



**CITY GAS DISTRIBUTION PROJECT  
FOR PROCUREMENT OF  
BARE / COATING / COATED LINE PIPES  
REPLIES TO BIDDER'S QUERIES**



**Tender No: 110304/WGI/GAIL GAS/03-R0**

**Dated – 24.05.2010**

Sr. No.	Section / Clause No.	Tender Doc. Page No.	Clause Description	Bidder's Query	Reply / Clarifications
1	Clause No.9.3	Sheet 23 of 104	Tensile Properties	We request to consider Mechanical Properties as per API 5L 44th edition	Tender Conditions Prevail
2	Clause No. 9.4.3	Sheet 24 of 104	Test Pressure	Test Pressure will be 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. Keeping a test pressure such that hoop stress generated is atleast 95% of SMYS.
3	Clause No. 9.11.3.4	Sheet 29 of 104	Straightness	Kindly allow straightness as per API 5L or 1.5 mm per meter.	Tender Conditions Prevail
4	Format A & B	Sheet 98 to 102 of 104		The mill who have already undertaken job of Gail/ Gail Gas/ Wood Group for supply of bare pipe and coating work should not submit format A and B.	Bidder's understanding is correct.
5	Clause No. 9.4	Sheet 24 of 104	Hydrostatic Test	We request to allow for 5 seconds. However we will do some pipe for 15 seconds.	Tender Conditions Prevail
6	Clause No. 9.4.3	Sheet 24 of 104	Test Pressure	We request to kindly consider the same to 85% of SMYS	Tender Conditions Prevail
7	Clause No. 9.4.5	Sheet 24 of 104	Burst Test	Burst Test shall not be applicable for seamless pipes	Tender Conditions Prevail
8	Clause No. 9.11	Sheet 28 of 104	Dimension, Mass & Tolerance	For Seamless pipes it is very difficult to maintain tolerance of +/- 10% we request to kindly allow either(-)5% (+) 15% or (+) 20% with zero negative tolerance. As per API it is (-) 12.5% & (+) 15%	Tender Conditions Prevail
9	Clause No. 9.12.5.2	Sheet 29 of 104	Plain Ends	It seems that there is typographic error. Bevel angle should be 30 deg with tolerance of + 5 deg, - 0 deg. Please confirm.	Bidder's understanding is correct.
10	Clause No. 9.15 and Appendix I	Sheet 30 and 39 of 104	Weldability of PSL2 Pipe and Appendix 1 Manufacturing Procedure Specification	We propose that Weldability test to be carried out during regular production and not as a part of first day production to avoid any delay on account of arrangement of welder etc. by the EPC contractor. Please confirm. As per Appendix I, we understand that EPC contractor will be responsible for WPS, PQR and	Weldability test stands deleted



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				arrangement of approved welder; and our scope will be to carry out all the testing as per API 1104 only. Please confirm.	
11	Clause No. E.4	Sheet 46 of 104	Annexure E	As clearly mentioned in Table E.1, we understand that radiographic inspection is not applicable for ERW pipes. Please confirm.	Confirmed and refer Clause E-3.2.1
12	Clause 13.9.1 and Appendix 1	Sheet 77 and 81 of 104	Impact Test & Appendix 1	As per CI 13.9.1, impact test energy requirement of 7.0 J min. is applicable on 3LPE coated pipes. For FBE coated pipes, impact test energy requirement for FBE coated pipes should be 1.5 J as per CAN.CSA.Z245.20-06.	Tender Condition Prevails
13	Clause 13.7.2 and Appendix 2	Sheet 77 and 83 of 104	Adhesion Test and Appendix 2	As per Appendix 2, Adhesion on FBE coated pipe test frequency given is 1 per 100 pipe. Please note that in 3LPE coating it is not possible to check the adhesion test on FBE coated pipe. Hence, we propose to perform this test on one pipe per day which was partly coated for epoxy thickness checking. Please confirm.	Tender Condition Prevails
14	Clause 13.10 and Appendix 2	Sheet 78 and 83 of 104	Cathodic Disbondment Test and Appendix 2	As per CI. 13.10, CD test for 28 days duration is required only for PQT. However, as per Appendix 2, CD test is mentioned for both 28 days and 48 hours duration during regular production. We understand / propose that during regular production, CD test shall be carried out only for 48 hours duration. Please confirm.	Tender Condition Prevails
15				<ul style="list-style-type: none"> <li>From clause 1.1.1 of SCC, we understand that GAIL Gas will arrange and maintain storage yard for stacking of line pipes at the designated location Vadodara i.e. bidder does not have to arrange for the land and maintain the storage yard. Whereas, in scope of work in Vol.-II (additional works for Option-2 &amp; 3), it is mentioned that "arrangement and maintenance of storage yards". Please clarify.</li> </ul> Also, we understand that the scope of unloading and stacking at storage yard including arranging for equipment and stacking material is in the scope of bidder. Please confirm.	Bidder's understanding is correct
16				In view of small quantity of line pipes required, we request you to delete this clause as it is not feasible to get steel in API 5L grade in small quantities.	



