

Pre-Bid Queries
Tender No.: REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
01	PTS-3 LPE EXTERNAL COATING OF LINEPIPE	7.5.1 (f)	Tests on pipe coated partly with epoxy and partly with epoxy & adhesive layers	Adhesion Test (24 hrs) shall be carried out on the epoxy coated pipe as per clause A.15 of ISO 21809-2	Testing as per Clause A-16 of ISO-21809-2,2014 is acceptable
02	PTS-3 LPE EXTERNAL COATING OF LINEPIPE	7.5.1 (g)	Tests on pipe coated partly with epoxy and partly with epoxy & adhesive layers	2° Flexibility test shall be carried out as per annexure A.12 of ISO 21809-2	Testing as per Clause A-13 of ISO-21809-2,2014 is acceptable
03	PTS-3 LPE EXTERNAL COATING OF LINEPIPE	7.5.2 (e)	Tests on pipe coated partly with epoxy and partly with epoxy & adhesive layers	One sample at 80 ⁰ C for 28 days CD shall be sent to NABL approved external laboratory.	In-house test are allowed provided equipment are calibrated by NABL accredited Lab
04	Cl. No. 1.0 of 3LPE External coating line pipe			Internal epoxy coating conforming to ISO 15741:2001 "Friction reduction coatings for the interior of on and off shore steel pipe lines for non corrosive gases".	Internal Coating has not been considered in this tender, Hence ISO 15741:2001 is not applicable



Pre-Bid Queries

Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
05	Cl. No. 3.0 of 3LPE External coating line pipe			ISO 21809-2:2007 : Petroleum and Natural Gas Industries- External Coatings for buried and	Refer Cl 6.1 of GCC, latest revision of Code /Standard is to be applicable, hence ISO-21809-2 -2014 shall be applicable
06	Cl. No. 4.1 of 3LPE External coating line pipe			The three layer coating system shall comprise of a powder epoxy primer, polymeric adhesive and a medium density polyethylene topcoat.	The Outer layer of 3 LPE coating shall be HDPE.
07	Cl. No. 4.2 of 3LPE External coating line pipe			The coating materials Manufacturer shall carry out tests for all properties specified in Para 5.3.1 and 5.3.2 for each batch of epoxy, adhesive and polyethylene compound.	The test performed by the Raw material manufacturer shall be reviewed by appointed TPIA for batch wise correlation of the test values
08	Cl. No. 4.4 of 3LPE External coating line pipe			<p>All materials to be used shall be supplied in sealed, damage free containers and shall be suitably marked with the following minimum information:</p> <ol style="list-style-type: none"> Name of the Manufacturer Manufacturing standard Health, safety and environmental Instructions Receiving inspection acceptance criteria Data Sheets Storage instruction. Type of Material Batch Number Place and Date of Manufacture Shelf Life/Expiry Date (if applicable) Quantity 	Certificate with inspection reports will be accepted and raw material bags shall be opened in presence of TPIA




Pre-Bid Queries

Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
09	Cl. No. 7.5.2 (f) of 3LPE External coating line pipe			Coating Resistance test The contractor at the start of production shall prepare a sample and perform the test as per DIN30670:2012 and submit the report to the customer.	Testing as per DIN-30670 stands
10	Cl. No. 8.6.1 of 3LPE External coating line pipe			All pipes shall be provided chemical pre-treatment with phosphoric acid solution. 10% solution of phosphoric acid, Oakite 31 / 33 or equivalent, shall be used to remove all soluble salts and other soluble contaminants.	Bidder intent to clarify that the phosphoric acid solution tolerance 10% (+/- 2) %
11	Cl. No. 8.6.5 of 3LPE External coating line pipe			After the de-ionised water wash, the pipe shall be dried with dry air and preheated to a temperature of 65°C to 85°C.	the pipe shall be dried with dry air and dry air temperature shall be 65°C to 85°C
12	Cl. No. 8.14.1 of 3LPE External coating line pipe			Following completion of abrasive blast cleaning, all pipe surface shall be chemically pretreated with a 10% strength chromate solution.	the chromate solution tolerance 10% (+/- 2) %
13	Cl. No. 8.14.4 of 3LPE External coating line pipe			The Contractor shall check that the concentration of the chemical pre-treatment solution remains within the range recommended by the chemical manufacturer for the pipe coating process. The concentration shall be checked at the make-up of each fresh solution and once per hour, using a method approved by the chemical manufacturer. The Contractor shall also ensure that the chemical pre-treatment solution remains free from contamination at all times. Recycling of chemical pre-treatment solution is not permitted.	Test frequency can be one at the start of the shift and other after 4 Hours interval
14	Cl. No. 9.2.1 of 3LPE External coating line pipe			Electrostatic application of epoxy powder of minimum dry film thickness 0.200 mm, unless otherwise specified. For LSAW line pipe required for HDD crossings, the minimum DFT of epoxy powder shall be 400 micron.	HDD Crossing is not envisaged in the present tender



