

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 : 15-12-2023

Venue: ONLINE

Date of Pre-bid Clarifications: 30-12-2023

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

COMMERCIAL QUERIES

Sr.	Tender Clause No. Annexure	Page No.	Clause Description	Bidders Comments / Queries	Owner Reply / Clarifications to Bidders
1	Clause No. 3.0 of SCC Payment Terms	71 of 97	<p>20% advance along with the Purchase Order against approval of submitted documents e.g. QAP, test reports, physical verification by client.</p> <ol style="list-style-type: none"> 1. Commercial invoice in triplicate 2. GST invoice 3. LR or GR (original) 4. Packing List 5. Material Test Certificate 6. Guarantee / Warranty Certificate 7. Dispatch clearance issued by Purchaser / Consultant 8. Inspection release note issued by Purchaser/ Consultant/ TPIA 9. Certificate of receipt of goods at Purchaser's store <p>Submission of final documents.</p> <p>80% payment on sight LC.</p>	<p>As discussed in pre-bid meeting, kindly update the payment term accordingly. I.e. 20% advance along with the Purchase Order against production plan and balance 80% through Letter of Credit and establishment of LC within 15 days after award of the Order.</p>	Ref Corrigendum#02
2	General			<p>We understand that PP-MII, DMI&SP is not applicable for this tender.</p> <p>Kindly Confirm.</p>	Bidder understanding is Correct.

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3	Clause No. 6.0 CONTRACT VALIDITY AND DELIVERY SCHEDULE		<p>Short term contract, the delivery to be completed with maximum 3 lot in a span of 3 month. The earliest lot delivery within 1 Month from the date of PO.</p> <p>The scope of work shall be completed, as per instructions of the Owner :</p> <ul style="list-style-type: none"> • Delivery of 1st lot shall be completed within 04 weeks from placement date of LOA/PO/ first intimation from Gasonet. • Delivery of 2nd lot shall be completed within 08 weeks from placement date of LOA/PO/ first intimation from Gasonet. • Delivery of 3rd lot shall be completed within 12 weeks from placement date of LOA/PO/ intimation from GSL. 	<p>Kindly define the minimum & maximum lot-wise quantities for more clarity.</p>	<p>Bidder may supply the readily available quantity upto complete LOT.</p>
4	Clause No. 13.2 EVALUATION METHODOLOGY		<p>The “Schedule of Rates” including GST quoted shall be carried out on item wise basis. The total quoted price in “Schedule of Rates” for complete scope of work shall be taken up for evaluation.</p>	<p>Item No. D, E & F are too less to manufacture individually. Bidder request that kindly evaluate the bid in Size-wise groups. E.g. for evaluation methodology as under: Group 1: ITEM NO. (A+E) Group 2: ITEM NO. (B+F) Group 3: ITEM NO. (C) Group 4: ITEM NO. (D)</p> <p>Kindly consider.</p>	<p>Evaluation shall be on following basis Group 1: ITEM NO. (A+E) Group 2: ITEM NO. (B+F) Group 3: ITEM NO. (C) Group 4: ITEM NO. (D)</p>
5	TERMS OF PAYMENTS		<p>20% advance along with the Purchase Order against approval of submitted documents e.g. QAP, test reports, physical verification by client.</p> <p>80% payment on sight LC</p>	<p>Bidder would like to proposed the payment are as follow:</p> <p>20% advance along with the Purchase Order against approval of submitted documents e.g. QAP only.</p> <p>80% payment against sight LC. LC shall be opened by GASONET within 15 days from the date of PO.</p> <p>If material get ready duly inspected by TPI, but site is not ready for taking the materials then GASONET will release the balance payment within 7 days from date of IRN.</p>	<p>Ref Corrigendum#02</p>

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				<p>Kindly confirm.</p> <p>Bidder would like to inform you that if any ready Ex Stock materials with us then we can supply the materials within 6 to 8 weeks from date of PO, approved QAP, LC whichever may be later.</p> <p>Further if we will go fresh rolling of the materials then we need 12 to 16 weeks from date of PO, approved QAP, LC whichever may be later.</p> <p>Kindly confirm.</p>	
6	Delivery Period		<p>Delivery of 1st lot shall be completed within 04 weeks from placement date of LOA/PO.</p> <p>Delivery of 2nd lot shall be completed within 08 weeks from placement date of LOA/PO.</p> <p>Delivery of 3rd lot shall be completed within 12 weeks from placement date of LOA/PO.</p>	<p>Tender Condition Prevails. However the delivery schedule maybe mutually revised, post order.</p>	
7	Clause 10.1.2	8 of 97	<p>Standard : API 5L , PSL -2 Material Grade X-42 or above, ERW/Seamless with 3LPE Coating</p>	<p>Considering our extensive experience in the pipe manufacturing business spanning over 30 years, we propose the inclusion of the above-mentioned clause in the tender document</p> <p>Standard : API 5L , PSL -2 Material Grade X-42 or above, H-SAW/L-SAW/ERW/Seamless with 3LPE Coating</p>	Refer Corrigendum#02
8	SOR & Cl. 5 of IFB	6 of 97	<p>6" X 6.4mm API 5L X-42/ X-52/ X-56 PSL 2 3LPE Coated Pipe Qty. 60000 Mtr.</p> <p>8" X 6.4mm API 5L X-42/ X-52/ X-56 PSL 2 3LPE Coated Pipe Qty. 6000 Mtr.</p>	<p>We propose to offer 6" X 6.4 mm size partial quantity from available stock in API 5L Grade B PSL 2 with 3LPE Coating and 8" X 6.4 mm size Partial Quantity from available stock in API 5L Grade X42 PSL2 with 3LPE Coating. Balance quantity will be fresh rolling.</p> <p>Kindly confirm</p>	<p>Considered grade are as follows: X-42/ X-52/ X-56</p>
9	6 of IFB / 5 of SCC	6 of 97	<p>6.0 CONTRACT VALIDITY AND DELIVERY SCHEDULE</p> <p>6.1 Short term contract, the delivery to be completed with maximum 3 lot in a span of 3 month. The earliest lot delivery within 1 Month from the date of PO.</p> <p>6.2 The scope of work shall be completed, as per instructions of the Owner:</p> <p>6.2.1 Delivery of 1st lot shall be completed within 04 weeks from placement date of LOA/PO/ first intimation from Gasonet.</p> <p>6.2.2 Delivery of 2nd lot shall be completed</p>	<p>1. We wish to bring it to your notice that in case of acceptance of pipes from available stock, delivery of 1st LOT within 4 weeks is feasible.</p> <p>However for fresh rolling, the delivery of 1st Lot within 4 week & 2nd Lot within 8 Weeks from date of Purchase Order may not be feasible because of lead time of steel procurement, pipe manufacturing, coating and delivery of pipes to distant locations (Bikaner & Churu Location) along with</p>	<p>Tender Condition Prevails. However the delivery schedule maybe mutually revised, post order.</p>

