



PHILIPPINE
PORTS
AUTHORITY



SUPPLEMENTAL/BID BULLETIN NO. 1 **BAGONG PILIPINAS**

SAN JOSE (DINAGAT) PORT EXPANSION PROJECT, PORT OF SAN JOSE, PROVINCE OF DINAGAT ISLANDS

TO : All Prospective Bidders
: Members, HO-BAC-EP
: Others Concerned

Relative to the Bid Documents posted in the PPA and PhilGEPS websites on 28 December 2024 for the above project, please be informed of the following amendments thereto, as follows:

I. ON THE TECHNICAL SPECIFICATIONS (PILING WORKS – SPSP)

ITEM 03 : PILING WORKS (STEEL PIPE SHEET PILE)

SCOPE OF WORK

This section covers the minimum requirements for the fabrication, hauling, spotting, driving and finishing of all interconnected tubular piles to be used as containment and berthing wall/wharf.

The Contractor may however, adopt, in addition to these minimum requirements additional provisions as may be necessary to ensure the successful prosecution of the work related to the said undertaking.

METHOD STATEMENT

Before the commencement of any piling works, the Contractor shall submit (allowing sufficient time for consideration) to the Engineer for approval a Safety Policy and a Method Statement which shall include the following information:

1. Program of Works detailing sequence and timing of individual portions of works.
2. Maximum proposed lead at any stage of driving between a pile and its neighbor and the limitations of same if hard driving is encountered.
3. Contingency plan in the event of encountering obstructions or reaching driving refusal to minimize disruption/delay especially when using pitch and drive methods.

MATERIAL REQUIREMENTS

STEEL PIPE PILES

Steel tubular piles required under this heading may either be fluted or plain, tapered or cylindrical, seamless or welded type or as indicated in the drawing conforming to the requirements of ASTM A 252, equal or better. Minimum shell thickness shall be as indicated in the drawings.

Steel sheet piles shall be of the type indicated on the drawings with continuous interlock. The sections and grade of steel shall be as shown on the drawings or approved equivalent. All steel sheet piles shall conform to ASTM A 328 or approved equivalent.

Tubular Pipe – ASTM 252 Grade 2, $f_y = 240\text{MPa}$, $f_s = 414\text{MPa}$
Interlock – ASTM 572 Grade 50/ S355, $f_y = 355\text{MPa}$, $f_s = 450\text{MPa}$

CONCRETE AND REINFORCEMENT WORKS

Concrete and reinforcement work for filler of steel pipe piles, concrete jacket and pile cap shall be in accordance with the Section "Reinforced Concrete" where the compressive strength at 28 days shall be 24 mpa (3,500 psi).

TIE - RODS, WAILING and FITTINGS

All components of tie-rod assemblies to be supplied, assembled and installed by the Contractor shall be in accordance with the applicable requirements of the ASTM standards. The tie-rods shall have upset treaded ends and the minimum yield point shall be as shown on the drawings.

Structural steel shapes for wailings shall be supplied, fabricated, assembled and installed by the Contractor as shown on the drawings. The sections and grade of steel shall be as shown on the drawings or approved equivalent.

Bolts for assembly of structural steel wailings and for connections or special sections shall conform to ASTM A 36, A 325, and ASTM A 307 and or as specified on the Drawings.

SAND FILLER

The filler materials shall be fine aggregates with the same requirements as in "Reinforced Concrete Aggregates". The volume shall be in accordance with the approved drawings and sounding conducted in site.

PROTECTIVE COATING

GENERAL

The following abbreviations and definition of terms are used in this Specification:

DFT	Dry Film Thickness
ISO	International Organization for Standardization
NACE	National Association of Corrosion Engineers
SSPC	Steel Structures Painting Council
μm	Micron
WFT	Wet Film Thickness

Definition of Terms

Company Representative	A duly appointed representative of the facility owner
"Shall"	A mandatory requirement of compliance
Spot Blast	Blasting operations carried out to remove localized corrosion, or damage, to otherwise sound coatings
Stripe Coat	Brush applied coating, usually to edges, welds, and other areas susceptible to coating breakdown
Substrate	Base material over which a protective coating is applied
Whip Blast	Light blasting carried out to abrade a surface, with minimal removal of substrate

CODES, STANDARDS AND TEST METHODS

Materials and workmanship shall comply with any requirements of any Acts or Regulations of any Statutory Authority having jurisdiction over the works. Occupational Health & Safety and Environmental legislations relevant to the works must be adhered to.

