



**INVENTORY CREATION PROJECT
FOR PROCUREMENT OF BARE / COATING / COATED LINE PIPES**



CORRIGENDUM – 1

DATED: 08.06.2011

TENDER NO. – 110330B/WG/GAIL/01-R0

E-Tender No. - 8000002989

Sr. No.	Page / Sheet No	Cl. No	Section / Doc No	Subject	Addition / Deletion / Modification	Remarks
1.	3 of 228		IFB	PART-I (UN-PRICED BID)	The last sentence shall be read as "Documents are to be submitted in respective sub-folders as available in E-Tender portal of GAIL India Ltd."	Modification
2.	167 of 228	3.2	SCC Works	Option -2 Delivery Schedule	The word "by Pipe Laying Contractor" shall be replaced by "at Vaghodia Warehouse of GAIL India Ltd"	Modification
3.				Option – 2 Price Schedule	Refer Revised SOR for Option 2 - "Transportation cost of bare pipe to coating contractor works is added as a separate column"	Modification
4.	23 of 228	13.1	ITB	Bid Validity	Please read bid validity as Three (03) months	Modification



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1	9.3	Tensile Properties	The actual yield strength shall be as close as possible to the specified minimum yield strength (SMYS) but in no case it shall be exceed more than 131 Mpa from specified minimum yield strength for X-42 grade.	Upper Limit of yield strength for sizes 4" shall be 495 Mpa (due to sample taken from longitudinal to the pipe axis) as per foot note 'e' of API 5L table-7, hence it may please be amended accordingly.	Tender Conditions prevail.
2	9.4.3	Burst Test	Burst test shall be done on each type of pipe for each size on lowest thickness and minimum burst test pressure shall not be less than the actual tensile stress factor & computed pressure.	Burst test shall be done on each type of pipe for each size on lowest thickness and minimum burst test pressure shall not be less than the minimum specified tensile strength & computed pressure., Because the tensile strength of material is varying from coil to coil.	Pressure calculations shall be as per the formula defined in the CI 10.2.6.6. Keeping a test pressure such that hoop stress generated is atleast 95% of SMYS.
3	9.10.1	Straightness	The deviation from straight line for all diameter shall not exceed 1 mm per meter, Length of pipe with maximum permissible limit of 12 mm	In smaller dia pipes, like 4" and 6" of double random length, during manufacturing pipes are bending more hence please amend the tolerances of straightness as per API 5L Clause 9.11.3.4, i.e $\leq 0.2\%$ of the pipe length.	Tender Conditions prevail.
4	Cl. No13, Appendix-I, Annexure E - E2(f)	Retention of Records etc.	Guided Bend Test, image for pipe inspection, Repair Welding Procedure, WPS, PQR/WPQT, Method of weld defect removal, full details of Radiography testing equipments including radiographic film, peaking, radiographic, welding procedures specification including the details of welding process, brand name, classification, size and grade of filler metal and flux, speed of welding, no of electrodes and polarity of each electrode, welding current and voltage for each wire, edge preparation, tack welding method and spacing of tackweld, details of seam tracking system for both inside and outside welding, method of checking the set up of the system, limits of external and internal weld reinforcement etc.	All are not applicable for ERW pipe.	Bidder shall furnish all relevant records for Radiographic images. Rest of the records need not be maintained for ERW pipes.
5	9.6	Reverse Bend Test	Reverse Bend Test	Reverse Bend Test may be waived off for sizes 4" & 6" due to small dia pipes. In this size the impact load is not from the weld and we shall do the flattening test at 0° which is more stringent.	Tender Conditions prevail.
6	9.7.3	Pipe Weld and HAZ Test	Impact Test for pipe weld, HAZ and Body	The extraction of samples in transverse orientation for weld, HAZ and Body is neither applicable nor feasible for size 6" as per API 5L Table 22 (Page 56) due to size and thickness constraint. However, we shall do the testing for body in longitudinal direction. Hence it may be waived off.	Impact Test is a mandatory requirement & if carried out in longitudinal direction then the values have to be factored accordingly.



