



ITER-India
(Institute For Plasma Research)



Title	BID NO: GEM/2023/B/4190594 for the repair of pipe spool weld joints
Subtitle	PART-A: Scope of Supply, Scope of Work and Technical Specifications and Other T&C



	Repair of pipe spool weld joints	Tender No.
		BID NO: GEM/2023/B/4081181

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1 Scope of Service

Repairing of weld joints of pipes which include cutting, edge preparations, sizing, fitting & aligning, re-welding, cleaning of joint followed by Radiography testing.

2 Scope of Work

- a. Bidder is responsible for cutting the existing weld joint including heat affected zone, preparing fresh weld edge, re-welding (full penetration TIG weld), visual and RT examination of weld joints of pipe spools.
- b. Fitting and aligning of pipes shall be as per drawings are within the scope of bidder.
- c. Welding equipment's, welding consumables, purging gas, cutting equipment's, fixtures, qualified manpower for welding and other supporting tools & activities required for the successful repair.
- d. The welding activities shall be performed at the ITER-India lab site.
- e. Radiography Testing of weld is within the scope of contractor. This may be by taking the spools out of the IPR premises or within the premises. In case the spools are take out, the necessary transportation to and from the RT lab shall be on the contractor.
- f. During the execution of contract if any extra welds are needed by the purchaser, the same shall be performed by the contractor and the charges incurred can be claimed by the contractor as per unit rate quoted in the tender.
- g. If any weld joint performed by the bidder could not pass the radiography testing, the weld joint shall be repaired without additional cost and re-welded followed by successful radiography testing.
- h. All pipe spools required to add or replace the existing pipe spools will be provided by the ITER-India.

3 Technical Specifications

- a. Allowed welding process – TIG welding
- b. The welding shall be performed by using the qualified welding procedure and by qualified welder as per ASME Sec IX. Existing qualification of the procedure and welder performance record are acceptable with prior approval of purchaser.
- c. All the weld shall be of full penetration welds
- d. All the weld shall be Radiography tested as per ASME B31.3 for normal fluid service
- e. The quantity and size of welds to be repaired as follows:

S.No.	Weld Joint Size	Quantity (Nos)
1	DN50 -10S (OD-60.3mm & Thk - 2.77mm)	15
2	DN80-10S (OD-88.9mm & Thk - 3.05mm)	1
3	DN100-10S (OD-114.3mm & Thk - 3.05mm)	2

4 Acceptance tests

All weld joints shall be visually examined to have weld free from burrs, sharp corners, weld spatter and surface defects.

All weld joints shall be RT qualified as per ASME B31.3 para.341.4 for normal fluid service.

5 Document deliverables

Visual examination reports & Radiography examination reports with RT films.

6 Delivery period

completion period is 20 days from the date of PO shall be specified.

7 Input drawings / documents

Followings drawings are enclosed:

1. INTF_NEU_PIPE_1
2. INTF_NEU_PIPE_2
3. INTF_RID_PIPE_1
4. INTF_RID_PIPE_2

8 Images of existing fabrications

The following images shows the fabricated spools, on which, 14nos of the welds of it to be repaired and examined to full extent.

Note: 1. Approximate weld locations and identification nos. (2°, 2.1°, 4.1°, 6°, 7°, 7.1°, 8.1°, 9°, 11°, 12°, 12.1°, 12.2°, 14°, 17°, 17.1°, 18°, 19° & 20°) are indicated in the drawings given in the section 7.

2. It is to apprise that, the inlet and outlet terminals of spools are joined by a spool.



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9 SAFETY CODE:

1. The contractor shall cover his employees/workers under PF, ESI, personal accident insurance policy and applicable laws.
2. The contractor shall be fully responsible and accountable for the behavior, conduct, theft and any breach at security etc. by his personnel and workers.
3. The contractor shall comply with all Govt. rules & regulations for his staff in regard to maintain the applicable labor laws, their amendments etc. in force from time to time.
4. The contractor shall comply with the instructions given by the engineer in charge, regarding safety regulations, safety precautions, protective measures, clean-up practices, housekeeping etc.

The contractor shall ensure adequate safety precautions at site as required under the law of land. Contractor must be entirely responsible and accountable for safety of their personnel and provide them safety helmets, safety shoes, other safety gadgets as required and prescribed.

10 Safety requirements:

The Supplier shall take all necessary precautions to ensure safety of personnel deployed for the said work. As the work is to be executed in a restricted area, the Supplier shall strictly observe all safety, security and labour regulations prevailing in the campus. The Supplier shall be responsible and accountable for the proper behavior of the staff employed by him and also for any breach of security regulations, thefts, sabotage etc. The Supplier shall withdraw any person so desired by ITER-India/IPR, if in the opinion of the representative of ITER-India/IPR it is not desirable to permit that particular person to work inside the campus.

11 SERVICE LEVEL AGREEMENT:

In case the contractor fails to carry out the work as per specified scope of work within the time as per order, ITER-India reserves the right to terminate the contract & get the work done from any other party at the risk & cost of contractor.

12 Accident/Third Party Liability:

The Service Provider will take all possible precautions to avoid damage to the Purchaser's property during its onsite activities. Service Provider shall also take insurance covering third party liability for the personnel and Equipment's and/or tools deployed at Purchaser's site against all risks, such as injuries, loss of life etc. Service Provider will be fully responsible for

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payment of compensation. In the event of loss and/or damage to Purchaser’s property / any item(s) / equipment and/or injury or loss of life to Purchaser’s personnel during the course of onsite activities due to the Service Provider’s default. Service Provider will be fully responsible and liable for such damages and/or losses and payment of appropriate compensation as assessed by the Purchaser. Service Provider will relieve the Purchaser from all the risk and liabilities under this clause.

13 Limitation of liability

Except in cases of criminal negligence or willful misconduct, the aggregate liability of the Contractor to the Purchaser, whether under the CONTRACT, in tort or otherwise, shall not exceed the total CONTRACT price, provided that this limitation shall not apply to the cost of repairing or replacing defective equipment.

14 Site Clearance:

On completion of the work, the Supplier shall clear away and remove from the site, all surplus materials, remainder, waste material and temporary works of every kind and clear/clean the whole site.

Bidder Signature		
Name of the signatory & Title	Name	Title
Bidder’s Official seal		
Place & Date	Place	DD-MM-YYYY