Pre-Bid Queries
Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
15	Cl. No. 9.2.8 of 3LPE External coating line pipe			The extrusion temperatures of the adhesive and polyethylene shall be continuously recorded. The monitoring instruments shall be independent of the temperature control equipment. The instruments shall be calibrated prior to start of each shift.	In the event calibration facilities are not available the Instruments can be got calibrated from NABL accredited laboratory other provision of the clause remain unaltered
16	Cl. No. 10.2.4 of 3LPE External coating line pipe			Bond Strength (Peel Test) The frequency of test for cut back portions shall be every 2 hrs and for middle of pipe shall be 4 hrs.	Peel off test distance from any end shall be = 0.5L+(-) 0.1L, L being the length of the line pipe
17	Cl. No. 10.2.10 of 3LPE External coating line pipe			Cathodic Disbondment Test a. 24 hours CD test shall be conducted as per sl. no. (f) of table in clause no. 5.3.3 of this specification. b. The frequency of this test shall be 2 Samples from total lot 1 for 28 days & 1 for 48 hrs.	The cathodic disbondment test shall be conducted every 24 hours as per clause 5.2.3 of this specification at the provision of Table 9 of ISO 21809-1 shall apply
18	Cl. No. 10.2.13 of 3LPE External coating line pipe			Cyclic test One cyclic test shall be conducted after completion of coating followed by strip test of coating to locate any failure on disbondment, for cyclic test, the pipe to be pressurized to 1.5 times of design pressure and then dropped to 5% of design pressure and again repressurized to 1.5 times of design pressure, continuously for about 100 cycles, then check for coating disbondment by stripping the pipe coating.	The cyclic test is meant for procedure qualification for acceration of mill. The bidder mill having produced and sold line pipes more than the quantity under present tender are exempted from this test.

Pre-Bid Queries

Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
19	Cl. No. 13.0 of 3LPE External coating line pipe			MARKING Colour band	White color on external coated surface and yellow color inside the pipe
20	Cl. No. 14.7 of 3LPE External coating line pipe			The coating pipe mill shall have internal tracking system for pipe traceability during regular coating to reduce manual interference. SAP base system is preferred.	Internal tracking system for pipe traceability ERP/SAP of the manufacturer is acceptable
21	Cl. No. A.8.5.10 & D.3 of QCT			ACTIVITY: Bare pipe temp. after Epoxy application by IR Thermometer TEST FREQUENCY: Every pipe by online pyrometer Recording ACCEPTANCE CRITERIA: 190-230°C or as per powder Manufacturer recommendation INSTRUMENTS: IR Optical pyrometer	Provisions of Cl A.8.5.10 and D.3 of QCT remain
22	Cl. No. J.5 of QCT			ACTIVITY: Hygrometer TEST FREQUENCY: Once in four month	The calibration for Hygrometer should be valid for entire coating work for client under this contract
23				Test frequency & acceptance criteria	QCT shall take priority over PTS and both in combination will have overriding effect on any referred Standard/Code



