 <b>MAHARASHTRA NATURAL GAS LIMITED</b>	<b>REPLY TO BIDDERS QUERIES AGAINST TENDER FOR PROCUREMENT OF 10" COATED LINE PIPES FOR CNG &amp; CGD NETWORK OF MNGL, PUNE BID NO. MNGL/C&amp;P/2017-18/117</b>
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Date: 07.02.2018

**Replies to Queries of the Bidders**


**SUB: Replies to queries of the bidders for Tender for Procurement of 10" Coated Line Pipe for CNG & CGD Network of MNGL, Pune**

REF: Bid Document No. MNGL/C&P/2017-18/117 dated 19.01.2018


Dear Sir,

Following are the replies to queries of the bidders. Kindly note the same.


Sl. No.	Bidder's Query / Clarification	MNGL' Reply
1	Extension of Due Date of submission of bid	<b>Due date of submission of Bid is extended upto 16.02.2018, 15:00 hours</b>
2	<p>Clause no. 6.2.6.2- of Client Spec MNGL/LINE-PIPE/TS/00</p> <p>Description: Vickers hardness tests shall be carried out on each specimen taken for metallographic examination in accordance with ASTM E- 92.</p> <p>Clarification required: ASTM E-92 has been withdrawn and replaced by ASTM E384, please refer normative reference of API 5L 45th edition clause 3.0 for reference purpose. Hence, it may be amended accordingly.</p>	Agreed
3	<p>Clause no. 9.8.5.2 of Client Spec MNGL/LINE-PIPE/TS/00</p> <p>Description: The reference standard shall contain notches (N5 or N10) or radially drilled holes (3.2mm).</p> <p>Clarification Required: We understand that for HFW pipes, UT reference standard shall be as following. Please reconfirm. HFW weld seam: N10 notch <math>\Phi</math> 6.35 mm x <math>\frac{1}{2}t</math> FBH depth for either side of welded seam &amp; Pipe end Pipe body- 8 mm width X <math>\frac{1}{2}t</math> Circumferential slot.</p>	Bidders understanding is correct
4	<p>Clause no. 9.8.5.4.2- of Client Spec MNGL/LINE-PIPE/TS/00</p> <p>Description: Acceptance limit for material edge examination shall be as per criteria laid down for Acceptance Level E2 of BS 5996: 1993.</p> <p>Clarification Required: Understands that the acceptance criteria for remaining plate/skelp (body) shall be as per Level B4 of BS 5996:1993. Please confirm.</p>	Tender condition prevails

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5	<p>Clause 1.1 of Client Spec: MNGL/LINE-PIPE/TS/00</p> <p>Client specification is based on API 5L 43th &amp; 44th editions</p> <p>As the latest edition of API 5L (45th edition) is already effective from July 1, 2013, and also it is a mandatory requirement of API 5L to follow the latest edition. Hence we wish to follow the latest edition of API 5L i.e. 45th. Kindly conform.</p>	<p>Please see clause no. 1.1 on page no. 110 of 208 which clearly states that 45<sup>th</sup> edition of API 5L may be followed however stringent conditions of API 43<sup>rd</sup> edition / Technical Specification shall govern.</p>
6	<p>Clause 5.4 of Client Spec MNGL/LINE-PIPE/TS/00</p> <p>Requirement: For Welded Pipes, the pipes shall be produced from plates / skelp which shall be quenched and tempered or controlled rolled or combined controlled rolled and accelerated cooled to impart uniformly fine ferritic grain structure to the finished steel.</p> <p>For Welded Pipes, the pipes shall be produced from plates / skelp which shall be quenched and tempered or controlled rolled or combined controlled rolled and accelerated cooled to impart uniformly fine ferritic grain structure to the finished steel with delivery condition of thermo mechanically rolled as per table no 1 of API 5L 45th edition. Kindly confirm.</p>	<p>Agreed.</p>
7	<p>Clause 6.2.5.2 (e) of Client Spec MNGL/LINE-PIPE/TS/00</p> <p>Requirement: Additionally, for pipes of all sizes and specified wall thicknesses, additional fracture (New) toughness requirements as per Supplementary Requirements SR 19 of API Spec. 5L and as modified in this specification shall be applicable for Body, weld and heat affected zone.</p> <p>We understand that the minimum absorbed energy requirement and test temperature for CVN impact tests shall be as per Appendix F of technical spec MNGL/LINE-PIPE/TS/00 i.e. test temperature 0°C &amp; average minimum absorbed energy for full size specimen shall be 41 J &amp; individual value 33 J for longitudinal samples as transverse specimens are not applicable for these size as per clause no. SR5.4 of Appendix F of Client Spec. MNGL/LINE-PIPE/TS/00. Kindly confirm</p>	<p>Agreed.</p>
8	<p>Clause No. 10.3.5 of Client Spec MNGL/LINE-PIPE/TS/00</p> <p>Requirement: A color 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.</p>	<p>Agreed.</p>