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			<p>within 08 weeks from placement date of LOA/PO/ first intimation from Gasonet.</p> <p>6.2.3 Delivery of 3rd lot shall be completed within 12 weeks from placement date of LOA/PO/ intimation from Gas</p> <p>Note:</p> <p>a. The basis of delivery shall be FOT, Gasonet Site/Store basis including unloading and stacking at Gasonet Site / Store at Rajasthan (Bikaner and Churu Districts).</p> <p>b. Gasonet may take the supply of full quantity in first” Lot” itself subject to the adequate availability of storage space at site.</p>	<p>unloading & stacking arrangements. Hence for fresh rolling please provide 4 weeks additional for Lot 1 and Lot 2.</p> <p>Kindly confirm.</p> <p>2. We would request you to confirm the minimum qty. required in each Lot.</p>	
10	CL. 9 of SCC	73 of 91	<p>9.0 CONTRACT-CUM-EQUIPMNET PERFORMANCE BANK GUARANTEE.</p> <p>9.1 Within thirty (30) Days of receipt of the Letter of Acceptance / Notification of Award, the successful bidder shall furnish to the Purchaser the Contract-Cum-Equipment Performance Bank Guarantee (CPBG) of 3% of total order value / contract value (Total order value will be inclusive of all taxes, duties and charges towards transportation, unloading etc. up to GSL site/store).</p>	<p>As per our management policy we won't give CPBG's to Private Companies, hence we request you to remove the CPBG clause from tender documents as this clause restrict us from bidding against this tender.</p>	Tender Condition Prevails.
11	3.0 of SCC	71	<p>3.0 TERMS OF PAYMENTS</p> <p>3.1 20% advance along with the Purchase Order against approval of submitted documents e.g. QAP, test reports, physical verification by client.</p> <p>3.2 80% payment on sight LC.</p>	<p>We request to accept the payment terms as 20% advance along with PO and 80% payment on sight LC. After receipt of 20% Advance order will be further processed for Raw Material procurement, QAP Approval etc. Kindly confirm.</p>	Refer Corrigendum#02
12	CL. 4 D of Volume II of HFW Specification	4	<p>D. RAW MATERIAL</p> <p>Bidder shall place the PO for raw material (coil) and shall submit the required documents, as per technical tender, to owner within 15 days of LOI/ First intimation/ PO. Indicative list of documents to be submitted shall include:</p> <ol style="list-style-type: none"> 1. Copy of PO with detailed technical specifications and delivery terms, 2. Documentary evidence for advance payment made (If Any). Purchaser may ask for other additional documents also. <p>Non-submission of above documents within</p>	<p>We request to accept the payment terms as 20% advance along with PO and 80% payment on sight LC. After receipt of 20% Advance order will be further processed for Raw Material procurement, QAP Approval etc. Kindly confirm</p>	Refer Corrigendum#02

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			stipulated time frame shall be treated as non-compliance of supply contract and penalty shall be levied @ 0.2 % of awarded group value per week.		
13	7 of SCC	73	7.0 PRICE REDUCTION SCHEDULE (PRS) Deduct a sum @ ½ % (Half Per Cent) of the value of the supply per week or part thereof for delay in supplies subject to a maximum ceiling of 5% of respective order value.		
14	FORM F-11: "SAMPLE INDICATIVE" FORMAT FOR CONTRACT	94	FOR MATERIAL: In case of delay in completion of supply beyond the stipulated time, penalty would be levied @ 1% of total value of the undelivered part per week or part thereof for each extra week taken by the vendor i.e. more than schedule time/period, subject to maximum of 10% of the total value of the undelivered part. In case of delay of more than 10 weeks in supply of material or services beyond a stipulated completion date, GSL reserves the right to terminate the contract and reserves the right to place order on another vendor. Any extra expenditure that GSL will have to incur for procurement of the balance material through the other supplier on account of higher rates quoted by the supplier will be recovered from the supplier's retention money, pending bills etc. All lots shall be considered separately for applying PRS in case of delay as described above.	As per our management policy we won't accept PRS Clause, hence we request you to remove the PRS clause from tender documents as this clause restrict us from bidding against this tender.	Tender Condition Prevails. However the delivery schedule maybe mutually revised, post order. In such case PRS is applicable on revised delivery schedule.
15	Cl. 13 of IFB	11	13.0 EVALUATION METHODOLOGY 13.1 Evaluation and comparison of bid shall be carried out according to the BEC criteria of the tender. 13.2 The "Schedule of Rates" including GST quoted shall be carried out on item wise basis. The total quoted price in "Schedule of Rates" for complete scope of work shall be taken up for evaluation. 13.3 In case it is observed that any bidder has not quoted (left blank) for any item in the Schedule of Rates (such unquoted item not	1) We understand that for evaluating price preference the Base Price will be considered Total Price inclusive of all taxes & duties i.e. including GST. 2) We understand that procurement will be done item wise in single grade from single bidder. Kindly confirm.	Bidder understanding is correct.

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			being in large numbers), the quoted price for the purpose of evaluation shall be considered as the maximum rate quoted by the remaining bidder for such items. 13.4 The OWNER / Consultant will evaluate and compare the price-bids who are found to be techno-commercially qualified.		
16	Cl. 5.5 of IFB	6	Price comparison among different grade of material shall be evaluated on the following method : Price Preference on X-46 over X-42: 1.5% of base price. Price Preference on X-42 over X-52: 3% of base price. Pro-rated premium to be evaluated b/w X-52 over X-46 based on above method.	1) We understand that for evaluating price preference the Base Price will be considered Total Price inclusive of all taxes & duties i.e. including GST. 2) We understand that procurement will be done item wise in single grade from single bidder. Kindly confirm.	Bidder understanding is correct.
17	2 (B) of IFB	4	Open domestic competitive bidding	1. We understand that this is Open domestic competitive bidding, single stage two bid system. 2. We also understand that rate contract is not applicable for this tender. Kindly confirm.	Bidder understanding is Correct.
18	8.1 of IFB	7	International Competitive Bidding basis. Single stage two bid system		
19	1.1 of ITB	15	1.1 Purchaser invites bids through open domestic competitive bidding mode for the entire work as specified in the Bid documents (hereafter referred to as the Work) on rate contract basis.		
20	E. 5 b of TECHNICAL VOLUME II OF II	5	b. Quantity may vary \pm 5% for coated pipe & \pm 25% for bare pipe. Final quantity will be informed to successful bidder.	We understand that final quantity will be informed to successful bidder at the time of placement of order and there will not be any quantity variations after placement of order. Kindly confirm.	Bidder understanding is Correct.
21	12.1 of IFB	10	12.1 GSL also reserves the right increase or decrease the scope of work before or after award of work.	We understand that final quantity will be informed to successful bidder at the time of placement of order and there will not be any quantity variations after placement of order. Kindly confirm.	Bidder understanding is Correct.