Pre-Bid Queries
Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
24	<p style="text-align: center;"><i>PTS – Line Pipe (HFW pipes)</i></p> <p style="text-align: center;"><i>GTS – Line pipes & As per QCT</i></p>			<p>The present Specification shall be read in conjunction with General Technical Specification (the GTS) and API 5L 45th edition which it amends and/or complements.</p> <p>The present Specification has to be read in conjunction with the API 5L forty-fifth edition, its addendum (December 2012) and the Particular Technical Specification (PTS) attached to the material requisition.</p> <p>The present Specification has to be read in conjunction with the API 5L forty-fifth edition, its addendum (December 2012) and the Particular Technical Specification (PTS) attached to the material requisition.</p>	<p>Latest edition will be applicable (Refer to clause no 6.1 of GCC)</p>



Pre-Bid Queries
Tender No.: REPI/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
25	<p>Cl. B of PTS – Line Pipe (HFW pipes)</p> <p>Cl. No. 9.11.1.1 of GTS</p> <p>Cl. No. 9.2 of QCT</p>			<p>Acceptable length shall be 12 ± 0.5 meter. For sampling pipe, the minimum length of 11.0 meter is acceptable.</p> <p>Nominal length shall be at least twelve metres (12 m) but not more than transportable by Road Trucks or railroad According to prevailing legislation. (See PTS).</p> <p>Pipe length shall be between 10.0 and 14.0 m. Thickness wise average length of pipes supplied shall not be less than 12.5 m. The average length shall be cumulative as measured at Pipe Mill despatch note.</p> <p>Nominal length shall be at least twelve metres (12 m) but not more than transportable by Road Trucks or railroad according to prevailing legislation. (See PTS).</p> <p>Pipe length shall be between 10.0 and 14.0 m. Thickness wise average length of pipes supplied shall not be less than 12.5 m. The average length shall be cumulative as measured at Pipe Mill despatch note.</p> <p>Length 11.5 – 12.5 meters for sample pipes 11.0 meter</p>	<p>Considering the transport restrictions the average length of the line pipe shall not be less than 11.5 meter with minimum length of any stray pipe not less than 10 meter</p>



Pre-Bid Queries

Tender No.:REPL/CUGL/STP/002/18

Sr.No.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
26	Cl. 8.1 of PTS – Line Pipe (HFW pipes)			Only the high Frequency Electric Resistance Welding (HFERW) process will be accepted for pipe manufacture and the WPS/PQR for the same shall be submitted after award of the agreement. Seam normalizing (As per WPS & PQR)	It is the matter of nomenclature Tender Specifications are provided
27	Cl. E.4 of annexure E of GTS			Radiography inspection of weld seam	Radiography is not waived off
28	Cl. 9.8 of PTS – Line Pipe (HFW pipes)	Cl. 9.8.3 of GTS	11.2.6 of QCT	CVN Impact test shall be carried out at 0°C. For base material, HAZ & Weld, one set of three specimens for each, shall be taken from coupon. For pipe weld and HAZ, 3 sets of 3 transverse specimens shall be taken transverse to the weld. For all base materials and welds: The CVN Impact test shall be conducted at both (-) 200 C & 00 C. Impact test value (For all base material and weld) shall conform to requirement of Table 8 of Cl. No. 9.8 (CVN Impact test for PSL 2 pipe) API 5L 45th Edition.	Provision of API 5L 46th edition shall prevail



Pre-Bid Queries
Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
29	Cl. No. 8.7 of PTS – Line Pipe (HFW pipes)			A color band to differentiate thickness of Pipes shall be provided at each extremity (50 cm from the end) of the pipe after coating of pipe by the coating applicator Barcode identification system shall be provided by the pipe supplies, which shall have a life of 5 years over and above the conventional marking as per API 5L.	Color Band for thickness differentiation is not required due to single thickness under this contract
30	Cl. E.1 of PTS			Staff in charge with the NDT shall be duly qualified according to International STD like, but not limited to ASNT-TC-1A. Qualification of personnel: final Non Destructive inspection shall be performed by Level II or Level III personnel. All level II personnel shall be qualified and certified for the specific NDT method by a certification body or level III in accordance WITH BSI BS EN 473 or the ASNT CP 189 or purchaser approved equivalent.	ASNT(ASNT-TC-1A) level II is required to perform all the NDT activities for the specific NDT method and One Level III(ASNT-TC-1A) shall be made available during the production at manufacturer's site, to supervise all the NDT activities.
31	Cl. No. B.7 of annexure B of PTS – Line Pipe (HFW pipes)			MECHANICAL PROPERTIES TEST Following test shall be carried out as per QCT / approved QAP. • Drop weight tear test	Code Provision shall Prevail



