

SCOPE OF WORK/SPECIAL CONDITIONS OF CONTRACT Annexure-I

- (1) BCPL intends to repair the absorber column. Original shell thickness of the absorber column is 45 mm with M.O.C.- SA 516 Gr 60. The service of the absorber column is to remove CO₂ using Amine solution. During thickness survey, thickness reduction observed in the absorber column in the vicinity of gas and amine mixing zone/area, become damaged which needs to be repair. Now BCPL intends to replace this portion i.e Bottom portion of absorber column from top of skirt to elevation of 3200 mm along with all nozzles, manhole etc as per BCPL drawing No-BCPL/LAKWA/ABSORBER/01 and OEM drawing No-TPE765-910-01,REV4, with little modification in the shell, total shell thickness 45 MM shall be 42 MM OF BASE METAL SA 516 GR 60 + 3 MM SS316 LINING to be provided to enhance the column life. The bid shall be analysed in overall basis, hence bidder has to quote on the items, i.e supply as well as deputation of service engineer/supervisor including transportation to completion. Single item quote will not be considered for evaluation.
- (2) The bidder should come up with their repair procedure when taken up in the future. The scheme for welding of the supplied bottom portion of the column with the existing column
- (3) 42 MM of base metal SA 516 GR 60 means minimum thickness of base metal shall be 42 mm and may be vary to nearest higher side if 42 mm same grade material is not available in the market, proper justification with documentary proof required from bidder side to establish next higher thickness and to be approved from BCPL before start of job. And also uneven welding procedure to be established and approved when actual field execution is done.
- (4) After placement of Purchase Order it is **Mandatory to visit site**. Bidder shall developed own drawing and the same needs to be approved from BCPL before starting of job. The bidder shall be deemed to have visited the site. Non-familiarity with site and Process Industry conditions will not be considered a reason either for extra claim or for not carrying out job in strict conformity with drawings, specifications
- (5) All materials required for fabrication of new part is in the bidders scope. The supply shall be as per BCPL drawing No-BCPL/LAKWA/001 and OEM drawing No-TPE6087-910-01,REV4, However there is a modification in terms of SS316 Lining in the shell. Total shell thickness 45 MM shall be 42 MM OF BASE METAL SA 516 GR 60 + 3 MM SS316 LINING. Bidder shall developed own drawing and the same needs to be approved from BCPL before starting of job. The bidder to submit the QAP (Quality Assurance Plan) & WPS (Welding Procedure Specification), and the same needs to be approved by BCPL before commencement of job. All required test certificates as required to be submitted during delivery.
- (6) The bidder to submit the QAP (Quality Action Plan) & WPS (Welding Procedure Specification), and the same needs to be approved by BCPL before commencement of job.
- (7) All welding procedure, Fit up and welding electrode required for the fabrication of new part shall be as per standard given in the drawings and duly approved by BCPL before starting the job.

- (8) The cost of Third party (approved) inspection to be incorporated in the Quote.
- (9) All NDT techniques and Pre/Post welding heat treatment and final hydro test required for the fabrication of new part shall be as per standard given in the drawings and duly approved by BCPL before starting the job.
- (10) Transportation of the column bottom portion to Lakwa Site is in the bidders scope. It includes Unloading of the column bottom portion at designated place in the Lakwa Site as per direction of Site in charge.
- (11) Bidder shall supply the new fabricated parts with all requisite to Lakwa site within Six months from the date of LOI.
- (12) The Service provider shall depute expert service engineers/supervisor as per requirement for providing technical services / best procedure for replacement of supplied Absorber column bottom portion at site..
- (13) service engineers/supervisor shall submit detailed procedure for replacement of new part at site.
- (14) After completion of job, trial run and performance test of the absorber column will be taken at maximum available load in the presence of deputed supervisor/ service engineer (s) to ensure functional completeness of the absorber column
- (15) Accommodation in BCPL guest house and to and fro local transport from airport to guest house shall be free of cost and bear by BCPL .Air fare and food shall be included in offered SOR.