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22	6 of GCC	38	6.0 TRANSPORTATION 6.1 Transportation of all items covered in the scope of contractor, will be arranged by contractor at his own cost including insurance and storage. Contractor will also be responsible for taking delivery of free issue material from Owner's store and Transportation to place of work including its coverage for transit insurance.	We understand that the storage insurance is in the scope of GSL and Bidder need not to consider any cost in their quoted prices. Kindly confirm.	The insurance of storage at GSL site shall be in the scope of GSL.
23	66.3 of GCC	67	66.3 CUSTOMS DUTY (CD) VARIATION	We would request you to provide the Format of Details of built in CIF Value of Import Content if applicable.	Not Applicable.
24	Tender Documents	General Query	PART ORDER/ SPLIT ORDER / REPEAT ORDER	We understand that PART ORDER/ SPLIT ORDER / REPEAT ORDER is not applicable for said procurements. Please confirm.	Bidder understanding is correct.
25	Volume II of II		Index Sr. no. 9 to 15	In Volume II of II Index Sr. no. 9 to 15 documents are missing in Volume II of II.	<ul style="list-style-type: none"> • ITP– Small size pipes- N/A • Checklist – Ref Corrigendum#02. • Compliance statement – N/A • No Deviation sheet – Ref Corrigendum#02. • Instruction to bidder – Commercial Vol I of II. • Reference list – N/A. • Vendor drawings / document schedule139 – N/A
26	CL. 4 C Vol II of II	4 of 118	Scope of Work	<p>1) We understand that bidder scope of work w.r.t warehouse is limited to unloading and stacking of pipes at designated storage yard. Please confirm.</p> <p>2) We understand that land for storage will be free issued by GSL in developed condition Further we understand that land development is not in the scope of bidder. Please confirm.</p> <p>3) Please also confirm whether arrangement of Sand Bags and Preparation of Sand Rows is in the scope of Bidder.</p>	Bidder understanding is correct.

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27	IFB - Clause 6.0 CONTRACT VALIDITY AND DELIVERY SCHEDULE 6.1-	7	'Short term contract, the delivery to be completed with maximum 3 lot in a span of 3 month. The Earliest lot delivery within 1 Month from the date of PO. 6.2.1 Delivery of 1st lot shall be completed within 04 weeks from placement date of LOA/PO/ first Intimation from Gasonet. 6.2.2 Delivery of 2nd lot shall be completed within 08 weeks from placement date of LOA/PO/ first Intimation from Gasonet. 6.2.3 Delivery of 3rd lot shall be completed within 12 weeks from placement date of LOA/PO/ Intimation from Gas.	Bidder intend to clarify the Minimum & Maximum Quantities per month to be delivered at site. Considering Steel Procurement & Production time we request you to please revise the delivery schedule as below: 1. Delivery of 1st lot from 6 - 8 Weeks 2. Delivery of 2nd lot from 8 - 12 Weeks 3. Delivery of 3rd lot from 13 - 16 Weeks	Tender Condition Prevails. However the delivery schedule maybe mutually revised, post order
28	IFB - Clause 6.0 CONTRACT VALIDITY AND DELIVERY SCHEDULE 6.2-	8	The basis of delivery shall be FOT, Gasonet Site/Store basis including unloading and stacking at Gasonet Site / Store at Rajasthan (Bikaner and Churu Districts).	Bidder request to please share tentative or firm quantities per site as distance between Bikaner & churu is approx. 200 Kms which plays vital role in costing. Also provide tentative delivery location with Pin Code.	Delivery Location Bikaner.
29	Instruction to Bidder: Clause 37.0 - Award Criteria	27	Subject to various clauses of ITB, the Owner/ Consultant will award the Contract to the successful bidder (s) whose bid has been determined to be substantially responsive and has been determined as a lowest bid on item wise basis based on the quoted multiple grades along with quantities that are ready available to GASONET and capacity of Bidders is as per qualification criteria and is determined to be qualified to satisfactorily perform the Contract.	As the Order Splitting is applicable hence, bidder suggest to please evaluate the bid as per below: Group 1: 2" (Bare) & 4" (Bare & Coated) Group 2: 6" (Bare & Coated) Group 3: 8" (Coated) As the quantity desired for Bare is not feasible to manufacture in case only bare pipes are awarded to one bidder.	Evaluation shall be on following basis Group 1: ITEM NO. (A+E) Group 2: ITEM NO. (B+F) Group 3: ITEM NO. (C) Group 4: ITEM NO. (D)
30	SPECIAL CONDITIONS OF CONTRACT: Clause : 3.0 Terms of Payment	71	3.1 - 20% advance along with the Purchase Order against approval of submitted documents e.g. QAP, test reports, physical verification by client. <ul style="list-style-type: none"> • Commercial invoice in triplicate • GST invoice • LR or GR (original) • Packing List 	As discussed in Pre-Bid Meeting Bidder understand that : 3.1 - 20% Advance shall be paid within 7 Working days from date of submission of Proforma Invoice / Date of LOA / PO whichever is later. 3.2 - Balance 80% against LC by reputed	Ref Corrigemdum#02

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			<ul style="list-style-type: none"> • Material Test Certificate • Guarantee / Warranty Certificate • Dispatch clearance issued by Purchaser / Consultant • Inspection release note issued by Purchaser/ Consultant/ TPIA • Certificate of receipt of goods at Purchaser's store • Submission of final documents. <p>3.2 - 80% payment on sight LC</p>	<p>bank on submission of below documents against readiness of material:</p> <ul style="list-style-type: none"> • Proforma Invoice of ready material. • Packing List • Material Test Certificate • Dispatch clearance issued by Purchaser / Consultant • Inspection release note issued by Purchaser/ Consultant/ TPIA 	
31			Quantity variation at time of award of contact.	As discussed in Pre-Bid Meeting Bidder understand that at time of award of contact Quantities may change $\pm 5\%$ (max.) at time of award of contract.	Bidder understanding is Correct.
TECHNICAL QUERIES					
1	Clause No. 4.3.6	75 of 118	<p>SURFACE IMPERFECTIONS :</p> <p>1) Anchor pattern/roughness profile shall be between 50 to 70 microns.</p> <p>2) Dust contamination shall be rating max. 2 as per ISO 8502-3.</p>	<p>1) For Better Cleaning we propose Anchor pattern/roughness profile 50 to 100 microns (Rz scale) as per relevant standard DIN 30670 i.e. 40 to 90 microns Rz.</p> <p>2) We will check dust contamination using transparent tape as per ISO 8502-3.</p> <p>3) Max dust Degree & Class 2.</p> <p>Kindly consider & Confirm.</p>	Confirm
2	Clause No. 3.2.5	67 of 118	The long duration Tests Coating Resistivity, Heat Ageing & Light Ageing. - Test carried out in an independent laboratory of national/international recognition on PE topcoat is also acceptable.	<p>These tests Thermal Ageing, Light Ageing & Coating Resistivity are long duration special type test, as per practice we will submit manufacturer test data for review the certificate conducted within 3 years at National/ International Lab.</p> <p>Kindly consider & Confirm.</p>	Confirm
3	Clause No. 3.7	69 of 118	Contractor shall obtain Infrared scan of each batch of epoxy powder to assure that powder used in manufacturing is same as powder used in qualification.	<p>As this is special type of test and testing will be performed by FBE manufacturer only. So, We will submit the infra-red scan graph with MTC of each batch of epoxy powder provided by raw material manufacturer for review purpose only.</p>	Confirm