Pre-Bid Queries
Tender No.: REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
32	<i>Annexure E of GTS</i>			Guidance for probe angle – Automatic UT inspection & manual ultrasonic testing:	The provision contained in API 5L 46th Edition and ISO 10893 shall apply
33	<i>Cl. 10.3 of QCT Cl. 8.9 of PTS</i>			Both pipe ends shall be provided with metallic caps Pipe Bevel ends shall be protected using Bevel protectors, to be supplied by Pipe Manufacturer. In addition, Plastic end caps are required for pipes, as per GTS requirement.	Plastic end cap or bevel Protectors for both ends of each pipe will suffice



Pre-Bid Queries
Tender No.: REPL/CU/GL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
34	Cl. No. 9.3.2 of GTS			<p>The ratio (Rt_{0.5}/Rm) between the measured values of yield strength (Y) at 0.5% elongation of the gauge length as determined by an extensometer and ultimate tensile strength (T) for the body of each test pipe (product pipe) on which, yield strength and ultimate tensile strength are determined shall not exceed 0.85 for Grades X60 and lower. For Grades X65 to X80 included, the same ratio may reach the value of 0.90.</p>	<p>As per clause 6.1 of GCC latest code/ standard are to be followed. Therefore Ys/Ts rations confirming to API 5L 46th Edition is acceptable</p>
	Cl. No. 9.3.2 of QCT				



[Handwritten signature in blue ink]

Pre-Bid Queries

Tender No.: REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
35	Cl. No. 10.2.6 of PTS – Line Pipe (HFW pipes) Cl. No. 10.2.6			<p>The hydrotest testing master gauge shall be calibrated by means of a dead weight tester, or equivalent before the start of the production order at the end of production order and at least once per month during production.</p> <p>The test pressure measuring device shall be calibrated by means of a dead weight tester, or equivalent at the beginning of each shift.</p> <p>The hydrotest testing master gauge shall be calibrated by means of a dead weight tester, or equivalent before the start of the production order at the end of production order and at least once per month during production.</p>	<p>Calibration of Pressure Gauge shall be less than a month old for each batch of production</p>
36	Cl. No. 10.2.6.1 of GTS Cl. No. 6.1 of QCT			<p>The hydrostatic test pressure shall be such as to create a hoop stress between 95% and maximum 100% of the specified minimum yield strength. Hydraulic pumps shall not activate during the 15 second test duration Hydrostatic testing shall be carried out on each pipe prior to final visual and final non-destructive inspection, except that cutting to length, beveling may take place after hydrostatic testing.</p>	<p>Test pressure of 95% SMYS shall be applicable Test pressure – calculated at 90% of SMYS</p>



Pre-Bid Queries
Tender No.: REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
37	Cl. No. 11.2.1 of GTS			Pipe individual number shall contain: the first two numbers to indicate the year of the purchase order and maximum five numbers specified in the purchase order and if those are not specified, they must be requested from the Purchaser.	Numbering of the pipe as manufacturer procedure is acceptable, However numbering should be contiguous



