

# ***GENERAL CONDITION***

## **GENERAL**

### **1. Employer's Drawings**

- 1.1. The drawings listed in the Tender document are the Employer's drawings and are provided by the Employer as illustrative of the Specification.
- 1.2. All data and information furnished in the drawings by the Employer is given in good faith but the Employer does not accept the responsibility for the completeness and accuracy thereof. The same shall be verified by the Contractor promptly pointing out errors or discrepancies thereof to the Engineer.

### **2. Drawing Sheet Format**

- 2.1. All drawings provided by the Contractor shall be on standard size sheets, prepared on computer with AutoCAD and shall show the following particulars in a title block located in the lower right hand corner, in addition to the name of Contractor and equipment manufacturer, date, scale, drawing number, revision number (R0 for drawings submitted initially, R1, R2, etc. for drawings submitted subsequently) and title.

A blank space of 90 mm x 100 mm shall be provided for the Engineer's approval stamp and provision shall be made for details of revisions to be recorded.

- 2.2. All drawings submitted by the Tenderer /Contractor shall use the English language and preferably SI units. All drawings shall be clearly and fully cross-referenced to the other drawings as relevant.

### **3. Tender / Contract Drawings**

- 3.1. Drawings submitted by the Tenderer shall show all the essential items of the Plant offered together with sufficient details to enable the general arrangement of the Plant to be determined.
- 3.2. The drawings and documents to be provided by the Tenderer / Contractor shall be as per the schedules of price but shall not be limited to those listed:

### **4. Submissions and Approval of Drawings**

- 4.1. The following shall be the procedure for submission and approval of drawings:
  - 4.1.1. The Contractor shall submit 4 copies of the drawings to the Employer. All the drawings are to be signed by the Contractor or his authorized representatives

- 4.1.2. The Engineer's Representative will review the drawings and, if found fit for approval, the Employer will return 2 copies to the Contractor duly approved.
- 4.1.3. In case the drawings/documents are not fit for approval but worth for review, the Engineer's Representative will mark the comments on the drawings and return 2 copies to the Contractor. In such case, the Contractor shall resubmit the revised drawings within two weeks as per sub-clause 5.1.1 above and the same shall be repeated till the drawings are finally approved as per sub-clause 5.1.2 above.
- 4.1.4. If the submitted drawings/documents are not worth for review, the Contractor will be informed accordingly.
- 4.1.5. On receipt of the approved drawings as per sub-clause 5.1.2 above, the Contractor shall submit floppy and documents to the employer.
- 4.1.6. After tests on completion, the Contractor shall submit, within 15 days of the conclusion of the tests, floppies of the "As Built Drawings" to the Employer.
- 4.2. When the drawings are received by the Engineer's Representative after revision by the Contractor, he will only review the revision made and hence the Contractor shall carefully identify all the revised details / dimensions and also describe the revisions in the revision block.
- 4.3. No drawings, with corrections made after taking the prints, will be accepted.
- 4.4. Approval of drawings by the Engineer shall not relieve the Contractor of his responsibility in terms of the Contract.

## **5. Delivery, Unloading and Storing at Site**

- 5.1. The Contractor shall be responsible for checking all materials delivered to Site and shall keep the Engineer's Representative fully informed of the state of deliveries. The Contractor shall carry out, at his cost, all instructions of Engineer or his Representative for proper unloading, preservation, maintenance, storage and security of materials delivered to Site until he fulfills all his obligations under the Contract.
- 5.2. The Contractor shall erect and maintain on the Site any temporary storage facility as required and approved by the Engineer.
- 5.3. Multiple handling and movement of materials during storage and retrieval shall be avoided.

## **6. Spare Parts:**

- 6.1. Spare Parts required after the taking over the Plant shall be filled up by the bidder in the price schedule.

- 6.2. Spares during pre-commissioning trials, commissioning tests/maintenance, guarantee etc. shall be provided by the Contractor. The necessary spares shall be brought by the Contractor prior to the pre-commissioning test so as to avoid the downtime of equipment due to non-availability of them. All these spares have to be provided as required, by Contractor free of cost.
- 6.3. All spare parts shall be new, unused and strictly interchangeable with the parts for which they are intended to be replacements and shall be treated and packed for long storage under the climatic conditions prevailing at the Site. Each spare part shall be clearly marked or labeled on the outside of its packing with its description, number and purpose. When more than one spare is packed in a single case or other container, a general description of its contents shall be shown on the outside of such case or container and a detailed list enclosed. All cases, containers and other packages shall be marked and numbered in an approved manner for the purpose of identification. Spares shall be delivered to Site after the completion of erection but before start of commissioning of Plant along with technical leaflets and details. Spare parts shall be indicated in the assembly drawing showing clearly the part numbers.
- 6.4. All cases, containers or other packages are liable to be opened for such examination as the Engineer's Representative may require and packing shall be designed to facilitate opening and thereafter re-packing. In the event of the some specific spares offered in the Contract being withdrawn from manufacture owing to changes in design of equipment or similar reasons viz., model being obsolete etc., the Contractor shall inform the Employer before such withdrawal so that the Employer can take timely alternative steps.
- 7. Tools:**
- 7.1. Tools shall be delivered to site just prior to Tests on Completion.
- 7.2. The specified tools shall not be used for the erection of the Plant being supplied and except that the Engineer may call upon the Contractor to demonstrate their use or effectiveness, they must be handed over to the Employer in a completely new and unused condition. Should the Contractor require any such tools at site for erection, he shall provide his own.