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				Kindly consider & Confirm.	
4	Clause No. 4.4.2	78 of 118	The instruments shall be calibrated from NABL approved laboratory.	Key measuring & monitoring instruments will be calibrated from ISO 17025 or equivalent agency.	Confirm
5	Clause No. 4.4.3 ANNEXURE – II 2.0	80 of 118	1) Coating cutback is 120mm +20 mm/(-0) mm Edge of the coating shall be shaped to form a bevel angle of 30° to 45°. 2) As per ANNEXURE – II 2.0 FBE Band/Toe : 20±5 mm.	In clause no. 4.4.3 coating cutback is mention without FBE Toe. But in annexure-II 2.0 Coating cutback requirement with FBE Toe: 20±5 mm. Please clarify FBE Toe required or not	FBE toe is required
6	Clause No. Table 5.3.2	83 of 118	Testing frequency of bond Strength is 1 in 25 pipes both end and middle.	1) We are using proven raw material combination, so we propose middle peel test one in 60 pipes to avoid more repair of coating due to coating damage during testing. 2) At the middle of pipe bond test is not possible to maintain test temperature, so we will perform the Middle testing at maximum feasible distance from the end (approx. 400mm from pipe end). Kindly consider & Confirm.	Tender Condition Prevails.
7	Clause No. 3.5	68 of 118	For each batch of all materials, the Contractor shall obtain from the manufacturer(s) relevant certificates of material conformity and test results as per DIN 10204, 3.1 b. These certificates shall be submitted to Company for approval prior to the use of material for coating application	Raw material MTC shall be provided by material manufacturer to confirm specification requirement with few properties mentioned as typical result as per material manufacturer standard practice. Kindly consider.	Confirm
8	Clause No. 5.3.12		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 epoxy and adhesive shall be tested at a voltage of 25kV. No holidays are permitted.	As per our practice & relevant spec./std. requirement we perform holiday on partly coated pipe FBE layer only @ 5 V/ micron. As per relevant stds requirement 10 KV /mm for holiday testing .But epoxy + adhesive thickness is below 1 mm's, the voltage 25 KV is very high for Epoxy + Adhesive thickness .So, we cannot accept holiday test on epoxy +adhesive portion at 25kV. Please consider the same & confirm.	Confirm

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9	Clause No. 5.5.3 Pipe Body Test	88 of 118	The average (set of three test pieces) absorbed energy value (KvT) for each pipe body test shall be as specified in Table 8 of this specification, based upon full sized test pieces at a test temperature of 0°C(32°F) and at -29o C (-20°F).	The average (set of three test pieces) absorbed energy value (KvT) for each pipe body test shall be as specified in Table 8 of this specification, based upon full sized test pieces at a test temperature of 0°C(32°F). Please confirm the same.	Confirm
10	Clause No. 5.5.3.2	18 of 118	The minimum average (set of three test pieces) shear fracture area shall be at least 85 % with one minimum value of 75%, based at a test temperature of 0 °C (32°F) and at -29°C (-20°F).	The minimum average (set of three test pieces) shear fracture area shall be at least 85 % with one minimum value of 75%, based at a test temperature of 0 °C (32°F). Please confirm the same.	Confirm
11	Clause No. 5.5.4 Pipe Weld & HAZ Test		The average (set of three test pieces) absorbed energy value (KvT) for each pipe weld and HAZ test shall be as specified in Table 8 of this specification, based upon full-size test pieces at a test temperature of 0°C (32°F) and at -29o C (-20°F).	The average (set of three test pieces) absorbed energy value (KvT) for each pipe weld and HAZ test shall be as specified in Table 8 of this specification, based upon full-size test pieces at a test temperature of 0°C (32°F). Please confirm the same.	Confirm
12	Annexure B5 MPQT		v- 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. The minimum average (set of three test pieces) shear fracture area at the test temperature specified in clause 5.5 of this specification shall be complied with. For other temperatures, the value shall be for information only.	v- Fracture Toughness Testing. Four (4) sets of CVN base metal test pieces shall be tested at, - 40°C, , -20°C, , 0°C, and + 20° C for shear area and absorbed energy to produce full transition curve. The minimum average (set of three test pieces) shear fracture area at the test temperature specified in clause 5.5 of this specification shall be complied with. For other temperatures, the value shall be for information only. Please confirm the same.	Confirm
13	Cl. No. 5 (Notes d.) of material Requisition Cl. No. 5.6.1.1 of standard specification for high frequency		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. All pipes shall be supplied with length between 11.5 m and 12.5 m. However, pipe with length	As per rules and regulations of Road and Transport department (RTO). The pipe length above 12.50m is not allowed. Hence it should be allowed to supply the pipes in the range between 11.20m to 12.19m with average length 11.80m and for sample pipes maximum 5% of ordered qty shall be between 10.0m to 11.20m.	Tender Condition Prevails.

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	welded line pipe		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	Kindly confirm.							
14	Cl. No. 5 (Notes e.) of material Requisition		For butt weld end, bevel shall be in accordance with API specification 5L or ASME B16.25 as applicable.	Bidder understands that pipe ends shall be beveled as per API 5L i.e. bevel angle 30°-35° and root face 1.6 mm ± 0.8 mm. Please confirm	Bevel shall be in accordance with API specification 5L or ASME B16.25.						
15	Cl. No. 5 (Notes f.) of material Requisition		Bevel Protector or end caps shall be installed on all pipe ends. End caps shall be hook-able type which shall allow the use of end hooks without the need for their removal during pipe handling. The bevel protector shall be the re-usable type	We understand that bevel protector or end caps shall be provided with respect to pipe sizes. We will provide ID end caps for pipe handling without the need for their removal. Please confirm.	Tender Condition Prevails						
16	Cl. No. 5.7.1.2 of standard specification for high frequency welded line pipe		<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">Wall thickness (mm)</th> <th style="text-align: center;">Tolerances c, d (mm)</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">t < 15.0 mm</td> <td style="text-align: center;">+0.20 t -0.0t</td> </tr> <tr> <td style="text-align: center;">t ≥ 15.0 mm</td> <td style="text-align: center;">+3.0 mm -0.0 mm</td> </tr> </tbody> </table> <p>a Deleted b Deleted c The + ve tolerance for wall thickness does not apply to the weld area. d See 9.13.2 of API Spec 5L and as modified herein for additional restrictions.</p>	Wall thickness (mm)	Tolerances c, d (mm)	t < 15.0 mm	+0.20 t -0.0t	t ≥ 15.0 mm	+3.0 mm -0.0 mm	We understand that the thickness tolerance shall be as per table 11 of API 5L 46 th edition as table 11 is more stringent than client spec. Please confirm.	Tender Condition Prevails
Wall thickness (mm)	Tolerances c, d (mm)										
t < 15.0 mm	+0.20 t -0.0t										
t ≥ 15.0 mm	+3.0 mm -0.0 mm										
17	Cl. No. 6 of standard specification for high frequency welded line pipe		Inspection certificate 3.2 in accordance with EN 10204 shall be issued for each dispatched pipe by Purchaser's authorized representative.	1. Bidder understands that Inspection certificate 3.2 in accordance with EN 10204 shall be applicable for Pipe & Steel coils. 2. However bidder requests to clarify that appointment of TPIA & associated cost will be in the scope of pipe manufacturer or client. 3. Also request you to please provide approved TPIA list if any.	1. Bidder understanding is correct. 2. Refer Clause No. 1.5 of SCC. 3. Only PNGRB approved TPIA's. May refer www.pngrb.gov.in						