Unless noted otherwise, all works shall be performed in accordance with the current version of the relevant global standard / test method (including ASTM, ISO, NACE & SSPC), including (but not limited to) those listed below:

ASTM D4285	Indicating Oil or Water in Compressed Air
ISO 8501	Preparation of steel substrates before application of paints and related products – Visual assessment of surface cleanliness
ISO 8502	Preparation of steel substrates before application of paints and related products – Tests for the assessment of surface cleanliness
ISO 8503	Preparation of steel substrates before application of paints and related products – Surface roughness characteristics of blast-cleaned steel substrates
ISO 8504	Preparation of steel substrates before application of paints and related products – Surface preparation methods
ISO 9000 Series	Quality Management Systems Series
NACE SP0188	Discontinuity (Holiday) Testing of New Protective Coatings on Conductive Substrates
SSPC-SP1	Steel Structures Painting Council (SSPC) – Solvent cleaning
SSPC-SP6	Commercial Blast Cleaning
SSPC-SP10	Steel Structures Painting Council (SSPC) – Near-white blast cleaning
SSPC Vis 1	Steel Structures Painting Council (SSPC) – Visual standard for abrasive blast cleaned steel

WORKMANSHIP

Application

All surface preparation and coating application activities shall be carried out by suitably trained operators, preferably with a minimum of two years' practical experience with these tasks.

The Contractor shall ensure that the supervision of application staff and all quality inspections are carried out by a suitably qualified specialist with a minimum of 3 years industry experience.

Quality Assurance

The Contractor shall compile appropriate Inspection & Test Plans for each part of the surface preparation and coating application works. These shall be submitted to the Company Representative for approval prior to the works commencing.

The Company Representative reserves the right to appoint a third party to conduct quality inspections of the coatings applied under this Specification. These inspections are in addition to those required by the Contractor. These inspections do not remove any of the Contractor's obligations under this Specification.

Non Conformances

Any work which does not conform to the requirements of this Specification shall be repaired to the satisfaction of the Company Representative. Such work may include complete removal of the non-conforming coating, surface preparation and application of the new coating system.

Such rectification work will be at the expense of the Contractor.

Work Method

Where possible, surface preparation and coating application shall be performed when all fabrication, including attachment of secondary steelwork and brackets, is complete. Where this is not possible, work method and inspection must ensure all exposed surfaces are treated in accordance with this specification.

Surfaces which are not to be painted shall be protected from damage and overspray. These surfaces include, but are not limited to:

- Stainless steel
- Machined surfaces
- Gauge faces

Access to the Work Surfaces

Access to the work surface must be suitable so as to allow full and proper treatment of all surfaces to be coated under this specification. Scaffolding, if necessary, shall be erected in accordance with local legislative requirements. Care shall be taken to minimize damage to coated surfaces during manipulation of scaffolding / access equipment. Any damage to the applied coating shall be repaired to the full requirement of this specification.

Protection of Environment

All work carried out under this specification shall be performed in accordance with local legislative and site specific requirements. Care shall be taken to eliminate impact on adjacent

