

GASONET SERVICES (RJ) LIMITED

QUERIES RAISED DURING PRE-BID MEETING BY BIDDER AND REPLY / CLARIFICATION TO BIDDERS BY OWNER

Tender No.: GSL/REPL/012/STPL

Date / Time of Pre- Bid : 23/01/2023

Venue: VC

Date of Pre-bid Clarifications: 02/02/2023

Tender Description: PROCUREMENT OF API 5L 3LPE COATED CS LINE PIPE

ADDITIONAL TECHNO-COMMERCIAL QUERIES/REPLIES

Sr.	Tender Clause No. Annexure	Page No.	Clause Description	Bidders Comments / Queries	Owner Reply / Clarifications to Bidders						
1	Cl. 4.4.1 (e) & 4.4.2 of Stnd. Spec. for 3LPE coating		<p>4.4.1 (e) Temperature measuring & monitoring equipment shall be calibrated twice every shift and/or as per Company Representative's instruction.</p> <p>4.4.2 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.</p>	<p>Bidder clarifies that pyrometers that are used for PE & adhesive temperature monitoring, are specialized equipment and are calibrated in specialized equipment outside laboratory, so we propose to review the outside lab calibration certificate.</p> <p>However the pyrometer shall be checked for errors every shift against a calibrated temperature-measuring instrument.</p>	Accepted						
2	Cl. 4.4.2 of Stnd. Spec. for 3LPE coating		<p>Minimum Coating Thickness In mm</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">Specified Pipe OD, Inches (mm)</th> <th style="text-align: center;">Normal Type (n)</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">Over 4½ (114.3)</td> <td style="text-align: center;">2.05</td> </tr> <tr> <td style="text-align: center;">Up to 10¾ (273.1)</td> <td></td> </tr> </tbody> </table> <p>Notes: 3. In case HDPE is used as top coat, 10% reduction in PE top coat thickness is permissible 4. Unless indicated otherwise in Purchase Order, total thickness corresponding to Normal Type (n) coating shall be applicable.</p>	Specified Pipe OD, Inches (mm)	Normal Type (n)	Over 4½ (114.3)	2.05	Up to 10¾ (273.1)		<p>Bidder going to use Borealis/Borouge HE3450H/HE3450 material which is HDPE top coat, hence understands that minimum total coating thickness shall be 1.8 mm.</p>	Tender Condition Prevail
Specified Pipe OD, Inches (mm)	Normal Type (n)										
Over 4½ (114.3)	2.05										
Up to 10¾ (273.1)											
3	Cl. 5.3.12 of Stnd. Spec. for 3LPE coating		<p>ONLY EPOXY / EPOXY AND ADHESIVE COATED PIPES</p> <p>Only epoxy coated section shall be subject to holiday inspection at a test voltage set to exceed 5V / micron of epoxy thickness. Section of pipe coated with both</p>	<p>Bidder clarifies that it is not practical to check section of pipe coated with both epoxy and adhesive for holiday test at a voltage of 25kV.</p>	Accepted						