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18	Cl. No. 1.2 & 3.1 of ITP – Welded pipes		Welding Parameters & Qualification Record Records - WPS, PQR & WPQ Welding Parameters as per WPS / PQR	MPS (Manufacturing Procedure Specification) & Welding Parameter Sheet shall be provided instead of WPS, PQR & WPQ as WPS/PQR is not applicable for HFW process. Kindly Confirm.	Confirm
19	Cl. No. 4.4 of ITP – Welded pipes		PMI Check Chemical Check	We shall do spectro analysis to cover all elements as per Client specification and API 5L 46 th Edition instead of PMI check. Please confirm	Confirm
20	Cl. No. 10 of standard specification for high frequency welded		PRODUCTION REPORT The Manufacturer shall provide one electronic copy and six hard copies of production report in English language indicating at least the following for each pipe.	Due to environmental concern bidder request to permit one hard copy and 6 electronic copy of the MRB. Please confirm	Tender Condition Prevails.
21	Cl. No. 7.2.4 of standard specification for high frequency welded		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.	Since, there is only one thickness per size so we understand that color band is not applicable for this tender. Please confirm	Tender Condition Prevails.
22	Cl. No. 5.5.3 of standard specification for high frequency welded		The average (set of three test pieces) absorbed energy value (KvT) for each pipe body test shall be as specified in Table 8 of this specification, based upon full sized test pieces at a test temperature of 0°C(32°F) and at -29° C (-20°F).	Bidder understands that the CVN test shall be performed at -29°C. Please re-confirm.	Confirm
23	Table 18 - of standard specification for high frequency welded		Product analysis 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	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	Confirm
24	Cl. No. 3.6 of Standard specification of 3LPE		All materials to be used shall be packed in damage free containers suitably marked with the following minimum information for identification: a. Name of the manufacturer. b. Type of material and product designation. c. Batch Number. d. Date and place of Manufacture e. Shelf Life / Expiry Date f. Storage Conditions g. Quantity	Epoxy powder bag printing marked complied all required points. However adhesive and polyethylene materials bag marked with all required point except of Manufacturing Date/Self life /Expiry date. These information will be provided on each batch test certificates.	Lot shall be verified by TPIA with test certificate and physical presence.

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			Any materials found without above identification markings shall be deemed suspect and rejected by Company. Rejected materials shall be promptly removed and replaced by the Contractor. Coating materials shall be segregated by batch number during shipment, storage and handling.		
25	Cl. No. 4.3.6 of Standard specification of 3LPE		The surface finish after blast cleaning shall conform to near white metal finish i.e. Sa 2½ of Swedish Standard SIS 055900.	Bidder clarifies that the surface finish after blast cleaning shall conform to near white metal finish (Sa 2½) as per ISO 8501-1 instead of Swedish Standard SIS 055900.	Confirm
26	Cl. No. 5.3.5 of Standard specification of 3LPE		BOND STRENGTH TEST 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).	Bond strength test is not feasible to carry out at middle of the pipe due to pipe size constraint. Therefore, bidder clarifies that middle peel test shall be carried out at maximum feasible distance from pipe end.	Tender Condition Prevails
27	Cl. No. 5.6 of Standard specification of 3LPE		After blast cleaning, all pipes shall be tested for salt contamination. One test shall be carried out at each end of each pipe using salt meter (SCM 400 or approved equivalent).	Bidder clarifies that Salt contamination test at each end of each pipe reduce the pipe production rate; if required, it will test randomly on other end of pipe. Hence, Bidder proposed that Salt contamination test should be carried out at one end of pipe using salt meter (SCM 400 or approved equivalent).	Tender Condition Prevails
28	Cl. No. 8.0 of Standard specification of 3LPE		MARKING AND PIPE IDENTIFICATION iii. Colour band	Please provide colour code for outside colour band after 3LPE coating; If any.	Not Required
29	4.B.	4 of 118	Compliance with specification The vendor shall be completely responsible for the receiving/taking over, design, materials, fabrication, 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.	Bidder clarifies that design is not under our scope of work.	Confirm

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30	4.E.	5 of 118	<p>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.</p>	<p>Bidder Clarifies that there is no list is provided for approved agency for appointing TPI. Please provide the same.</p> <p>Also Clarify that TPI is appointed on Steel mill or Pipe mill or as for both mills.</p>	<p>Only PNGRB approved TPIA's. May refer www.pngrb.gov.in</p> <p>Both Mills.</p>
31	5.0 Note. d 5.6.1.1	5 & 21	<p>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.</p> <p>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.</p>	<p>Bidder confirms to supply pipe with the length tolerance specified in the client spec. CL 5.6.1.1 as below: "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." "</p>	Confirm
32	5.0 Note. e 5.7.1 5.8.1.1	5 & 21	<p>For butt weld end, bevel shall be in accordance with API specification 5L or ASME B16.25 as applicable.</p> <p>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.</p> <p>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.</p>	<p>Bidder clarifies that bevel end preparation shall be as per CL 9.12.5.2 of API 5L.</p>	<p>Tender Condition Prevails.</p> <p>"Bevel shall be in accordance with API specification 5L or ASME B16.25 as applicable."</p>
33	1	12 of 118	<p>Scope The sections, paragraphs and annexes contained herein have the same numbering as that of API Spec 5L in order to facilitate reference. Additional requirements, which are not specified in API Spec 5L, have also been numbered and marked as "(New)".</p>	<p>Bidder clarifies that the client specification does not contain same numbering as that of API 5L.</p>	Tender Condition Prevails.

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34	2	12 of 118	<p>NORMATIVE REFERENCES The latest edition (edition enforce at the time of issue of enquiry) of following additional references are included in this specification: ASTM E112-13: Standard Test Methods for Determining Average Grain size</p>	<p>Bidder understands that the latest year edition of ASTM E112 is of 2013(Re-Affirmed: 2021).We confirm to follow this latest edition.</p>	<p>Bidder understanding is correct. Latest edition to be followed.</p>			
35	6.2.1.1 Table 18	24	<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> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="text-align: center; width: 5%;">2</td> <td style="width: 40%;">Product analysis ^b</td> <td style="width: 55%;">Two pipes per lot (maximum 100 pipes) per heat</td> </tr> </table>	2	Product analysis ^b	Two pipes per lot (maximum 100 pipes) per heat	<p>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.</p>	<p>Confirm</p>
2	Product analysis ^b	Two pipes per lot (maximum 100 pipes) per heat						

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36	<p>6.2.1.3</p> <p>6.2.2.1</p>	25 of 118	<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.</p> <p>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" data-bbox="596 748 989 1146" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th style="text-align: center;">Sample Location</th> <th style="text-align: center;">Type of test</th> <th style="text-align: center;">Number, Orientation and location of test pieces per sample < 219.1 mm (8.625 in)</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">Pipe body</td> <td style="text-align: center;">CVN</td> <td style="text-align: center;">3T90</td> </tr> <tr> <td style="text-align: center;">Seam Weld</td> <td style="text-align: center;">CVN</td> <td style="text-align: center;">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	<p>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.</p> <p>Also as per API 5L Table 22, sample extraction (full size / sub size) for the above specified sizes not specified.</p> <p>However, for Longitudinal samples can be extracted for 4.5" & 6.625" OD only for base metal.</p>	<p>Tender Condition Prevails.</p> <p>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.</p> <p>Lower pipe sizes wherein preparation of transverse sub-sized specimen is not possible, CVN impact testing shall be carried out on longitudinal test specimen</p>
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												
37	<p>10.2.8.7</p>	28 of 118	<p>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 Representative on request</p>	<p>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.</p> <p>However, Bidder clarifies that calibration of dimension measuring equipment shall be done on yearly basis from an external NABL lab.</p>	Confirm									