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	<p>We understand, it shall not be applicable for this enquiry as due to only one Size &amp; thickness. Hence, it may be waived off.</p>	
9	<p>Clause 9.5 - Client Spec MNGL/LINE-PIPE/TS/00</p> <p>Requirement: The measuring equipment requiring calibration or verification under the provisions of API 5L shall be calibrated with manual instruments at least once per operating shift (12 hours maximum).</p> <p>We shall follow the API (45th edition) requirements regarding to comply the calibration &amp; verification frequency of instruments &amp; equipments.</p>	Tender condition prevails
10	<p>Clause 9.4.3: Test Pressure Page 125 of 207</p> <p>The test pressure for all sizes and grades of pipe shall be such that hoop stress (fibre stress) generated is at least 95% of SMYS, computed based on the formula mentioned in API Spec 5L para 9.4.3 (Note 2).</p> <p>Para 9.4.3 (Note 2) is deleted in 45<sup>th</sup> edition of API 5L. Test pressure shall be as per 45<sup>th</sup> edition of API 5L.</p>	Tender condition prevails.
11	<p>S. No. 1C of Inspection &amp; Test Plan- MNGL/LINE-Pipe/TS/00</p> <p>Ultrasonic inspection required of coil/Raw material for checking of lamination, internal imperfection.</p> <p>We shall do the pipe body ultrasonic testing with 100% minimum coverage area as an alternative of Coil UT for lamination after hydrostatic test. Kindly confirm.</p>	Agreed
12	<p>S. No. 6 Inspection &amp; Test Plan- MNGL/LINE-Pipe/TS/00 <b>Destructive Testing :-</b> Quantum of check:- Material specification, 6-71-0005, PR.</p> <p>We understand that quantum of check shall be as per technical specification MEC/TS/05/21/012, Table No- 18 &amp; API 5L 45th edition. Please confirm.</p>	Agreed
13	<p>Clause 9.5 Dimensional Testing Page 125 of 207</p> <p>The measuring equipment requiring calibration or verification</p>	Agreed

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	<p>under the provisions of API 5L shall be calibrated with manual instruments at least once per operating shift (12 hours maximum).</p> <p>Shift wise calibration of measuring equipment is not possible, measuring equipment shall be calibrated from outside authorized calibration agency and RMTL.</p>	
14	<p>Clause 9.8.3.3 Skelp Inspection Page 127 of 207</p> <p>Coil for EW pipe may be tested after welding of the longitudinal seam by rotary ultrasonic testing of the pipe body.</p> <p>We shall do Coil UT instead of pipe body UT.</p>	Agreed
15	<p>Clause 5.3.1 Properties of Epoxy Powder and Adhesive Page 161 of 207</p> <p>Epoxy powder properties shall be as per CSA Z245.20.98.</p> <p>We propose as per latest edition, please confirm.</p>	Agreed
16	<p>Clause 5.3.3.c Properties of coating system Page 162 of 207</p> <p>Indentation Hardness  -@ 23+2oC – Requirement 0.2mm max  -@ 70+2oC - Requirement 0.3mm max</p> <p>We propose as per latest edition of DIN 30670, please confirm.</p>	Agreed
17	<p>Clause 5.3.3.h Properties of coating system Page 163 of 207</p> <p>Cathodic disbondment  -@ 65oC – After 30 days  -@ 65oC – After 48 hrs</p> <p>We understand this is min. temperature and max temp. Is not defined. Please confirm.</p>	Tender condition prevails
18	<p>Clause 5.3.3.i Degree of Cure of Epoxy Page 163 of 207</p> <p>Test Method  CSA Z245.20-98(*)</p>	Agreed

