

TENDER No. UCSL/CC/SER/T/CSL/262-1A/2026
Dt-31.08.2026

TENDER FOR STRUCTURAL STEEL STRENGTHENING
WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON
ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES AT
ALUMINIUM FABRICATION SHOP, COCHIN SHIPYARD
LIMITED



UDUPI COCHIN SHIPYARD LIMITED

UDUPI COCHIN SHIPYARD LIMITED

MALPE, UDUPI 576108





Udupi Cochin Shipyard Limited
TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON
ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES AT
UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026

TENDER NOTICE

Tender No. & date	UCSL/CC/SER/T/CSL/262-1A/2026 Dt. 31 st July 2026
Name of work	TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES AT ALUMINIUM FABRICATION SHOP, COCHIN SHIPYARD LIMITED
Site Visit	07th September 2026 (Monday), 10:00Hrs
Last date & time of receipt of tender	14th September 2026 (Monday), 15:30Hrs
Date & time of opening of Technical Bid (Part-I)	14th September 2026 (Monday), 15:30Hrs

1. Password protected quotations in the prescribed form is invited from bidders for the work specified above, subject to the terms and conditions as mentioned in the annexure to the tender enquiry so as to reach the undersigned by email or through postal mode, as mentioned on or before the date and time as stipulated.
2. Bidders are requested to visit the site on the specified date to familiarize themselves with the site conditions and operational requirements prior to submitting their bids, the bidder should send the details of the personnel visiting the yard to contractcell@udupicsl.com on or before 07th Sep 2026.
3. Site visit will be conducted at CSL Cochin Yard.
4. Clarifications if any, is to be forwarded on or before **14th September 2026 (Monday), 15:30hrs.**
5. **The following shall be submitted along with the quote: -**

PART- I: TECHNICAL BID

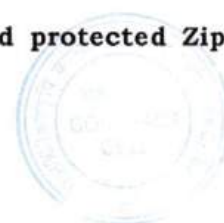
- a. **Tender document duly signed on all pages** - Including Terms & conditions & Scope of work- at Annexure I & II.
- b. **The techno commercial Check List** at Annexure VII to be filled up completely and duly signed.
- c. Duly filled form at Annexure -IV, V & VI.

PART-II: PRICE BID

- a. The price bids shall be prepared based on the price bid format at Annexure III.

3. Mode of Submission of Quote:

- i. Bid shall be submitted as **Password Protected Zip File** in two parts.
Part I: Technical Bid – with all enclosures and annexures as mentioned in Para 5 above
Part II: Price Bid.
- ii. The files are to be forwarded as **Two (2) separate password protected Zip files** to contractcell@udupicsl.com





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- iii. **Part I and Part II are to be protected with separate and distinctly different passwords.**
- iv. The Bids will be opened on online mode during which the bidder will be advised to share the password through SMS with which the technical bid will be opened.
- v. The price bids will be opened after technical evaluation and **only the technically qualified bidders will be invited for opening of price bids** which shall also be conducted on online mode.
- vi. However, subject to travel restrictions, the bidders can also attend the bid opening physically at Udupi Cochin Shipyard Limited, Baputhotta Ware house complex Office.
- vii. The contractors can also submit the quotations in sealed covers (Two-Bid) – as separate sealed covers for Technical Bid and Price bid, both enclosed in a common sealed cover to reach the below mentioned address before the stipulated time.
6. The bidders shall ensure the receipt of bids at contractcell@udupicsl.com An acknowledgement mail shall be sent to the bidders on receipt of bids. UCSL takes no responsibility for delay, loss or non-receipt of tenders by mail by the stipulated time.
7. The tender should be addressed to the **Assistant General Manager (Contract Cell), Udupi Cochin Shipyard Limited, Malpe Harbor Complex, Malpe, Udupi 576 108, Karnataka, India.**
8. No deviations on the tender conditions will be accepted, and bids with deviations will be considered technically disqualified. The acceptance of a tender or part thereof will rest with the Assistant General Manager (Contract Cell), Udupi Cochin Shipyard Limited and reserves the authority to reject the tender received without assigning any reason.

Contact person: Pradeep K: Ph. No: 9895705138

Assistant General Manager (Contract Cell)

अखिल आर पी
AKHIL R P
प्रबंधक MANAGER
उडुपि कोचीन शिपयार्ड लिमिटेड
UDUPI COCHIN SHIPYARD LIMITED
माल्पे, कर्नाटक/MALPE, KARNATAKA-576 108

Encl:

- | | |
|------------------------------------|----------------|
| 1. Terms & Conditions | - Annexure I |
| 2. Scope of work | - Annexure II |
| 3. Price Bid | - Annexure III |
| 4. Power of Attorney | - Annexure IV |
| 5. Unconditional Acceptance Letter | - Annexure V |
| 6. Undertaking by Agency | - Annexure VI |
| 7. Techno Commercial Check List | - Annexure VII |



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TERMS AND CONDITIONS

TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES AT ALUMINIUM FABRICATION SHOP, COCHIN SHIPYARD LIMITED

1. DESCRIPTION OF WORK

- 1.1. This tender is invited for the design (where applicable), supply, installation, testing, commissioning, and associated structural strengthening works for two (02) numbers of 25 T capacity Electric Overhead Travelling (EOT) Cranes at the Aluminium Fabrication Shop located within the premises of Cochin Shipyard Limited (CSL), Kochi, for Udupi Cochin Shipyard Limited (UCSL).
- 1.2. The scope includes dismantling of the existing crane rails, structural strengthening of the crane runway girders and supporting columns, installation and alignment of crane rails, erection and commissioning of the EOT cranes, load testing, and all other incidental works required for the successful completion of the project, as specified in the tender documents.
- 1.3. **The bidder shall carefully study the tender documents, specifications, drawings, and scope of work and shall satisfy themselves regarding the nature and extent of the work before submitting their bid. The bidder shall seek clarification from UCSL regarding any discrepancy or ambiguity in the tender documents prior to submission of the bid.**
- 1.4. The bidders are strongly advised to visit the work site and familiarize themselves with the existing site conditions, accessibility, working environment, available facilities, and any constraints that may affect the execution of the work. Submission of the bid shall be deemed to indicate that the bidder has fully understood the site conditions and has taken all such factors into account while quoting their rates. No additional claim on account of lack of site knowledge or unforeseen site conditions that could reasonably have been ascertained during the site visit shall be entertained by UCSL.
- 1.5. **Working Environment:** The work shall be executed within an operational shipbuilding facility. The Contractor shall plan and execute the work in coordination with UCSL/CSL to ensure minimum disruption to ongoing production activities. The Contractor shall comply with all applicable safety regulations, work permit systems, security requirements, and instructions issued by UCSL/CSL during the execution of the work.

2. GENERAL SCOPE OF WORK

- 2.1. It is proposed to decommission and dismantle the existing 12.5 t crane and replace it with above two cranes. To accommodate two numbers of 25t capacity crane the existing crane girder and columns have to be strengthened. The crane rails run over a plate girder supported on columns provided at a spacing of 10m at two sides. It also projects outside by



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5m at one side to facilitate direct loading and unloading of materials from trucks. The crane rails are at an elevation of about 13 m from the ground. The rails are positioned using clamps at a spacing of 384 mm which are tightened using M16 bolts. The existing girders and columns are not sufficient to take the load of the two 25t capacity cranes and require strengthening.

2.2. Refer **Annexure II** for detailed scope of work

3. ELIGIBILITY CRITERIA

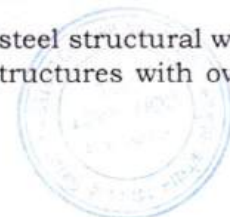
The bidder shall submit documentary evidence in support of the following minimum eligibility criteria along with the Technical Bid (Part-I). Failure to furnish the required documents may result in rejection of the bid. The bidder shall have successfully completed at least one project involving the installation, replacement, modernization, or relocation of EOT cranes of 20 T capacity or above, including crane runway alignment and/or structural strengthening of supporting steel structures, during the last five (05) years.

3.1.Registration

- The bidder shall be a legally registered entity under the applicable laws of India (Company, Partnership Firm, LLP, Proprietorship, etc.) and shall submit valid registration documents, including incorporation/registration certificate, GST registration, PAN, and any other statutory registrations applicable to the business.

3.2.Work Experience

- The Only experienced contractors with proven experience of having executed works of similar nature for reputed government agencies such as CPWD, BPCL, CoPA, KMRL, DMRC, CSL, CIAL, Petronet LNG, FACT, UCSL, HCSL, IWAI etc. or other reputed private agencies etc. in last 7 financial years ending on the date of submission of tender with following prior experience shall participate in this tender;
- Documentary evidence in the form of Work Orders, Completion Certificates, and/or Performance Certificates clearly indicating the scope of work, dimensions (where applicable), and satisfactory completion shall be submitted along with the Technical Bid.
- The bidder shall satisfy any one of the following criteria:
 - Three similar works, each work costing not less than Rs. 12 Lakhs
 - or
 - Two similar works, each work costing not less than Rs. 15 Lakhs
 - or
 - One similar work costing not less than Rs. 25 Lakhs
- Similar nature of work shall mean fabrication and erection of heavy steel structural work OR fabrication and erection of high rise industrial/commercial steel structures with overhead crane rail installation etc.





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- The experience certificate/work order submitted shall clearly indicate the nature of works executed by the bidder.
- The value of work executed shall be brought to current value by enhancing the figures at simple rate of 7% per annum.
- Bidders have to submit notarized work completion certificate, notarized copy of final bill certified by client and notarized work order along with the technical bid for fulfilling experience criteria. In case, the bidder is furnishing an experience certificate of works executed for private agencies to qualify for the work, the bidder should submit a relevant TDS Certificate along with notarized work order and notarized completion certificate.

A. Technical Competency

The bidder shall possess demonstrated experience in:

- Structural analysis and strengthening of crane runway girders.
- Installation and alignment of crane rails.
- Installation and commissioning of heavy-duty EOT cranes.
- Precision alignment of crane runway systems.
- Load testing and commissioning of EOT cranes.
- Working at elevated heights on industrial steel structures.

B. Key Personnel

The bidder shall deploy qualified personnel having experience in EOT crane projects, including:

- Structural Engineer
- Mechanical Engineer
- Electrical Engineer
- Site Supervisor
- Certified Welders
- Riggers
- Crane Erection Technicians
- Safety Officer

The Contractor shall submit the qualifications and experience of key personnel prior to commencement of work.





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C. Safety Performance

The bidder shall have a satisfactory safety record and shall furnish:

- Details of major accidents, if any, during the last three years.
- Valid safety certifications (if available), such as ISO 45001.
- HSE policy and safety organization chart.

3.3. Financial Capacity

- Turnover - Average annual financial turnover (Revenue from operations) of last three financial years ending 31st March 2026 shall be at least Rs. 20 Lakhs. The value of annual turnover figures shall be brought to current value by enhancing the actual turnover figures at a simple rate of 7% per annum. The audited balance sheet and profit and loss account of the last 3 financial years shall also be notarized and submitted by the applicant. For those firms whose FY 2025-2026 financial statement is yet to be finalized and audited, financial details of FY 2022-2023, 2023-2024 & 2024-2025 shall be considered.

3.4. Declaration of Eligibility

- The bidder shall not have been **blacklisted, debarred, suspended, or declared ineligible** by the Government of India, any State Government, Public Sector Undertaking, or any Government Agency as on the date of submission of the bid.
- A self-declaration to this effect, on the bidder's letterhead, shall be submitted along with the Technical Bid.

4. SCHEDULE OF COMPLETION

4.1 Completion Period

The entire scope of work shall be completed within **forty-five (45) calendar days** from the date of commencement of work or issuance of the Work Order/Letter of Intent (LOI), whichever is earlier, unless otherwise specified by UCSL.

4.2 Work Planning

The Contractor shall plan and execute the work in close coordination with UCSL so as to **avoid disruption to the ongoing shipbuilding and fabrication activities**. The work may be required to be carried out in phases, during non-working hours, holidays, or shutdown periods as directed by the Engineer-in-Charge.