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			epoxy and adhesive shall be tested at a voltage of 25kV. No holidays are permitted.	Bidder understands that only epoxy coated section of partly coated pipe to be check for holiday test at test voltage set to 5 V/micron. Holiday test voltage shall not exceeds to 5 V/micron for partly coated pipe. Bidder would like to state that it is practically difficult to achieve no holiday at 200 microns dry film thickness. Hence holiday acceptance criteria shall be one holiday per meter length in accordance with Table 9 of CAN/CSA Z 245.20.			
4	Cl. 5.3.5 of Stnd. Spec. for 3LPE coating		One test shall be performed at cut back portion at each end and one in the middle of test pipe for each specified temperature (i.e. total 6 tests per pipe).	Bidder proposes to carry out bond strength test using manual peel test machine (Spring loaded type test assembly) due to size constraint. Please confirm. Bidder also propose to conduct Middle peel test within feasible distance from pipe end to maintain the test temperature. We request to kindly consider the practical difficulty.	Accepted		
5	Cl. 5.6 of Stnd. Spec. for 3LPE coating		Any pipe having salt contamination exceeding 2 µg/cm ² shall be treated by phosphoric acid wash followed by de- ionized water wash in accordance with the recommendations of the manufacturer.	Bidder understands that phosphoric acid wash is not a mandatory requirement according to CORRIGENDUM NO 01 DATED 28-01-2023, S. No. 3 of Technical Queries/Replies- 3LPE.	Phosphoric acid followed by de-ionised water wash shall be carried out only in case salt contamination exceeding 2µg/cm ² .		
6	Cl. 8.0 of Stnd. Spec. for 3LPE coating		MARKING AND PIPE IDENTIFICATION iii. Colour band	Please clarify if any specific colour band is require.	As per Standard (ASME A13.1)		
	Cl. 7.2.4 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High Frequency Welded Line Pipe		A Colour code band shall be marked on inside surface of finished pipe for identification of pipes of same diameter but different wall thickness, as indicated in the Purchase Order. The Colour code band shall be 50 mm wide and shall be marked at a distance of 150 mm from the pipe ends.	Welspun understand that the specified requirement for colour code is not applicable as the project is having same thickness for different diameters. Accordingly not considered.	Tender Condition prevail		
7	ANNEXURE-I of Stnd. Spec. for 3LPE coating		LIST OF ACCEPTABLE COMBINATIONS OF COATING MATERIALS <table border="1" style="margin-left: auto; margin-right: auto;"><tr><td>PE Compound (Manufacturer)</td></tr><tr><td>HE 3450H (BOREALIS / BOROUGE)</td></tr></table>	PE Compound (Manufacturer)	HE 3450H (BOREALIS / BOROUGE)	Bidder understands that polyethylene material HE 3450 is also acceptable instead of HE 3450H.	Gasonet to comment
PE Compound (Manufacturer)							
HE 3450H (BOREALIS / BOROUGE)							
8	Cl. 4.B. Doc No. <u>GSL/REPL/012/STPL</u> Dated 19/01/2023		Compliance with specification The vendor shall be completely responsible for the receiving/taking over, design , materials, fabrication,	Bidder clarifies that design is not under our scope of work.	The terms design to be interpreted as line pipe design for manufacturing as per tender		