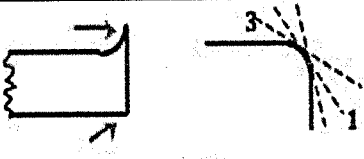
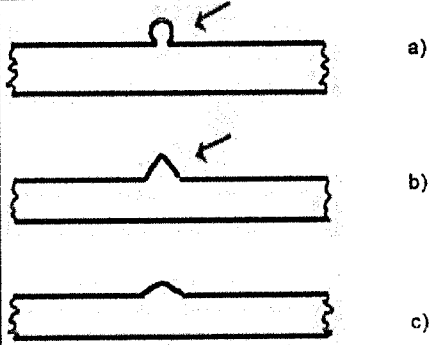
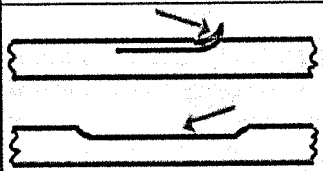
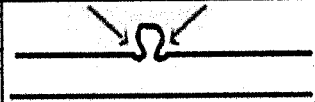
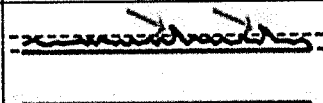
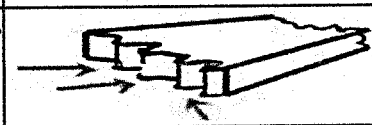
work areas from noise, dust, overspray and other activities. Paint, thinners, rags, empty paint cans and other refuse generated shall be disposed of thoughtfully and in accordance with local legislative requirements.

SURFACE PREPARATION

General

Prior to surface preparation activities, the steel surface to be coated shall be thoroughly cleaned to remove all oil, grease, fats, drilling and cutting compounds, and other contaminants in accordance with ISO 8504, or SSPC-SP1. Soluble salts shall be removed by thorough water washing. Where a chloride level of greater than 50 mg/m² (or less if recommended by the protective treatment supplier) as determined by ISO 8502, the substrate shall be wet abrasive blasted, high-pressure water jetted, or otherwise washed, and then reblasted. The substrate shall then be retested for chloride salt contamination, and the cleaning / reblasting process shall be repeated until the chloride level is shown to be less than the required value.

All sharp edges, corners, holes, feathering at saw cuts, or sharp irregularities shall be ground to a minimum radius of 2.0mm, where specified on the project engineering drawing. Burrs, surface shell, slag, weld spatter and other surface defects such as cracks, laminations and slag inclusions shall be repaired before the commencement of blast cleaning activities. Temporary welds shall be ground to a flush finish. Weld porosity and associated defects shall be removed by grinding and repaired/filled with weld. Please see table below for surface imperfections.

SHARP EDGE	Edges should be treated to a rounded radius of minimum 2mm, or subjected to three pass grinding or equivalent.	
WELD SPATTER	<ol style="list-style-type: none"> 1. Remove spatter observed before blasting by grinder, chipping hammer etc. 2. For spatter observed after blasting: <ol style="list-style-type: none"> a) Remove with chipping hammer/scrapper etc. b) Where spatter is sharp, use disc sander or grinder until obtuse c) Obtuse spatter - no treatment required 	
PLATE LAMINATION	Any lamination to be removed by grinder or disc sander	
UNDERCUT	Where undercut is to a depth exceeding 1mm and a width smaller than the depth, repair by welding or grinding may be necessary	
MANUAL WELD	For welding bead with surface irregularity or with excessive sharp edges, remove by disc sander or grinder	
GAS CUT SURFACE	For surfaces of excessive irregularity, remove by disc sander or grinder	

Abrasive Blast Cleaning

Blast cleaning operators shall wear approved safety clothes and equipment at all times during the blast cleaning process. Helmets shall meet all required statutory requirements and guidelines.

Work shall NOT be performed in the following circumstances:

- When the relative humidity of the surrounding air is above 85%.

Unless otherwise stated herein, all surfaces to be coated shall be abrasive blast cleaned to Sa2½ (in accordance with ISO 8501-1); or in accordance with SSPC-SP10.

Unless otherwise stated herein, a surface profile of 50-75 microns (2 - 3 mil) shall be achieved as measured by ISO 8503. The resultant surface shall have a sharp angular profile.

The use of silica sand, flint, or ilmenite abrasives shall NOT be permitted. Steel shot alone shall not be used but a mix of steel shot and grit may be used.

The type and size of abrasive, the equipment and the procedure adopted shall be chosen to ensure the required degree of cleanliness and surface profile is achieved. The blasting medium

shall be free of organic material and shall have a chloride salt content not greater than 50 ppm. The compressed air supply used for blasting shall be completely free of water and oil. The design of the compressed air system shall incorporate the appropriate number of serviceable in-line separators and traps which shall be cleaned and drained on a regular basis.