The test equipment shall include special purpose items essential to the testing or re-calibration of related items of Facilities.

***DETAIL SPECIFICATION***  
***OF***  
***MATERIAL & CIVIL WORKS***

## **MATERIALS AND WORKMANSHIP**

### **1. Introduction**

- 1.1. This part of the Specification sets out the general standards of materials to be supplied and the workmanship required to be ensured by the Contractor. All component parts of the Works shall, unless otherwise specified, comply with the provisions of employer's requirement or be subject to the approval of the Employer. Particular attention shall be paid to a neat, orderly and well-arranged installation carried out in a methodical competent manner.

### **2. Reference Specifications and Standards**

- 2.1. Where reference is made in the Specification to a British Standard Specification (hereinafter abbreviated to 'B.S') issued by the British Standards Institution of 2, Park street, London W.I., or to an Indian Standard Specification (I.S.) issued by the Bureau of Indian Standards, (earlier known as Indian Standard Institution), Manak Bhavan, 9 Bahadur shah Zafar Marg, New Delhi 110 002, or American Society for Testing and materials (ASTM) issued by ASTM 1916 Race Street, Philadelphia, P.A., 19103, U.S.A. or American national Standards Institute (ANSI) issued by ANSI 1430, Broadway, New York, N.Y., 10018, U.S.A. or Japanese Industrial Standards (JIS) issued by Japanese Standards Association, 4-1-24, Akasaka, Minato-Ku, Tokyo 107, Japan or to any other equivalent Standard it shall be to the latest revision of that Standard at the Tender opening date.
- 2.2. The Contractor may propose at no extra cost to the Employer, the use of any relevant authoritative Internationally recognised Reference Standard.
- 2.3. All details, materials and equipment supplied and workmanship performed shall comply with the specified Standards. If Tenderer offers equipment to other Standards, the equipment/material should be equal or superior to those specified and full details of the difference shall be supplied.
- 2.4. In the event of conflict between this Specification and the Codes for equipment, provisions of this Specification shall govern. Certain specifications issued by national or other widely recognized bodies are referred to in this Specification. In referring to the Standard Specifications the following abbreviations are used:

IS	:	Indian Standard
ANSI	:	American National Standards Institute
API	:	American Petroleum Institute
ASME	:	American Society of Mechanical Engineers
ASTM	:	American Society of Testing and Materials
AWS	:	American Welding Society
AWWA	:	American Water Works Association
ISO	:	International Organization for Standardization
DIN	:	Deutsches Institute fur Normung

BS	:	British Standard
IEC	:	International Electrotechnical Commission
IEE	:	Institution of Electrical Engineers
IEEE	:	Institute of Electrical and Electronic Engineers
NEMA	:	National Electrical Manufacturers Association
AGMA	:	American Gear Manufacturer's Association

### **3. Materials - General**

- 3.1. All materials incorporated in the Works shall be the most suitable for the duty concerned and shall be new and of reputed make/approved quality, free from imperfections and selected for long life and minimum maintenance. Non-destructive tests, if called for in the Specification, shall be carried out. All submerged moving parts of the Plant, or shafts and spindles or faces etc. in contact with them shall be of corrosion resistant materials. All parts in direct contact with various chemicals, shall be completely resistant to corrosion, or abrasion by these chemicals, and shall maintain their properties without aging due to the passages of time, exposure to light or any other cause.

### **4. Workmanship - General**

- 4.1. Workmanship and general finish shall be of first class quality and in accordance with best workshop practice.
- 4.2. All similar items of the Plant and their component parts shall be completely interchangeable. Spare parts shall be manufactured from the same materials as the originals and shall fit all similar items.
- 4.3. All parts, which can be worn or damaged by dust, shall be totally enclosed in dust proof housings. All materials incorporated in the Works shall be the most suitable for the duty concerned, free from imperfections and selected for long life and minimum maintenance. All necessary accessories required for satisfactory and safe operation of the Plant shall be supplied by the Contractor unless it is specifically excluded from his scope. Suitable provision by means of eyebolts or other means are to be provided to facilitate handling of all items that are too heavy or bulky for lifting and carrying by two men.

### **5. Welding**

- 5.1. Welding shall comply with the latest revision of the BS 5135 Code.
- 5.2. Welders shall be qualified in accordance with the requirement of the appropriate section of BS 4871. The Engineer shall have the right to call for further qualification from time to time from any welder who in the opinion of the Engineer does not produce weld in accordance with the qualification. Each welder shall be assigned a number and letter. Each weldments shall clearly be identified as to its welder marking the welder's Code adjacent to the welds. A record chart shall be maintained for each welder showing the

procedures for which he has qualified, the date of such qualification, the type of defects produced and their frequency. The Engineer shall disqualify the welder whose Work requires a disproportionate amount of repairs. All procedures where required shall be qualified as per BS EN 283-3.