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4.3 Detailed Work Programme

Within **seven (07) days** of award of the contract, the Contractor shall submit a detailed work programme indicating:

- Activity-wise execution schedule.
- Resource deployment plan (manpower, equipment, and tools).
- Material procurement schedule.
- Crane rail dismantling, structural strengthening, installation, alignment, testing, and commissioning sequence.
- Safety and quality inspection milestones.
- Critical path and completion milestones.

The programme shall be approved by the Engineer-in-Charge before commencement of the work. Any revision to the approved schedule shall require prior approval from UCSL

4.4 Progress Monitoring

The Contractor shall deploy adequate manpower, supervision, equipment, and other resources to ensure completion of the work within the stipulated period. Weekly progress review meetings shall be held with UCSL, and the Contractor shall submit weekly progress reports highlighting completed activities, planned activities, and any issues affecting the schedule.

4.5 Delay in Completion

Time shall be the essence of the Contract. Any delay attributable to the Contractor shall be dealt with in accordance with the provisions of the Contract, including levy of Liquidated Damages (LD), unless the delay is due to reasons attributable to UCSL or Force Majeure.

4.6 Site Coordination

The Contractor shall coordinate all activities with the Engineer-in-Charge and other agencies working at the site. Work shall be executed only after obtaining the necessary work permits, safety clearances, and shutdown approvals wherever applicable.

4.7 Testing and Handover

The work shall be considered complete only after:

- Completion of all structural strengthening and crane rail installation works.
- Final alignment of crane rails within specified tolerances.
- Successful load testing and commissioning of both 25 T EOT cranes (where included in the scope).





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- Submission of all inspection records, test certificates, as-built drawings, and completion documents.
- Issuance of the Completion Certificate by UCSL.

4.8 Working Hours

The Contractor shall execute the work as per the working hours prescribed by UCSL. However, to meet the project schedule or to avoid interference with production activities, the Contractor may be required to work during extended hours, night shifts, weekends, or holidays without any additional cost to UCSL, subject to prior approval from the Engineer-in-Charge.

5. PERIOD OF CONTRACT & COMMENCEMENT OF SERVICES

5.1 Contract Period

The Contract shall come into effect from the date of issuance of the Letter of Intent (LOI)/Work Order and shall remain valid for a period of twelve (12) months or until successful completion of all contractual obligations, including rectification of defects (if applicable), whichever is earlier.

5.2 Commencement of Work

The Contractor shall commence the work within seven (07) days from the date of issue of the Work Order or from the date of handing over of the work site, whichever is later, unless otherwise instructed by UCSL.

5.3 Completion of Work

Notwithstanding the overall validity of the Contract, the Contractor shall complete the entire scope of work within the completion period specified under Clause 4 – Schedule of Completion, unless an extension of time is granted in writing by UCSL.

5.4 Rate Validity

The rates quoted by the Contractor shall remain firm and fixed throughout the validity of the Contract. No escalation in rates on account of increase in the cost of labour, materials, fuel, taxes (except statutory changes specifically provided for in the Contract), freight, exchange rate fluctuations, or any other reason shall be entertained by UCSL.

5.5 Extension of Contract

If required for completion of the work or due to reasons not attributable to the Contractor, UCSL reserves the right to extend the validity of the Contract on the same terms and conditions without any change in the quoted rates, unless otherwise mutually agreed in writing.





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6. METHOD OF AWARDING CONTRACT

- 6.1. UCSL also reserves the right to split the work orders to any number of bidders willing to match with L1 rate, if the performance of selected bidder is not satisfactory.
- 6.2. UCSL reserves the right to distribute the work between the bidders for faster execution of the work or to cancel the tender, if so, felt necessary.

7. VALIDITY

- 7.1. The offer shall be valid for a period of 12(Twelve) months from the due date of the tender.

8. RATE

- 8.1. Rates are to be quoted in the Price Bid Format at Annexure III attached herewith.

9. PAYMENT

- 9.1. Payment Terms Payment will be made in 4 stages.
 - a) Stage-1 : **20%** of the contract value against dismantling of crane rails, removal of clamps, fish plates, and completion of surface preparation.
 - b) Stage-2 : **60%** against fabrication, supply, erection, welding, and installation of additional flange plates and web plates based on measured quantities.
 - c) Stage-3 : **15%** against reinstallation of crane rails, alignment, bolting, painting, and completion of all associated works.
 - d) Stage-4 : **5%** after final completion, submission of all documents, and issuance of the completion certificate.
- 9.2. Payment shall be made within 30 days from receipt of invoice and necessary documentation as applicable.
- 9.3. Statutory levies such as I.T, Contribution towards PF, ESI, PT etc., shall be deducted from the bill as applicable.
- 9.4. Payment will be made by RTGS/NEFT to the account of Agency. The name of the bank, branch, A/C No., IFSC code & other particulars shall be furnished by the Agency in the proforma of UCSL.

10. TAXES & DUTIES

- 10.1. GST shall be applicable extra on the prescribed work. You are requested to furnish the following details in the invoice/Bill.
 - Applicable rate of GST/SAC Code
 - Firms GST Reg. NO.
 - Service accounting code (SAC) as prescribed by statutory authorities.





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- GST Reg. No. of Udupi Cochin Shipyards Limited **(29AAACT1281B1ZO)**.

11. SECURITY DEPOSIT

- 11.1. The successful tenderer shall remit 5% of the value of the contract as security deposit within 15 days of receipt of the work order. This amount may be remitted by way of demand draft or bank guarantee (in approved proforma of UCSL) from any of the nationalized banks, valid till the satisfactory completion of the entire work. The Security Deposit will be released on certification of satisfactory completion of the contract and no liability to UCSL by Officer-in charge. The Security Deposit retained will not bear any interest.

12. WARRANTY

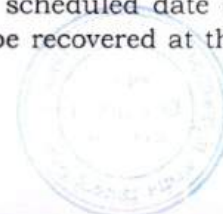
- 12.1. The Contractor shall provide a warranty of 12 months from the date of commissioning or 15 months from the date of invoicing, whichever occurs earlier. This warranty shall cover manufacturing defects for the items expect drag chain and tele radio remote and ensure the defect-free and safe operation of the cranes During the warranty period, if any repairs require the replacement of spare parts supplied and installed by the Contractor, such parts shall be replaced free of cost by the Contractor.
- 12.2. For Tele radio and Drag chain required warranty will be 2 years and 5 years from the date of commissioning.

13. PERFORMANCE GUARANTEE

- 13.1. The complete work carried out by the contractor shall be guaranteed against defective on poor workmanship for a period of 12 months from the date of completion of work. Any work found defective during this period is to be repaired entirely at the contractor's cost.
- 13.2. Should any unsatisfactory performance and / or damage or failure occur due to poor workmanship and poor-quality material used by the contractor, the contractor shall be solely responsible for payment/reimbursement of expenditure incurred for rectifying the defect.
- 13.3. Towards this, a performance guarantee equivalent to 5% of the value of the contract to be furnished by the contractor on completion of the works by way of a bank guarantee (in approved proforma of UCSL) from a nationalized bank valid till the expiry of the guarantee period. In case the contract fails to submit the PG in time, SD mentioned at Clause 12 will be retained till the expiry of guarantee period.

14. LIQUIDATED DAMAGES

- 14.1. The progress of work will be monitored against the mutually agreed detailed schedule. Liquidated damages for delays in execution of the work beyond the scheduled date of completion, for any reason other than force majeure conditions, will be recovered at the





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rate of half percent of the value of the contract per week or part thereof, subject to a maximum of ten (10) percent of the value of the contract.

- 14.2. For better clarity, order values mentioned in LD clause are values excluding duties and taxes (Basic value). Liquidated damages, if any, shall be decided and settled only after the completion of the entire project but prior to the release of Final stage Payment.
- 14.3. If, for any reasons, supplier has a justification towards delay in supply / work execution and would intend to consider applicability/ non applicability of LD, the same shall be intimated to UCSL by way of a letter, failing which it will be deemed that delay is attributable to the supplier.
- 14.4. Delay in supply/Interruption of the work for reasons not attributable to supplier shall entitle extension of the order execution period for proportionate period without any additional cost to UCSL.

15. POWER OF ATTORNEY

- 15.1. The tenderer(s) shall have to sign in each page of the tender documents with official stamp as a token of his acceptance of the conditions stated therein.
- 15.2. The person signing the tender form on behalf of another or on behalf of a firm, shall enclose to the tender, a Power of Attorney or the said deed duly executed in his favour or the partnership deed giving him such power showing that, he has the authority to bind such other persons or the firm, as the case may be, in all matters pertaining to the contracts. If the Person so signing the tender, fails to enclose the said Power of Attorney, his tender shall be liable for being summarily rejected. The Power of Attorney shall be signed by all partners in the case of partnership concern, by the Proprietor in the case of a proprietary concern, and by the person who by his signature can bind the company in the case of a Limited Company.

16. TERMINATION & LIMITATION OF LIABILITY

- 16.1. This contract may be terminated upon the occurrence of any of the following events.
- 16.2. By agreement in writing of the parties hereto;
- 16.3. By the non-defaulting party, upon default by the other party, of any clause of this contract, if not remedied within fifteen (15) days, or such longer time as may be agreed upon by the parties, after receipt of notice thereof in writing from the non-defaulting party;
- 16.4. By the other party, upon either party;
 - (i) Making the assignment for the benefit of creditors, being adjudged a bankrupt or becoming insolvent; or





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- (ii) Having a reasonable petition filed seeking its' dissolution or liquidation, not stayed or dismissed within sixty (60) days; or
- (iii) Ceasing to do business for any reason.

- 16.5. For fraud and corruption or other unacceptable practices.
- 16.6. Upon expiry or termination of this Contract, neither party shall be discharged from any antecedent obligations or liabilities to the other party under this Contract unless otherwise agreed in writing.
- 16.7. UCSL may by notice in writing to Agency terminate the order after issuing due notice i.e., 30 days' notice period. UCSL shall be entitled to compensation for the loss limited to the order value.
- 16.8. Liability maximum that can be claimed by the Agency shall be limited to what is due to be and has been paid by UCSL for work done as per the payment milestones and limited to work order value.

17. ARBITRATION & JURISDICTION

- 17.1. Any disputes arising during the period of the contract shall, in the first instance be settled by mutual discussions and negotiations. The results of such resolution of dispute shall be incorporated as an amendment to the contract, failing which supplier shall approach the UCSL Grievance Redressal Committee as per relevant clause of the Contract.
- 17.2. If any dispute, disagreement or question arising out of or relating to or in consequence of the contract, or to its fulfillment, or the validity of enforcement thereof, cannot be settled mutually or the settlement of which is not herein specifically provided for, then the dispute shall within thirty days from the date either party informs the other in writing that such disputes, disagreement exists, be referred to arbitration. The arbitrators shall be appointed and the arbitration proceedings shall be conducted in accordance with and subject to the Arbitration and Conciliation Act, 1996 (No. 26 of 1996) as amended from time to time and the decision of the Arbitrators shall be final and binding on the parties hereto. The arbitration will be done by a Board comprising one arbitrator nominated by each party, and a mutually agreed Umpire. Each party shall bear its own cost of preparing and presenting its case. The cost of arbitration shall be shared equally by the parties unless the award provides otherwise. Performance under this Contract shall however, continue during arbitration proceedings and no payment due or payable by the parties hereto shall be withheld unless any such payment is or forms a part of the subject matter of arbitration proceedings.
- 17.3. Seat & Venue of Arbitration: The seat & venue of arbitration shall be at Bangalore.
- 17.4. Language of Arbitration: The Language of arbitration shall be English.
- 17.5. Governing Law: The contract shall be governed by Indian Law





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17.6. In case of disputes, the same will be subjected to the jurisdiction of courts at Bangalore, Karnataka.

18. SUB CONTRACTING AND ASSIGNMENT

- 18.1. Contractor shall not assign or transfer the Purchase Order/ Work Order or any share or interest therein in any manner or degree to any third party without the prior written consent of UCSL.
- 18.2. Contractor shall not contract with any subcontractor and/or vendor without the prior written consent of UCSL. Such consent shall not relieve the Contractor from any of his responsibilities and liabilities under the Purchase Order/ Work Order. In addition, Contractor shall ensure that the terms and conditions of any such contract shall comply with and correspond to the terms and conditions of the Purchase Order/ Work Order.