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38	11.2.8	29 of 118	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.	Please provide the colour code band colours for different wall thickness or diameter.	Yellow for 6.4mm
39	Annex B CL B.5.2.c.v	33 of 118	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.	Tender Condition Prevails
40	E.5.1.1	35 of 118	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 center.	Bidder intend to clarify that Ultrasonic testing for pipe Body for size 4.5" and 6.625" OD 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. However, the requirement of automatic weld seam tracking system is confirmed for the pipe size OD \geq 8.625".	Confirm
41	Technical Volume II of II		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.	Confirm
42	Cl. 4.4.1 (e) & 4.4.2 of Stnd. Spec. for 3LPE coating	77 of 118	4.4.1 (e) Temperature measuring & monitoring equipment shall be calibrated twice every shift and/or as per Company Representative's instruction. 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	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. However the pyrometer shall be checked for errors every shift against a calibrated temperature-measuring instrument.	Confirm

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			<p>equipment. The instruments shall be calibrated prior to start of each shift.</p> <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 epoxy and adhesive shall be tested at a voltage of 25kV. No holidays are permitted.</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> <p>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.</p>	
43	Cl. 5.3.12 of Std. Spec. for 3LPE coating	87 of 118	<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 epoxy and adhesive shall be tested at a voltage of 25kV. No holidays are permitted.</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> <p>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.</p>	Confirm
44	Cl. 5.3.5 of Std. Spec. for 3LPE coating	85 of 118	<p>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).</p>	<p>Bidder proposes to carry out bond strength test using manual peel test machine (Spring loaded type test assembly) due to size constraint. Please confirm.</p> <p>Bidder also propose to conduct Middle peel test within feasible distance from pipe end to maintain the test temperature.</p> <p>We request to kindly consider the practical difficulty.</p>	Tender Condition Prevails.

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45	Cl. 8.0 of Std. Spec. for 3LPE coating	92 of 118	MARKING AND PIPE IDENTIFICATION iii. Colour band	Please clarify if any specific colour band is require.	Not Required																																			
46	ANNEXURE-I of Std. Spec. for 3LPE coating	94 of 118	LIST OF ACCEPTABLE COMBINATIONS OF COATING MATERIALS	Bidder understands that polyethylene material HE 3450 is also acceptable instead of HE 3450H.	Confirm																																			
47	MR OF TECHNICAL VOLUME II OF II, Doc. No. GSL/REPL/012/STPL , Date: 07/12/2023	5 of 118	<p>2. SCOPE OF SUPPLY</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th>Item No.</th> <th>Size (Inch)</th> </tr> </thead> <tbody> <tr><td>A</td><td>4"</td></tr> <tr><td>B</td><td>6"</td></tr> <tr><td>C</td><td>8"</td></tr> <tr><td>D</td><td>2"</td></tr> <tr><td>E</td><td>4"</td></tr> <tr><td>F</td><td>6"</td></tr> </tbody> </table>	Item No.	Size (Inch)	A	4"	B	6"	C	8"	D	2"	E	4"	F	6"	<p>Bidder has considered the Standard size as per API Spec. 5L 46th edition as below:</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th>Item No.</th> <th>Size (Inch)</th> <th>Size (mm)</th> </tr> </thead> <tbody> <tr><td>A</td><td>4" or 4.50"</td><td>101.6 mm or 114.3 mm</td></tr> <tr><td>B</td><td>6.625"</td><td>168.3 mm</td></tr> <tr><td>C</td><td>8.625"</td><td>219.1</td></tr> <tr><td>D</td><td>2.375" or 2.875"</td><td>60.3 mm or 73.0 mm</td></tr> <tr><td>E</td><td>4" or 4.50"</td><td>101.6 mm or 114.3 mm</td></tr> <tr><td>F</td><td>6.625"</td><td>168.3 mm</td></tr> </tbody> </table> <p>Further bidder request to confirm the Project sizes for OD 4" or 4.50" and 2.375" or 2.875" instead of 4" and 2" respectively.</p> <p>Moreover, be noted that HFW Specification shall be applied to line pipe of size 4.5" (114.3 mm) OD thru 20" (508.0mm) OD (both sizes included).</p>	Item No.	Size (Inch)	Size (mm)	A	4" or 4.50"	101.6 mm or 114.3 mm	B	6.625"	168.3 mm	C	8.625"	219.1	D	2.375" or 2.875"	60.3 mm or 73.0 mm	E	4" or 4.50"	101.6 mm or 114.3 mm	F	6.625"	168.3 mm	Confirm
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48	MR OF TECHNICAL VOLUME II OF II, Doc. No. GSL/REPL/012/STPL , Date: 07/12/2023	5 of 118	<p>4. GENERAL NOTES</p> <p>B. COMPLIANCE WITH SPECIFICATION</p> <p>The VENDOR shall be completely responsible for the design, materials, fabrication, testing, inspection, preparation for shipment and transport of the above equipment strictly in accordance with the Material Requisition and all attachments there to.</p>	<p>Bidder clarifies that Design is not our scope of work.</p> <p>Bidder is responsible for the materials, fabrication, testing, inspection, preparation for shipment and transport as per applicable Standards / Specification.</p>	Confirm																																			
49	MR OF TECHNICAL VOLUME II OF II, Doc. No. GSL/REPL/012/STPL , Date: 07/12/2023	5 of 118	<p>5. DESIGN DATA</p> <p>NOTES:</p> <p>d. Pipes shall be supplied between 11.5 m to 12.5 m.</p> <p>Coating material combination shall be as per Annexure-I for carrying out 3-layer polyethylene coating. The minimum thickness</p>	<p>Bidder understands that 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.</p>	Confirm																																			

