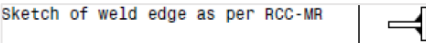
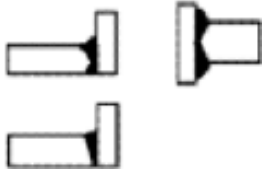


This is an amendment-3 issued to section-B of **Tender Notice No. I-ITN21005 dated 17th January 2022** for “**Manufacturing, testing and supply of vacuum vessels for HNB3 (beam line vessel and beam source vessel) and DNB**” (**TWO PART PUBLIC TENDER**)”. This amendment forms an integral part of the original tender documents of the above referred tender and may be attached thereto. Except those notified through this amendment, all Essential Eligibility Criteria, Scope of Work, Scope of Supply, Technical and Management Specifications, Drawings, Terms & Conditions and other details of the above mentioned tender shall remain unchanged.

Sr. No.	Tender Section & Clause Ref. / drawing details	In place of	To be read as
1	DNB_Vessel compliance_with_construction__4A DNG4_v1_0  Page 17 & 18 of 23 (VESSEL_STIFFENER_WELD_DETAIL) (DNB_VESSEL_INTERNAL_WELD)  Page 20 of 23 (TOPLID_STIFFENER_WELD_DETAIL)		weld of stiffeners with the vessel shall be full penetration weld (below sketches) as per RCC-MR    The above is also applicable to fabricate the stiffener itself (i.e weld between flange and web of stiffener)
2	Clarification about the alternative joint preparation for the vacuum boundary weld joints.  (For example Dwg no. 046910 sheet 25 detail HO.)	Full penetration butt weld with 100% RT requirement	Full penetration butt weld with 100% RT requirement <b>OR</b> Full penetration corner weld with 100% UT examination (requirements of the UT qualification as per RCC-MR shall be fulfilled) may be considered for the vacuum boundary weld joints. The requirement of joint efficiency=1 shall be complied with.
3	DNB Vessel Drawings: Drawing no. 01-01-01 (all sheets)	Tolerances were not defined	Consider the tolerances defined in the HNB3 Vessel dwg no. 046910 at corresponding locations / sheet.

4	Drawing:01-01-01, sheet: 06 OF 21	Note 2: Flatness and localisation to be adjusted according to remote handling rail required specification, see drawing ***** sheet ** detail **. (Information was missing in the drawing)	Note 2: Flatness and localisation to be adjusted according to remote handling rail required specification, see drawing 046465 sheet 11.
5	Clarification about the “ <b>transverse cross section crossing the vacuum boundary</b> ” requirement of the clause 3 of Annexure-4C & 4G	The requirement is applicable only when one transverse c/s is exposed to vacuum and another side of c/s is exposed to atmosphere.  The requirement is not applicable when one transverse c/s is exposed to the vacuum and another c/s is welded to subsequent component and therefore not exposed to vacuum.	
6	Annexure-5 (clause 4.2)	No baking (because of use of LDP accepted product) is <b>not</b> requested for DNB Vessel and HNB3 Vessel.	No baking (because of use of LDP accepted product) is requested for DNB Vessel and HNB3 Vessel.
7	Annexure- (Clause 14.11 and clause 15)	14.11: The item is baked to a temperature of 300°C or whatever other temperature has been specified for a minimum period of 24 hours at temperature in accordance with Annexure 9: Baking.  15: Air Baking	Baking of the vessel is not a requirement. These clauses shall be considered as deleted.
8	Annexure 2 clause 2.8	All non-destructive tests shall be carried out by suitable qualified personnel (e.g Level II and Level III (for validation and authorization of the results) through written practice based on ASNT or similar international standards).	All non-destructive tests shall be carried out by competent and qualified personnel as per ISO 9712 for performing the examination, interpretation, validation and authorization of the results. (This requirement already exists in the Annexure 6B clause 9.3. This clarification is provided to remove the discrepancy in the spec).

9	Clause 3.6.7.1 of Annexure 6A	Chemical analysis: S $\leq$ 0.015 %, P $\leq$ 0.025 %, Co $\leq$ 0.05, Nb $\leq$ 0.01, Ta $\leq$ 0.01	Chemical analysis: S $\leq$ 0.025 %, P $\leq$ 0.025 %, Co $\leq$ 0.2
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