19. SECRECY & RESTRICTION ON INFORMATION TO MEDIA

- 19.1. The information contained in the enquiry as such shall NOT be communicated to any third party without prior approval of UCSL.
- 19.2. Information in respect of contracts/orders shall NOT be released to the national or international media or anyone not directly involved in its execution without the written approval of UCSL.

20. CANCELLATION OF ORDER AND RISK CONTRACTING

- 20.1. In the event the Agency fails to complete the work promptly and satisfactorily as per the terms of the order, and if any work is delayed beyond thirty (30) days from the agreed schedule, UCSL, without prejudice, reserves the right to cancel the order and get the work done at Agency's cost and the expenditure so incurred including any damage or loss will be recovered from him and the Security Deposit furnished by him is liable to be forfeited either in whole or in part.
- 20.2. UCSL also reserves to right to impose penalties ranging from Rs. 100 to Rs.500 to the employees of agencies and will be deducted from the bills, for any habitual offence on the cleanliness of uniforms, lack of obedience, not attending the tasks etc, and will be to the discretion of the Officer in charge for the work.

21. FORCE MAJEURE

- 21.1. Should failure in performance of any part of this contract arise from war, insurrection, restraint imposed by Government act or legislation of other statutory authority, from explosion, riot, legal lock-out, flood, fire, act of God or any inevitable or unforeseen event beyond human control which will be construed as a reasonable ground for





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extension of time, UCSL may allow such additional time as is mutually agreed to be justified by the circumstances of the case.

22. STORAGE OF MATERIAL AND EQUIPMENT

- 22.1. The Contractor shall arrange the storage of the materials/ equipment etc. if any, at a suitable location assigned by UCSL and shall ensure the safe and secure possession and handling of the items thus handed over to contractor. UCSL shall allot storage space within UCSL premises, if available.
- 22.2. As regards the equipment/materials stored by him as above as also in use by him, UCSL will not be responsible for any damage, pilferage, accident that may take place during the course of execution of the work. It will be entirely his responsibility to keep all the equipment, materials etc., in safe custody as also hold them duly insured at his expense.

23. IMS GUIDELINES

- 23.1. UCSL implemented an Integrated Management System (IMS) and the Quality Management System (QMS) within the yard. As part of IMS, subcontractors shall comply with the following measures related to the Quality, Health, and Safety & Environment (QHSE) policy of UCSL.
- a) Meeting or exceeding customer requirements.
 - b) Assuring quality of the products and service.
 - c) Preventing occupational ill health & injuries.
 - d) Ensuring safe work sites.
 - e) Conserving natural resources.
 - f) Preventing / minimizing air, water & land pollution.
 - g) Handling and disposal of Hazardous wastes safely.
 - h) Complying with statutory & regulatory and other requirements.
 - i) Developing skills and motivating employees.
- 23.2. Occupational Health, safety & Environmental requirements of UCSL shall also include the following.
- a) The contractor (or a sub-contractor performing work on behalf of the contractor) is deemed to comply with the Occupational health, safety and environmental policy of the company and also to all operational controls/standard operating procedures and shall undertake the work in total compliance with the requirements of the established Integrated Management System (IMS) of the company.





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- b) The Contractor shall undertake the work in total compliance with all applicable legal/statutory requirements related to occupational health, safety and environment effective in the state of Karnataka.
- c) It is the sole responsibility of the contractor to assure that any sub-contractor/s who shall perform works in company lands/facilities/worksites on behalf of the contractor, is also following all requirements related to the Integrated Management System of the company and the health/safety/environmental Rules effective in the state.
- d) The contractor shall provide/implement and operate/practice all occupational health, safety and environmental management measures/facilities, for their period of contract, in their activities/at their work sites, which shall be required according to the IMS of the company or that required by the health/safety/environmental Rules established and effective in the state, at their own cost.
- e) If any contractor failed to comply with or violated any clauses/requirements of occupational health, safety and environmental Rules effective in the state, in their activities or at work sites and the same shall be exposed to the government or any competent authorities upon inspections, the contractor shall be solely responsible for all liabilities caused by his/her action and shall be responsible for paying the penalty and taking stipulated corrective actions insisted by the authorities within the specified time, at their own cost. Any liability to the company in this regard needs to be compensated by the contractor.
- f) Upon completion of the work, contractor shall clear the area and shall not leave any Occupational health/safety/environmental liabilities to the company, from their activities at the worksites.
- g) Any clarification related to IMS requirements of the yard, may be obtained by the contractor from the AGM (HSE) or the authorized representative of the contract, prior to the commencement of work.

24. SAFETY OF PERSONNEL AND FIRST AID

- 24.1. The Agency shall be entirely responsible for the safety of all the personnel employed by him on the work. In this regard, he may adopt all the required safety measures and strictly comply with the safety regulations in force. In this regard, the Agency will have to fully indemnify UCSL against any claims made by his workmen/other personnel.
- 24.2. The Agency may arrange to suitably insure all his workmen/ other personnel in this regard. UCSL will not be responsible for any injury or illness to the Agency's workmen/other personnel during execution of the works due to whatsoever reasons.
- 24.3. The Agency shall provide and maintain so as to be readily accessible during all working hours, a first aid box with prescribed contents at every place where he employs contract labor for executing the works.



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25. LABOUR LAWS AND REGULATIONS

- 25.1. The Agency shall undertake and execute the work with contract Labor only after taking license from the appropriate authority under the Contract Labor (Regulation & Abolition) Act 1970.
- 25.2. The Agency shall observe and comply with the provisions of all labour and industrial laws and enactments and shall comply with and implement the provisions of the Factories Act, 1948, Employees Provident Funds & Miscellaneous Provisions Act, 1952, Employees State Insurance Act, Payment of Gratuity Act, minimum Wages Act, Payment of Bonus Act, Contract Labour (Regulation and Abolition) Act and all other enactments as are applicable to him and his workmen employed by him. The Agency shall inform UCSL his license number from the Central Labour Commissioner.
- 25.3. All Persons, except those exempted under the respective Acts, shall necessarily be insured under the ESI scheme and be made members of the EPF Scheme from the day of their engagement as personnel in the Company. In Case 1, All such insured Persons should carry with them their ESI Identity Card for verification by the authorities. No Persons without a valid ESI Identity Card for verification by the authorities will be permitted to work in the company.
- 25.4. The Agency shall submit the Labour Reports/Returns as required by the Company from time to time in respect of their workmen in standard format to the concerned contracting officer so as to enable the same to reach Contract cell by the 5th of every month. Delayed submission of the same shall attract penal interest /damages at the rate as levied by the respective authorities under the relevant Acts.
- 25.5. The Agency shall maintain the records viz. Muster Roll, Acquittance Roll with full details, Account books etc., in original. These are required for inspection by the concerned authorities under each scheme.
- 25.6. If the Agency fails to pay any contributions, charges or other amounts payable under any of the aforementioned provisions of law, UCSL shall deduct or adjust amounts equivalent to such contribution, charges or amounts from amount payable to him by UCSL, including any deposit or amounts payable against bills and make payments on his account to the appropriate authority. He shall not be entitled to question or challenge such deductions, adjustments or payment made by UCSL.
- 25.7. Any other amount payable under any law or in respect of any person employed by the Agency, if not paid by him, shall be deducted or adjusted by UCSL out of any amount payable to the Agency including any Security Receipt and paid ever or withheld for payment by UCSL.
- 25.8. The Agency shall be fully responsible for the conduct and discipline of the workmen employed by him in the Company premises. If such workmen commit any misconduct or criminal act inside the Company, the Agency shall take appropriate action against such workmen. The Agency shall abide by the instructions/ guidelines issued by the





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Company for maintenance of discipline and good conduct among the workmen employed by him.

25.9. All persons who are engaged for various works in UCSL either directly or through Agency/contractors, should produce the following documents prior to issuing their entry passes:

25.10. Passport/Aadhaar attested copy of passport with photo and address particulars.

OR

Police clearance certificate with photo and address particulars. (Police clearance certificate to the effect that the concerned person is staying in the area of jurisdiction of the certificate issuing Police Station and that the person is not involved in any criminal offences as per the records available therein.)

25.11. Application and Declaration for enrolling under Employees Provident Fund and ESI Scheme- 3 individual passport size photographs and two copies of family photographs of the members.

25.12. **Agency shall familiarize themselves with the labour rules & regulations.**

26. ELECTRICITY RULES AND REGULATION

26.1. The contractor shall adhere to the various rules in respect of electrical installation as per the Indian Electricity Rules and Regulations and Electrical Inspectorate Standards in order to make sure that men and materials are safe from hazards.

27. OVERWRITING & CORRECTIONS

Tenders shall be free from overwriting or erasures. Corrections and additions, if any, shall be duly attested and a separate list of such corrections shall be attached with the offer

28. OTHER TERMS & CONDITIONS

28.1. Quality of services shall conform to the specification/ standards laid down by UCSL.

28.2. UCSL reserves the right to accept / reject any offer.

28.3. During the evaluation of tender, officer-in-charge may seek clarifications from the bidders. Clarification if any shall be given in writing/e-mail. Officer-in-charge's decision will be final and binding on the bidder.

28.4. Compliance of all statutory safety requirements and other safety rules stipulated by UCSL and other applicable statutory bodies shall be the responsibility of the Agency



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while working at UCSL premises. The Agency should ensure that their workmen and staff are adequately covered under Insurance.

- 28.5. Damages caused to the Shipyard properties/tools/accessories should be rectified by the Agency at his cost or proportional recoveries will be made from the Agency while passing their bills for payment.
- 28.6. The service provider shall have to engage men on round the clock basis and also on Sundays and holidays. Service has to be completed to the satisfaction of Udupi Cochin Shipyard Limited officer in-charge.
- 28.7. The service provider shall indemnify UCSL or its officers against any claims arising out of accidents or injuries to workmen or other persons or damage to other property which may arise during the execution of the contract or from breach of any Law or Regulation prior to delivery and acceptance of the items at UCSL.
- 28.8. The service provider shall also be governed by the General Conditions of Contract of UCSL, General Safety Rules and other relevant labour laws.
- 28.9. The upper age limit of all workers and supervisors employed by the Agency and those Agency who do or supervise the job themselves shall be as per the prevailing rules of UCSL and shall comply to the requirements of this tender.
- 28.10. Assistant General Manager, or his authorized representative will be the Officer-in-charge of these contracts.





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SCOPE OF WORK

SCOPE OF WORK FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES AT ALUMINIUM FABRICATION SHOP, COCHIN SHIPYARD LIMITED

1. PROJECT OVERVIEW:

- 1.1. The Udupi Cochin Shipyard Limited (UCSL) is to strengthen the existing crane girder system of the Aluminium Fabrication Shop at Cochin Shipyard Limited for installation and operation of two numbers of 25 Ton Electric Overhead Travelling (EOT) Cranes.
- 1.2. The work consists of dismantling the existing crane rail system, strengthening the existing plate girders and supporting columns by providing additional structural steel members as per the drawings, reinstating the crane rail with new fastening arrangements, and carrying out painting of the modified structural members.
- 1.3. The strengthening scheme has been developed based on the structural design and drawings. The Contractor shall execute the work strictly in accordance with the approved fabrication drawings, technical specifications and instructions of the Engineer-in-Charge.

2. GENERAL

2.1. Introduction

Udupi Cochin Shipyard Limited (UCSL) is to strengthen the existing structural steel crane girder system of the Aluminium Fabrication Shop at Cochin Shipyard Limited to facilitate the installation and safe operation of Two (02) Nos. 25 Ton Electric Overhead Travelling (EOT) Cranes.

The strengthening works comprise dismantling of the existing crane rail system, strengthening of existing crane girders and supporting columns by welding additional structural steel members, reinstallation and alignment of the crane rails pre & post dismantling, painting of the modified steel structures, inspection, testing and all associated works necessary for successful completion of the project.

The Contractor shall execute the work strictly in accordance with this Technical Specification, approved design drawings, approved fabrication drawings, relevant Indian Standards, applicable statutory regulations and the instructions of the Engineer-in-Charge.





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2.2. Objective

The objective of this specification is to establish the minimum technical requirements governing:

- Supply of structural steel materials
- Fabrication
- Surface preparation
- Welding
- Inspection
- Painting
- Erection
- Testing
- Quality Assurance
- Documentation

required for successful completion of the strengthening works.