- 5.3. Inspection and quality of surveillance shall not be limited to the examination of finished welds. The techniques employed shall be based on methods which are known to produce good results and which have been verified at Site by actual demonstration.
- 5.4. Haphazard striking of the electrodes for establishing an arc shall not be permitted. The arc shall be struck either on the joint or on a starting tag. The starting tag shall be of the same material or a material compatible with the base metal being welded. In case of any inadvertent strike on place other than the welding, the area affected shall be ground flushed and examined by liquid penetration method.
- 5.5. Generally, a stringer bead technique shall be used with a slight oscillation of necessary to avoid slag and to minimize the number of beads needed to fill exceed 3 times the wire diameter. Vertical welds shall be made in upward direction. For all pipes above 300 mm dia., welding shall be done whenever possible, by 2 welders working simultaneously along both sides of the pipe.
- 5.6. The root pass shall have less than 1.5 mm internal reinforcement. Defects like icicles, burn through and excessive “such back”, etc. shall be cause for rejection of welds.
- 5.7. Final welds shall be suitable for appropriate fabrication of the non-destructive examination of the weld. If grinding is necessary, the weld shall be blended into the parent metal without gouging or thinning of the parent metal in any way. Uneven and excessive grinding may be a cause for rejection. Fillet weld shall preferably be convex and free from undercutting and overlap at the toe of weld. Convexity and concavity shall not exceed 1.5 mm. The leg lengths shall not exceed the specified size by more than 1.5 mm.
- 5.8. All attachments such as lugs, brackets and other non-pressure parts shall also be done by qualified welders in accordance with the design details and materials specifications. Temporary attachments shall be removed in a manner that will not damage the parent metal. Areas of temporary attachments shall be dressed smooth and examined by ultrasonic or liquid penetration methods.
- 5.9. All tack welds shall be made using qualified procedure and welders, the number of size of tack welds shall be kept as small as to consist of adequate strength and joint alignments. All tack welds shall be examined visually for defects and if found defective shall be completely removed. As welding proceeds, tack welds shall be either removed completely or shall be properly prepared by grinding or filling their starting ends so that they may be satisfactorily incorporated in the welds. Unacceptable defects shall be removed by grinding machine or chipping or gouging. Flame gouging may be permitted provided gouged surfaces are ground at least by 1.0 mm below the deepest indentation.



- 5.10. All weld repairs shall be carried out using the approved welding procedures and welders. Re-welded areas shall be re-examined by the methods specified for the original welds and the Engineer's Representative shall duly qualify repair procedures.

## **6. Pre-heating and Post-heating Treatment**

- 6.1. Pre-heating and post heating treatment shall conform to the relevant application Codes. Pre-heating not exceeding 121 deg. C for all carbon steel construction above 25 mm thickness would be mandatory. Such pre-heating would be maintained during flame cutting, flame or arc gouging, welding and repairs and may be done by gas heating by gas torches/gas rings with neutral flame. The temperature shall be checked by temperature indicating crayons. However, such pre-heating will not be necessary for welds less than 6 mm size. In large diameter pipe fabricated out of plate materials, production control test plates in accordance with the BS 4870 part 1 Table 6 to represent 30% of the long seams and each welder's performance would be mandatory.

## **7. Electrodes**

- 7.1. All electrodes shall be stored in their original sealed containers under dry conditions. Electrodes shall remain identified until consumed. All electrodes shall be dried before use. Drying ovens shall be provided in Work areas for drying purposes. Electrodes withdrawn from oven shall be promptly used and excess unused electrodes shall be promptly returned to oven.

## **8. Examination/NDT/Radiography**

- 8.1. The various stages of examination and types shall be as stipulated in the respective fabrication Codes. Radiographic examination shall be carried out as per provisions of BS 2600 or BS 2910; Ultrasonic tests where called for shall be carried out as per provisions of BS 3926; magnetic particle tests shall be carried out as per BS 6072. Liquid penetration tests shall be carried out as per BS 6443.

## **9. Stainless Steel Welding**

- 9.1. All welding consumable such as electrodes, filler weirs, argon gas for shielding and purging shall be of high quality and the proposed brand shall be furnished for approval of the Engineer. Weld deposits shall have similar or higher physical properties and similar chemical composition to the members joined.
- 9.2. All electrodes shall be purchased in sealed containers only and stored in their packing intact. The packets opened shall be consumed as early as possible. The electrodes removed from the containers shall be kept in holding ovens at temperatures recommended by electrode manufacturer. Special care shall be taken in avoiding mixing of electrodes in the oven. The electrodes and filling wires shall be free from rust, oil, grease, earth and other foreign matter.
- 9.3. Argon gas with purity 99.5% shall be used for shielding and purging. The purity of gas shall be certified by the gas manufacturers.

- 9.4. Non-destructive examination of the welds shall be carried out to ensure quality of weld.
- 9.5. The electric current for welding shall be direct current, straight polarity (electrode negative). The welding current shall be kept minimum possible to ensure minimum heat affected zone in the parent material. Other side of the weld joint shall be periodically flushed with argon gas.