Care shall be exercised to ensure spent blast media does not impinge onto soft or freshly applied coating when blast cleaning in close proximities (e.g. on-site repair).

Welding spatter, slivers, surface shell, cracks, lamination, deep pitting and other surface defects detrimental to the performance of the protective coating system exposed by the blast cleaning process shall be removed by grinding or other approved method. Where necessary these defects shall be welded closed after grinding, and the repair ground to blend in with the adjacent surface. The repair area shall be re-blasted to re-establish the correct surface condition.

Immediately after completion of the blast cleaning process, the surface shall be dusted, vacuumed or blown down with clean dry compressed air to remove spent abrasive. Special attention shall be given to corners, intersects and horizontal areas where settlement of dust is likely to occur.

Where site abrasive blasting is required over water, preventative measures shall be employed to protect the environment from contamination by spent abrasive and blast debris. All used blast materials shall be disposed off-site in a statutory approved dumping facility.

Power Tool Cleaning (for small areas/ repair only)

Power Tool cleaning operators shall wear approved safety clothes and equipment at all times during the power tool cleaning process.

Work shall NOT be performed in the following circumstances:

- If the surface is wet, or likely to become wet after power tool and before primer application.
- On surface where the formation of condensation is likely i.e. where the surface temperature of steel is less than 3°C above dew point.
- When the relative humidity of the surrounding air is above 85%.

Unless otherwise stated herein, all carbon steel surfaces shall be power tool cleaned using an orbital sander with cup brush followed with disc sanding pad (flap disc) having grit size ideally ranging from 80- 120, to create profile (roughness). Care should be exercised so as to not over grind the carbon steel. The objective is to leave the metal bare and generate surface profile. A bare metal power-tool cleaned surface, when viewed without magnification, shall be free of all visible oil, grease, dirt, rust, coating, oxides, mill scale, corrosion products, and other foreign material. Slight residues of rust and coating are permitted to remain in the lower portions of pits if the original surface is pitted. Acceptable variations in appearance that do not affect surface cleanliness as defined earlier include variations caused by type of steel, original surface condition, thickness of the steel, weld metal, mill or fabrication marks, heat treating, heat-affected zones, or the texture/features associated with the use of a particular power tool.

Immediately after completion of the power tool cleaning process, the surface shall be dusted, vacuumed or blown down with clean dry compressed air to remove debris from removed coatings, corrosion etc. Special attention shall be given to corners, intersects and horizontal areas where settlement of dust is likely to occur.

Care of Prepared Surfaces

The application of the prime coat to the prepared surface shall commence within four (4) hours of the commencement of the blasting process, and before any deterioration of the prepared surface occurs. The time lapse between blasting and primer application shall be recorded on the Contractor's Inspection report forms.

Blast cleaned surfaces shall be kept free of any contamination and shall not be touched by bare hands or contaminated gloves.

Any prepared surface which becomes contaminated shall be re-blasted to the specified visual condition above.

APPLICATION OF COATINGS

General

Coating application operators shall wear approved safety clothes and equipment at all times during the blast cleaning process. Respirators and associated equipment shall meet all required statutory requirements and guidelines.

Work shall NOT be performed in the following circumstances:

- If the surface is wet, or likely to become wet after blasting and before primer application.
- On surface where the formation of condensation is likely i.e. where the surface temperature of steel is less than 3°C above dew point.
- When the relative humidity of the surrounding air is above 85%.
- When the ambient temperature, or the surface temperature, exceeds 50°C or is less than 5°C.

Immediately prior to paint application, the surface shall be dusted, vacuumed or blown down with clean dry compressed air to remove spent abrasive. Special attention shall be given to intersects and horizontal areas where settlement of dust is likely to occur.

Each coat shall be free of sags, runs, mud cracking, wrinkling, fat edges, blisters, pinholes, holidays, dry spray, entrapped foreign bodies, heavy brush marks and other similar defects consistent with a finish for industrial applications. Prior to the commencement of work, the Contractor shall produce a "reference area" for approval by the Company Representative. The reference area shall be representative of the type of surfaces being treated. Once approved by the Company Representative the reference area shall be used to determine acceptable finish quality.

All ventilation equipment required during application shall be left operating until cure of the applied coating is achieved.

Adhesion of all coats shall be sound throughout. Coatings with poor adhesion shall be removed and re-instated at the cost of the Contractor.

The Contractor acknowledges that variations in weather conditions affects minimum and maximum recoat times of coating material, and that this is taken into account when planning coating operations.

Materials

All primers and final coat shall be of the approved make, type and colour. All coats in the system applied shall be from coating manufacturer only.

Where two component paint is used, it shall be mixed at the site of application in the manner prescribed by the coating manufacturer. Mixed paint remaining unused after the coating manufacturer's prescribed pot life shall be discarded and removed from the site of application.

All colouring or tinting of paint shall be performed by the coating manufacturer.

Stripe Coating

All external edges shall be stripe coated (either spray or brush) prior to spray application of the full coat. All welds, crevices, holes, corners, and other difficult access areas shall be stripe coated by brush painted prior to spray application of the full coat. All nuts and bolts which have been specified to be painted, or which the Company Representative has instructed to be painted, shall be brush painted prior to spray application of the full coat. This process shall be repeated where necessary to ensure the correct film thickness is achieved over these areas.

Brush and Roller Application

Application by brush or roller shall be limited to small areas only. Multiple application of each coat in the system will be required to achieve the required dry film thickness. A uniform method of application shall be adopted when painting large areas. The application direction shall be towards already painted areas so as to maintain a wet edge and minimize paint joint buildup.

The paint shall be spread evenly over the entire area with the minimum practical amount of brushing. The method of application and type of brush used shall be suitable to the paint specified and the surface being painted.

The method of "laying off" shall be suitable to the paint specified and shall be executed with the minimum amount of brush marking.

Measurement of Film Thickness

Irrespective of the method of application, the Contractor shall ensure that frequent measurements of wet film thickness are taken throughout the application process. An approved wet film gauge shall be used. The level of thinner additional shall be taken into account when measuring wet film thickness to ensure the correct dry film thickness is achieved.

After each coating has cured, the dry film thickness shall be tested and recorded by the Contractor. Inspection regime and acceptance of results shall be in accordance with ISO 2808.

The minimum dry film thickness considered acceptable is that specified within the given coating system, where the measurement has been determined according to the rules in ISO 2808.

The maximum dry film thickness considered acceptable is dependent on products and systems being applied, and should be determined in consultation with the coating manufacturer.

Multiple Coat Applications

The existing surface shall be treated in accordance with Section General of the Application of Coatings of this Specification. Ensure the previously coated surface is free of water, moisture, dust and dirt immediately prior to application of the successive coat.

Successive coats shall be applied only under the following conditions:

- The surface is clean and dry.

- The coating manufacturer's stated minimum recoat time has elapsed, and the maximum recoat time has not been exceeded. If the maximum recoat time has been exceeded, then pre-treatment of the surface shall be in accordance with the coating manufacturer's recommendation.

- Damaged and non-conforming areas in the previous coating have been made good.

Transport and Handling

Particular care shall be taken to avoid damage to coatings in handling and transport. Coated items shall not be handled until the coating has cured in accordance with the manufacturer's instructions. Coated items shall be handled and transported in a manner that will not chip, abrade or otherwise damage the finished coatings. All slings, lifting devices, dunnage, packing, tie-downs, and the like, shall be of a type that is designed to achieve this end.

No sign writing, stenciling, or marking whatsoever shall be applied to painted surfaces of plant, machinery and equipment unless specifically approved by the Company Representative. Such markings shall be compatible with the specified coating system.

Rectification and Touch-up Painting

Surfaces where the paint coating has been damaged or marked in any way shall be touched up or repainted in accordance with the coating manufacturer's instructions, this Specification, and as otherwise approved by the Company Representative. Repairs performed after installation require special attention to ensure blast media, paint overspray, fumes and other contaminants, do not affect adjacent work areas.

The treatment shall be:

- Pre-clean the damaged area in accordance with Section General of Surface Preparation on this Specification.
- Remove the damaged coating back to a sound adherent surface in accordance with Section Abrasive Blast Cleaning of Surface Preparation on this Specification.
- Spot abrasive blast clean the damaged area
- Feather back the repair area by a minimum 50mm overlap by sanding or sweep blasting.
- Clean surface to remove dust.
- Build up the repair area using the same type of paints and same dry film thickness as were originally specified in the appropriate section of this Specification.

INSPECTION AND TESTING

Initial Inspection

The procedure associated with the surface preparation and application of each coating shall, in the first instance, be carried out in the presence of the Contractor's site supervisor, the Company Representative or any other technical representative.

Once the procedure for each stage of the operation has been witnessed and approved, these procedures shall then apply to all similar operations unless subsequently varied by the Company Representative. Work subsequently identified as being carried out using procedures not previously approved shall be rejected or improved at the sole discretion of the Company Representative.

The Contractor shall give the Company Representative a minimum of five (5) working days' notice of the intention to paint the steel work.

Contractor Inspection

The Contractor shall ensure that all work is inspected and appropriate testing carried out progressively to ensure that it is in accordance with the specified requirements. Inspection and testing records shall be maintained on a daily basis. As a minimum, these reports shall include appropriate information concerning the following:

- Job identification;
- Surface preparation performed and equipment used;
- Surface profile measurement;
- Coating applied and equipment used;
- Material used, batch number, colour, mix ratio and thinner;
- Application details including which coat was applied, wet film thickness and dry film thickness of each coat;
- Weather conditions including air temperature, surface temperature, relative humidity, dew point, wind conditions and general weather conditions. These measurements shall be taken immediately prior to surface preparation and application work, and then every four (4) hours, or whenever a change in the weather conditions is apparent.

Inspection & Test Plans (ITP) shall be compiled and submitted to the Company Representative prior to any work commencing. In addition, the Contractors facility and inspection records shall be made available to the Company Representative for inspection of the works at any time during the performance of the contract.

Inspection by Company Representative

Steelwork will be inspected by the Company Representative at each stage of the coating operation in this case, after surface preparation, prior to application of each coat, and following final topcoat application. Additional inspection will also be conducted after any touch up coats that may be required.

The Company Representative may, at their discretion, vary the frequency of inspection. This may involve the waiver of inspection for a specific step in the operation. Such a waiver shall not be deemed as the precedent to determine the frequency of any future inspection.

Inspection performed by the Company Representative, as well as any waiver of inspection, shall not relieve the Contractor of the obligation to perform their own supervision and inspection of surface preparation and coating application operations as required by this Specification.

Test Methods

The following, but not limited to, test methods shall be used for inspection of the surface preparation and coating application operations:

Compressed Air Quality

Prior to using compressed air, the quality of air downstream of the separator shall be tested in accordance with ASTM D4285. The test shall be performed at the beginning of each shift and at four (4) hourly intervals. The test also shall be made after any interruption of the air compressor operation or as required by the Company Representative. The air shall be used only if the blotter test indicates no visible contamination, oil, or moisture. If contaminants are evident, the equipment deficiencies shall be corrected and the air stream shall be retested. Separators shall be bled continuously. All lines shall be tested individually prior to use. Surfaces which are determined to have been blasted, blown down, or applied using

contaminated air shall be re- cleaned to remove oil, grease, and contaminants and new coatings applied using clean air.

Surface Profile

Surface profile shall be tested after every blasting operation. Surface profile shall be measured in accordance with ISO 8503. The tape shall be included in the test reports for future reference.

Salt Contamination Test (Surface)

Surface Salt Contamination Test on surface shall be tested after every blasting operation. Test method in accordance with ISO 8502-6 and 9 results shall be recorded, value shall be 10 micrograms/cm² or below.

Dust Assessment Test

Dust contamination on substrate prior to application of primer and subsequent coats shall be tested in accordance with ISO8502-3, dust quantity must be less than or equal to Class 2 of ISO 8502-3 Dust Quantity Rating. Test results shall be included in the test reports for future reference.