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	<u>MATERIAL REQUISITION FOR 3LPE COATED LINE PIPES</u>		testing, inspection, preparation for shipment, transport, storage at specified Dump Yard/Warehouse of the above items strictly in accordance with the Material Requisition and all attachments thereto.		specification.
9	<u>Cl. 4.E. Doc No. GSL/REPL/012/STPL Dated 19/01/2023 MATERIAL REQUISITION FOR 3LPE COATED LINE PIPES</u>		INSPECTION The vendor shall appoint approved Third Party Inspection Agency for carrying out the inspection as per approved ITP and TPIA charges shall be borne by vendor	Bidder Clarifies that there is no list is provided for approved agency for appointing TPI. Please provide the same. Also Clarify that TPI is appointed on Steel mill or Pipe mill or as for both mills.	Authorized TPI agencies for Steel Pipe Inspection are accepted TPI shall be appointed for Pipe mill
10	<u>Cl. 5.0 Note. d Doc No. GSL/REPL/012/STPL Dated 19/01/2023 MATERIAL REQUISITION FOR 3LPE COATED LINE PIPES</u>		Pipes shall be supplied between 11.5 m to 12.5 m. Coating material combination shall be as per Annexure-I for carrying out 3-layer polyethylene coating. The minimum thickness of finished coating shall be as per aforesaid specification.	Bidder confirms to supply pipe with the length tolerance specified in the client spec. CL 5.6.1.1 as below: <i>“All pipes shall be supplied with length between 11.5 m and 12.5 m. However, pipe with length between 10.0 m and 11.5 m can also be accepted for a maximum of 5% of the ordered quantity. “</i>	Accepted
11	<u>Cl. 5.6.1.1 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 MATERIAL REQUISITION FOR 3LPE COATED LINE PIPES</u>		All pipes shall be supplied with length between 11.5 m and 12.5 m. However, pipe with length between 10.0 m and 11.5 m can also be accepted for a maximum of 5% of the ordered quantity. Overall length tolerance shall be (-) Zero and (+) One pipe length to complete the ordered quantity. Table 12 of API Spec 5L stands deleted.		
12	<u>Cl. 5.0 Note. e & 5.7.1 & 5.8.1.1 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 MATERIAL REQUISITION FOR 3LPE COATED LINE PIPES</u>		For butt weld end, bevel shall be in accordance with API specification 5L or ASME B16.25 as applicable. Plain ends During removal of inside burrs at the pipe ends, care shall be taken not to remove excess metal and not to form an inside cavity on bevel. Removal of excess metal beyond the minimum wall thickness as indicated in clause 5.7.1.2 of this specification shall be a cause for re-bevelling. In case root face of bevel is less than that specified, the pipe ends shall be re-bevelled and rectification by filing or grinding shall not be done.	Bidder clarifies that bevel end preparation shall be as per CL 9.12.5.2 of API 5L.	For Plane ends – CL 9.12.5.1 & 9.12.5.2 of API 5L will be followed
13	<u>Cl. 1 Doc No. GSL/REPL/012/STPL Dated 19/01/2023</u>		Scope The sections, paragraphs and annexes contained herein have the same numbering as that of API Spec 5L in	Bidder clarifies that the client specification does not contain same numbering as that of API 5L.	Some additional technical specification consider as “New” in Technical Volume that are not

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	Specification for High Frequency Welded Line Pipe		order to facilitate reference. Additional requirements, which are not specified in API Spec 5L, have also been numbered and marked as "(New)".		specified in API 5L Specification									
14	Cl. 6.2.1.1 Table 18 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High Frequency Welded Line Pipe		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 5%; text-align: center;">2</td> <td style="width: 35%;">Product analysis ^b</td> <td style="width: 60%;">Two pipes per lot (maximum 100 pipes) per heat</td> </tr> </table> <p>b Pipes selected shall be such that one at the beginning of the heat and one at the end of the heat are also represented.</p>	2	Product analysis ^b	Two pipes per lot (maximum 100 pipes) per heat	Bidder confirms for product analysis in pipes with 2 samples / 100 pipes / heat shall be selected randomly from the heat used at pipe mill for pipe production with lot of 100 pipes.	Inspection shall be done according to table no 18 of clause 6.2.1.1 of technical volume						
2	Product analysis ^b	Two pipes per lot (maximum 100 pipes) per heat												
15	Cl. 6.2.1.3 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High Frequency Welded Line Pipe		<p>Test pieces for the CVN impact test In addition to the API Spec 5L requirements, following shall also be applicable: The test pieces shall be prepared in accordance with ASTM A370. Non-flattened test pieces shall be used. The axis of the notch shall be perpendicular to the pipe surface. Charpy V-notch impact testing shall be performed on full-sized test pieces. However, if preparation of full size test piece is not possible, then standard sub-sized test pieces shall be prepared as per ASTM A370. Lower pipe sizes wherein preparation of transverse sub-sized specimen is not possible, CVN impact testing shall be carried out on longitudinal test specimen [see Note 'a' of Table 8 of this specification].</p> <p>General</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 20%;">Sample Location</th> <th style="width: 10%;">Type of test</th> <th style="width: 70%;">Number, Orientation and location of test pieces per sample < 219.1 mm (8.625 in)</th> </tr> </thead> <tbody> <tr> <td>Pipe body</td> <td>CVN</td> <td>3T90</td> </tr> <tr> <td>Seam Weld</td> <td>CVN</td> <td>3W and 3HAZ</td> </tr> </tbody> </table>	Sample Location	Type of test	Number, Orientation and location of test pieces per sample < 219.1 mm (8.625 in)	Pipe body	CVN	3T90	Seam Weld	CVN	3W and 3HAZ	Bidder clarifies that sample extraction for 4.5" & 6.625" OD with the specified wall thickness in transverse direction for CVN impact test is not feasible even for sub size specimen. Also as per API 5L Table 22, sample extraction (full size / sub size) for the above specified sizes not specified. However, for Longitudinal samples can be extracted for 4.5" & 6.625" OD only for base metal.	Noted
Sample Location	Type of test	Number, Orientation and location of test pieces per sample < 219.1 mm (8.625 in)												
Pipe body	CVN	3T90												
Seam Weld	CVN	3W and 3HAZ												
	Cl.6.2.2.1 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High Frequency Welded Line Pipe													
16	Cl. 6.2.8.2 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High		The measuring equipment requiring calibration or verification under the provisions of API Spec 5L shall be calibrated with manual instruments at least once per operating shift (12 hours maximum). Such calibration records shall be furnished to Purchaser's	Bidder confirms that repeatability of measuring instruments Verification of all measuring instruments shall be done in each shift of 12 hours at final station. Record of same shall be furnished to the appointed representative.	Accepted									

