stipulated in Standard Technical Particulars attached with, with the specified tolerance on standard length.

1.6.2 Random length will be accepted provided no length is less than 70% of standard length and the total quantity of random lengths is not more than ten (10) percent of the total quantity in each shipment.

#### 2.0 Tests and Standards

##### 2.1 Type Tests

The following tests shall be conducted on sample/ sample(s) of the earthwire required under the package from manufacturing works from which the earthwire is to be manufactured & supplied: -

a)	DC resistance test	Annexure-A
b)	UTS test on stranded earthwire	

2.1.1 Type tests specified under Clause 2.1 shall not be required to be carried out if supplier has conducted these tests earlier on the same type of earthwire and valid type test certificates are available. The test certificate shall be considered valid if,

- i) Tests conducted earlier is either conducted in accredited laboratory (accredited based on ISO/IEC vide 25/ 17025 or EN 45001 by the National accreditation body of the country where laboratory is located) or witnessed by the representative(s) of POWERGRID or utility and
- ii) Type test reports contain valid Calibration reports of the relevant testing equipment and information pertaining to ratings, the relevant drawings, model number, test circuit, calculations (if any), photos, acceptance

criteria/values specified in Technical Specification/relevant standards (IS/ IEC) and compliance to the same and

- iii) Tests conducted on the samples of earthwire manufactured from same manufacturing works within 10 (ten) years as on the date of NOA for the package.

Further, test certificates of samples manufactured from same manufacturing works shall also be considered valid, if the same has already been approved/ accepted by POWERGRID & tests have been conducted within the above-mentioned validity period.

In case the tests have been conducted earlier than the above stipulated period or carried out on samples manufactured from any other manufacturing works or in case of revision/ amendment in the provisions/ test procedure of the IS/IEC as referred in the TS or in the event of any discrepancy in the test report (i.e. due to non-inclusion of valid calibration certificate, desired information etc. or any test not applicable due to any design/ material/ manufacturing process change including substitution of components or due to non-compliance with the requirement stipulated in the Technical Specifications), the tests shall be conducted by the supplier at no extra cost to the purchaser.

**2.2 Acceptance Tests**

a)	Visual and dimensional check on drum	Annexure-A
b)	Visual check for joints, scratches etc. and lengths measurement of earthwire by rewinding	
c)	Measurement of diameter of individual steel strands	
d)	Check for lay-length	
e)	Galvanising test	
f)	Torsion and elongation test	
g)	Breaking load test	
h)	Wrap test	
i)	DC resistance test	
j)	Barrel strength test on wooden drum	
k)	Chemical Analysis of steel	

### 2.3. Routine Tests

a)	Check for correctness of stranding
b)	Check that there are no cuts, fins etc. on the strands
c)	Check that drums are as per Specification

### 2.4. Tests During Manufacture Earthwire

a)	Chemical analysis of zinc used for galvanising	Annexure-B
b)	Chemical analysis of steel	Annexure-B

### 2.5 Testing Expenses

2.5.1 In the event of type testing, bidders shall indicate the laboratories in which they propose to conduct the type tests. They shall ensure that the tests can be completed in these laboratories within the time schedule.

2.5.2 In case of failure in any type test the Contractor is either required to manufacture fresh sample lot and repeat the entire test successfully once or repeat that particular type test three times successfully on the sample selected from the already manufactured lot at his own expenses. In case fresh lot is manufactured for testing then the lot already manufactured shall be rejected. The decision of the Employer in this regard shall be final and binding on Contractor.

2.5.3 The entire cost of testing for the type, acceptance and routine tests and tests during manufacture specified herein shall be treated as included in the quoted unit price except for the expenses of the inspector/ Employer's representative.

2.5.4 In case of failure in any type test, repeat type tests are required to be conducted, then all the expenses for deputation of Inspector/ Employer representative shall be to the supplier's account. Also, if on receipt of the Contract's notice of testing the Employer's representative/ Inspector does not find the test samples or testing facilities/ equipment ready for testing, the expenses incurred by the Employer for re-deputation shall be to the supplier's account.

### 2.6 Additional Tests

2.6.1 The Employer reserves the right of having at his own expenses any other test(s) of reasonable nature carried out at Contractor's premises, at site, or in any other place in addition to the aforesaid type, acceptance and routine tests to satisfy himself that the materials comply with the Specifications.

2.6.2 The Employer also reserves the right to conduct all the tests mentioned in this specification at his own expense on the samples drawn from the site at Contractor's premises or at any other test center. In case of evidence of non-compliance, it shall be binding on the part of Contractor to prove the compliance of the items to the technical specifications by repeat tests, or correction of deficiencies, or replacement of defective item all without any extra cost to the Employer.

## **2.7 Sample Batch For Type Testing**

2.7.1 In case the type tests are required to be carried out, the samples for type testing shall be manufactured in accordance with the Standard Manufacturing Quality Plan.