Pre-Bid Queries
Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
38	<p style="text-align: center;"><i>Cl. 8.7 PTS</i></p> <p style="text-align: center;"><i>Cl. 11.1.2 of GTS</i></p> <p style="text-align: center;"><i>Cl. 13.0 of QCT</i></p> <p style="text-align: center;"><i>Cl. 13.1 of QCT</i></p> <p style="text-align: center;"><i>Cl. No. 1.0 of 3LPE External coating line pipe</i></p>			<p>Add: The minimum information to be die-stamped shall be:</p> <ul style="list-style-type: none"> • The name or mark of the Manufacturer of the pipe, • The specified outside diameter, • The specified wall thickness, Die-stamping or vibro etching: <p>Die stamping shall not be permitted on the pipe body</p> <p>Die stamping by low stress punch on end and stencil marking on the outside surface of the pipe on both sides shall be used for marking on pipes.</p> <p>Marking shall be Paint stenciled at right angle to the pipe axis at 150mm from one end with letter size 30mm min. on Outside & inside(8" & above).</p> <p>One end of each pipe from inside and outside after coating.</p> <p>Pipe no. shall be stamped at one end on bevel at the right side to the longitudinal weld seam.</p> <p>Or</p> <p>Pipe no. shall be stamped at one end with low stress dot punches at the outside surface of the pipe at a distance at least 2 cm of the end of pipe on the right side of the weld.</p>	<p>The pipe number marking shall be as per QCT i.e.</p> <p>Pipe number shall be stamped at one end with low stress dot punches at the outside surface of the pipe at a distance of 150 mm from one end on the right side of the weld</p> <p>Other than pipe number stenciling all the information like manufacturer name heat no, pipe dia, wall thk, API monogram, PO No etc. shall be white paint stencilled on outer surface of the pipe along the axis. the letter size of stenciling is allowed to be 25 mm</p>



Pre-Bid Queries

Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
39	Cl. No. B5.4 of GTS			Weldability of PSL2 pipes Manufacturer shall ensure, and demonstrate the weldability of the pipes in accordance with this specification and under normal operational site condition.	Code Provision shall Prevail
40	Cl. 3.1.4.2 of annex E of GTS			Manual Ultrasonic Testing: Manual ultrasonic inspection of weld seams shall be accordance with ISO 17640. Table E.11 (added) – Guidance for probe – Manual UT inspection	Ultrasonic testing as per API 5L 46 Edition and ISO 10893 shall be applicable
41	S. No. 1.3.1 of QCT			Ultrasonic Testing required for each coil.	In view of small thickness, Pipe body Ultrasonic testing with 100% coverage of area after hydrostatic test of the pipe in accordance with API 5L 46th Edition & ISO 10893 shall suffices.
42	Table B.1 of GTS			Macro etch of slab / skelp representing head, middle and tail of all stands to be used for production heats.	Only Macrography for the pipe required
43	Table B.1 of GTS			Chemical analysis of weld metal.	Chemical analysis of the weld metal is required as per tender
44	Cl. No. B.7 of GTS			All weld tensile tests shall be carried out as per ASME Section IIC to ensure the properties of welding consumables.	The provision of code shall prevail



[Handwritten signature]

Pre-Bid Queries

Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
45	Cl. No. E2.2 of GTS			For angle beam scanning of the weld zone, the maximum number of legs of beam travel shall be 3 (1.5 skips) for detection of imperfections.	Tender Documents shall Prevail
46	PTS - Line Pipe	8.5		Reverse Bend test for Pipes shall be carried out as per requirements Part – II [sec 3(i)], Annexure III of PNGRB Notification, 2008.	Attached
47	GTS	4.53		Over thickness of weld deposit : 2mm	In view of the smaller thickness of line pipe over thickness of the weld deposit is retained to be 2 mm
48	GTS	8.6		Previously qualified WPS and PQR are valid provided all essential variables identified in Annex D, D.2.2 of API SPEC 5L are within the stated limits. The following essential variables shall also apply: a) Increase in parent metal carbon of more than 0.02%.	Increase in carbon percentage for allowing previously qualified WPS/PQR is not acceptable However PQR/WPS conducted for same grade of steel (X-42) is acceptable
49		9.3.3		At least one HAZ hardness indent shall be positioned in the coarse grain structure immediately adjacent to the fusion line.	Hardness test to be carried out in HAZ shall be acceptable
50		9.11.1.1		Pipe length shall be between 10.0 and 14.0 m. Thickness wise average length of pipes supplied shall not be less than 12.5 m. The average length shall be cumulative as measured at Pipe mill despatch note.	Provision of PTS clause B prevail, Clarification at S. No. 1 above