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17	Clause 8.1	Sheet 21 of 104	Process of Manufacturing	Third Party Inspection shall be carried out steel mill to carry out the tests. We understand that you are asking for raw material inspection at raw material manufacturer's Works. Kindly provide scope of inspection and confirm who will bear the inspection charges of TPIA.	Inspection shall be carried out by owner / owner's representative at pipe mill only.
18	Clause 9.3	Sheet 23 of 104	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 exceed more than 131 Mpa from specified minimum yield strength for X-42 grade. Upper limit of yield strength for sizes 4", 6" and 8" shall be 495 Mpa. Because samples as per foot note 'e' of API 5L table -7 shall be taken longitudinal to the pipe axis. Hence it may please be amended accordingly.	Tender conditions Prevails
19	Clause 9.4.5	Sheet 24 of 104	Burst Test	Minimum burst test pressure shall not be less then the actual tensile stress factor and computed pressure.  The tensile strength of the material varies coil to coil. Hence please amend the same as "the burst pressure shall not be less then the minimum specified tensile stress factor and computed pressure."	Tender Condition Prevails
20	Clause 9.8	Sheet 26 of 104	CVN Impact Test for PSL2	Impact Test for pipe weld, HAZ and Body. The extraction of samples for sizes 4", 6" & 8" in transverse orientation for weld, HAZ and Body is not applicable as per API 5L Table 22 (Page 56) and is not feasible also for sizes 4", 6" and 8" due to size and thickness constraint. However, we shall do the testing for weld, HAZ and Body in transverse orientation for size 10". Hence it may be waived off.	Impact Test is mandatory requirement & if carried out at longitudinal direction, the value shall be factored accordingly.
21	Clause 9.11.2	Sheet 28 of 104	Mass per Unit length	Please provide MASS tolerances.	Tolerance in Mass per unit length is not applicable as tolerance on thickness & diameter is already specified.
22	Clause 9.11.3.4	Sheet 29 of 104	Straightness	The deviation from a straight line for each pipe length shall not exceed 1 mm per mtr. Length of pipe with maximum permissible limit of 12 mm. In smaller dia pipes, due to lower D/t ratio like 4" and 6" of double random length, during manufacturing, tendency of the pipe to bend 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 Condition Prevails



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23		Sheet 29 of 104	Plain Ends	Clause 9.12.5.4(b) for the weld seam of welded pipes 7 degree. We understand this clause is not applicable for ERW pipes.	This Clause is not in Tender.
24	Clause 9.15, Appendix II (new) d, Weldability Test	Sheet 30 & 41 of 104	Weldability Test of PSL2, Appendix 2 First Day Production Tests	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	Weldability Test stands deleted.
25	Clause 10.1.3 (g), clause 13, Appendix I, Annexure E E2(f)	Sheet 31,36,39 & 44 of 104	Inspection Doc. For PSL2 Pipe, Retention of Records, Appendix I, Manufacturing Procedure Specification, Annexure E Non Destructive Inspection for other than sour service or offshore service	Radiological, Image quality indicator, guided bend test, radiographic image for pipe inspection, Repair welding procedure, WPS, PQR/WPQT, Method of Weld defect removal, full details of radiographic testing equipments including radiographic film, peaking, radiographic, Welding procedure 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 tack weld, 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. The above are not applicable for ERW pipes. Please confirm the same.	Refer Sr.No. 1 of Corrigendum 1
26	Appendix II (New)	Sheet 41 of 104	1st Day Production Tests	There are contradiction in two clauses, 'c (iv)' and 'e' for Impact Testing. Please clarify which one shall be followed.	Impact Test shall be carried out as per Clause (e) of Appendix II (New) – First Day Production
27	Appendix I	Sheet 39 of 104	Manufacturing Procedure Specification	Ultrasonic testing of plates / skelp and pipes for lamination Your spec. main clause does not ask for ultrasonic testing of plates/skelp and pipes 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 6 mm width x 1/2 T depth (T = specified thickness of pipe) with	UT for plates / skelp and Pipe for laminar check is required