2.7.2 The Contractor shall offer at least three drums for selection of sample required for conducting all the type test.

2.7.3 The Contractor is required to carry out all the Acceptance tests successfully in presence of Employer's representative before sample selection.

## **2.8 Test Reports**

2.8.1 In case type tests have been carried out earlier by the supplier and valid type test reports are available as specified in clause 2.1.1 above, the supplier shall submit one copy of the test report along with approval letter issued by Employer or utility.

2.8.2 In case fresh type tests have been carried out under the package, type test reports shall be furnished in original alongwith two copies. One copy will be returned duly certified by the Employer.

2.8.3 The commercial production of the earthwire can be taken up by the supplier after clearance from the purchaser.

2.8.4 Record of routine test reports shall be maintained by the Contractor at his works for periodic inspection by the Employer's representative.

2.8.5 Test Certificates of tests during manufacture shall be maintained by the Contractor. These shall be produced for verification as and when desired by the Employer.

## **2.9 Inspection**

2.9.1 The Employer 's representative shall at all times be entitled to have access to the works and all places of manufacture, where earth wire shall be manufactured and representative shall have full facilities for unrestricted inspection of the Contractor's works, raw materials and process of manufacture for conducting necessary tests as detailed herein.

2.9.2 The Contractor shall keep the Employer informed in advance of the time of starting and of the progress of manufacture of earth wire in its various stages so that arrangements can be made for inspection.

2.9.3 No material shall be dispatched from its point of manufacture before it has been satisfactorily inspected and tested, unless the inspection is waived off by the Employer in writing. In the latter case also the earth wire shall be dispatched only after satisfactory testing for all tests specified herein have been completed.

2.9.4 The acceptance of any quantity of material shall in no way absolve the Contractor 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.

## **2.10 Test Facilities**

2.10.1 The following test facilities shall be available at the Contractor's works:

- a) Various testing and measuring equipment for carrying out specified acceptance tests, routine tests and tests during manufacture inter alia including tensile testing machine, resistance measurement facilities, torsion & wrap testing machine, dimension checking instruments viz. digital vernier and micrometer etc., galvanizing test instruments viz. digital elcometer and standard preece test etc., burette, digital thermometer, barometer etc.
- b) Digital milli/micro ohm meter along with standard resistance for calibration of resistance bridges.
- c) Finished Earth wire shall be checked for length verification and surface finish on separate rewinding machine at reduced speed (variable from 8 to 16 meters per minute). The rewinding facilities shall have appropriate clutch system and free of vibrations, jerks etc., with traverse laying facilities.

## **2.11 Packing for Earth wire**

2.11.1 The Earth wire shall be supplied in non-returnable, strong, wooden drums and provided with lagging of adequate strength, constructed to protect the Earth wire against all damage and displacement during transit, storage and subsequent handling and stringing operations in the field. The Contractor shall be responsible for any loss or damage during transportation handling and storage due to improper packing. The drums shall generally conform to IS:1778-1980, except as otherwise specified hereinafter.

2.11.2 The drums shall be suitable for wheel mounting and for letting off the earth wire under a minimum controlled tension of the order of 5 kN

2.11.3 The standard drawing of the drum for earthwire is enclosed with the specification. The Bidder shall supply the earthwire in the drum conforming to the standard drawing only.

2.11.4 For Earth wire, two standard lengths shall be wound on each drum.

- 2.11.5 For Earth wire, each strand shall be individually welded to prevent parting of two lengths at a tension less than 15 kN. The two ends where the first length finishes and the second length starts, shall be clearly marked with adhesive tape and no weld should be present outside these marks. The length between the two marks shall be treated as scrap and will not be taken into account for measurement purposes.
- 2.11.6 All wooden components shall be free from defects that may materially weaken the component parts of the drums. Preservative treatment shall be applied to the entire drum with preservatives of a quality which is not harmful to the earth wire.
- 2.11.7 As an alternative to non-returnable wooden drums, bidder may supply the earthwire in returnable steel drum. However, for bid evaluation purpose, both types of drums shall be treated at par and bidder may quote accordingly.
- 2.11.8 The empty steel drums shall be taken back by the contractor/ supplier as & when these are available after usage of earthwire. However, 2% of the total drums shall not be returned to the contractor/ supplier as these may be used for storage of spare earthwire by the purchaser.
- 2.11.9 The steel drums may get damaged and/or wear & tear during transportation, normal handling & operation at site, which shall be rectified by the supplier before re-use.
- 2.11.10 Solid Polypropylene sheet of minimum 5mm thickness shall be used for outer covering of earthwire in steel drum. Outside the covering, there shall be minimum two binders consisting of hoop iron/ galvanised steel wire. Two numbers of additional binders per drum shall also be supplied for re-wrapping the polypropylene sheet with each lot of earthwire and 5 nos. crimping machines with the first lot of earthwire for crimping the binders at site. As an alternative, supplier may use wooden lagging of minimum 50 mm thickness for outer covering of earthwire without any extra financial implication to the purchaser.
- 2.11.11 Before reeling, cardboard or double corrugated or thick bituminous waterproof bamboo paper shall be secured to the drum barrel and inside of flanges of the drum by means of a suitable commercial adhesive material over which HDPE sheet to be provided. After reeling the earth wire, the exposed surface of the outer layer of earth wire shall be wrapped with self-adhesive plastic sheet to preserve the earth wire from ingress of water dirt, grit and damage during storage transport and handling.
- 2.11.12 The earth wire ends shall be properly sealed and secured on the side of one of the flanges to avoid loosening of the earth wire layers during transit and handling.
- 2.12 Marking**
- Each drum shall have the following information stenciled on it in indelible ink along with other essential data