## **10. Castings**

- 10.1. Cast iron shall be of standard grey close-grained quality. The structure of the castings shall be homogeneous and free from non-metallic inclusions and other injurious defects. All surfaces of castings, which are not machined, shall be smooth and shall be carefully fettled to remove all foundry irregularities.
- 10.2. Minor defects in depth not exceeding 12.5 percent of total metal thickness and which will not ultimately affect the strength and serviceability of the casting may be repaired by approved welding techniques. The Engineer shall be notified of large defects and no repair welding of such defects shall be carried out without prior approval of the Engineer. If the removal of metal for repair should reduce the stress resisting cross section of the casting by more than 25 percent, or to such an extent that the computed stress in the remaining metal exceeds the allowable stress by more than 25 percent, then casting shall be rejected. Test coupons cast simultaneously with the main castings shall be identified to check physical, chemical analysis of casting. Major defects on casting are not acceptable. Castings repaired by welding for minor defects shall be stress-relieved after such welding. Non-destructive tests as directed by the Engineer will be required for any casting containing defects whose extent cannot otherwise be judged, or to determine where repair welds have been properly made.

## **11. Forging**

- 11.1. All major stress-bearing forging shall be made to a Standard Specification. Forging shall be subjected to magnetic particle testing or dye penetration test at the areas of fillets and change in section. The testing shall be conducted after rough machining (10 microns). Any defect, which will not machine out during the final machining, will be gouged out fully, inspected by dye penetration or magnetic particle inspection to ensure that the defect is fully removed and repaired using an approved repair procedure. Any indication, which proves to penetrate deeper than 2.5% of the finished thickness of the component, shall be reported to the Engineer giving the details like location, length, width and depth. For the magnetic particle inspection the choice of wet or dry particles shall be at the Contractor's discretion.
- 11.2. All forging shall be demagnetized after test and shall be heat-treated for the relief of residual stresses.

## **12. Design Life**

- 12.1. The Works as a whole shall be new, of sound workmanship, robustly designed for a long reliable operating life and shall be capable of 24 hours per day continuous

operation for prolonged period in the climatic and working conditions prevailing at the Site, and with the minimum of maintenance. Particular attention shall be given to temperature changes, the stability of paint finish for high temperatures, the rating of engines, electrical machinery, thermal overload services, cooling systems and the choice of lubricants for possible high and prolonged operating temperatures. The Contractor shall be called upon to demonstrate this for any component part either by service records, or evidence of similar equipment already installed elsewhere or relevant type tests. Routine maintenance and repair shall as far as possible not requires the services of highly skilled personnel.

- 12.2. The Plant shall be designed to provide easy access to and replacement of component parts, which are subject to wear, without the need to replace whole units. No parts in contact with water shall have a life from new to replacement or repair of less than five years.
- 12.3. Design features shall include the protection of Plant against damage caused by vermin, dirt, dust and dampness and to reduce risk of fire. Plant shall operate without undue vibration, and parts shall be designed to withstand the maximum stresses under the most severe condition of normal service. Materials shall have a high resistance to change in their properties due to the passage of time, exposure to light, temperature and any other cause, which may have a detrimental effect upon the performance or life of the Works.
- 12.4. Plant located outside lockable areas/building shall have additional features to prevent un-authorized operation.

### **13. Name Plate**

- 13.1. Each item of the Plant shall have permanently attached to it in a conspicuous position, a nameplate and rating plate. Upon these shall be engraved or stamped, the manufacturer's name, type and serial number of Plant, details of the loading and duty at which the item of Plant has been designed to operate, and such diagrams as may be required by the Engineer. All indicating and operating devices shall have securely attached to them or marked upon them designations as to their function and proper manner of use.
- 13.2. Nameplates, rating plates and labels shall be of a non-flame propagating materials, either non-hygroscopic or transparent plastic with engraved lettering of a contrasting colour. Fixing shall be by means of non-corrosive screws; drive rivets or adhesives shall not be used.
- 13.3. Warning labels shall be provided where necessary to warn of dangerous circumstances or substances. Inscriptions or graphic symbols shall be black on a yellow background.
- 13.4. Instruction labels shall be provided where safety procedures such as wearing of protective clothing are essential to protect personnel from hazardous or potentially hazardous conditions. These labels shall have inscriptions or graphic symbols in white on a blue background.

## **14. Nuts, Bolts, Studs and Washers**

- 14.1. Nuts, bolts, studs and washers for incorporation in the Plant shall conform to the requirements of the appropriate standard. Nuts and bolts shall be of the best quality of specified grade, machined on the shank and under the head and nut
- 14.2. Fitted bolts shall be a light driving fit in the reamed holes they occupy, shall have the screwed portion of such a diameter that it will not be damaged in driving and shall be marked in a conspicuous position to ensure correct assembly at Site.
- 14.3. Washers, locking devices and anti-vibration arrangements shall be provided where necessary. Jointing hardware for the entire Plant shall be provided with sufficient spares to cater for site losses.
- 14.4. Where bolts pass through structural members taper washers shall be fitted, where necessary, to ensure that no bending stress is caused in the bolt. Where there is a risk of corrosion, bolts, nuts and studs shall be designed so that the maximum stress does not exceed half the yield stress of the material under any conditions. All bolts, nuts and washers that are subject to frequent adjustment or removal in the course of maintenance and repair shall be made of nickel-bearing stainless steel.
- 14.5. The Contractor shall supply all holding down, alignment and leveling bolts complete with anchorages, nuts, washers and packing required to attach the Plant to its foundations, and all bed plates, frames and other structural parts necessary to spread the loads transmitted by the Plant to concrete foundations without exceeding the design stresses.