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	Frequency Welded Line Pipe		Representative on request	However, Bidder clarifies that calibration of dimension measuring equipment shall be done on yearly basis from an external NABL lab.	
17	Cl. 7.2.3 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High Frequency Welded Line Pipe		The pipe number shall be placed by cold rolling or low stress dot marking or vibro-etching on the outside surface of the pipe at an approximate distance of 50 mm from both ends. In case of non-availability of either cold rolling or low stress dot marking facility in pipe mill, an alternative marking scheme of a permanent nature may be proposed by the Manufacturer.	As permitted in Technical specification, as an alternate marking scheme, Bidder proposes that the use of Laser Marking machine shall also be permitted (permanent in nature) for placing the pipe number on OD surface.	Accepted
18	Cl. Annex B CL B.5.2.c.v Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High Frequency Welded Line Pipe		Fracture toughness testing Four (4) sets of CVN base metal test pieces shall be tested at, - 40°C, -30°C, -20°C, - 10°C, 0°C, +10°C and + 20° C for shear area and absorbed energy to produce full transition curve.	In lieu of 4 sets at each temperature, Bidder proposes to extract one set of CVN sample for base metal at each temperature specified herein.	Accepted
19	Cl. E.5.1.1 Doc No. GSL/REPL/012/STPL Dated 19/01/2023 Specification for High Frequency Welded Line Pipe		In addition to the API Spec 5L requirements, all automatic ultrasonic equipment shall have an alarm device, which continuously monitors the effectiveness of the coupling. The equipment for the automatic inspection shall allow the localization of both longitudinal and transverse defects corresponding to the signals exceeding the acceptance limits of the reference standard. The equipment shall be fitted with a paint spray or automatic marking device and alarm device for areas giving unacceptable ultrasonic indications. All ultrasonic testing equipment shall be provided with recording device. In addition, an automatic weld tracking system shall be provided for correct positioning of the probes with respect to weld centre.	Bidder intend to clarify that Ultrasonic testing for pipe Body will be carried out after pipe forming using ROTO UT (immersion technique) as per Client Spec CL E.11, where seam tracking will not be applicable for OD ≤ 6.625 ".	As per CL E11, If the manufacturer opts for rotary ultrasonic testing of full pipe in accordance with this clause, then, the requirement for ultrasonic inspection as per clause E.3.1.1, E.3.2.3, E.8 and E.9 of API Spec 5L and as modified herein shall not be applicable
20	Cl no. 10.5 of GSL/REPL/012/STPL		Frequency Regular production: One out of 25 pipes	We proposed that frequency is more stringent and difficult to maintain in regular production. We proposed that in case result will consistently achieved within acceptance limit, then the frequency of testing may be relaxed for cut back portions shall	Tender condition prevails