- a) Contract/Award letter number.
- b) Name and address of consignee.
- c) Manufacturer's name and address.
- d) Drum number
- e) Size of earth wire
- f) Length of earth wire in meters
- g) Gross weight of drum with earth wire & lagging
- h) Weight of empty drum with lagging
- i) Arrow marking for unwinding
- j) Position of the earth wire ends
- k) Number of turns in the outer most layer
- l) Barrel diameter at three locations and an arrow marking at the location of measurement
- m) CIP/MICC No.

### 2.13 Verification of Earth wire Length

The Employer reserves the right to verify the length of earth wire after unreeling. The quantity for verification shall be between a minimum of five percent (5%) to a maximum of ten percent (10%) in a lot offered for inspection. The actual quantity will be discussed and mutually agreed to by the supplier & purchaser.

### 2.14 Standards

The earth wire shall conform to the following Indian Standards, which shall mean latest revisions, amendments/changes adopted and published, unless otherwise in the Specification.

In the event of the supply of earth wire conforming to standards other than specified, the Contractor shall confirm in his bid that these standards are equivalent to those specified. In case of award salient features of comparison between the standards proposed by the Contractor and those specified in these documents will be provided by the Contractor to establish their equivalence.

Sl. No.	Indian Standard	Title
1	IS 209	Specification for zinc
2	IS 12776	Galvanized Strand for Earthing-Specification
3	IS 1778	Reels and Drums for Bare Conductors
4	IS 2629	Recommended Practice for Hot Dip Galvanizing of Iron and Steel
5	IS 2633	Method of Testing Uniformity of Coating on Zinc Coated Articles
6	IS 4826	Galvanized Coating on Round Steel Wires

7	IS 6745	Methods of Determination of Weight of Zinc Coating of Zinc Coated Iron and Steel Articles
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The standards mentioned above are available from:

Reference Abbreviation	Name and Address
BIS/IS	Beureau Of Indian Standards. Manak Bhavan, 9, Bahadur Shah Zafar Marg, New Delhi 110001 India

### 3.0 Manufacturing Quality Plan

Earthwire manufacturing shall be carried out in accordance with Standardized Manufacturing Quality plan as given in the Appendix -I of this section

Annexure-A

**1.0 Tests on Earth wire**

**1.1 DC Resistance Test**

An earth wire sample of minimum 5m length two contact clamps shall be fixed with a predetermined bolt torque. The resistance shall be measured by a Kelvin double bridge by placing the clamps initially at zero meter and subsequently one meter apart. The test shall be repeated at least five times and the average value recorded. The value obtained shall be corrected to the value at 20°C. The test results shall conform to the requirement specified in the STP.

**1.2 UTS Test on stranded earthwire**

Circles perpendicular to the axis of the earth wire shall be marked at two places on a sample of earth wire of minimum 5 m length suitably compressed with dead end clamps at either end. The load shall be increased at a steady rate up to 50% of UTS and held for one minute. The circles drawn shall not be distorted due to relative movement of strands. Thereafter the load shall be increased at steady rate to 100% of UTS and held for one minute. The earth wire sample shall not fail during this period. The applied load shall then be increased until the failing load is reached and the value recorded.

**1.3 Visual and Dimensional Check on Drums**

The drums shall be visually and dimensionally checked to ensure that they conform to the requirements of this Specification.

**1.4 Visual Check for Joints, Scratches etc. and Length measurement of Earth wire by rewinding**

Ten percent drums from each lot shall be rewound in the presence of the Employer. The Employer shall visually check for scratches, joints etc. and see that the earth wire generally conforms to the requirements of this Specification. The length of earth wire wound on the drum shall be measured with the help of counter meter during rewinding.

**1.5 Measurement of diameter of individual steel strands**

The diameter of the individual strands shall be checked to ensure that they conform to the requirement specified in the STP.