2.3. Location

The work shall be carried out inside the Aluminium Fabrication Shop of Udupi Cochin Shipyard Limited (UCSL), Kochi.

The Contractor shall familiarize himself with the site conditions before submission of the bid.

No additional claims arising out of ignorance of site conditions shall be entertained

2.4. Nature of Contract

The work shall be executed on a Turnkey Basis.

The Contractor shall provide all labour, supervision, materials, consumables, temporary works, tools, tackles, lifting appliances, welding equipment, testing equipment, safety arrangements, transportation, loading, unloading, handling, storage and all incidental items necessary for complete execution of the work unless specifically stated otherwise.

The 16 mm plates required for main girder strengthening and the 6 mm plates required for column strengthening will be supplied by UCSL. Bidders shall consider these plates as being under the scope of supply of UCSL.

Scaffolding/working platforms for execution of the works shall be provided by UCSL, as appropriately required.

2.5. Definitions

For the purpose of this Specification, the following definitions shall apply.





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Employer

Udupi Cochin Shipyard Limited (UCSL).

Engineer-in-Charge

The officer authorized by UCSL to supervise, inspect and administer the work.

Contractor

The successful bidder to whom the Contract is awarded.

Work

All activities necessary for complete execution of the structural strengthening including fabrication, erection, testing, painting and handing over.

2.6. Contractor's Responsibility

The Contractor shall be deemed to have examined all drawings, specifications, site conditions and work requirements before submitting his offer.

Submission of bid shall constitute confirmation that the Contractor has understood the complete scope of work.

No claim for extra payment arising from misunderstanding of the work shall be entertained.

Supply includes

- Structural Steel
- Bolts
- Electrodes
- Primer
- Paint
- Welding consumables

Execution includes

- Fabrication
- Erection
- Welding
- Rail removal
- Rail alignment
- Testing
- Painting

2.7. Mobilization Schedule

Contractor shall mobilize manpower, machinery and materials within 10 days from the date of Work Order.





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3. SCOPE OF WORK:

3.1. Dismantling of Existing Crane Rail.

- Removal of approximately 20 MT of existing R52 crane rails installed over the plate girders at approximately 13 m elevation.
- Prior to dismantling, carry out a detailed survey and record the existing rail alignment, gauge, level, and any horizontal or vertical misalignment between the two crane rails. The survey records shall be submitted to the Engineer-in-Charge for reference.
- Carefully remove all rail clips, fish plates, bolts, clamps, and associated fastening accessories without causing damage to the reusable components or the supporting steel structure.
- Stack and store the dismantled rails and reusable accessories at the location designated by the Engineer-in-Charge.
- Ensure adequate temporary supports, lifting arrangements, and safety measures are provided during dismantling to prevent damage to the existing structure and ensure safe execution of the work.
- Any damaged or unserviceable fastening components identified during dismantling shall be reported to the Engineer-in-Charge for replacement as directed.
- The Contractor shall clear the work area of all debris generated during dismantling and maintain good housekeeping throughout the operation.
- The 16 mm plates required for main girder strengthening and the 6 mm plates required for column strengthening will be supplied by UCSL. Bidders shall consider these plates as being under the scope of supply of UCSL.
- Scaffolding/working platforms for execution of the works shall be provided by UCSL, as appropriately required.

3.2. Surface Preparation.

Cleaning and preparation of approximately 290 m² of existing steel girders and columns by

- Removal of existing paint
- Removal of rust
- Removal of mill scale
- Cleaning by mechanical tools/wire brush/power tools to obtain suitable welding surface.

3.3. Structural Strengthening.

Supply, fabrication and erection of approximately 52 MT of new structural steel members required for strengthening of the existing crane girder system consisting of

- Additional bottom flange plates
- Additional top flange plates
- Additional flange plates over cantilever girders
- Additional web plates for selected columns

Refer the drawings attached with the tender document for the reference including





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- cutting
- bending
- drilling
- machining
- preheating
- welding
- grinding
- erection
- alignment
- primer coating

strictly in accordance with approved fabrication drawings.

Bolt holes shall be drilled. Gas-cut holes shall not be permitted under any circumstances.

Contractor shall prepare, check, and submit fabrication drawings for approval prior to commencement of fabrication.

3.4. Reinstallation of Crane Rail

Reinstallation of approximately 290 m of dismantled crane rail including

- transportation from storage
- alignment
- fixing using reused clamps
- reused fish plates
- new M16 bolts
- drilling matching bolt holes
- tightening
- rail alignment
- joint adjustment

3.5. Painting

Painting of approximately 320 m² of fabricated and modified structural members consisting of

- One coat Zinc Chromate Primer
- Two coats Synthetic Enamel Paint

including all surface preparation after welding.

3.6. Temporary Works

Contractor shall provide

- Lifting arrangements
- Chain pulley blocks
- Mobile cranes
- Welding machines
- Gas cutting equipment (except hole making)
- Grinding machines
- Safety nets
- Safety harness





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- Temporary supports wherever required without additional cost.

3.7. Testing and Inspection

Contractor shall carry out

- Visual inspection
- Weld inspection
- DPT wherever instructed
- Ultrasonic testing wherever instructed
- Dimensional inspection to the satisfaction of Engineer-in-Charge.

3.8. Completion

After completion the Contractor shall

- remove all temporary works
- clean the work area
- remove debris
- hand over completed work.

4. DESIGN BASIS

The strengthening has been designed based on installation of two numbers of 25 Ton EOT Cranes.

The structural strengthening has been developed considering:

- Maximum Girder Moment: 1406 kNm
- Maximum Cantilever Moment: 953 kNm
- Maximum Girder Shear: 653 kN
- Maximum Beam Deflection: 27 mm
- Maximum Column Axial Load: 1221 kN

The Contractor shall execute the strengthening exactly as shown in approved drawings without altering plate sizes, welding details or connection arrangements unless approved by Engineer-in-Charge.

5. SPECIFICATION

5.1. This specification covers the general requirements for supply, fabrication, painting, and erection at site of structural steel and bolts.

5.2. This specification also covers preparation of all shop fabrication drawings, inspection and shop painting of structures.





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6. APPLICABLE CODES & SPECIFICATIONS

- 6.1.** The following specifications, standards and codes are made a part of this specification. All standards, specifications and codes of practices referred to herein shall be the latest editions including all applicable official amendments and revisions.
- 6.2.** In case of discrepancy between this specification and other documents referred to herein, this specification shall govern. (Refer latest version of standards)

MATERIALS

Sl No.	Material Code	Description
1	808	Dimensions for Hot Rolled Steel sections
2	814	Covered Electrodes for Manual Metal Arc Welding of Carbon and Carbon Manganese Steel
3	1161	Steel Tubes for structural purposes
4	1239	Mild steel tubes, tubular and other wrought steel fittings Part-1-Mild steel tubes Part 2- Mild steel Tubular and other wrought steel pipe fittings
5	1363	Hexagon Head Bolts, Screws and Nuts of product (Parts 1 to 3) Grade C (Size range M5 to M64)
6	1367	Technical Supply Conditions for Threaded Fasteners (All Parts)
7	1852	Rolling and Cutting Tolerances for Hot Rolled Steel products
8	2062	Steel for General Structural Purposes
9	2074	Ready Mixed Paint, Air drying, Red Oxide Zinc Chrome and Priming
10	3757	High Strength Structural Bolts
11	5369	General Requirements for Plain Washers and Lock Washers
12	5372	Taper Washers for Channels
13	5374	Taper Washer for I Beams
14	6610	Heavy Washers for Steel Structures
15	8500	Structural Steel-micro alloyed (medium and high strength qualities)
16	803	Code of practice for design, fabrication and erection of vertical mild steel cylindrical welded storage tanks
17	806	Code of practice for use of steel tubes in general building construction



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18	816	Code of Practice for use of Metal Arc Welding for General construction in Mild Steel
19	822	Code of Procedure for Inspection of Welds
20	1182	Recommended Practice for Radiographic examination of Fusion - Welded Butt Joints in Steel Plates
21	1200	Method of Measurement in Building Civil Engineering Works
22	2595	Code of Practice for Radiographic Testing
23	3658	Code of Practice for Liquid Penetrant Flaw De
24	4000	High strength bolts in Steel Structures - Code of Practice
25	5334	Code of Practice for Magnetic Particle Flaw Detection of Welds
26	7215	Tolerances for Fabrication of Steel Structures
27	102	Ready Mixed paint, Brushing, Red Lead, Non-setting, Priming.
28	110	Ready Mixed paint, brushing, grey filler for enamels for use over primers.
29	117	Ready Mixed paint, Brushing, Finishing, Exterior Semi-gloss for general purposes, to Indian Standard colors.
30	158	Ready Mixed paint, Brushing, Bituminous, Black, Lead free, acid, alkali and heat resisting.
31	159	Ready Mixed paint, Brushing, Acid resisting.
32	341	Black Japan, Types A, B and C
33	1477	Codes of Practice for painting of ferrous metals in buildings. Part-I-Pre-treatment Part -II - Painting
34	2339	Aluminum paint for general purposes, in Dual container
35	2932	Specification for enamel, synthetic, exterior, type 1, (a) Undercoating (b) finishing
36	2933	Specification for enamel, exterior, type 2, (a) Undercoating, (b) finishing
37	5905	Sprayed aluminum and zinc coatings on Iron and Steel.
38	6005	Code of practice for Phosphating of Iron and Steel.
39	9862	Specification for ready mixed paint, brushing, bituminous, black, lead free, acid, alkali, water & chlorine resisting.
40	13183	Aluminum paint, Heat resistant.



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SL. No	Material Code	Description
1	IS: 800	Code of Practice for General Construction in Steel
2	IS: 801	Code of Practice for Use of Cold Formed Light Gauge Steel Structural Members in General Building Construction
3	IS: 806	Code of Practice for Use of Steel Tubes in General Building Construction
4	IS: 7205	Safety Code for Erection of Structural Steel Work
5	IS: 7215	Tolerances for Fabrication of Steel Structures
6	IS: 4000	High Strength Bolts in Steel Structure - Code of Practice

7. MATERIALS

7.1. All Steel materials like plates, angles, channels, Tees, I section and rounds etc. except 16 mm plates and 6 mm plates shall comply with the specifications laid down under respective item of Bill of quantities and relevant IS Codes. All materials supplied by the contractor shall be new, unused, and free from defects. Steel conforming to IS: 2062, E250 grade shall be used

- Every structural member shall be traceable to the corresponding Material Test Certificate (MTC).

Add

- Heat Number
- Plate Identification
- Material Traceability Register
- The 16 mm plates required for main girder strengthening and the 6 mm plates required for column strengthening will be supplied by UCSL. Bidders shall consider these plates as being under the scope of supply of UCSL.
- Bolt material shall be of mild steel (property class 4.6) and shall conform to IS: 1367 – Part 3 and IS: 5624. Grade of Bolt steel shall be E250A. Structural steel shall conform to IS 2062 Grade E250 unless otherwise specified. Washers shall conform to IS:2016, IS:5369, IS:5372, IS: 5374, IS: 6610 and IS: 6649 as applicable. Spring washers shall be provided for those parts, which carry dynamic loads and where black bolts for connection are permitted. Welding Consumables Mild steel electrodes shall conform to IS: 814.
- The electrodes used for welding shall be of suitable type and size depending upon specification of parent material, method of welding, position of welding and quality of welds desired. The Contractor shall furnish a certificate issued by the manufacturer to the effect that the electrodes supplied are in accordance with the above specifications.





