

Dated: 19.07.2018

REPLY TO PRE-BID QUERIES

BIDDING DOCUMENT NO. : MEC/23TS/01/51/S2/ST/SU/0005

SUBJECT OF BIDDING DOCUMENT : SUPPLY OF CARBON STEEL COATED PIPE LINES

Sr. No.	PART / Section / Clause No.	Page No.	Clause Description	Bidder's Query	Reply to Bidder's Query
1.	General	-	-	We manufactures and supply Alloy or Carbon steel Seamless Tubes/Pipes of less than or equal to 273 mm outside diameter (10 Inches). And the cost of seamless will be quiet higher as compare with ERW. Please confirm.	As per the tender, bidder can supply either Seamless or ERW pipes.
2.	Section 1.1 Bid Evaluation Criteria, PART-I of tender document	-	A. 1.1 of c) Mill Qualification and 1.2.1 of b) Coating plant Qualification.	You have mentioned in both the Clauses to furnish a Certificate for proposed Pipe Mill and Coating Plant complying with the technical requirements specified in the bid documents. We request you to provide the Certificate Format as required by you.	Party shall submit the certificates complying to requirements of Bid Evaluation Criteria.
3.	Material Requisition, Section-1, Part-III of tender document	Page no. 6 of 13	Clause No. 4.1 List of Acceptable Steel Coil/ Billet Manufacturer	You are requested to incorporate M/s TATA Steel Limited, Jamshedpur (Up to API 5L X-60 & for WT upto 9.35 mm) as the same is already approved by MECON Delhi in the recent tenders floated by MECON, Delhi for GAIL GAS LTD Vide Tender No. 05/51/23TQ-TP-QQ/GAIL GAS/012A and SGL vide Tender No. 05/51/U999/SGL/012A (Copy attached)	Agreed.

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4.	PART-III, CL NO. 4.1(4.3.1)	-	Regarding colis	As we have not supplied 5000MT of API 5L PSL2 in a single order, but we have supplied in multiple orders. Pl. consider our HR Coil from Angul Plant in Odisha,	Tender condition prevails
5.	PART-III, MEC/TS/05/21 /012 Rev-2	-	In addition to this specification, wherever stringent, requirement / provision /amendments of the latest 44th edition of API 5L (effective October 2008) shall apply.	API 5L 45 th Edition -2012 will be applicable.	Accepted
6.	PART-III, MEC/TS/05/21 /012 Rev-2 cl. no. 6.2.5.2	-	For all pipe sizes and specified wall thickness CVN TEST shall be applicable for body, weld and heat affected zone	For size 114.3 OD x 6.4 WT & 168.3 x 6.4 mm -Seam Weld and HAZ is not possible and It is not applicable as per API -5L Table 22. Kindly waived of the same.	Refer Annexure-1 at Corrigendum-1
7.	PART-III, MEC/TS/05/21 /012 Rev-2 cl. no. 12.1.2	-	The certificate shall comply with ISO 10474 type 3.1.c. For tests witnessed by the Purchaser, type 3.1.c. certificates shall be issued.	Certificate issued as per EN 10204 type 3.2 this specification equivalent to ISO 10474 same requirement specified in API 5L clause 10.1.2.	Accepted as per API 5L 45th edition
8.	CL. NO. 1.0 of Client Spec. MEC/TS/05/21 /012	-	Client specification is based on API 5L 43 rd editions	As the latest edition of API 5L (45th edition) is already effective from July 1, 2013, and also it is a mandatory requirement of API 5L to follow the latest edition. Hence we wish to follow the latest edition of API 5L i.e. 45th. Kindly confirm.	Accepted
9.	CL. NO. 2.0 of Client Spec. MEC/TS/05/21 /012	-	Reference: ASTM E 92 : Test Method for Vickers Hardness of Metallic Materials	The specification ASTM E 92: Test Method for Vickers Hardness of Metallic Materials is based on 44th edition. Hence, we understand that the ASTM E-384 is applicable for Test Method of Vickers Hardness of Metallic Materials as per API 5L (45th edition). Kindly confirm.	Confirmed