Pre-Bid Queries
Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
51		9.13.3		All pipes shall be checked for misalignment of weld beads.	Weld bead Misalignment shall be checked on Metallographic examination
52		10.1.1		TPIA shall witness all mechanical/chemical testing on all heats and put the acceptance stamp on each coil/plate.	In the event steel mill do not permit stamping the coil, The TPJA witnessing the mill for heats shall correlate the Mill's identification of the coil with test certificate and sign
53		10.1.1		Pipes shall be tested as one pipe per inspection lot of 50 pipes per heat (all tests as per Annex Q).	Provision of tender Shall prevail
54		10.1.1		Burst test to be done for each size and thickness at the time of first day production test.	Provision of tender Shall prevail
55		11.1		Marking: All dimensions and hydrostatic test pressure markings shall be in SI units.	Nominal OD, nominal thickness, actual length & hydrostatic test pressure markings shall be in SI units.



Pre-Bid Queries

Tender No.: REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
56		B.5.2.5.		Transverse CVN transition curves for pipe body, weld centreline and HAZ; temperature range of +20° C (+68°F) to M 50°C (-58°F) (5 temperatures). One HAZ notch location shall be tested- the location that gives the lowest values when performing the tests in item 4 of this table.	The provision of API 5L 46th Edition shall prevail
57		4.3		c) iv, Moisture content	Moisture content test as per manufacturer recommendation or as per ASTM D570 clause 5.3.2 e
58		5.2.3 (a)		Test method	Refer Cl 6.1 of GCC, latest revision of Code /Standard is to be applicable.
59		5.2.3 ©		Properties : Indentation hardness	Refer Cl 6.1 of GCC, latest revision of Code /Standard is to be applicable.
60		5.2.3 (d)		Elongation at failure (Test method) ISO 527-3	Elongation at failure test method shall be ap per ISO 527-2
61		7.2.2 (e)		One sample at 80° C for 28 days CD shall be sent to NABL approved external laboratory	Test from outside laboratory acceptable which are either NABL approved or Government Laboratory including autonomus bodies like as IIT/NIT

Pre-Bid Queries
Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
62		7.2.2 (i)		Coating resistivity: the contractor at the start of production shall prepare a sample and perform the test as per DIN30670:2012 and submit the report to the customer.	Coating resistivity test certificate from coating manufacture shall also be accepted provided the test has been conducted on the batch supplied and confirming to DIN 30670 latest edition
63		9.2.3		In case the relative humidity exceeds 80%, the adhesive and polyethylene material shall be dried using hot air as per the directions of COMPANY representative.	For drying Manufacturer recommendation shall be followed and copy should be made available to client
64		10.3		The coating thickness shall be determined by taking at least 10 measurements at locations uniformly distributed over the length and periphery of each pipe.	The provision of this clause remains unaltered



Pre-Bid Queries
Tender No.:REPL/CUGL/STP/002/18

Sr.NO.	3LPE Spec.No.	3LPE Spec. Clause No.	Section	Section Description	Clarification
65		10.5.b Cl. No. 10.2.4 of 3LPE External coating line pipe		Coated or one pipe per shift whichever is higher. On each Selected pipe, bond strength shall be performed for each specified temperature. Test shall be performed at each cut back portion and one in the middle of pipe. The system shall disband / separate cohesively either in adhesive layer or in polyethylene layer. Majority of the peeled off area on the pipe shall show presence of adhesive. Disbondment / separation at epoxy to steel interface or epoxy/ adhesive interface or adhesive/ polyethylene Interface shall not be permitted. The failure mode shall be recorded for each test.	The provision of this clause will adherence to relevant code like ISO 21809-1
66		12		Repair materials clearly establishing the compliance of the repair materials with the applicable coating requirements indicated in this specification.	The repairing of the coating shall be done by client approved repair coating material.
67		12 Cl. No. 12.0 of 3LPE External coating line pipe		Irrespective of type of repair, the coating shall be as follows: maximum numbers of repair of	The repair generated due to test will not qualify for repair on account of coating failure.