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8. DRAWINGS PREPARED BY THE CONTRACTOR

- 8.1. The Contractor shall prepare all general, detailed, fabrication and erection drawings for the entire work. All the drawings for the entire work shall be prepared in metric units. The drawings shall preferably be of one standard size and the details shown there in shall be clear and legible.
- 8.2. All fabrication drawings shall be submitted to the Engineer-In-Charge for approval.
- 8.3. No fabrication drawings will be accepted for Engineer-In-Charge's approval unless checked and approved by the Contractor's qualified structural engineer and accompanied by an erection plan showing the location of all pieces detailed. The Contractor shall ensure that connections are detailed to obtain ease in erection of structures and in making field connections.
- 8.4. Fabrication shall be started by the Contractor only after Engineer-In-Charge's approval of fabrication drawings. Approval by the Engineer-In-Charge of any of the drawings shall not relieve the Contractor from the responsibility for correctness of engineering & design of connections, workmanship, fit of parts, details, material, errors or omissions of any and all work shown thereon. The Engineer-In-Charge's approval shall constitute approval of the size of members, dimensions and general arrangement but shall not constitute approval of the connections between members and other details.
- 8.5. The drawings prepared by the Contractor and all subsequent revisions etc. shall be at the cost of the Contractor for which no separate payment shall be made.
- 8.6. Contractor shall submit detailed methodology for carrying out structural fabrication, painting and erection at site for the approval of Engineer-In-Charge.

9. FABRICATION

9.1. GENERAL

All workmanship and finish shall be of the best quality and shall conform to the best approved method of fabrication. All materials shall be finished straight and shall be machined/ground smooth true and square, where so specified. All holes and edges shall be free of burrs. Shearing and chipping shall be neatly and accurately done and all portions of work exposed to view shall be neatly finished. Unless otherwise directed/ approved, reference may be made to relevant IS codes for providing standard fabrication tolerance. Material at the shops shall be kept clean and protected from weather.

9.2. CONNECTIONS

- a. Shop/field connections shall be as per approved fabrication drawings.
- b. In case of bolted connections, taper washers or flat washers or spring washers shall be used with bolts as necessary. In case of high strength friction grip bolts, hardened washers shall be used under the nuts or the bolt heads whichever are turned to tighten the bolts. The length of the bolt shall be such that at least one thread of the bolt projects beyond the nut,



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except in case of high strength friction grip bolts where this projection shall be at least three times the pitch of the thread.

- c. In all cases where bearing is critical, the unthreaded portion of bolt shall bear on the members assembled. A washer of adequate thickness may be provided to exclude the threads from the bearing thickness if a longer grip bolt has to be used for this purpose.
- d. All connections and splices shall be designed for full strength of members or loads indicated on Engineer-In-Charge's design drawings. Column splices shall be designed for the full tensile strength of the minimum cross section at the splice.
- e. All bolts, nuts, washers, electrodes, screws etc. shall be supplied/brought to site 10% in excess of the requirement in each category and size. Rates shall cover the cost of this extra quantity.
- f. Fabrication drawings shall clearly indicate:
 - Plate sizes
 - Weld sizes
 - Bolt locations
 - Hole details
 - Splice details
 - Member identification
 - Fabrication shall commence only after written approval from Engineer-in-Charge.

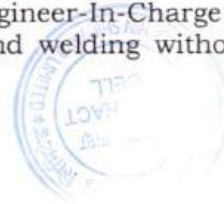
9.3. STRAIGHTENING

All materials shall be straight and, if necessary, before being worked shall be straightened and/or flattened by pressure and shall be free from twists. Heating or forging shall not be resorted to without the prior approval of the Engineer-In-Charge in writing.

Cutting, punching, drilling, welding and fabrication tolerances shall be generally as per relevant IS codes.

9.4. WELDING

- a. Welding procedure, WPS, PQR shall be submitted to Engineer-In-Charge for approval. Welding shall be entrusted to only qualified and experienced welders who shall be periodically tested and graded as per IS 817, IS: 7310 (Part 1) and IS: 7318 (Part 1).
- b. While fabricating plated beams and built-up members, all shop splices in each component part shall be made before such component part is welded to other parts of the members. Wherever weld reinforcement interferes with proper fit-up between components to be assembled for welding, these welds shall be ground flush prior to assembly.
- c. Approval of the welding procedure, WPS, PQR, WPQ by the Engineer-In-Charge shall not relieve the Contractor of his responsibility for correct and sound welding without undue distortion in the finished structure.





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- d. No welding shall be done when the surface of the members is wet nor during periods of high wind. Contractor to ensure the quality of work to provide electrode baking, low hydrogen electrode storage, weld numbering & weld maps.
- e. Each layer of a multiple layer weld except root and surfaces runs may be moderately pecked with light blows from a blunt tool. Care shall be exercised to prevent scaling or flaking of weld and base metal from over pecking.
- f. No welding shall be done on base metal at a temperature below (-) 5 Deg.C. Base metal shall be preheated to the temperature as per relevant IS codes.
- g. Electrodes other than low-hydrogen electrodes shall not be permitted for thicknesses of 32 mm and above.
- h. Welding sequence shall be planned to minimize distortion.
- i. Weld shrinkage shall be controlled by proper welding sequence.

9.5.INSPECTION OF WELDS

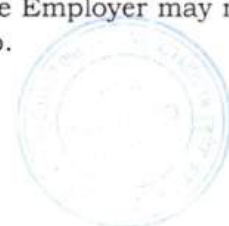
- a. All welds shall be inspected for flaws by any of the methods described under "Inspection". The choice of the method adopted shall be determined by the Employer/Engineer-In-Charge.
- b. The correction of defective welds shall be carried out as directed by the Engineer-In-Charge without damaging the parent metal. When a crack in the weld is removed, magnetic particle inspection or any other equally positive means as prescribed by the Engineer-In-Charge shall be used to ensure that the whole of the crack and material up to 25 mm beyond each end of the crack has been removed. Cost of all such tests and operations incidental to correction shall be to the Contractor's account.

9.6.TOLERANCES

The dimensional and weight tolerances for rolled shapes shall be in accordance with IS:1852 for indigenous steel and equivalent applicable codes for imported steel. The tolerances for fabrication of structural steel shall be as per IS: 7215.

9.7.INSPECTION

- 9.7.1. Contractor shall give due notice to the Engineer-In-Charge in advance of the work getting ready for inspection. All rejected materials shall be promptly removed from the shop and replaced with new material for the Engineer-In-Charge's approval/ inspection. The fact that certain material has been accepted at the Contractor's shop shall not invalidate final rejection at site by the Engineer-In-Charge if it fails to conform to the requirements of these specifications, to be in proper condition or has fabrication inaccuracies which prevents proper assembly, nor shall it invalidate any claim which the Employer may make because of defective or unsatisfactory materials and/or workmanship.





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- 9.7.2. No materials shall be painted or dispatched from fabrication yard or manufacturer to site without inspection and approval by the Engineer-In-Charge unless such inspection is waived in writing by the Engineer-In-Charge.
- 9.7.3. Contractor shall provide all the testing and inspection services and facilities for shop work except where otherwise specified.
- 9.7.4. For fabrication work carried out in the field the same standard of supervision and quality control shall be maintained as in shop fabricated work. Inspection and testing shall be conducted in a manner satisfactory to the Engineer-In-Charge.
- 9.7.5. Inspection and tests on structural steel members shall be as set forth below.

- **Material Testing**

If mill test reports are not available for any steel materials the same shall be got tested by the Contractor to the Engineer-In-Charge's satisfaction to demonstrate conformity with the relevant specification.

- **Tests on Welds**

100% of welds shall be inspected for external defects. Dimensions of welds shall be checked. Welds shall be free from unfilled craters on the surfaces, undercuts, slag on the surface and visible cracks. Weld gauges shall be used to measure the size of welds. The Contractor shall carry out radiographic/ ultrasonic or other non-destructive testing as and when required by the owner through the approved agency. Dye penetration test of welds shall be carried out using standard solutions.

Acceptance criteria shall conform to

- IS 822
- AWS D1.1
- Approved WPS

- **Visual examination**

- All welds shall be 100% visually inspected to check the following:
 - Presence of undercuts
 - Surface cracks in both welds and base metals.
 - Unfilled craters
 - Improper weld profile and size
 - Excessive reinforcement in weld
 - Surface porosity
- Before inspection, the surface of weld metal shall be cleaned of all slag, spatter matter; scales etc. by using wire brush or chisel.





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- c. Dye penetration test (DPT)
 - d. This shall be carried out for all important fillet welds and butt welds to check the following.
 - 1. Surface cracks
 - 2. Surface porosities
 - e. 5% of the total length, dye-penetration test shall be carried out to the root run.
 - f. Dye Penetration Test shall be carried out in accordance with American National Standard ASTM E165.
- **Ultrasonic testing**
 - a. Ultrasonic tests shall be conducted for all groove welds and heat affected zone in dynamically loaded structures and for other important load bearing butt welds in statically loaded structures as desired by Employer to detect the following:
 - i. Cracks
 - ii. Lack of fusion
 - iii. Slag inclusions
 - iv. Gas porosity
 - b. Ultrasonic testing shall be carried out in accordance with American National Standard ANSI / AWS D1-92 Chapter 6: Part C.
 - c. Before Ultrasonic test is carried out, any surface irregularity like undercuts, sharp ridges etc. shall be rectified. Material surfaces to be used for scanning by probes must allow free movement of probes. For this purpose, surface shall be prepared to make it suitable for carrying out ultrasonic examinations.
 - **Magnetic Particle Test**

Where welds are examined by magnetic particle testing, such testing shall be carried out in accordance with relevant IS codes. If heat treatment is performed, the completed weld shall be examined after the heat treatment. All defects shall be repaired and retested. Magnetic particle tests shall be carried out using alternating current. Direct current may be used with the permission of the Engineer-In-Charge.
 - **Liquid Penetrant Inspection**

In the case of welds examined by Liquid Penetrant Inspection, such tests shall be carried out in accordance with relevant IS Code. All defects shown shall be repaired and rechecked.
 - **Dimensions, Workmanship & Cleanliness**

Members shall be inspected at all stages of fabrication and assembly to verify that dimensions, tolerances, alignment, surface finish and painting are in accordance with the requirements shown in the Contractor's approved fabrication drawings and the Engineer-In-Charge's drawings.



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• Test Failure

- a. In the event of failure of any member to satisfy inspection or test requirement, the Contractor shall notify the Engineer-In-Charge or his authorized representative. The Contractor must obtain permission from the Engineer-In-Charge before repair is undertaken. The quality control procedures to be followed to ensure satisfactory repair shall be subject to approval by the Engineer-In-Charge. The Engineer-In-Charge has the right to specify additional testing as and when required. Contractor shall maintain records of all inspection and testing which shall be made available to the Engineer-In-Charge or his authorized representative.
- b. The contractor shall submit the proposal and methodology for testing of old/new structural steel members.
- c. Contractor shall mark all accepted and rejected materials and stack it separately by giving proper identification marks as discussed and advised by the Engineer-In-Charge.

10. Quality Documents to be Submitted

The contractor should submit

- Fabrication Drawings
- Bill of Materials
- Material Test Certificates
- Welding Procedure Specification
- Welder Qualification Certificates
- NDT Reports
- Paint Inspection Reports
- DFT Reports
- Final As-built Drawings

11. SHOP MATCHING

- 11.1. All steel work, such as columns along with the tie beams/bracings may have to be shop assembled to ensure satisfactory fabrication, obtaining of adequate bearing areas etc. if so desired by the Engineer-In-Charge. All these shop assemblies shall be carried out by Contractor at no extra cost to the Employer.

12. DRILLING HOLES FOR OTHER WORKS

- 12.1. As a part of this Contract, holes in members required for installing the rail shall be drilled by the Contractor at no extra cost to the Employer. The hole shall match with the holes already existing in the flange of the existing girders. The information for any extra holes required shall be supplied by the Employer/Engineer-In-Charge.





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13. MARKING OF MEMBERS

- 13.1.** After checking and inspection, all members shall be marked for identification during erection. This mark shall correspond to distinguishing marks on approved erection drawings and shall be legibly painted and stamped on it. The erection mark shall be stamped with a metal dye with figures at least 20 mm high and to such optimum depth as to be clearly visible.
- 13.2.** All erection marks shall be on the outer surface of all sections and near one end, but clear of bolt holes. The marking shall be so stamped that they are easily discernible when sorting out members. The stamped marking shall be encircled boldly by a distinguishable paint to facilitate easy location.
- 13.3.** Erection marks on like pieces shall be in identical locations. Members having lengths of 7.0 m or more shall have the erection mark at both ends.