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10.	CL. NO. 5.4 of Client Spec. MEC/TS/05/21 /012	-	The pipes shall be produced from skelp which shall be quenched and tempered or controlled rolled or combined controlled rolled and accelerated cooled to impart uniformly fine ferritic grain structure to the finished steel. Other types of heat treatment shall be agreed upon between Purchaser and Manufacturer.	SRL suggests that please allow to use the thermo mechanically rolled steel coils for making the pipes. Kindly confirm	Tender conditions prevails.
11.	CL. NO. 6.2.5.2, 9.3.5.1, 9.3.5.2 , SR5 & SR19 of Client Spec. MEC/TS/05/21 /012	-	For all pipe sizes and specified wall thickness, additional fracture toughness requirements as per Supplementary Requirements Appendix-F SR 19 of API Spec 5L and as modified in this specification shall be applicable for body, weld and heat affected zone.	Due to smaller pipe size 4" & 6" & less wall thickness constraint, the extraction of samples in transverse orientation for weld, HAZ and base metal is not feasible. Considering the same table 22 of API 5L 45 th edition does not recommends the impact test for this size and thickness combination. However impact test shall be carried out for the base metal by extracting the samples at 90° in longitudinal orientation as per your technical specification & API 5L 45 th Latest Edition. However, the Charpy impact test (for Size 8") shall be carried out as per API 5L 45 th edition & Client spec. Kindly Confirm.	Refer Annexure-1 at Corrigendum-1.
12.	CL. NO. 9.3.1.4 & 9.3.1.5 of Client Spec. MEC/TS/05/21 /012	-	Transverse Tensile Tests:- The transverse tensile tests shall be carried out on flattened rectangular specimen. Weld Tensile Tests:- Inside and outside flash of weld in	For sizes 4" & 6" transverse Tensile Test and Weld Tensile Test are neither applicable nor feasible as per table 20 of API 5L. However, longitudinal tensile test shall be carried out by extracting the sample from 90 degree to the weld seam. Hence, Transverse Tensile Tests and Weld	Refer Annexure-1 at corrigendum-1

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			excess of pipe wall thickness shall be removed from the specimen either by grinding or machining. Specimen shall be tested for ultimate tensile strength only.	Tensile Tests for sizes 4" & 6" may be waived off. However, the transverse tensile test for weld & body (for Size 8") shall be carried out as per API 5L 45th edition & Client spec. Please confirm.	
13.	Inspection & Test Plan for ERW pipe of Client Spec MEC/TS/05/21 /012	-	Scope of inspection S. No. 2a column record – Approved WPS required	MPS (Manufacturing Procedure Specification) shall be provided instead of WPS/PQR, as WPS/PQR is not applicable for ERW process.	MPS will serve the purpose.
14.	CL. No. 10.3.5 Of Client Spec. MEC/TS/05/21 /012	-	A color band shall be marked on inside surface of finished pipe for identification of pipe of same diameter but different wall thickness, as indicated in the purchase order. The colour code band shall be 50mm wide and shall be marked at a distance of 150mm from the pipe ends.	Since, there is only one thickness per size so we understand that color band is not applicable for this tender. Please confirm.	Accepted
15.	CL. No. 6.2.7 Of Client Spec. MEC/TS/05/21 /012	-	Out of Roundness Pipe Size Tolerance ≤ 10 ³ / ₄ - 2mm ≥ 12 ³ / ₄ - 3 mm	The out of roundness should be in accordance with the API 5L 45 th latest edition. Please Confirm.	Accepted