## **15. Allowances for Wastage**

- 15.1. The Contractor shall supply reasonable excess quantities to cover wastage of those consumable, which will be normally subject to waste during erection, commissioning and setting to Work.

## **16. Painting – General**

- 16.1. The Contractor shall be responsible for the cleaning, preparation for painting, and priming or otherwise protecting, as specified, all parts of the Plant at the place of manufacture prior to packing.
- 16.2. Parts may be cleaned but surface defects may not be filled in before testing at the manufacturer's works. Parts subject to hydraulic test shall be tested before any surface treatment. After test, all surfaces shall be thoroughly cleaned and dried out, if necessary by washing with an approved de-watering fluid prior to surface treatment. Except where the specification provides to the contrary all painting materials shall be applied in strict accordance with the paint manufacturer's instructions.
- 16.3. All protective coatings shall be suitable for use in warm humid climates. All primers, under coats and finishes shall be applied by brush or airless spray, except where

otherwise specified. Consecutive coats shall be in distinct but appropriate shades. All paints shall be supplied from the store to the painters, ready for application, and addition of thinners or any other material shall be prohibited.

## **17. Painting at Place of Manufacture**

- 17.1. Steel and cast iron parts shall be sand blasted to near white cleaning before painting. Edges, sharp covers etc. shall be ground to a curve before sand blasting. A primer coat of a zinc rich epoxy resin based coating with at least 75 microns dry film thickness is to be provided. In addition the parts are to be provided with adequate number of coats of coal tar epoxy polyamine coating to a dry film thickness of 175 microns including primer coating.

## **18. Painting at Site**

- 18.1. Immediately on arrival at the site, all items of Plant shall be examined for damage to the paint coat applied at the manufacturer's works, and any damaged portions shall be cleaned down to the bare metal, all rust removed, and the paint coat made good with similar paint.
- 18.2. After erection, such items, which are not finish painted, shall be done so and, items that have been finish painted at the manufacturer's works shall be touched up for any damaged paintwork. For finish painting, two coats of synthetic enamel conforming to IS: 2932 shall be applied. Dry film thickness of each coat shall be at least 25 microns.
- 18.3. The dry paint film thickness shall be measured by Electrometer or other instruments approved by the Employer. In order to obtain the dry film thickness specified the Contractor should ensure that the coverage rate given by the paint manufacturer would enable this thickness to be obtained. Strength of adhesion shall be measured with an adhesion tester and this value shall not be less than 10 kg/cm<sup>2</sup>. Painted fabricated steel work which is to be stored prior to erection shall be kept clear of the ground and shall be laid out or stacked in an orderly manner that will ensure that no water or dirt can accumulate on the surface. Suitable packing shall be laid between the stacked materials. Where cover is provided, it shall be ventilated.

## **19. Galvanizing**

- 19.1. Wherever galvanizing has been specified the hot dip process shall be used. The galvanized coating shall be of uniform thickness. Weight of zinc coatings for various applications shall not be less than those indicated below:

- |    |   |              |
|----|---|--------------|
| a) | Fabricated steel                                  |              |
|    | Thickness less than 2 mm but not less than 1.2 mm | 340 gms/sq.m |
|    | Thickness 2 mm and above                          | 460 gms/sq.m |
| b) | Fasteners   |              |
|    | Up to nominal size M10                            | 270 gms/sq.m |
|    | Over M10  | 300 gms/sq.m |

19.2 Galvanizing shall be carried out after all drilling; punching, cutting, bending and welding operations have been carried out. Burrs shall be removed before galvanizing. Any Site modification of galvanized parts should be covered well by zinc rich primer and aluminum paint.

**20. Support for Pipe work & Valves**

All necessary supports, saddles, sling, fixing bolts & foundation bolts shall be supplied to support the pipe work. Valve and other facilities mounted in the pipe work shall be supported independent of the pipes to which they connect.

## **INSPECTION AND TESTING AT MANUFACTURER'S PREMISES**

### **1. Inspection and Tests**

#### **1.1. Valve**

1.1.1. During testing there shall be no visible evidence of structural damage to any of the valve component.

1.1.2. Motorized valves shall be tested with their actuators, with a differential head equivalent to their maximum working pressure, to prove that the actuators are capable of opening and closing the valves under maximum unbalanced head condition within the specified opening or closing period.

1.1.3. The following test shall be carried out for butterfly valves:

- a) Seat leakage test at rated pressure
- b) Body hydrostatic test at 1.5 times the rated pressure
- c) Disc strength test at body test pressure
- d) Valve operation with and without actuator
- e) Crack opening test under tension

1.1.4. The following test shall be carried out for sluice valves:

- a) Seat leakage test at rated pressure
- b) hydrostatic test at 1.5 times the rated pressure
- c) Valve operation

1.1.5. The following test shall be carried out for non-return valves:

- a) Seat leakage test at rated pressure
- b) Body hydrostatic test at 1.5 times rated pressure
- c) Operation

#### **1.2. Pipe work**

1.2.1. Testing of pipes and fitting shall be carried out in accordance with relevant Indian Standard and internationally approved standard. Pipes, fittings and expansion bellows shall be hydrostatically tested for 1.5 times the rated pressure.