14. ERRORS

- 14.1.** Any error in shop fabrication which prevents proper assembling and fitting up of parts in the field by moderate use of drift pins or moderate amount of reaming will be classified by the Engineer-In-Charge as defective workmanship. In case Engineer-In-Charge rejects such material or defective workmanship, the same shall be replaced by contractor free of cost. The materials and workmanship shall meet the Engineer-In-Charge's requirements.

15. PAINTING

Activity	Requirement
Surface Cleaning	Power Tool Cleaning St-3 or Sa2½ where specified
Primer	Zinc Chromate Primer
DFT	20 µ
Finish	Synthetic Enamel
Number of Coats	2 coat primer and 2 coat finish
Total DFT	100 µ





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• SURFACE CLEANING WELDING

Before welding of the additional plates/ members, the surface of the existing structure shall be buffed and cleaned of all paints, rust and scaling if any to the satisfaction of the Engineer-in-charge. Power operated wire brushes shall also be used if required Oil and grease removal if found on the members shall be carried out either by solvent cleaning or by using alkali type degreasing agents or emulsifier. After cleaning, the surface shall be washed with water.

• SURFACE TREATMENT

- a. All the surfaces of steel work earmarked by the Engineer-in-charge, to be painted shall be thoroughly cleaned of all loose mill scale, rust, grease, dirt, and other foreign matter. The type of surface treatment shall be as directed by Engineer-In-Charge. The workmanship shall generally conform to the requirements of IS 1477-Part I.
- b. Oil and grease removal shall be carried out either by solvent cleaning or by using alkali type degreasing agents. To remove grease material the surface shall be cleaned with solvents containing emulsifier. After cleaning, the surface shall be washed with water. When the surface has cement pelts or salts, the cleaning shall be done with strong alkalis. After cleaning, water rinsing and subsequent passivation by dilute chromic acid rinsing shall be carried out to ensure that no traces of alkali are left on the surface. The procedure for cleaning by above mentioned methods shall be as per manufacturer's instructions.
- c. De-rusting and de-scaling of steel shall be carried out either manually, mechanically, or chemically as per requirement of Engineer-In-Charge.
 - i. Manual or Hand Tool Cleaning

Loose mill scale, loose rust and loose paint shall be removed by wire brushing, scrapping, chipping, and rubbing with abrasive paper or steel wool. This method shall not be employed when the surface has firmly adhering mill scale. After hand tool cleaning, the surface shall be rubbed with sandpaper so as to ensure that no loose material exists and the surfaces shall be dusted off.
 - ii. Mechanical Cleaning
 - iii. Power Tool Cleaning

This shall be carried out by employing power operated wire brushes. Power tool cleaning shall be resorted to only if sand/shot blasting is not possible/ permissible and high quality of surface preparation is required.

The surface prior to such cleaning shall be cleaned of dust; grease etc. and heavier layers of rust shall be removed by chipping.





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The power tool cleaning shall remove loose mill scale and rust by adopting very thorough scrapping, grinding and machine brushing. After the surfaces are cleaned by compressed air, it shall have a pronounced metallic sheen.

iv. Flame Cleaning

Hard mill scale and rust shall be removed through Oxy- acetylene flame. The work shall be carried out by trained workmen to ensure that only mill scale is removed without affecting the parent steel. The work shall be carried out carefully on welded surfaces so that the strength of weld is not affected due to heating.

v. Sand Blasting and Shot Blasting

- a. (If required) and /Shot blasting shall be resorted to only after removal of grease, oil, and other contaminants. The work shall be carried out by impinging under pressure of air, a jet of sharp sand or granulated steel (steel grits) on to the metal surface. The process shall ensure complete removal of rust and firmly adhering mill scale. Special care shall be taken on weld areas to remove flux and spatter. Blasting shall ensure an even colour of the surface and the surface shall have silver grey colour. Precautions shall be taken when sand or shot blasting of light gauge steel surfaces to ensure that buckling does not occur to continuous impingement of sand or steel shots under high velocity.
- b. Sand/Shot blasting shall be adopted for structures which are exposed to corrosive conditions for which superior paint protection is to be adopted. The finished surfaces shall conform to the requirements of Sa 2½ or Sa 3 as per Swedish Standard SIS-05- 5900 as specified in the item of work. As sand blasting causes dust nuisance necessary clearance shall be obtained by the Contractor from competent authorities prior to commencing sand blasting.
- c. As Sandblasting causes dust nuisance necessary clearance shall be obtained by the Contractor from Competent authorities prior to commencing Sand blasting.

vi. Chemical Cleaning (Pickling)

- a. Cleaning shall be done by pickling in sulphuric, hydrochloric or phosphoric acids. Pickling shall be carried out in accordance with detailed procedure as given in IS 6005.
- b. Washing after pickling shall remove all traces of the acids. All work pieces shall be thoroughly inspected and in particular the inaccessible corners.
- c. Contractor shall submit the Method Statement for surface treatment and painting works for old and new structural components/elements, for approval of Engineer-In-Charge.





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- d. At least 24 hours shall elapse between the applications of successive coats. Each coat shall vary slightly in shade, and this shall be got approved by the Engineer-In-Charge.

16. MATERIALS

16.1. Primer Paint

- a. The steel structures as earmarked by the Engineer-in charge shall receive One coat Zinc Chromate Primer followed by Two coats Synthetic Enamel Paint and its DFT shall be 20 microns for each coat. Primer paint shall be red oxide zinc chromate of approved make, quality and colour.
- b. Steel surface which is to be applied with primer paint shall be cleaned of dust and grease and the heavier layers of rust shall be removed by chipping prior to actual surface preparation.
- c. First coat of primer shall be given in shop after fabrication, before dispatching to erection site. The second coat of primer shall be applied after erection and final alignment of the erected structures.

16.2. Finish Paint

- a. All steel structures shall receive two coats of finished paint and shall be applied after erection.
Finish paint shall be 2 coats of synthetic enamel paint of approved brand. Dry film thickness of each finish coat shall be 30 microns. The undercoat and finish coat shall be of different tint to distinguish the same from finish paint. The total dry film thickness shall be 100 microns. All paints shall be of approved brand and shade as per the Engineer-in-charge's requirement.
- b. All the materials shall be of the best quality from an approved manufacturer. Contractor shall obtain prior approval of the Engineer-In-Charge for the brand of manufacture and the colour/shade prior to procurement for usage in the works.
- c. Primer and finish paints shall be compatible with each other to avoid cracking and wrinkling. As such it is recommended that the primer and finish paint shall be from the same manufacturer.
- d. The colour and shade shall conform to IS Standards referred to in Appendix 'D' of IS 1477-Part II. To facilitate choosing the correct shade/number from the alternatives available, Contractor shall adopt trial painting in small patches in consultation with and as directed by the Engineer-In-Charge.
- e. All paint delivered to the fabrication shop/site shall be ready mixed, in original sealed containers, as packed by the manufacturer. Thinner shall not be permitted for usage unless specifically directed by the Engineer-In-Charge.
- f. Paints shall be stirred thoroughly to keep the pigment in suspension.





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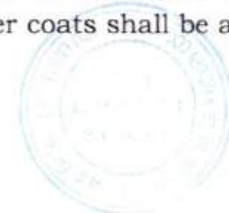
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- g. Contractor shall at his own cost arrange for testing of paints as per relevant Indian Standards in laboratory whenever Employer wants the tests to be carried out for each batch of paints. Test results shall be submitted to the Engineer-in-charge for obtaining approval.
- h. Joints to be site welded shall have no paint applied within 100 mm of welding zone. Similarly, where Friction grip fasteners are to be used no painting shall be provided. On completion of the joint the surfaces shall receive the paint as specified.
- i. Surfaces inaccessible after assembly shall receive two coats of primer prior to assembly.
- j. Surfaces inaccessible after erection shall receive one additional coat of finish paint over and above number of coats specified before erection. Portion of steel member embedded / to be encased in concrete shall not be painted.

16.3. WORKMANSHIP

- 16.3.1. No painting shall be done in frosty/foggy weather or when the humidity is high enough to cause condensation on the surface to be painted. Paint shall not be applied when the temperature of the surface to be painted is at 5°C or lower. Primers shall adhere to the surface firmly and offer a key to the subsequent coats. The application of paint film shall serve the twin purpose of protecting the steel from corrosion and giving the decorative appearance. A paint which gives the steel adequate protection over a long period together with good appearance shall therefore be adopted. Workmanship shall generally conform to requirements specified in IS: 1477-Part II.
- 16.3.2. It is essential to ensure that immediately after preparation of the surfaces; the first coat of primer paint shall be applied by brushing and working it well to ensure a continuous film without "holidays". After the first coat becomes hard dry a second coat of primer shall be applied by brushing to obtain a film free from holidays.
- 16.3.3. Structural steel surfaces shall be given the first coat of primer at shop and the second coat after it is erected in position. Further, any abraded surfaces of the first coat during transport from shop to site and during erection shall be provided with a touchup coat of the primer.
- 16.3.4. Application of finishing paints shall be carried out within the shortest possible time interval after primer since the primer coats are too thin to give adequate corrosion protection to the steel surface over a long duration.
- 16.3.5. Filler coats shall be applied to fill dents and to obtain a smooth finish wherever necessary. Only factory prepared filler suitable for steel work shall be used. Fillers prepared by whiting and linseed oil by craftsmen at site shall never be used as such fillers may be unbalanced and incompatible with primer and finishing coats. Application of filler shall be done with good 'putty knife' and necessary skill. Filler applied shall be just sufficient to fill the depression or unevenness and it shall be restricted to the minimum. It shall be applied in thin layers. In filling depression or unevenness, as many coats as are necessary may be applied allowing each layer to dry hard. The hardened coat shall be cut down by wet rubbing before the subsequent coat is applied. Where necessary, filler coats shall be applied over the undercoats also.





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- 16.3.6. Painting shall be carried out either by brushing or by spraying. Contractor shall procure the appropriate quality of paint for this purpose as recommended by the manufacturer.
- 16.3.7. After the second coat of primer is hard dry, the entire surface shall be wet rubbed cutting down to a smooth uniform surface. When the surface becomes dry, the undercoat of paint shall be applied by brushing/spraying with minimum of brush marks. The coat shall be allowed to hard dry. The under coat shall then be wet rubbed cutting down to a smooth finish, taking adequate care to ensure that at no place the undercoat is completely removed. The surface shall then be allowed to dry.
- 16.3.8. At least 24 hours shall elapse between the applications of successive coats. Each coat shall vary slightly in shade and this shall be got approved by the Engineer-In-Charge.
- 16.3.9. The thickness of film shall be measured by an Elcometer to be supplied by the Contractor.
- 16.3.10. The Contractor shall calibrate the Elcometer frequently for different settings. Necessary calibrating accessories should be kept ready for calibration/testing of Elcometer at any time.
- 16.3.11. Epoxy primer and epoxy paint shall be applied within the specified pot life as per recommendations of the manufacturer.
- 16.3.12. Surfaces inaccessible after assembly shall receive two coats of primer prior to assembly.
- 16.3.13. Surfaces inaccessible after erection, including top surfaces of beams supporting the rail shall receive one additional coat of finish paint over and above the number of coats specified prior to erection.
- 16.3.14. Joints to be site welded shall have no shop paint for at least 50mm from the welding zone.
- 16.3.15. Similarly, the steel surfaces shall not be painted in areas where connection is by use of friction grip bolts. On completion of the joint, the surfaces shall receive the painting as specified.
- 16.3.16. Maintenance painting of steel structures would become necessary if the painting already carried out shows signs of chalking, hairline cracking, deep checking, fine checking, and peeling, blistering and rusting. The breakdown of a paint film is progressive from the top finish paint to the primer coat and the object of maintenance painting is to renovate periodically to effectively check the breakdown and protect the steel surfaces from corrosion. It is essential that same quality of paint as specified earlier need be adopted to ensure compatibility. The general workmanship for maintenance painting shall conform as per Clause. 7 of IS 1477-Part II.
- 16.3.17. Contractors shall provide suitable protection as necessary to prevent paint finishes from splashing on equipment, floors, walls etc.





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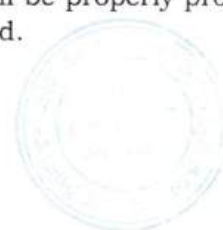
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- 17.1 An experienced and qualified Supervisor shall be in full time charge of the job.
- 17.1. Contractor shall complete all preliminary works at site well before the arrival of structural steel, such as establishment of a well-equipped and adequately staffed site office, stores, unloading gantry, unloading and preassembly yard, labour quarters if any, electrical winches, derricks, cranes, compressors, all tools and tackles, rivet guns, welding sets, torque wrenches, spud wrenches, staging, etc. as well as experienced erection and supervisory personnel as part of this contract and any other work that may be necessary so as to start erection immediately after the arrival of the first batch of steel at site. Contractor shall arrange his own generator of required capacity for the work. He shall also arrange required potable water for his work force.
- 17.2. Contractor shall furnish at his own expense, necessary noninflammable staging and hoisting materials or equipment required for the erection work and shall remove and take them away after completion of the job. Contractor shall also provide necessary passageways, fences, safety belts, helmets, lights and other fittings to the satisfaction of the Engineer-In-Charge and to meet the rules of local authorities and for protection to his men and materials. A licensed electrician shall be kept on the job for the entire duration of the work to maintain Contractor's electrical equipment and connections.
- 17.3. Contractor shall protect all existing plant, structures, piping, conduits, equipment and facilities against damage during erection. Any damage caused by Contractor shall be rectified entirely at Contractor's cost, to the satisfaction of Engineer-In-Charge. If work has to be carried out adjacent to existing switch yards or electrical installations which are live, Contractor must ensure suitable safety precautions in consultation with Engineer-In-Charge.
- 17.4. If a portion of the work of the project area cannot be made available to Contractor for his activities due to operations being carried out, he shall suitably modify his sequence of operations so as to continue work without interruption. Contractor shall work in coordination with other agencies working on the project site and plan his work suitably so as not to hinder the progress of construction at site.

18. ACCEPTANCE OF STEEL, ITS HANDLING & STORAGE

- 18.1. Contractor should carefully check the steel to be erected at the time of acceptance. Any fabrication defect observed should be brought to the notice of Engineer-In-Charge.
- 18.2. No dragging of steel shall be permitted. All shall be stored 300mm above ground on suitable packing to avoid damage. It shall be stored in the order required for erection, with erection marks visible. All storage areas shall be prepared and maintained by Contractor.
- 18.3. Scratched or abraded steel shall be given a coat of primer for protection after unloading and handling prior to erection. All milled and machined surfaces shall be properly protected from rust/corrosion by suitable coating and also from getting damaged.





Udupi Cochin Shipyards Limited

TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES

UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026**19. ASSEMBLY & CONNECTIONS**

- 19.1. Field connections may be affected by welding as shown on the design and erection drawings.
- 19.2. All field connection works shall be carried out in accordance with the approved fabrication drawing. All bolts, nuts, washers, rivets, electrodes required for field connections shall be supplied by contractor free of cost.
- 19.3. All assembling shall be carried on a level platform suiting the configuration.
- 19.4. Drifts shall be used only for drawing the work to proper position and must not be used to such an extent as to damage the holes. Size of drifts larger than the nominal diameter of hole shall not be used. Any damaged holes or burrs must be rectified to the satisfaction of Engineer-In-Charge.
- 19.5. Any error in the shop, which prevents proper fit on a moderate amount of reaming and slight chipping or cutting, shall be immediately reported to Engineer-In-Charge.

20. ERECTION

- 20.1. All structural steel shall be erected as shown on the drawings. Proper size steel cable slings, etc., shall be used for hoisting. Guide wire shall not be anchored to existing structures, foundations, etc. unless so permitted by Engineer-In-Charge in writing. Care shall be taken to see that ropes in use are always in good condition.
- 20.2. Temporary bracings shall be introduced wherever necessary to take care of all loads to which the structure may be subjected, including erection equipment and the operation thereof. Such bracings shall be left in place as long as may be required for safety and stability.
- 20.3. As erection progresses, the work shall be securely bolted to take care of all dead load, wind, seismic and erection stresses.
- 20.4. No riveting or welding or final bolting shall be done until the structure has been properly aligned and approved by Engineer-In-Charge. No cutting, heating or enlarging of the holes shall be carried out without the prior written approval of Engineer-In-Charge.

21. INSPECTION

- 21.1. Engineer-In-Charge or his authorized representatives shall have free access to all parts of the job during erection, and all erection shall be subjected to their approval. In case of faulty erection, all dismantling and re-erection required will be at Contractor's cost. No paint shall be applied to field welds or bolts until these have been approved by Engineer-In-Charge.





Udupi Cochin Shipyard Limited

TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES

UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026**22. PAINTING**

22.1. After steel has been erected, all bare and abraded spots, field welds, bolt heads and nuts shall be spot painted with primer. Before paint is applied, the surface shall be dry and free from dust, dirt, scale and grease. All surfaces inaccessible after erection shall receive two coats of the approved primer and paint before erection as per specification. Any damage if found in the structure/element shall be checked and if found damaged, shall be rectified or shall be repainted.

23. CLEAN UP OF WORK SITE

23.1. During erection, the Contractor shall without any additional payment, at all times keep the working and storage areas used by him, free from accumulation of waste materials or rubbish. Before completion of erection, he shall remove or dispose of in a satisfactory manner all temporary structures, waste and debris and leave the premises in a condition satisfactory to Engineer-In-Charge.

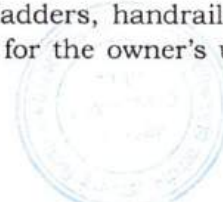
24. SAFETY

24.1. The safety precautions to be applied during the erection of the steel structures shall be in accordance with IS: 7205 and other appropriate IS standards.

- Work at Height Permit
- Hot Work Permit
- Confined Space Permit (if required)
- Crane Permit
- Daily Toolbox Talk
- PPE
- Safety Officer
- Emergency Response
- Barricading

25. INSPECTION AT SITE

25.1. After fabrication of the structures, the Contractor shall carry out inspections and checks in the presence of Engineer in order to demonstrate completeness of the works and correctness of the assembly. The Contractor, subject to Engineer's approval shall propose the inspections and checks to be carried out. In order to facilitate inspections as well as future maintenance, the structures shall be provided with steps, ladders, handrails, and other facilities at approved positions. The Contractor shall provide for the owner's use all equipment and instruments for inspection.





Udupi Cochin Shipyard Limited

TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES

UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026**26. MODE OF MEASUREMENT AND PAYMENT**

Payment shall be made based on actual quantities executed.

Item	Unit
Removal of Rail	Tonnes
Surface Preparation	m ²
Structural Steel Fabrication & Erection	Tonnes
Rail Reinstallation	Running Metres
Painting	m ²

26.1. FABRICATION

- For the purpose of payment, the weight of the actual completed structures shall be calculated from the approved shop drawings for different items of work. The Contractor shall submit to the Engineer-In-Charge relevant material list containing weight of each item.
- No allowances will be permitted for bolts, nuts, washers, studs, screws etc., galvanizing, welding or for rolling margins. One tonne for the purpose of the payment shall mean ONE METRIC TONNE i.e. 1000kg.
- The weight of a member made out of standard rolled section such as beams, channels, angles, etc. shall be based on the standard IS:808 without deductions for holes, notches, bevel cuts, etc. Where a component consists of a cut joist or channels, the full weight of the rolled section shall be considered only if more than half the depth of the original section is used. Otherwise, only half the section unit weight shall be considered for calculation of the weight of the components.
- Deductions shall be made in the weight of gussets/plates for cuts and a notch as specified in IS 1200 part 8.
- The weight of any built-up member shall be based on the weight of each component.

26.2. ERECTION WORKS

- For the purpose of payment, the weight of the actual, completed structures shall be calculated from the approved drawings for different items of work. Contractor shall submit to Employer relevant material list containing weight of each item. No allowance will be permitted for weights of rivets, bolts, washers, screws etc. in calculating the weight of the complete structure. No allowances will be permitted for galvanizing, welding or for rolling margins. One tonne for the purpose of payment shall mean ONE METRIC TONNE i.e. 1000 Kg.
- The weight of a member made out of standard rolled sections such as beams, channels, angles, etc. shall be based on the weight of the member given in IS 808, without deducting for holes, notches, bevel cuts, etc. Where a component consists of a cut joist or channel, the full weight of the rolled section shall be considered only if more than half the depth of the



Udupi Cochin Shipyard Limited

TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES

UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026

section is used. Otherwise only half the section unit weight shall be taken. Deductions shall be made in the weight of gussets/plates for skew cuts, notches and openings as specified in IS 1200 part 8.

- c. The weight of any built-up member shall be separated into the weight of each component.
- d. Erection bolts installed by contractor shall be left in position on completion of erection; however, no additional payment shall be made either for supply or use of such bolts. If erection bolts are removed after erection is complete, holes shall be plug welded and ground smooth. No extra payment shall be made for such plug welding.
- e. Erection work shall not be measured separately if erection work is already included in the scope of item of work of fabrication/erection of steel.

26.3. PAINTING

- a. Method of measurement for payment for painting shall be in sq. meters, correct to two places of decimals, if so specified, in the respective item of work.
- b. Painting work shall not be measured separately, if primer painting and/or primer and finish painting are already included in the scope of the item of work of fabrication and erection of structural steel since the rate per tonne of steel is deemed to include for painting as specified.
- c. Prior to commencement of fabrication contractor has to submit a detailed bill of material statement along with shop drawing in which item wise length, quantity, painting area shall be indicated. Fabrication has to be carried out only using shop drawing approved by Engineer-In-Charge
- d. After completion of the work as mentioned above, joint measurements shall be taken and signed by Engineer-In-Charge and Contractor for the work completed.

26.4. CONTRACTORS RESPONSIBILITY

- a. The Contractor shall execute all incidental works required for satisfactory completion of the project whether specifically mentioned in the BOQ or not.
- b. No additional payment shall be made for temporary arrangements, consumables, safety measures, handling, shifting, or any other incidental works required for completion.
- c. The Contractor shall rectify any defect arising due to defective workmanship or materials during the Defect Liability Period of twelve (12) months from the date of completion at no additional cost.
- d. Contractor shall maintain good housekeeping throughout execution. Daily removal of welding rods, scrap, bolts and debris shall be mandatory.





Udupi Cochin Shipyard Limited
TENDER FOR INSTALLATION OF EOT CRANES AT ALUMINUM FABRICATION BAY AT CSL FOR
UCSL
UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026

UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st July 2026
PRICE BID FORMAT

Sl.No	Description	Unit	Quantity	Rate	Total Amount
1	Removing the existing crane rail from top of the girder, provided at a height of 13 m above ground level, by unbolting the M16 bolts spaced at 384 mm c/c and releasing the clamps and fish plate, using suitable crane and stacking the rail, bolts and clamp at a location within 50m from site as directed by the Engineer-in-charge within CSL premises, to be reused once again excluding bolts. Rate quoted shall include all works such as providing scaffolding, unbolting and removal of bolt and clamp and fish plate and bringing down the clamps, bolts, fish plates and rail and transporting and stacking them at specified location including cost of all men, material, machinery and equipments including providing safety harness etc. all complete.	Tonne	20		
2	Cleaning and carrying out surface preparation of the area in the girder/ columns for receiving the additional flange plate in beams and web plate in column using suitable equipments and tools as described in the technical specification including cost of providing scaffolding, men, material, machinery and equipment including providing safety harness etc. all complete.	m2	290		





Udupi Cochin Shipyard Limited

TENDER FOR INSTALLATION OF EOT CRANES AT ALUMINUM FABRICATION BAY AT CSL FOR

UCSL

UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026

3	Fabricating and providing, additional flange plate at top and bottom of the existing girder, providing web plates to selected columns to augment the capacity of beam and column as per drawing and technical specifications and approved fabrication shop drawings , including providing necessary scaffolding and all necessary operations such as but not limited to preheating as per specifications, straightening, bending, cutting, punching, drilling required holes for bolting the clamps to fix rail, grinding, threading, machining if required, welding, erecting etc. complete including cleaning using wire brush, mechanical tools or by using suitable chemical methods, grinding and removing the welding burr, scales and applying one coat of approved Zinc Chromate primer as per the technical specifications and as directed by Engineer- in- Charge including providing safety harness all complete. Gas Cutter shall not be permitted to drill the required hole in the flange plate. (Fabrication drawing is to be prepared by the contractor and got approved from the Engineer-in-Charge before commencement of work)	tonne	24.33		
4	Transporting the dismantled rail and clamps stacked at the storage place and re-erecting the same at location as shown in the drawing by providing and fixing M16 bolts of suitable length and providing necessary joints to rail using fish plates including cost of all men, materials, machinery, equipments and tools including providing necessary scaffolding including providing safety harness etc. all complete	m	290		
5	Painting over fabricated structural members Application of two coats of synthetic enamel paint over one coats of zinc chromate primer of approved quality and colour, conforming to technical specification, including cost of providing scaffolding, materials, labour, other incidentals including providing safety harness etc. all complete as instructed by Engineer-in- Charge.	m2	320		
6	TOTAL AMOUNT				
7	GST				
8	GRAND TOTAL AMOUNT				



Udupi Cochin Shipyard Limited

TENDER FOR INSTALLATION OF EOT CRANES AT ALUMINUM FABRICATION BAY AT CSL FOR
UCSL
UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026

****Note:**

- i. L1 will be arrived based on the lowest total amount quoted at Sl.No.06
- ii. In the case of error in multiplication/ addition in the amount calculated, the unit rate quoted will be calculated accordingly.
- iii. The above indicative list of items along with respective quantities (not limited) shall be considered as minimum requirement for preparing the quotation, if any additional item other than those specified above is required for the satisfactory completion of project as per the scope of work shall be under scope of contractor under no extra cost.
- iv. Payment shall be done based on the actual quantity of work executed.
- v. Quotes with Conditional rates / additional charges / Conditional discounts will be disqualified.