**1.6 Check for Lay Length**

The lay length shall be checked to ensure that they conform to the requirements specified in the STP.

**1.7 Galvanising Test**

The test procedure shall be as specified in IS 4826. The material shall conform to the requirements of this Specification. The adherence of zinc shall be checked by wrapping around a mandrel four times the diameter of steel wire.

**1.8 Torsion and Elongation Test**

The minimum number of twists which a single steel strand shall withstand during torsion test shall be eighteen for a length equal to 100 times the standard diameter of the strand. In case test sample length is less or more than 100 times the stranded diameter of the strand the minimum number of twists will be proportioned to the length and if number comes in the fraction then it will be rounded off to next higher whole number. In elongation test, the elongation of the strand after breakage, for a gauge length of 200 mm after stranding, shall not be less than the value specified in STP.

**1.9 Wrap Test**

The test procedure shall be as specified in IS 12776 except the test shall be carried after stranding.

**1.10 Breaking load test**

The breaking load of individual strands of earthwire (after stranding) shall be determined by means of a suitable tensile testing machine. The load shall be applied gradually and the rate of separation of the jaws of the testing machine shall be not less than 25 mm/min and not greater than 100 mm/min. The ultimate breaking load of the specimens shall be not less than the value specified in in the STP.

**1.11 Barrel strength test on Wooden Drum**

The barrel strength test shall be conducted as per IS 1778 on one drum of each lot offered for inspection. Barrel batten strength shall not be less than 300 kg.

**1.12 Chemical Analysis of Steel**

Samples taken from the steel ingots/ coils/ strands shall be chemically/ spectrographically analysed. The same shall be in conformity to the requirements stated in this Specification.

**1.13 Chemical Analysis of Zinc**

Samples taken from the zinc ingots shall be chemically/ spectrographically analysed. The same shall be in conformity to the requirements stated in the Specification.

**Standard Technical Particulars for Galvanised Steel Earth wire**

Sl. no.	Description	Unit	Standard Technical Particular of GS Earthwire			
			7/3.15 mm GS Earthwire	7/3.66 mm GS Earthwire	7/4.5 mm GS Earthwire	19/ 3.00 mm GS Earthwire
1.0	<b>Raw Materials</b>					
1.1	<b>Steel wires / rods</b>					
a)	Carbon	%			0.55 (Max)	
b)	Manganese	%			0.40 to 0.90	
c)	Phosphorous	%			0.04 (Max)	
d)	Sulphur	%			0.04 (Max)	
e)	Silicon	%			0.15 to 0.35	
1.2	<b>Zinc</b>					
a)	Minimum purity of Zinc	%			99.95	
2.0	<b>Steel strands</b>					
2.1	<b>Diameter</b>					
a)	Nominal	mm	3.15	3.66	4.5	3.00
b)	Maximum	mm	3.20	3.74	4.58	3.05
c)	Minimum	mm	3.10	3.58	4.42	2.95
2.2.	<b>Minimum breaking load of strand after stranding</b>	KN			16.49	7.84
			8.55	10.58		
2.3	<b>Galvanising</b>					
a)	Minimum weight of zinc coating per sq.m. after stranding	gm	275	275	290	230
b)	Minimum number of dips that the galvanized strand can withstand in the standard preece test	Nos.	3 dips of 1 minute and one dip of ½ minute			2 dips of 1 minute and one dip of ½ minute

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c)	Minimum number of twists in a gauge length equal to 100 times diameter of wire which the strand can withstand in the torsion test, after stranding	Nos.	18			
d)	Min. elongation of the strand (after stranding) for a gauge length of 200 mm (after break)	%	3.5			
3.0	<b>Stranded Earth wire</b>					
3.1	Minimum UTS of Earth wire	KN	56	68	106.2	139.3
3.2	Lay length of outer steel layer					
a)	Standard	mm	160	181	230	270
b)	Maximum	mm	175	198	243	330
c)	Minimum	mm	145	165	216	210
3.3	Maximum DC resistance of earth wire at 20 <sup>o</sup> C	Ohm/ km	3.375	2.5	1.66	1.50
3.4	Standard length of earth wire	m	2300	2000	2000	2000
3.5	Tolerance on standard length	%	±5			
3.6	Direction of lay for outside layer		Right hand			
3.7	Linear mass					
a)	Standard	kg/km	428	583	882	1062
b)	Maximum	kg/km	441	600	913	1100
c)	Minimum	kg/km	414	552	851	1020
3.8	Overall diameter	mm	9.45	10.98	13.5	15
3.9	Cross sectional area	sq. mm	54.55	73.65	111.33	134
3.10	Modulus of Elasticity	Kg/mm <sup>2</sup>	18993	19361	19361	19000
3.11	Coefficient of linear expansion	Per deg C	0.0000115	0.0000115	0.0000115	0.0000115