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7	9.10.1	"Mass per Unit length"	"Mass per Unit length"	Please provide tolerances of MASS.	Tolerance in mass per unit length is not applicable as tolerance on the thickness in diameter is already specified.
8	9.11.2.2(b)	Plain Ends	Internal Taper angle for the weld seam of welded pipes 7 degree	We understand that this clause is not applicable for ERW pipes.	Bidder understanding is correct.
9	Appendix-II	First Day Production Tests	First day production	Being small quantity of sizes OD 12" x 7.1 mm WT , first day production may be waived off. However, First Day Production shall be carried out for size 4" OD x 6.40 mm WT, 6" OD x 6.40 mm WT, 12" OD x 8.7 mm WT	Tender conditions prevail.
10	9.8	DWT Test	DWT Test for PSL 2 welded pipes.	We understand that above test is not applicable for this tender due to size constraint. This test is applicable for size > =20" as per API 5L, Table 18. Kindly confirm the same.	Bidder's understanding is correct.
11	9.3 and Appendix II d	Weldability of PSL2 Pipes	"Weldability Test	We are manufacturer of ERW Pipes, in this process no filler material is used. Hence, we do not have qualified welders and necessary equipments to carry out this test. However, we shall ensure reasonable level of carbon equivalent in the raw material to ensure good weldability of our pipes. Thus, it may be waived off as the same has to be carried out by the pipe laying contractor.	Tender conditions prevail. Bidder shall arrange for all the Equipments, procedures, consumables necessary for performing Weldability test.
12	Appendix-II	First Day Production Tests	Fracture Toughness Test	There are contradiction in two clauses , 'c(iv)' and 'e' for Impact Testing.	Tender condition Prevail. Bidder has to follow both test separately.
13	Appendix-I	Manufacturing Procedure Qualifications	Ultrasonic testing of plates / skelp and pipes for lamination	Your spec. main clause does not ask for ultrasonic testing of plates/skelp for lamination. However, in Appendix I, says ultrasonic testing of plates / skelp and pipes for lamination Please clarify whether it is applicable or not. If it is applicable, then we shall do pipe body UT for lamination (after hydro testing). The reference standard for pipe body UT for lamination shall have circumferential slot of 8 mm width x ½ T depth (T = specified thickness of pipe) with minimum coverage area of 25%.	UT for pipe body / plates skelp is a mandatory requirement.
14	9.4.3	Burst Test	Burst test shall be done on each type of pipe for each size on lowest thickness and minimum burst test pressure shall not be less than the actual tensile stress factor & computed pressure.	Burst Test will be carried out during regular production only. The same will not be the part of first day production test. Burst test is not required to perform for pipe sizes 323.9mm OD x 8.7 mm WT as will be carried out for pipe size 323.9 mm OD x 7.1 mm WT.	Tender Conditions prevail.



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15	9.1	Dimensions, Mass & Tolerance (Pipe End)	Diameter tolerances for the pipe ends indicated in API 5L Table 8 shall be applicable.	There is a Typographical error; it should be read as diameter tolerances for the pipe ends indicated in API spec 5L Table 10 shall be applicable.	Accepted.
16	10.2	Specific Inspection	Inspection Frequency for CVN Impact Test.	CVN impact test frequency is not specified in this table. We are considering the same as Per API 5L Table 18 i.e one pipe per heat (one pipe consist of 1 set of three specimens each from base, weld and HAZ)	Bidder understanding is correct & is in line with the tender condition
17	9.3 and Appendix II d	Weldability of PSL2 Pipes	Appendix-II(d) weldability test shall be conducted at pipe mill on first day's production. This shall ensure Weldability & strength as per code. Welding shall be done as per WPS approved by Owner / Owner's representative.	Weldability test to be carried out by EPC contractor at site and should not be first day production test.	Tender condition Prevail.
18	E.8 of Annexure-E	Laminar Imperfection in the Pipe body of EW, SAW and COW Pipes	E.8 (b) ISO 10124:1994, acceptance level B3, if such inspection is done after seam welding.	There is a contradiction between clause E.5.2.6.1 and E.8 . Pls clarify.	UT for pipe body / plates skelp is a mandatory requirement. Clause E.2.5.6.1 providing the Acceptance limit for Skelp/plates and Cls.E.8 providing The Acceptable limit of pipe body after seam weld .
19	Appendix-II	First Production Test	Three length each of completely finished pipes of first day's production from three different heats shall be selected at random for testing.	One pipe each from three different heats (Total Three Pipes) will be selected for First day production test.	Bidder understanding is correct
20	9.3	Tensile Properties	The actual yield condition shall be as close as possible to the specified minimum yield strength.	Consider Mechanical properties as per API 5L 44th edition.	Tender Conditions prevail.
21	9.4.2	Test Pressure	The test pressure for all sizes and grades of pipe shall be such that hoop stress generated at least 95 % of SMYS	We propose Test pressure as per API 5L or 90% SMYS. End correction factor will be applicable.	Pressure calculations shall be as per the formula defined in the CI 10.2.6.6. Keeping a test pressure such that hoop stress generated is atleast 95% of SMYS.
22	9.10.1	Straightness	The deviation from straight line for all diameter shall not exceed 1 mm per meter, Length of pipe with maximum permissible limit of 12 mm	Straightness will be as per API-5L (44th edition) or 1.5 mm per meter.	Tender Conditions prevail.
23	9.4	Hydrostatic Testing	Test pressure shall be held for a minimum period of 15 seconds	We request to allow for 5 seconds. However 10% pipes may be check for 15 seconds.	Tender Conditions prevail.
24	9.4.2	Test Pressure	The test pressure for all sizes and grades of pipe shall be such that hoop stress generated at least 95 % of SMYS	We suggest Hydro Test pressure 85% of min. YST	Tender Conditions prevail.
25	9.4.3	Burst Test	Burst test shall be done on each type of pipe for each size	Burst test shall not be applicable for seamless pipes.	Tender Conditions prevail.