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			of finished coating shall be as per aforesaid specification.		
50	MR OF TECHNICAL VOLUME II OF II, Doc. No. GSL/REPL/012/STPL , Date: 07/12/2023 Clause 5, 5.7 of HFW Spec.	33 of 118	5. DESIGN DATA NOTES: e. For butt weld end, bevel shall be in accordance with API specification 5L or ASME B16.25 as applicable. 5.7 Finish of Pipe Ends 5.7.1 Plain ends	Bidder understands that pipe ends shall be bevelled as per API 5L i.e. bevel angle 30°-35° and root face 1.6 mm ± 0.8 mm. Please confirm.	Confirm
51	MR OF TECHNICAL VOLUME II OF II, Doc. No. GSL/REPL/012/STPL , Date: 07/12/2023 Clause 5.8.1.2 of HFW Spec.	22 of 118	5. DESIGN DATA NOTES: f. Bevel Protector or end caps shall be installed on all pipe ends. End caps shall be hook-able type which shall allow the use of end hooks without the need for their removal during pipe handling. The bevel protector shall be the re-usable type. g. Plastic push fit types end caps shall be installed on all small diameter pipe ends. 5.8.1.2 Bevel Protectors Both pipe ends of each pipe shall be provided with metallic or high impact plastic bevel protectors as per Manufacturer's standard. Bevel protectors shall be of a design such that they can be re-used by coating applicator for providing on externally anti- corrosion coated pipes subsequent to coating of line pipe.	Bidder would like to use metallic bevel protectors of our standard design fixed with HDPE sheet/woven sacks to close the pipe ends in order to prevent ingress of moisture, dust & other foreign materials.	Tender Condition Prevails.
52	MR OF TECHNICAL VOLUME II OF II, Doc. No. GSL/REPL/012/STPL , Date: 07/12/2023	22 of 118	5. DESIGN DATA NOTES: n. ITP for line pipe are enclosed with Bid. Bidder to follow the same.	Bidder clarifies that the Project Specific ITP will be submitted, the ITP shall have detail all the manufacturing aspects/stages in a logical sequence relating to their work program. The received ITP retained for information.	Noted
53	MR OF TECHNICAL VOLUME II OF II, Doc. No. GSL/REPL/012/STPL , Date: 07/12/2023		6. DOCUMENTS & DATA REQUIREMENTS Number of copies = 3 / 4 nos. 10 PRODUCTION REPORT	Due to environmental concern, Bidder request to allow Final technical file shall be supplied in one hard copy (Xerox copy) and in electronic format (PDF Acrobat files) on 2 or 6 CD-ROMs/ Pen drive.	Tender Condition Prevails.

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	Clause 10 of HFW Spec.		The Manufacturer shall provide one electronic copy and six hard copies of production report in English language indicating at least the following for each pipe. International system of units (SI) shall be adopted.								
54	Clause 5, 5.2, Table 5 of HFW Spec.	46 of 118	<p>5 ACCEPTANCE CRITERIA 5.2 Chemical composition Table 5 - Chemical composition for pipe</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th style="text-align: center;">Element</th> <th style="text-align: center;">% max</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">C</td> <td style="text-align: center;">0.16 max. (For Grade BM to X56M)</td> </tr> <tr> <td style="text-align: center;">Mn</td> <td style="text-align: center;">1.20 max. (For Grade BM to X46M) 1.40 max. (For Grade X52M & X56M)</td> </tr> </tbody> </table>	Element	% max	C	0.16 max. (For Grade BM to X56M)	Mn	1.20 max. (For Grade BM to X46M) 1.40 max. (For Grade X52M & X56M)	<p>Bidder requests that Table 5 footnote b) of API 5L 46th Edition to be permitted for Carbon – Manganese relation i.e. For each reduction of 0.01 % below the specified maximum for C, an increase of 0.05 % above the specified maximum for Mn is permissible, up to a maximum of 1.65 % for grades \geq L245 or B, but \leq L360 or X52</p>	Tender Condition Prevails
Element	% max										
C	0.16 max. (For Grade BM to X56M)										
Mn	1.20 max. (For Grade BM to X46M) 1.40 max. (For Grade X52M & X56M)										
55	Clause 5, 5.2.3, Table 5 of HFW Spec.	16 of 118	<p>5.2.3 For heat analysis and product analysis, all the elements listed in Table 5 of this specification shall be analysed and reported, even if those are not purposely added but are present as residuals only.</p>	<p>Bidder clarifies that Heat analysis shall be performed at Steel Mill and same shall be reported in Raw Material Test Certificate, the RMTC shall be submitted to CLIENT/TPIA for review before commencement of production.</p> <p>However Product analysis shall be performed at Pipe mill as per API 5L Table 18 i.e. Two analyses per heat of steel (taken from separate product items).</p> <p>Please re-confirm our understanding.</p>	Confirm						
56	Clause 5, 5.2.3 of HFW Spec.	16 of 118	<p>Tensile properties The finished pipe (after all heat treatment & sizing operations) shall conform to the requirements of Table 7 of API Spec 5L and as modified herein. The actual yield strength shall be as close as possible to the specified minimum yield strength (SMYS) but in no case it shall exceed the limits specified here under: API Spec 5L Grade Permissible in excess of SMYS, MPa (psi) Up to and including X46 M = 131 (19,000) X52M to X60M = 125 (18,000)</p>	<p>Putting additional restrictions over the API 5L Specification requirements makes it Very difficult to source the steel, as no raw material supplier is ready to give Permissible in excess of SMYS to 131 MPa & 125 MPa band for such a material grade API 5L X42M , X46M & X52M PSL2. Hence, bidder proposes to permit guarantee SMYS + 180 MPa band for X42 & X46 and SMYS + 150 MPa for X52, however other parameters shall remain same as per client specification.</p>	Tender Condition Prevails						

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57	Clause 5, 5.6.4 of HFW Spec.	50 of 118	<p>5.6.4 Laminations Any lamination or inclusion either extending into the face or bevel of the pipe or present within 50 mm from pipe ends shall be classified as defect. Pipes that contain such defects shall be rejected or cut back until no lamination or inclusion is present at the pipe ends and shall be treated in accordance with clause C.3 b) or c) of API Spec 5L.</p>	<p>Bidder understand that Lamination or inclusion acceptance criteria shall be in accordance with the API 5L 46th Edition. Pipe which exceed the acceptance criteria of lamination or inclusion shall be rejected or cut back until no lamination or inclusion is present at the pipe ends and shall be treated in accordance with clause C.3 b) or C.3 c) of API Specification SL.</p>	Noted				
58	Clause 6.1	22 of 118	<p>6.1.1.1 Inspection certificate 3.2 in accordance with EN 10204 shall be issued for each dispatched pipe by Purchaser's authorized representative.</p>	<p>Bidder request to confirm the Inspection certificate for Steel (Coils).</p> <p>Bidder request to provide the List of approved steel mill if any.</p>	Tender Condition Prevails				
59	Clause 6.3	52 of 118	<p>Table 18 — Inspection Frequency of Pipe Product analysis b Footnote: 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>	<p>Bidder clarify that it is practically not possible to select pipes from beginning of the heat and at the end of the heat. This also delays testing and release of pipes for dispatches.</p> <p>Hence bidder is maintaining the traceability basis of receiving of heats as first comes heat to be treated as beginning of the heat, same applicable for last heat.</p>	Tender Condition Prevails				
60	Clause 6.3	52 of 118	<p>Table 18 - Inspection Frequency of Pipe</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">TYPE OF INSPECTION</th> <th style="text-align: center;">FREQUENCY OF INSPECTION</th> </tr> </thead> <tbody> <tr> <td style="padding: 5px;">Metallographic testing (including Vicker's hardness test) of the longitudinal seam weld of pipe as defined in clause 6.2.5 of this specification</td> <td style="padding: 5px;">At least one finished pipe from each lot of 50 pipes per heat or at least once per operating shift (12 hrs max.) whichever is occurring more frequently and whenever changes of grade, diameter or wall thickness <u>are</u> made and whenever significant excursions from operating heat treatment conditions are encountered and at the beginning of the production of each combination of specified outside diameter and specified wall thickness.</td> </tr> </tbody> </table>	TYPE OF INSPECTION	FREQUENCY OF INSPECTION	Metallographic testing (including Vicker's hardness test) of the longitudinal seam weld of pipe as defined in clause 6.2.5 of this specification	At least one finished pipe from each lot of 50 pipes per heat or at least once per operating shift (12 hrs max.) whichever is occurring more frequently and whenever changes of grade, diameter or wall thickness <u>are</u> made and whenever significant excursions from operating heat treatment conditions are encountered and at the beginning of the production of each combination of specified outside diameter and specified wall thickness.	<p>Bidder understands that the test frequency for Metallographic testing & Vicker's hardness test as below:</p>	Bidder understanding is correct.
TYPE OF INSPECTION	FREQUENCY OF INSPECTION								
Metallographic testing (including Vicker's hardness test) of the longitudinal seam weld of pipe as defined in clause 6.2.5 of this specification	At least one finished pipe from each lot of 50 pipes per heat or at least once per operating shift (12 hrs max.) whichever is occurring more frequently and whenever changes of grade, diameter or wall thickness <u>are</u> made and whenever significant excursions from operating heat treatment conditions are encountered and at the beginning of the production of each combination of specified outside diameter and specified wall thickness.								