#### **1.3. E.O.T. Crane**

1.3.1. The cranes shall be completely assembled in the Contractor's or subcontractor's Works and shall be subjected to the tests as specified in IS 807/IS 3177 or relevant internationally approved standard. The Contractor shall provide the test weights.

**CRITERIA FOR PREPARATION OF DESIGNS OF RCC ESR /**  
**SUMPS BY PRIVATE AGENCY**

**1.0 GENERAL:**

- 1.1.0 Capacity of the container of the tank shall be the volume of the water it can store between the designed full supply level (F.S.L) and lowest supply level (L.S.L) i.e. the level of the lip of the outlet pipe. Due allowance shall be made for 20 mm. thick plastering the tank from inside, while calculating the capacity of the tank.
- 1.2.0 Free board is the vertical distance between F.S.L. and Soffit of covering slab or dome or beam supporting the cover. In any case the free board shall not be less than 300 mm from bottom of beam.
- 1.3.0 Height of the staging or height of the tower shall be the vertical difference between L.S.L. of the tank and the average ground level at the site of tank.
- 1.4.0 Dead storage shall be the storage capacity of water below L.S.L. depth of dead storage shall be the vertical distance between the top outlet level and wash out level. The washout pipe level shall be at the lowest portion of the container.
- 1.4.1 Minimum depth of water for dead storage shall be 100 mm even for flat bottom slab and not more than 300 mm for inlet i.e. bottom dome slab type tank.
- 1.5.0 Water depth in the tank shall be the vertical distance between L.S.L. and F.S.L. of tank.
- 1.6.0 The allowable bearing pressure or the safe bearing pressure on the strata as specified in the table of IS 1004-1978 or its latest revision, whichever is less shall be considered and design of foundation shall be based on this unit pressure unless specified.
- 1.6.1 Not with standing anything mentioned above regarding S.B.C. whenever the Engineer-in-charge of design directs that bearing capacity shall be determined by carrying out actual soil exploration and tests due to conditions as mentioned in para 2.0 of IS 1992-1969. The same shall be carried out by a Government laboratory or any other approved laboratory and allowable bearing capacity so arrived shall be taken as the basis of design. The factor of safety adopted in case of actual test shall be as per clause 6.1 (A) of IS 6403-1971.

**2.0 GENERAL REQUIREMENTS:**

- 2.1.0 Cement concrete shall be in accordance with IS 456-2000 fine and coarse aggregates shall be confirming to IS 383-1963 or its latest revision. The selection of the type of fine and coarse aggregate to be actually used shall be as directed by the Engineer-in-charge.
- 2.2.0 For parts of the tank in contact with stored water and closing vapour above FSL shall be in concrete grade M250 or in richer grade.
- 2.3.0 Inlet, Outlet, Overflow and Washout pipe:



## **Materials:**

Cast iron flanged pipe of appropriate class shall only be used.

### **2.3.1 Inlet Pipe:**

The size of inlet pipe shall be same that of rising main to ESR.

### **2.3.2 Outlet Pipe:**

The outlet pipe shall be of one diameter higher as that of inlet pipe.

### **2.3.3 Overflow pipe:**

The size of overflow pipe shall be one diameter higher than that of inlet pipe.

### **1.3.4 Washout Pipes:**

Outlet cum washout arrangement shall be provided with sluice valves at GL. Detailed drawing showing all the pipes, duck foot bends, chamber, sluice valves and other necessary connection shall be furnished in the plan. Plain concrete block in M-150 for duck foot bands shall be of minimum depth of 600 mm. The width of the block shall have an offset minimum of 150 mm.

### **2.4.0 Water Level Indicator:**

A water level indicator shall be provided for the tank reading depth of water in meters with least count of 10 cm. The system shall consist of uncorrodable material and shall be simple and easy to maintain. The water level indicator shall be provided and fixed as approved and directed by the Engineer-in-charge.

### **2.4.1 Access to roof for an entry to the inside of the tanks shall be provided. At roof level of the tank the access to roof manhole from the ladder or stair shall be properly provided with parapet or railing. At ground level or at walkway level the access forgoing up shall be provided with a door and locking arrangement. Railing at roof level and at gallery level shall be provided.**

### **2.4.2 At least two manhole with frame and cover of CI medium type shall be provided with ladder for entering into the container for maintenance purpose. The size of manhole frame shall be 0.9 x 0.6 meter 75 kg.**

### **2.5.0 Lightning Arrestor:**

Lightening arrestors shall be provided on the roof of the tank as per IS 2309-1969. Position and height of lighting arrestors shall be such that the whole structure shall be enclosed within dome having its apex at top and of the arrestors and generated by a line inclines at  $60^{\circ}$  to the vertical. The arrestors shall be suitably earthed. Copper strip shall be covered with GI pipe 25-mm dia up to 4-meter height from GL.

### **2.6.0 The roof of the tank shall be ventilated by providing cowls or ventilators with mosquito proof met for ventilators. They shall be fixed with proper framing. Ventilation area shall nit be less than of (A) 0.04% of the free water surface when cowl type ventilators are provided. (B) Cross sectional area of the inlet pipe. (C) Cross sectional area of the outlet pipe.**

## 2.7 Seismic Forces.

2.7.1 All tanks shall be checked for seismic forces confirming to IS 1893-1975 or its latest revision and wind forces also.