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				<p>be every 2 hrs and for middle of pipe shall be 4 hrs. On each selected pipe for both temperature.</p> <p>Please confirm.</p>	
21	Cl no. 3.2.5 of GSL/REPL/012/STPL		<p>Properties of coating system:</p> <ul style="list-style-type: none"> -Coating Resistivity -Heat Ageing -Light Ageing 	<p>Test certificates from PE compound manufacturer for tests for thermal aging coating resistivity and aging under exposure to light shall be provided for your review.</p> <p>These test certificates shall not be older than three years.</p>	Accepted
22	Cl no. 4.2.9 of GSL/REPL/012/STPL		On completion of coating application procedure qualification, the Contractor shall completely remove the coating on all remaining intact pipes coated for the purpose of procedure qualification and recycle them for production coating.	<p>We proposed that all 4 3LPE coated pipes including PQT pipes shall be considered acceptable provided they meet the requirements of this specification and need not be stripped and re-cycled.</p> <p>Please confirm.</p>	Tender condition prevails
23	GSL/REPL/012/STPL Cl. No. 5.5.3.1 & 5.5.4		Based upon full sized test pieces at a test temperature of 0°C(32°F) and at -29°C (-20°F).	<p>As we are performing Impact test at -29°C temperature which is more stringent than 0°C temperature. So we understand that there is no need to perform this test at 0°C.</p> <p>Kindly confirm.</p>	Tender condition prevails
24	Inspection And Test Plan For Electric Welded Line Pipes Doc no: GSL/REPL/012/STPL Dated 19/01/2023		General	Bidder has retained Inspection & Test Plan of Electric Welded Line Pipes for information only, however project specific ITP shall be submitted upon receipt of award of Contract.	Bidder understanding is correct
25	EMD			We also request you to kindly withdraw EMD Bank Guarantee Clause because we will not be able to submit EMD_BG to private sector customers as per management rules	EMD is waved off for this tender Please refer to corrigendum -02

ANNEXURE-01

GASONET SERVICES (RJ) LIMITED

[Submitted on Non-Judicial Stamp Paper]
DECLARATION FOR BID SECURITY

To,
Gasonet Services (RJ) Limited
8th Floor, 807, World Trade Tower,C-1, Sector 16,
Noida, Gautam Buddha Nagar, Uttar Pradesh.
Pin Code: 201301

Subject: Procurement of API 5L 3LPE Coated CS Line Pipe
Tender No.: GSL/REPL/012/STPL

Dear Sir,

After examining/reviewing provisions of the above referred tender documents (including all corrigendum/ Addenda), we M/s. (Name of Bidder) have submitted our offer/ bid no.

We, M/s _____ (Name of Bidder) hereby understand that, according to your conditions, we are submitting this Declaration for Bid Security.

We understand that we will be put on the watch list/holiday/ banning list (as per policies of Gasonet Services (RJ) Limited in this regard), if we are in breach of our obligation(s) as per the following:

- a) Have withdrawn/modified/amended, impairs or derogates from the tender, my/our bid during the period of bid validity specified in the form of bid; or
- b) Having been notified of the acceptance of our bid by the Gasonet Services (RJ) Limited during the period of bid validity:
 - Fail or refuse to execute the Contract, if required, or
 - Fail or refuse to furnish the Contract Performance Security by provisions of the tender document.
 - Fail or refuse to accept 'arithmetical corrections' as per the provision of the tender document.
- c) Having indulged in corrupt/fraudulent /collusive/coercive practice as per the procedure.

Place:
Date:

[Signature of Authorized Signatory of Bidder]
Name:
Designation:
Seal: