RFQ 4113

Targeted Exterior NDE & Structural Integrity Verification of Stainless Steel Coal Silos for GREC

Q&A

Q: Is GRDA seeking Nondestructive Testing (NDT) Services or Mechanical Integrity/API Inspections?

A: NDT services so GRDA can evaluate and confirm mechanical integrity

Q: Can GRDA provide any photos?

A: No photos are available.

Q: Can GRDA provide any drawings?

A: A drawing is available that lists dimensions and material specifications for all seven coal silos. Please see included drawing with this Q&A

Q: Can GRDA provide any previous inspection history?

A: There are no previous inspection records of any Volumetric NDE on these silos.

Q: Will the parts be shipped to our laboratory for testing, or will the testing be onsite?

A: All testing will be done on site.

Q: Will GRDA extend the close date and time of this RFQ by two weeks?

A: GRDA CANNOT extend the close date of this RFQ

REV.	DATE	INIT	REV DESCRIPTION
D	10-29-82	SG	FINALISED LOCATION & SIZE OF CO2 NOZZLES, VERT SEAMS IN EACH SECT.; ADDED DET. OF WELDING IN SECT C-C'. REV. HOLE SIZE IN ANGLE AT EL-772'-7 & NOTE-12. DELETED "HOLD" FOR UPPER CONE SECT. ADDED NOTE-17.
E	11-4-82	GN	ADDED NOTE-17. SURFACE OF WELDS OR PROJECTIONS ON INSIDE OF CONE TO BE GROUND SMOOTH TO PREVENT COAL HANG UP. LAST PASS OF GRINDING TO BE IN DIRECTION OF COAL FLOW
F	11-22-82	GN	REVISED DET. 1 TO AGREE WITH GN'S ADDED BOLTS & NUTS IN DET. 4. REVISED DET. 11

NOTES

1. DO NOT SCALE THIS DRAWING. USE FIGURE DIMENSIONS ONLY.
2. ABBREVIATIONS USED ON THIS DRAWING ARE IN ACCORDANCE WITH AMERICAN STANDARD "ABBREVIATIONS FOR USE ON DRAWINGS".
3. PLATES AND STRUCTURAL STEEL SHALL BE IN ACCORDANCE WITH ASTM SPECIFICATION A-36 UNLESS OTHERWISE NOTED.
4. SILO FABRICATION TO BE PER F.W. SPEC. SECT. 30 CLASS SP PAGES 2.0 THRU 2.5
5. WELDS IN CYLINDRICAL SECTION OF SILO TO BE UNGROUND. VERTICAL WELDS IN CONICAL HOPPER TO BE GROUND FLUSH WITH PLATE SURFACE. HORIZONTAL WELDS IN HOPPER AND WELD AT JUNCTION OF HOPPER AND CYLINDRICAL SHELL AND OUTLET TO BE GROUND FLUSH AND POLISHED TO MATCH FINISH ON HOPPER PLATES.
6. WELDING ELECTRODES FOR S.S. TO S.S. SHALL BE AWS A5.4 TYPE E 308, S.S. TO C.S. SHALL BE E309.
7. ALL CARBON STEEL COMPONENTS TO BE PAINTED WITH CARBO-ZINC-11.
8. ALL BUTT WELDS FOR SILOS SHALL HAVE ROOT OF INITIAL WELD BACK GOUGED OR CHIPPED TO SOUND METAL BEFORE WELDING ON BACK FACE.
9. CURVED PLATES AND STRUCTURAL MEMBERS SHALL BE FORMED TO PROPER SHAPE BY PRESSURE NOT BY BLOWS.
10. SPACE BETWEEN TOP OF SILO AND CONCRETE FLOOR TO BE SEALED BY OTHERS.
11. ALL MATERIALS FOR ERECTION AND ALIGNMENT (CLIPS, JACKS, ETC.) TO BE FURNISHED BY ERECTOR.
12. LOCATION OF FIELD WELDS TO BE ESTABLISHED BY VENDOR TO GIVE MINIMUM LENGTH OF FIELD WELD CONSISTENT WITH SHIPPING LIMITATIONS.
13. SURFACE OF INSIDE OF HOPPER TO BE FINISHED TO A VISUAL APPEARANCE AND SURFACE ROUGHNESS EQUIVALENT TO A 2B (COLD ROLLED, BRIGHT) FINISH. PLATE SURFACE TO BE PROTECTED DURING HANDLING, FORMING AND SHIPMENT TO FIELD. LIFTING LUGS TO BE PROVIDED ON HOPPER SECTIONS ONLY FOR ERECTION.
14. USE JACKING PAD ① & ② TO JACK UP SUPPT. [A], JACKING PAD ② & ③ TO JACK UP SUPPT. [B], JACKING PAD ③ & ④ TO JACK UP SUPPT [C] AND JACKING PAD ④ & ① TO JACK UP SUPPT. [D]
15. ALL BOLTS, NUTS & WASHERS SUPPLIED BY SILO FABRICATOR
16. FILL THE GAP WITH ST. STL WELD METAL. FINISH THE HORIZONTAL ST. STL WELD A 2B FINISH IN HOPPER SEC. ONLY.

REFERENCE DRAWINGS

COAL SILO DETAILS 79-4105-5-381

REV.	DATE	INIT	DESCRIPTION
C	7-19-83	SG	FINALISED LOCATION OF POKE HOLES ADDED 1/2" THK ST. STL LINER TO HOPPER SECTION, DET-9, DET-10. NOTE 15 & 16, DET. 11 REV. DET-4, DET-6 & SEC B-B HOPPER SECTION WAS 5/16 THK.
B	6-4-82	AP	ADDED NOTE 14, VERTICAL FIELD SEAMS NOTE, SECTION A-A' & B-B' ROTATED 22½°. ADDED DET 8, WELD SEAMS IN SECT. B-B' (EXCLUDING STIFFENER IN SECT. B-B'). REV. DET 6 & 7 TWO LEFT HAND TWISTED, NO. OF JACKING PADS IN SECT. A-A' - WAS (8)
A	4-21-82	BN	FIRST ISSUE

REVISIONS

ACCEPTED FOR RECORD
REJECTED FOR RECORD - PLEASE RESUBMIT
ONTARIO HYDRO POWER GROUP
BY
DATE 1-8-88

NO EXCEPTIONS TAKEN — REJECTED
CORRECT AS NOTED & SUBMIT CORRECTED COPIES
RECEIVED FOR INFORMATION ONLY

Corrections or comments made on the shop drawings during this review do not relieve contractor from compliance with requirements of the drawings and specifications. This check is only for review of general conformance with the design concept of the project and general compliance with the information given in the contract documents. The contractor is responsible for confirming and correlating all quantities and dimensions; selecting fabrication processes and techniques of construction; coordinating his work with that of all other trades; and performing his work in a safe and satisfactory manner.

BENHAM-HOLWAY POWER GROUP
BY
DATE

V 0222
11 80 032 01

COAL SILO
GENERAL ARRANGEMENT
BV 0222
GRAND RIVER DAM AUTHORITY
GRDA NO. 2
CONTRACT NO. 1
FWEC CONTRACT 2-79-4105

DRAWING NUMBER	SCALE	REVISION
79-4105-5-380	NONE 1:1-0	E

DRAWN BY	JW	4-6-82	2-79-4105
CHECKED BY	RSam	11-21-82	
APPROVED BY	DPMac	11-1-82	

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1180-032-01-V222

FORM 152-3850

BRUNING 44-231 28990-1

TYPICAL TOP FLG PUNCHING FOR SILO SUPPORTS AT ELEV 725'-8⅜

SECTION "A-A"

DETAIL-1
TYPICAL WELDING FOR HORIZONTAL & VERTICAL SEAMS FOR CYL

DET-10
TYP PLUG WELDING DET FOR S.S LINING

DET. 11

SECTION "B-B"
TYPICAL ELEVATION

DETAIL 8

DETAIL #4

SECTION "C-C"

SECTION "D-D"

DETAIL 3

DET-9

DET-3

HORIZONTAL & VERTICAL WELDS IN HOPPER

KEY PLAN

SECTION "E-E"

DETAIL #5

DETAIL #6 (SEE KEY PLAN)
(4) REQD PER SILO

DETAIL #7 (SEE KEY PLAN)
(4) REQD PER SILO

DETAIL #2

SHIMS PACK
(8) REQD PER SILO
MADE-UP OF THE FOLLOWING THKNS
(1) 1/2" → C9F
(2) 1/4" → C9E
(2) 1/8" → C9D
(2) 1/16" → C9C