2.7.2 Water tank in vicinity of mines, galleries and blasting sites or in areas which may be subjected to blasting sites or in areas which may be subjected to blast or shock, shall be designed for the dynamic forces developed due to blast equipment.

2.7.3 Members of towers, which are primarily subjected to dynamic stresses, shall be checked for ductility of the members at the joint.

2.7.4 Staircase and all columns shall be tied together just above foundation level by structural members such as a braced or a tie ring beam.

2.8 Following shall be the minimum thickness of various members of the tank container.

Roof slab	100 mm
Bottom slab	200 mm
Roof Dome	100 mm
Container Dome	150 mm
Vertical wall including shaft wall	150 mm
Inclined wall or shall requiring shuttering of one side	170 mm
(i) Slope with horizontal more than 30°	150 mm
(ii) -Do less than 30°	150 mm

2.9.0 Error up to 2 % in weights, forces, moments etc. in the design calculations may be neglected.

## 3.0 LOADS:

3.1.0 For all RCC and PCC component unit weight shall be taken as 25000 N/m<sup>3</sup>, 24000n/m<sup>3</sup> respectively, allowance of platter up to 20 mm. Inside surface of container shall be taken in to consideration of in normal circumstances.

3.2.0 Water load shall be taken as 10000n/m<sup>3</sup>.

3.3.0 Live load and snow load shall be taken as per IS: 875-1964 or its latest revision.

3.3.1 No live load may be assumed while designing the staggering (or tower) and foundation for seismic loads.

3.3.2 Live load on gallery all round the elevated tank shall be considered as 1500 n/m<sup>3</sup>.

3.4.0 Wind load as per Fig. i.e. basis maximum wind pressure or Indian including winds of short duration as per IS 875/1964 shall be considered.

3.5.0 Seismic forces on the tower shall be as per IS 1893-1975 or its latest revision.

Wind and seismic forces shall not be assumed to act simultaneously.

### **INCREASES IN PERMISSIBLE STRESSES:**

Where stresses due to wind or earth quack temperature & shrinkage effects are combined with those due to dead, live and impact loads the stresses specified in table 13, 16 & 17 of 456-1978 may be increased up to a limit of 33.50%.

## **4.0 DESIGN:**

### **4.1.0 General:**

4.1.1 Shape of the structure shall be as directed by Engineer-in-charge and shall be selected depending upon site condition from the standard shape

4.1.2 General description and salient feature as mentioned below of the design shall be not approved by the Engineer-in-charge and shall be mentioned in the design before detail design calculations starts.

4.2 Sketch showing dimensional section, elevation with plan shall be given.

4.3 Safety against over turning :

4.3.1 The safety against over turning of structure shall be computed quite accurately.

4.3.2 Design shall be based on the worst possible combination of various loads, moments, shears and resultant stress in the tank for the following two cases.

- (i) Tank Full 'A'
- Tank Empty

Tank full means depth of water inside the container up to full height of the container without consideration of free board.

Or safe bearing capacity of soil based on actual soil investigation report of the laboratory.

Position of sub soil water level.

Chemical analysis if sub soil water and soil where possibility of brakish/saline water is ascertained.

Location of site on index plan with respect to latitude and longitude.

4.3.3 Design shall be based on accepted basis and methods of design as well as the provision of IS 3370-1965, IS 456-1978, IS 1343-1960, IS 2210-1962, IS 2204-1962 etc. and their latest revision. However methods based on experimental investigation as mentioned in para 18.2 % "C" in IS 456-1978 shall not be entertained.

4.4.0 The parts of the structure neither in contact with the liquid on any face more enclosing the space above the liquid as in the case of stages of a tower shall be designed on working stress method on accordance with the requirement of IS 456-1978. Staging may be designed on limit method as per IS 456-1978.

4.5.0 Design of members other than these excluded by above (i.e. roof, walls, floor etc. of the container) shall be based on consolidation of adequate resistance of cracking as well as adequate strength calculation of stresses shall be para s per 3.2.2 of IS 3370 (part-II) 1965 or its latest revision.

#### 4.5.1 PERMISSIBLE STRESS IN CONCRETE FOR RESISTANCE TO CRACKING:

For calculations relating to the resistance of members to cracking the permissible stresses in tension (direct and due to bending) and shear shall confirm the values specified in Table-I of IS 3370 (part-II 1965)

The permissible tensile stresses due to bending apply to the fact of the member in contact with the liquid. In members less than 225 mm thick and in contact with the liquid on one side, these permissible stress in bending apply to the face remote from liquid.

#### 4.5.2 FOR STRENGTH CALCULATION:

In strength calculation, the permissible concrete stresses shall be in accordance with para-44 of IS 456-1978. Where the calculated shear stress in concrete alone exceeds the permissible value reinforcement acting in conjunction with diagonal compression in the concrete shall be provided to take the whole of the shear.

#### 4.5.3 Permissible compressive stress (Directly only) insheels (i.e. Top Dome, Conical Wall and shall be reduced by 43% for 10 cm thick walls. For thickness more than 30 cm, the compressive stress shall be reduced by 50% and for inter media thickness 10 cm. to 30 cm. linear interpolation shall be done.

