

Technical Queries

Client: Assam Gas Company Limited

Tender No: AGCL/BD/PMC-GHT/LINEPIPE/2019/06

Bidder: Maharashtra Seamless Limited

S. No	Tender Clause Description	Bidder's Query / Clarification	AGCL/VCS Response
Seamless Pipes Technical Specification SS-PL-033:			
1	Clause 9 Acceptance Criteria: 9.2.2 Table 5 - Chemical Composition for pipe	We propose Carbon 0.18% max in place of 0.16% & Manganese 1.35% max in place of 1.20%	Tender conditions shall prevail.
2	Clause 9.11.3.3: The minimum average length of the entire ordered quantity in any case shall be 12.0 m.	We will maintain minimum average length between 11 to 12.5 meters	Tender conditions shall prevail.
3	Clause 10.2.1.2 Table 18 - Inspection frequency of pipe	We request Test frequency of one Sample per heat/size/lot of 100 pipes in place of two samples	Tender conditions shall prevail.
4	Clause 10.2.6.1: Test pressure shall be held for a minimum period of 15 seconds for all sizes and grades of pipes.	We request Hold time of 05 seconds instead of 15 seconds	Tender conditions shall prevail.
5	Clause 10.2.8.1: Diameter measurements shall be made with a circumferential tape only.	Dimensional testing shall be carried out by Vernier Caliper & Micrometer only. Circumferential tape shall not be used	During MPS stage
6	Clause 11.2.3: The pipe number shall be placed by cold rolling or low stress dot marking or vibro-etching on the outside surface of the pipe	Marking by cold rolling, low stress dot marking, vibro-etching not to be used. We shall be applying paint stenciling only.	Noted. Paint Stenciling shall comply clause 11.2.2 of Line Pipe specification.
7	Clause 15: Inspection of Field Tests	Inspection of field test is not applicable, all testing shall be done in house only	No testing at sit is envisaged from the bidder.
8	Annex B: Manufacturing Procedure Qualification for PSL 2 pipe	Any two finished pipes from two different heat shall be selected for MPQT/FDPT **Only for Chemical, Tensile, Hardness, Impact, Micro/Grain size test witness by TPIA	Tender conditions shall prevail.

9	Annex E: Clause E.5	Ultrasonic or Electromagnetic test, any one method to be used for checking imperfection of surface/subsurface at 10% Notch in place of 5%	Tender conditions shall prevail.
10	First Day Production Tests (PQT)	Since it is a Hot Finished continuous process, holding of mill is not possible till clearance of all results of First Day Production Tests, however we shall submit an undertaking to HPCL/TE at the time of production for commencement of Regular Production at our Risk & Cost.	Will be taken up during MPS stage & after award.
HFW Pipes Technical Specification SS-PL-032:			
11	Table 20 of SS-PL-032	Specified outside diameter, D mm <219.1 mm (8.625 in)' ~219.1mm (8.625 in) It Should be Specified outside diameter, D mm <219.1 mm (8.625 in)' ≥219.1mm (8.625 in)	Noted
12	Clause 9.3 Tensile Properties: The actual yield strength shall be as close as possible to the specified minimum yield strength but in no case it shall exceed the limits specified here. Upto and including X-46 131MPa	Please expand actual yield strength Limit for Grade B 205MPa. As per API 5L Table-7. YS=245 – 450 MPa	Tender conditions shall prevail.
13	Annex E: Inspection of HR coil	Please confirm HR Coil inspection at Steel Mill or Pipe Mill? As per your standard QAP Raw material witness not required.	All inspection at coil manufacturer is vendor's responsibility.