Signature:

Address of the contractor:

Seal:



POWER OF ATTORNEY

(On Applicant's letter head)

(Date and Reference)

To
The Assistant General Manager (Contract Cell)
Udupi Cochin Shipyard Limited
Fishing Harbour complex, Malpe,
Udupi -576 108.

Subject: Power of Attorney

Mr. / Mrs. / Ms..... (Name of the Person(s)), domiciled
at(Address),
acting as..... (Designation and name of the company), and whose
signature is attested below, is hereby appointed as the Authorized Representative and authorized on
behalf of (Name of the
company) to provide information and respond to enquiries etc. as may be required by the Employer for
the project of (Project title) and is
hereby further authorized to sign and file relevant documents in respect of the above.

(Attested signature of Mr.)

For.....
(Name & designation)

(Company Seal)



UNCONDITIONAL ACCEPTANCE LETTER

(Unconditional acceptance to be given by in letter head)

ACCEPTANCE OF TENDER CONDITIONS

Tender Document no. UCSL/CC/SER/T/CSL/262-1A/2025 dated 31st August 2026 for STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES AT ALUMINIUM FABRICATION SHOP, COCHIN SHIPYARD LIMITED has been received by me/us and I/We hereby unconditionally accept the tender conditions of tender documents in its entirety for the above work.

It is further noted that it is not permissible to put any remarks/conditions in the tender enclosed in "Part-2 (price bid)". I/We agree that the tender shall be rejected and ACCEPTING AUTHORITY.

Yours faithfully,

(Signature of the tenderer) with rubber stamp

Date:



Tender No.: UCSL/CC/SER/T/CSL/262-1A/2025

Dt: 31st August 2026

UNDERTAKING BY CONTRACTOR

Name of Service: - TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES AT ALUMINIUM FABRICATION SHOP, COCHIN SHIPYARD LIMITED

1. "I / WE COMPLY WITH ALL CONDITIONS OF TENDER BY UCSL AND CONFIRM THAT RATES QUOTED IN THE PRICE BID ARE INCLUSIVE OF ALL TAXES AND DUTIES INCLUDING SERVICE TAX IF APPLICABLE. I / WE ALSO CONFIRM THAT PART - 2 (PRICE BID) DO NOT CONTAIN ANY CONDITIONS".
2. "I / WE HAVE NOT MADE ANY PAYMENT OR ILLEGAL GRATIFICATION TO ANY PERSON/AUTHORITY CONNECTED WITH THE BID PROCESS SO AS TO INFLUENCE THE BID PROCESS AND HAVE NOT COMMITTED ANY OFFENCE UNDER THE PC ACT IN CONNECTION WITH THE BID."

Signature:

Seal:

Name & address of the contractor:





Udupi Cochin Shipyard Limited
TENDER FOR STRUCTURAL STEEL STRENGTHENING WORKS FOR INSTALLATION OF TWO (02) NOS. 25 TON
ELECTRIC OVERHEAD TRAVELLING (EOT) CRANES
UCSL/CC/SER/T/CSL/262-1A/2026 Dt 31st August 2026

ANNEXURE-VII

TECHNO COMMERCIAL CHECK LIST (To be submitted by the bidder)

(Bidders may confirm acceptance of the Tender Conditions/deviations if any to be specified)

SL No.	Tender Enquiry Requirements	Confirmation from bidder (Strike off whichever is not applicable)	Specific comments /Remarks
1	Terms & conditions / Scope of work Specification (Annexure I, & II)	Agreed as per tender /Do not agree	
2	Unconditional Acceptance	Agreed as per tender /Do not agree	
3	Offer Validity (date)	01 Years - Agreed as per tender /Do not agree	
4	Taxes & Duties	Specified/included in Price	
5	Payment terms - confirm		
a	As per Clause 10 of Annexure - I	Agreed as per tender /Do not agree	
6	Price shall remain firm and fixed and No Escalation in prices after awarding of contract	Agreed as per tender /Do not agree	
7	Security Deposit	Agreed as per tender /Do not agree	
8	Performance guarantee	Agreed as per tender /Do not agree	
9	Force Majeure	Agreed as per tender /Do not agree	
10	Liquidated damages and cancellation of contract	Agreed as per tender /Do not agree	
11	Arbitration & Jurisdiction clauses	Agreed as per tender /Do not agree	
12	Confirm all other terms and conditions of our enquiry are acceptable.	Confirmed/Not confirmed	
13	Eligibility Criteria	Agreed as per tender /Do not agree	
14	Deviations from Tender conditions	No Deviations	

Signature:

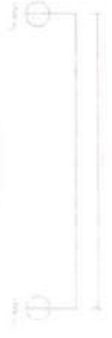
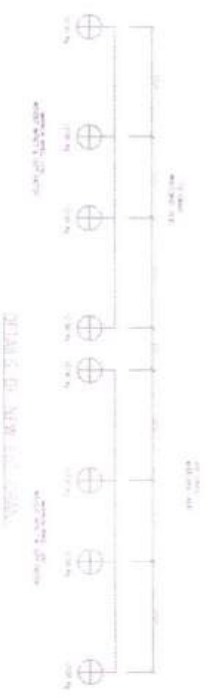
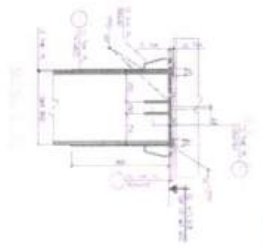
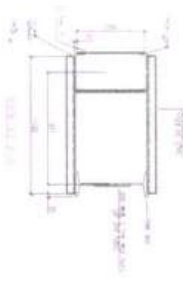
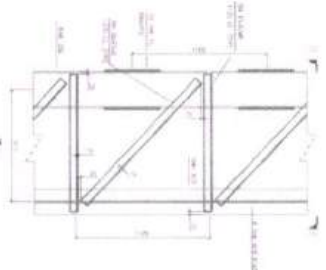
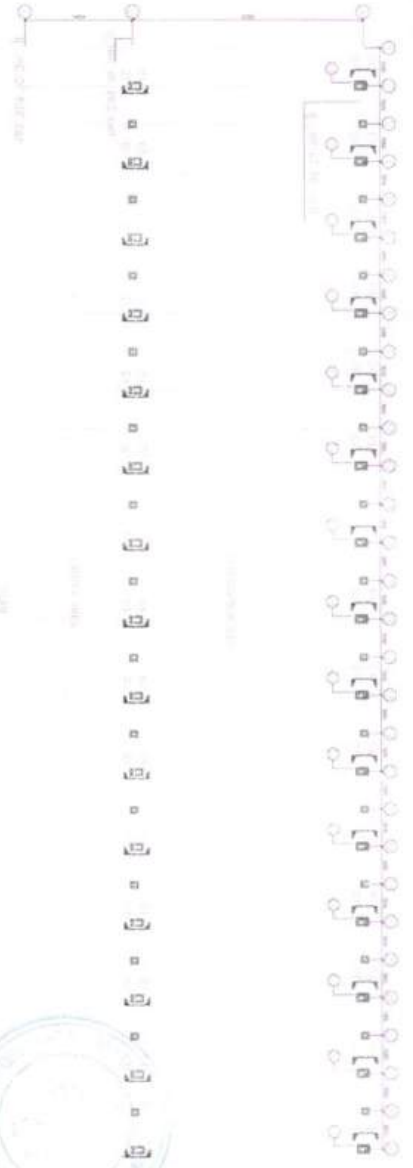
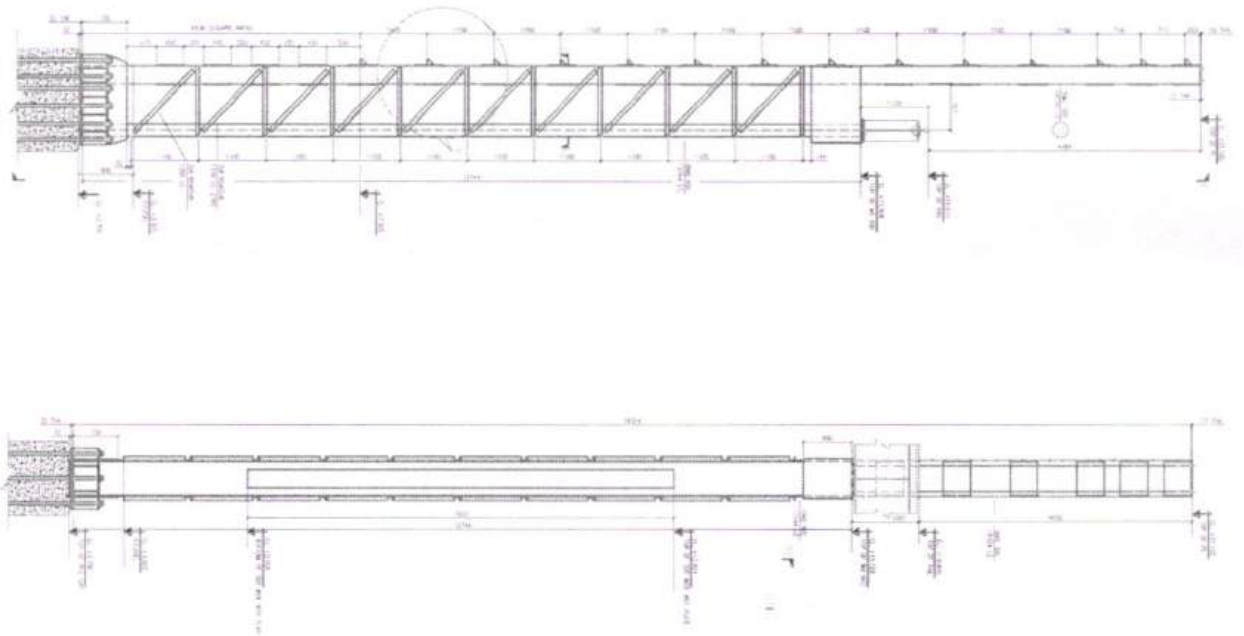
Address of the Contractor:

Seal:



[illegible]

Client	M/S COCHIN SHIPPAID LTD., Cochin - 682015			
Project	PREPARATION BAY AND SORTING AREA			
Title	Pile and Pilecap Details			
Designed	Checked	Approved	Drawn	Wapnam
			Date	23-10-07
			Scale	N T S
			Proj. No	COCHIN/10
Submitted to	(Designation)	Prof. Dr. P. K. Aravindan	Sheet No.	02



DETAILS OF FACIAD ELEVATION

NO.	REVISION	DATE	BY	CHECKED	APPROVED
1					
2					
3					
4					
5					
6					
7					
8					
9					
10					