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16.	S. No. 6 of Inspection & Test Plan of Client Spec MEC/TS/05/21/012	-	Destructive Testing :- Quantum of check:- Material specification, 6-71-0005, PR.	We understand that quantum of check shall be as per technical specification MEC/TS/05/21/012 & API 5L 45 th edition. Please confirm	Accepted
17.	CL. No. 6.2.7 Of Client Spec. MEC/TS/05/21/012	-	Reverse bend test shall be executed with the same number of tests and retests specified for flattening tests in para 9.3.2 of API Spec. 5L.	We understand that the pipe samples shall be two samples / coil (One sample to be taken from first and last accepted pipes). Please confirm	Shall be as per API 5L
18.	CL. No.10.2 Of Client Spec. MEC/TS/05/21/012	-	Marking shall be paint stenciled on length of the pipe at right angles to the pipe axis. Stencil marking shall be placed on the inside surface length except that on pipe size smaller than 16, marking may either be placed on inside or outside.	Due to smaller diameter of pipe sizes (up to 8"), We understand that the Pipe marking / stenciling shall be done on outside surface of the pipe starting at a point between 450mm and 750mm from one of the pipe ends as per API 5L 45 th edition & client requirements. Please confirm.	Bidder understanding is correct.
19.	Amendments to Line pipe	-	All pipes shall be supplied with length between 10 meter and 13 meter but not more than transportable by Road Trucks according to prevailing legislation. Thickness wise average length of pipes supplied shall not be less than 12 meter. API 5L Table 11 shall not be applicable. Overall length tolerance shall be (-) zero and (+) one length to complete the ordered quantity.	Please note that the pipe length above 12 meter is not allowed according to the rules and regulations of Road and Transport department. Hence it should be allowed to supply the pipes in the range between 10-12 meters however the order average length shall not be less than 11.5 meter.	Accepted.

Note: This Corrigendum shall form an integral part of the bidding document and shall be signed/stamped and submitted along with the bid.

(STAMP & SIGNATURE OF BIDDER)

Dated: 19.07.2018

TECHNICAL CORRIGENDUM #1

TO

BIDDING DOCUMENT

BIDDING DOCUMENT NO. : MEC/23TS/01/51/S2/ST/SU/0005

SUBJET OF BIDDING DOCUMENT : SUPPLY OF CARBON STEEL COATED PIPE LINES

The terms and conditions of the Bidding Document stands modified to the extent indicated below and all other terms and conditions of the Bidding Document remains unaltered:

Sn. No.	Volume of Bidding Document	Section	Page No.	Clause No.	Clause Description	Additions / Deletions / Modifications
1.	PART-II	Amendment to Tech. Spec.	-	----	Amendments To Technical Specification No. MEC/TS/05/21/12	Amendments to referred TS are enclosed herewith as Annexure- I.

Note: This Corrigendum shall form an integral part of the bidding document and shall be signed/stamped and submitted along with the bid.

(STAMP & SIGNATURE OF BIDDER)

**AMENDMENTS TO COATING TECHNICAL SPECIFICATION Nos.
MEC/TS/05/21/12**

1. LINE PIPE: Amendment to TS No. MEC/TS/05/21/012

a) 10.2.3.1 Table-20 (Modified)

Sample Location	Type of test	Number, Orientation and location of test pieces per sample ^a	
		Specified outside diameter, <i>D</i> mm (in)	
		<219.1 mm (8.625 in)	≥219.1 mm (8.625 in)
Pipe body	Tensile	1L90	1T180 ^c
	CVN	3T90	3T90
Seam Weld	Tensile	-	IW ^d
	CVN	3W and 3HAZ	3W and 3HAZ
	Hardness	1W (As shown in figure 10.2.5.3 of this specification)	
Pipe body and weld	Flattening	As shown in figure 6 a) of API Spec 5L	
	Reverse Bend	As shown in figure 10.2.4.9.1 of this specification	
<p>a) See figure 5 (b) of API Spec 5L for an explanation of the symbols used to designate orientation and location.</p> <p>b) Deleted</p> <p>c) The transverse tensile test shall be carried on flattened rectangular strip specimen prepared according to ASTM A370.</p> <p>d) Test specimen shall be tested for transverse tensile strength.</p>			

b) Annexure-B: Cl. No. B 5.2 (c) ii. Tensile Test (Modified)

Tensile tests shall be conducted on:

For pipe with specified outside diameter, $D < 219.1$ mm (8.625 inch) :

- Two (2) longitudinal test pieces from base metal

For pipe with specified outside diameter, $D \geq 219.1$ mm (8.625 inch):

- Two (2) transverse test pieces from base metal
- Two (2) transverse test pieces from the longitudinal weld seam