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				TYPE OF INSPECTION	FREQUENCY OF INSPECTION												
				Metallographic testing	At least one finished pipe from each lot of 50 pipes per heat or at least once per operating shift (12 hrs max.) whichever is occurring more frequently and whenever changes of grade, diameter or wall thickness are made and whenever significant excursions from operating heat treatment conditions are encountered and at the beginning of the production of each combination of specified outside diameter and specified wall thickness.												
61	<p>Table 20 of HFW Spec.</p> <p>Clause 6.2.1.2 of HFW Spec.</p>	25 of 118	<p>Table 20 of API Spec 5L stands replaced by Table 20 of this specification.</p> <table border="1" style="width: 100%; border-collapse: collapse; margin-bottom: 10px;"> <thead> <tr> <th style="width: 15%;">Sample Location</th> <th style="width: 15%;">Type of test</th> <th style="width: 70%;">Number, Orientation and location of test pieces per sample a</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> <td style="text-align: center;">Specified outside diameter, D mm (in)</td> </tr> <tr> <td></td> <td></td> <td style="text-align: center;">< 219.1 mm (8.625 in)</td> </tr> <tr> <td>Pipe body</td> <td>Tensile</td> <td style="text-align: center;">1 L90</td> </tr> </tbody> </table> <p>6.2.1.2 Test pieces for the tensile test Longitudinal tensile tests for pipe body with specified outside diameter, D < 219.1 mm (8.625 inch) shall be carried out on a strip specimen representing full wall thickness of the pipe prepared according to ASTM A370.</p>	Sample Location	Type of test	Number, Orientation and location of test pieces per sample a			Specified outside diameter, D mm (in)			< 219.1 mm (8.625 in)	Pipe body	Tensile	1 L90	<p>Bidder request to allow Transverses Base Tensile test for Pipe OD < 219.1 mm (8.625 in)</p>	Tender Condition Prevails
Sample Location	Type of test	Number, Orientation and location of test pieces per sample a															
		Specified outside diameter, D mm (in)															
		< 219.1 mm (8.625 in)															
Pipe body	Tensile	1 L90															

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62	Clause 6.2.8.2 of HFW Spec.	28 of 118	6.2.8.2 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 Representative on request.	Bidder clarifies that calibrated measuring equipment (calibration done by NABL approved Laboratory) shall be used for dimensional measurement, calibration certificates can be reviewed. Only NDT machines & Hydro test pressure gauge which require calibration as per API 5L & client specification shall be calibrated. We shall follow the API (46th edition) requirements regarding to comply the calibration & verification frequency of instruments & equipment's.	Tender Condition Prevails															
63	Clause 7.1.2 of HFW Spec.	29 of 118	7.1.2 (New) The marking of finished line pipe should also contain the Purchase Order No, Item No, Pipe No, Heat No, coated pipe No, Inspection mark by TPI, Diameter of pipe and wall thickness (to be marked in white color).	Bidder intent to clarify that Inspection mark by TPI on each final accepted pipe is not practicable, hence bidder would like to apply Inspection agency name with stenciling marking.	Noted															
64	Clause 7.2.4 of HFW Spec.	29 of 118	7.2.4 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.	Since the pipes are intent for External coating and the colour code at inside surface is worthless to identify the same diameter but different wall thickness, bidder request to allow the colour code band on external surface only after coating.	Yellow for 6.4mm															
65	ITP for Welded pipe	103 of 118	1.2 WPS,PQR & WPQ	MPS (Manufacturing Procedure Specification) shall be provided instead of WPS/PQR, as WPS/PQR is not applicable for ERW process. Please re-confirm our understanding	Confirm															
66	ITP for Welded pipe	111 of 118	4.4 PMI Check	Bidder clarifies that PMI is not applicable to HFW pipes since the Chemical analysis to be performed by Spectro method.	Confirm															
67	Cl. No 3.2.5 of 3LPE spec.	66 of 118	<p>COATING SYSTEM PROPERTIES</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 5%;">h</td> <td style="width: 35%;">Cathodic Disbondment</td> <td style="width: 15%;">mm radius of disbondment</td> <td style="width: 15%;">15 max. 7 max.</td> <td style="width: 30%;">ASTM G42</td> </tr> <tr> <td></td> <td>• @ +65 °C after 30 days</td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td>• @ +65 °C after 48 hrs</td> <td style="text-align: center;">(**)</td> <td></td> <td></td> </tr> </table>	h	Cathodic Disbondment	mm radius of disbondment	15 max. 7 max.	ASTM G42		• @ +65 °C after 30 days					• @ +65 °C after 48 hrs	(**)			Bidder intent clarify that in our understanding for cathodic Disbondment test acceptance criteria will be 1. 30 days: 15 max. 2. 48 hrs. : 7 max.	Bidder understanding is correct.
h	Cathodic Disbondment	mm radius of disbondment	15 max. 7 max.	ASTM G42																
	• @ +65 °C after 30 days																			
	• @ +65 °C after 48 hrs	(**)																		

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68	Cl. No 3.6 of 3LPE spec.	68 of 118	<p>MATERIAL IDENTIFICATION All materials to be used shall be packed in damage free containers suitably marked with the following minimum information for identification:</p> <p>a. Name of the manufacturer. b. Type of material and product designation. c. Batch Number. d. Date and place of Manufacture e. Shelf Life / Expiry Date f. Storage Conditions g. Quantity</p>	Bidder intent clarify that all these detail will be provided in Test certificate & only batch no. will be provided on packing.	Bidder understanding is correct.
69	Clause 4.3.6	75 of 118	Anchor pattern/roughness profile shall be between 50 to 70 microns.	Bidder indent to clarify that there is a narrow requirement it should be 50 to 100 microns.	Tender Condition Prevails.
70	Clause 5.6	88 of 118	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 manufacture	Bidder understand that phosphoric acid wash & high pressure water wash is not required if salt contamination is less than 2 µg/cm ² .	Bidder understanding is correct.
71	Clause 3.0	99 of 118	Application of varnish on external surface of cut back area.	Bidder intent to clarify that a single coat of varnish may be applied on external cut back area of both ends in order to prevent rust during storage and transit. Please confirm if the same is acceptable to client.	Confirm.