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26	9.10	Dimensions, Mass & Tolerance	The tolerance on specified wall thickness shall be (+)10% and Zero negative tolerance.	For seamless pipes it is difficult to maintain tolerance of +/- 10% we request to kindly allow (+)20% with no zero negative tolerance. However Gail will get better pipes with no extra cost.	Tender Conditions prevail.
27	10.2	Specific Inspection	Product Analysis- Two pipes per heat per lot of 50 items. Tensile Test- Test shall be made at the frequency of two pipe per lot of 100 pipes.	For Seamless pipes these test frequencies are very high we request to consider the lot as per Table 18 of API specification.	Tender Conditions prevail.
28	9.5 & 9.6	Flattening & Reverse Bend Test	Flattening & Reverse Bend Test	As per API Flattening & Reverse bend test are not applicable for SMLS pipe.	Accepted.
29	9.8	DWT test for PSL2 Welded pipe	DWT test	As per API Impact test is not required on seamless pipes for thickness <7.6 mm.	Accepted.
30	9.13	Weldability Test	Weldability test shall be conducted at pipe mill on First day Production.	Request to ignore the same for seamless pipe.	Tender conditions prevail.
31	Appendix-II	First day Production	First day Production Tests	Since the quantity are very small kindly wave off the first day production test for Seamless pipe.	Tender conditions prevail.
32	E.4.1	Radiographic Technique	For ERW pipes, radiographic inspection of the weld seam shall be conducted in accordance with ISO 12096 or ASTM E94 to image quality class R1	This Test is not feasible for ERW pipes.	Tender condition prevail Random radiography (wherever required) is included in the scope of bidder.
33	E.5.2.6.1	Ultra sonic Testing	Each skelp rolled shall be Ultrasonically inspected for laminations using an oscillating or straight running pattern of probes, so as to provide inspection coverage of 100% of skelp surface uniformly spread over the area. Alternatively the pipe may be tested after welding of the longitudinal seam by rotary ultrasonic testing of the pipe body.	We suggest 100% pipe body UT. Kindly confirm if same is acceptable or not.	UT for pipe body / plates skelp is a mandatory requirement.
34	2.0	Scope of Work	Scope of Work Option -2 and 3	Kindly clarify whether developing storage yard and maintenance of storage yard in bidder scope	After handing over the pipes at GAIL Vagodia , maintenance & management of ware house is in GAIL's scope
35		SOR	Price Schedule - Option 2	Please note that excise duty is also applicable on freight charges for transportation of bare pipes from pipe mill to the coating plant. Hence, column 9 of price schedule should be bifurcated in two column separately for freight charges for inward bare pipes & for outward coated pipes; and column for inward freight charges should be inserted alongside column 6 in line with past tenders of GAIL.	Rfer Revised SOR for Option - 2



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36	3.1 of SCC Works	Delivery Schedule	Delivery Schedule	<p>It is mentioned that date of LR / handing over and receipt of coated line pipes by pipe laying contractor shall be date of completion schedule. For this tender, arrangement and maintenance of warehouse is not in the scope of bidder and pipes have to be delivered at GAIL Vaghodia store. Hence, handing over of pipes to laying contractor is not applicable and this clause should be deleted.</p> <p>During past execution of orders for delivery of pipes at GAIL Vaghodia store, we have observed that unloading of pipes is allowed only during limited working hours on weekdays and no unloading is allowed on weekends / holidays. This results in only a few trailers getting unloaded on a working day. Considering the additional time required for unloading of material at GAIL store, we request that delivery period for Option-2 be enhanced by at least 2-3 weeks.</p>	<p>Refer Corrigendum - 1</p> <p>Tender Condition Prevail</p>
37	38.1	Quantity Variation	Section II / ITB	<p>As you are aware, steel prices are very volatile these days hence we request you to kindly increase the final quantity upto 15% at the time of placement of FOI/LOI since steel in API grade is always procured against specific requirement and it is very costly affair which have used financial implications.</p>	<p>Tender Condition Prevail</p>
38	43.1	Repeat Order	Section II / ITB	<p>Repeat Order for 20% of the order quantity should be deleted due to following reasons:</p> <ol style="list-style-type: none">1. As per tender you have 4 sizes with different thickness.2. Raw material suppliers require minimum 400 MT for each size.3. Further for such a small quantity, it is very difficult to take the independent economic rolling. Since it is a fixed quantity tender, it should not be kept open for repeat order for 6 month since steel prices are very uncertain <p>In view of above, we request you to kindly consider 20% increase in quantity at the time of placement of order OR delete the same.</p>	<p>Tender Condition Prevail</p>



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39	6.1	Delivery Schedule	Section IIIB / SCC Goods	Due to many sizes, please amend the Delivery period commencing from 14 weeks and completed within 18 weeks.	Tender Condition Prevail
40	1.1.1.1	Payment Terms Option 1 Bare Line Pipe	Section IIIC / Terms of Payment and Mode of Payment	Please amend the payment terms as 100% of invoice amount shall be paid against submission of documents once the material is handed over to the coating contractor within 15 days.	Tender Condition Prevail