Wet Film Thickness

Wet film thickness shall be tested during the application operation of all coats in any given coating system. Wet film thickness shall be measured in accordance with ISO 2808.

Dry Film Thickness

Dry film thickness shall be tested following application of each coat within the system, and following application of the final coat. Dry film thickness shall be measured in accordance with ISO 2808. An electronic gauge (Elcometer 345 or similar) shall be used. Calibration of the gauge shall be performed weekly or as required using certified calibration plates. Refer Section 8.6 for acceptance criteria details.

Continuity "Holiday" Testing

Steelwork shall be fully tested for holidays and pinholes. Since thickness is more than 500 microns, High Voltage (Spark) Holiday Test based on NACE SP0188-2006 Discontinuity (Holiday) Testing of New Protective Coatings on Conductive Substrates shall be used.

PROTECTIVE COATING SYSTEMS

	Product Name	Coat Type	Site OR Shop	Application Method	VS %	WFT micron	DFT micron	TSR*1 m ² /l	Overcoating interval at 25C Min - Max	Pot Life at 25C	Thinner
1	Interzone 954 Subsea, Abrasion Resistant and Splash Zone - Modified Epoxy	Full Coat	Shop/site	Airless Spray, Brush, Roller	85	471	400	1.7	5.5 Hr - 7 D	45 Min	GTA220
2	Interzone 954 Subsea, Abrasion Resistant and Splash Zone - Modified Epoxy	Full Coat	Shop/site	Airless Spray, Brush, Roller	85	471	400	1.7	5.5 Hr - 7 D	45 Min	GTA220
							800				

TSR*1 – Theoretical Spreading Rate

WELDING REQUIREMENTS

The welding material used for the production of steel piles by circumferential welding of steel pile or in the attachment of accessories shall have a tensile strength not less than the following test standards.

- JIS Z 3211 - Covered Electrodes for Mild Steel
- JIS Z 3213 - Covered Electrodes for High Tensile Strength Steel
- JIS Z 3312 - MAG Welding Solid Wires for Mild
- JIS Z 3313 - Flux Cored Wives for Gas Shielded and self-shielded Metal Arc Welding of Mild Steel, High Strength Steel and Low Temperature Service Steel
- JIS Z 3352 - Submerged Arc Welding Fluxes for Carbon Steel and Low Alloy Steel

EXECUTION

MARKING

The pile shall be marked on with durable paint indicating:

1. Serial Number, marked close to both ends
2. Date of Arrival, marked same as (1)
3. Length of pile, marked same as (1)
4. Meters mark in two faces, throughout the length

DOCUMENTS TO BE SUBMITTED

1. Steel Pipe manufacturing plan (Steel pipe production plan, welding method, welding material, production location, production method, transportation, etc.)

2. Design plan
3. Manufacturing process
4. Shipment method and stacking plan
5. Steel pipe inspection certificate
6. Size inspection record
7. Radiographic Test record

STEEL PIPE PILES

The Contractor shall submit to the Engineer three (3) copies of test reports by the approved steel mill certifying that the steel pipe pile meets the requirements specified in these technical specifications.

REINFORCED CONCRETE

The requirements regarding testing of concrete and reinforcement used in the reinforced concrete piles and sheet piles shall be in accordance with Section "Reinforced Concrete".

SAND FILLER

The requirement regarding testing of fine aggregates shall be used.

STORAGE AND HANDLING

1. Piles may be stored in open air but on wooden sleepers to be placed in a manner so as not to cause excessive bending.
2. Piles shall be stacked on a stable yard and shall not be stacked more than three (3) tiers high.
3. All piles shall be carefully lifted at the location of the lifting points as indicated in the Drawings. Other practical and convenient methods may be used subject to the approval of the Engineer.

DRIVING OF PILES

A diesel or hydraulic pile hammer shall be used for driving the steel pipe piles.

The required weight of ram for the diesel or hydraulic pile hammer ranges from 2.5 to 3.5 tons or at least 25% (1/4) of the weight of longest pile.

Piles driven shall be held firmly in position in axial alignment with the hammer by means of leads of adequate length. Approved cushions shall be provided to the pile butts.