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	We propose as per latest edition.	
19	<p>Clause 7.5.2.e Cathodic Disbondment Test Page 169 of 207</p> <p>One test shall be carried out for 30 days duration and another test for 45 hours duration.</p> <p>We understand this is 48 hrs, please confirm</p>	Agreed
20	<p>Clause 8.6.1 Chemical Pretreatment with Phosphoric Acid Solution Page 172 of 207</p> <p>All pipes shall provided chemical pretreatment with phosphoric acid solution. 10% solution of phosphoric acid, Oakite 31 / 33 or equivalent, shall be used to remove all soluble salts and other soluble contaminations.</p> <p>Exact 10% is not practical, we propose it is to be min. 10% or 10+/-2%, please confirm.</p>	Agreed
21	<p>Clause 8.6.2 Page 173 of 207</p> <p>Quality of the deionised water shall be monitored at the start of each shift and at every four hours interval.</p> <p>We propose quality to be monitored once/shift.</p>	Tender condition prevails
22	<p>Clause 8.6.4 Page 173 of 207</p> <p>After the de-ionised water wash, the pipe shall be dried with dry air and preheated to a temperature of 65°C to 85°C.</p> <p>We propose it is to be dried with hot air temperature 65 to 85, please confirm</p>	Tender condition prevails.
23	<p>Clause 8.7 Page 173 of 207</p> <p>Abrasive cleaning carried out shall be such that the resultant surface profile is not dished and rounded when viewed with 30X magnification. The standard of finish for cleaned pipe shall conform to near white metal finish to Sa 2½ of Swedish Standard SIS 055900 latest edition. Surface of pipe after</p>	Agreed

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	<p>abrasive blast cleaning shall have an anchor pattern of 50 to 70 microns (Rz). This shall be measured for each pipe by a suitable instrument such as surface profile depth gauge.</p> <p>SIS 055900 is merged with ISO 8501-1 we can comply same. We propose roughness 40 to 90 as per DIN 30670 and roughness to be measured by digital roughness gauge.</p>	
24	<p>Clause 9.2.8 Page 179 of 207</p> <p>Extruded polyethylene layer shall be applied over the adhesive layer within the time limit established during PQT stage and within the time/ temperature range Recommended by the manufacturer. The extrusion temperatures of the adhesive and polyethylene shall be continuously recorded. The monitoring instruments shall be independent of the temperature control equipment. The instruments shall be calibrated prior to start of each shift.</p> <p>Such instrument calibrated in specialized equip laboratory, we proposed review of outside lab calibration certificated.</p>	Agreed
25	<p>Clause 10.4.b Holiday Detection Page 181 of 207</p> <p>The holiday detector shall be a low pulse DC full circle electronic detector with audible alarm and precise voltage control with DIN VDE 0433 Part 2. The set voltage for inspection shall be 25 kV. Travel speed shall not exceed 300 mm/s.</p> <p>Mention standard is obsolete we will conform as per DIN 30670:2012, latest edition.</p>	Agreed

Please submit the signed & stamped copy of Replies to Queries of the Bidders along with tender document with your techno-commercial offer as a token of acceptance.

All the others terms and conditions of the bid documents are unchanged.

With regards.

Ganesh Said  
Sr. Manager (C&P)