				minimum coverage area of 25%.	
28	Appendix II (New)	Sheet 41 & 42 of 104	First day production	Due to small quantity of size 4", 6", 8" and (10" x 9.3mm WT). First Day Production may be waived off because these quantity shall be rolled less than a day however, first day production shall be carried out for 10" x 6.40mm WT	Tender conditions prevail.
29	Clause No. 9.11	Sheet 28 of 104	Out of roundness	Out of Roundness Pipe size Tolerance <10% 3mm max ≥12% 5mm max Kindly clarify the tolerance for out of roundness for dia 10%	For ≤10 ¾ Out of Roundness is 3 mm (Max)
30				You have mentioned that "Repeat Order shall be applicable upto 20% of the order quantity within contractual delivery period or 6 months from the date of FOI. We wish to inform you that steel prices are fluctuating every month. Hence it is not viable to accept the repeat order clause. We request you to please delete the same OR freeze the final quantity at the time of placement of order.	Tender Condition Prevail
31				During field hydro testing, if pipe fails, Rs.11 lakh per pipe shall be charged which is too exorbitant. Maximum amount should be Rs. 3 lakh instead of Rs.11 lakh. This amendment will help us to submit the competitive price without taking any extra price cushion on this account.	Tender Condition Prevail
32				You have mentioned that 100% invoice value will be paid progressively after adjustment against PRS and submission of Invoice with a period of 30 days. Please amend the terms of payment as 100% payment within 10 days after submission of invoice and handed over of pipes to coating contractor.	Tender Condition Prevail
33				The quantity for 4", 6" and 8" is very small. For such a small quantity, no raw material supplier is ready to supply the raw material. They require minimum 350 - 400 MT order quantity in single width. So you are requested to please increase the quantity as under: 4" x 6.4 mm from 2500 Mtrs to 25 km 6" x 6.4 mm from 3700 Mtrs to 18 km 8" x 6.4 mm from 1700 Mtrs to 12 km	Tender Condition Prevail
34				As mentioned 3 Months form due date request you to please amend the same as 30 days due to steel price	Tender Condition Prevail

				has going to be hike & also steel market scenario is totally volatile, hence to make most competitive offer, amend the validity as 30 days form due date	
35				We wish to inform you that steel prices are fluctuating every month. Hence it is not viable to accept the repeat order clause. We request you to please delete the same .	Tender Condition Prevail
36				Recovery shall be applied of Rs.1280000/-, request you to please amend the same as maximum upto Rs 2,00,000/-	Tender Condition Prevail
37				In case of delay in delivery of materials or delay in completion, total contract price shall be reduced by 1/2 % of the total contract price per complete week of delay or part thereof subject to maximum of 5% (five percent) of the total contract price, request you to please amend as 5% of total undelivered material value	Tender Condition Prevail
38				(1)Right now we are not meeting the qualification criteria, but before due date i.e. 07.06.2010 we are bidding in GAIL E tender for VKPL project and DBNPL project which is due on 12.5.2010 & 14.05.2010 through demonstration route by manufacturing 10 Nos of size 12 x 8.00 mm thk as per API 5L Gr.X60 (PSL-2), so kindly confirm after successful demonstration and receiving of certificate, shall our mill be treated as qualified in this tender because your requirement (size & grade) is lower than the above 2 project.	Evaluation will be done as per tender condition and document provided by bidder with unpriced bid
39				(2) Right now we are not meeting the qualification criteria, but wish to participate in the said tender through demonstration route as other GAIL project (VKPL & DBNPL) E tender mentioning the same, request you to please incorporate the demonstration route also.	Evaluation will be done as per tender condition and document provided by bidder with unpriced bid
40				(3) In case suppose tender got extended, and between this tenure we manufacture 8" x 6.4 mm dia. pipes as per API 5L Gr.X56 (PSL-2)- 50 KM against CAIRN Energy order (under execution) than our offered mail shall be qualified for this tender upto 8" size and we can quote for item no. 1.2,3 i.e. upto 8" size, please confirm.	Evaluation will be done as per tender condition and document provided by bidder with unpriced bid
41				Bid Due Date Due date is 07.06.2010, request you please extend the same till 21.06.2010	No Extension is allowed

				because we understand the RM will fall down by June month end.	
42	Clause No. 9.15	Sheet 30 of 104	Weldability of PSL2 Pipe	We request to kindly ignore the weldability test for seamless pipes.	Weldability Test stands deleted
43				Kindly confirm that the Gail Gas will issue road permits wherever required in sufficient quantity without any financial implication on bidders	Confirm However, seller has to provide his requirement well advance
44				Due to uncertainty prevailing in the steel prices we request you to keep the validity of bid 2 months	Tender Condition Prevail
45				The completion should be 10 weeks from the date of intimation of last pipe by Gail Gas /WGI. Please also note that the complete lot of bare pipes should be given in one go only enabling coating contractor to take up the coating work	Tender Condition Prevail