BEARING POWER OF PILES

Each pile shall be driven to attain not less than the required minimum bearing power shown in the pile schedule, as determined by the Hiley's Formula as follows:

For Diesel Pile Hammer :
$$R = \frac{1}{6} \times \frac{2WH}{S + 2.54}$$

where : R = allowable bearing capacity of pile (tf)

W = weight of ram (tf)

H = fall of ram (cm)

S = set (cm)

DRIVING RECORDS

The Contractor shall keep complete and accurate piling records. Two (2) signed copies of these records shall be submitted to the Engineer not more than 48 hours from the date of works detailed therein. The pile records shall always be submitted with sufficient time for the Engineer's approval.

The records shall contain the following information:

1. Pile reference number
2. Pile type and Steel Grade
3. Pile Length
4. Commencing surface level and final toe level
5. Depth driven, time, date when piles were driven
6. Where required the number of blows to drive each 250 mm over the last 2.5 meter shall be recorded
7. Comments regarding unusual/unexpected driving conditions

INTERRUPTED DRIVING

When driving is stopped before final penetration is reached and/or refusal is attained, the record of pile penetration shall be taken only after a minimum of 30 cm. (12 in.) total penetration has been obtained on resumption of driving.

ALIGNMENT TOLERANCE

Piles driven shall be within the allowable tolerance in alignment of 10 cm. (4 in.) in any direction.

DAMAGED AND MISDRIVEN PILES

1. Piles shall not be more than 10 cm. (4 in.) out of place at cut-off level. All steel pipe piles shall not be more than 2% out of plumb.

2. Any pile damaged by improper driving or driven out of its proper location, or driven out of elevation fixed on the plans, shall be corrected correspondingly at the Contractor's expense by any of the following methods:
 - a. Withdrawal of the pile and replacement by a new pile.
 - b. Driving a second pile adjacent to the defective one.
 - c. Splicing an additional length.

The method to be adopted in each case shall be at the discretion of the Engineer.

EXTRACTION OF SEABED MATERIALS FROM DRIVEN PILES

Extraction of seabed materials, if necessary, shall be in accordance to the required elevations and sections in conformance to the drawings.

All extracted materials shall be disposed in the location approved by the Engineer in coordination with the authority.

II. ON THE BILL OF QUANTITIES

BILL NO. 3 CONSTRUCTION OF PORT OPERATIONAL AREA

xxx xxx xxx

- 3.02 Supply and apply high-build epoxy protective coating steel sheet piles (Abrasion Resistant Modified Epoxy With $\geq 85\%$ Volume Solid, Min. Dry Film Thickness = 800 Microns

III. ON BQ-17

BOQ AND ATTACHMENTS

Annex 4 – Construction Safety and Health Requirements

xxx xxx xxx

EQUIPMENT/MATERIALS

Personnel Protective Equipment

xxx xxx xxx

55 pairs Safety Shoes

xxx xxx xxx

**IV. ON BIDDING FORMS
(Const. Methodology)**

CONSTRUCTION METHODOLOGY

XXX XXX XXX

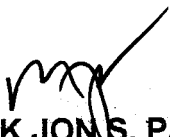
B. CONSTRUCTION OF PORT OPERATIONAL AREA

XXX XXX XXX

6. Supply and place tie-rods of various sizes (steel 45) incl. accessories (184 sets)
7. Supply and place sand and gravel fill (18,523 cu.m.), geotextile filter (3,364 sq.m.), subbase (3,541 cu.m.), base course (799 cu.m.) and gravel bedding (96 cu.m.)
8. Construction of Portland Cement Concrete Pavement, 300mm thk (3,993 sq.m.) including construction joint (56 l.m.) and drainage system (69 l.m.)
9. Supply and install rubber dock fenders, V-type 500H x 1500L (22 sets) and mooring bollards, T head type (13 sets)
10. Construct security fence
11. Supply and install port lighting system, power shore outlet and distribution line
12. Supply and place steel ramp protection (10 units)

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Issued this 10th day of January 2025


MARK JONS. PALOMAR
Chairperson, HO-BAC-EP