#### 4.6 PERMISSIBLE STRESSES IN STEEL:

##### 4.6.1 For resistance to cracking the steel and the concrete are assumed to act together. For checking the tensile stresses in un cracked concrete for avoidance of cracks, the tensile stress in the steel shall be the product of the modular ratio and the corresponding allowable tensile stress in concrete as per IS 3370(part-II) 1965 or its latest revision. Modular ratio "M" for different concrete mix shall be taken as under:

Grade of Concrete    Modular Ratio "M"

M-150	19
M-200	13
M-250	11
M-300	09

##### 4.6.2 For strength calculation (concrete assumed to be cracked), the permissible stresses in reinforcement shall be as per Table -2 of IS 3370(part-II) 1965 or its latest revision. For steel, the stresses shall be as per IS 1966 or its latest revision.

#### 4.7 The analysis of staging of the tank shall be done by using any established method such as portal method etc. The staging shall be analyzed from combination of dead, dead live loads and wind seismic loads. The effect of continuity of beams of the junction shall be properly accounted and column reaction worked out, for different condition of loading, axial force, shear force, bending moments.

#### 4.8 MEC :

##### 4.8.1 Modules of elasticity of concrete MEC shall be taken as $5700/FC$ where equal to characteristic cube strength of concrete in $N/m^2$ as per IS 456-1976.

- 4.8.2 Columns shall be checked for tensile stress for both the conditions as mentioned in para 4.3.2 in combination with axial tension and bending due to wind or seismic loads, and shall be checked for bond for maximum tensile stress arrived.
- 4.8.3 Columns may be assumed to be fixed at the top of footing.
- 4.8.4 Water Tower in seismic zone (V) of IS 1393-1975 twin diagonal (crossed) backing of steel in vertical plane in addition to the horizontal bracing may be provided.
- 4.9 COLUMNS:
- 4.9.1 Reinforcement shall be provided on both faces of the load-bearing shaft. Minimum vertical reinforcement in the shaft shall be of 0.4% of the gross concrete area required, Minimum horizontal reinforcement shall be 0.3% of the gross concrete area. Required in case, for tower in high seismic zone (IV & V) minimum horizontal reinforced shall be 0.4% of the gross concrete area; for before bars of medium tensile or high tensile steel the above steel requirements may be reduced by 20 %.
- 4.9.2 Shaft shall be checked for combined axial load and bending due to wind or seismic loads and shall satisfy the provision of IS 456-1978 in tank full and tank empty condition.
- 4.9.3 Horizontal construction joints in shaft shall be as minimum as possible. On account of minor in accordance in construction shaft the allowable direct compressive stress shall be reduced by multiplying with 0.8% factor. On account of buckling reduction factor, if any, shall be multiplied to the value 0.85. For the calculation of direct compressive stress the contribution of steel shall be neglected.
- 4.9.4 Age factor for increasing strength shall not be considered.
- 4.9.5 Shaft shall be checked for tensile stress for worst condition in combination with axial tension on bending due to wind or seismic load.
- 5.0 FOUNDATION:**
- 5.1 The permissible increase in bearing pressure for different types of foundation shall be as per table -I of IS 1893-1965 or its latest revision. When seismic forces are considered and for wind forces it shall be as per IS 1904-1966 or its latest revision.
- 5.2 For the purpose of the design of foundation the loading data shall be given the magnitude of vertical load, lateral load and moments at top of footing (Foundation) level. The data shall be made available, for both the cases as per para 4.3.2.
- 5.3 General :
- 5.3.1 The foundation area, door, individual column footings, combined footings, angular rafts and solid rafts shall be worked out on the basis of lower most value of the safe bearing capacity or allowable bearing pressure values as derived from IS 1904-1978, IS 9403-1971, IS 8009-1976 or their latest revision.
- 5.3.2 In case of purely cohesive and CI pipe of soil particulars attention should be given to IS 1903-1978 clause 6 & 7. Settlement shall be calculated as per IS 8009 (part I) 1976 for foundation.

- 5.3.3 In case of purely cohesion less soil, foundation shall be design for safe bearing capacity and shall be checked for permissible total as well as differential settlement values as given in relevant IS.
- 5.3.4 If the foundation consists of individual columns footing, minimum clear distance between center of column shall be equal to twice the width of footing and clear distance between the edge of footing shall be not less than width of footings.
- 5.3.5 In case of soil beneath the footings are not of the same characteristics the footing shall be designed for the soil having lowest SNC or ANP as the case may be. In such conditions the permissible limits of total as well as differential settlement shall be limited to 75% of the permissible limit given in ISS.
- 5.3.6 For special type of foundations like well foundation under beam pipe foundation etc., decision of Superintending Engineer, Public health Design Circle shall be final and binding to the designer.
- 5.3.7 Classification of soil and all characteristics of soil relevance to BSBC and APB shall be as per the soil in irrigation reports of Government stipulation. Government approved investigators.
- 5.4 For the design of foundation angular or solid raft type, the "PLACE THEORY" shall be adopted.
- 5.5 In normal circumstances minimum 100-mm thick plain cement concrete with 100 mm projection around in Grade M 100 with coarse aggregate as metal shall be provided as leveling course. Where injurious soil progressive water is expected the leveling course shall be grade not weaker than M 15 and if necessary Sulphate resisting or the special cement shall be used. The ground level within the foundation area of the structure shall be consolidated properly with a suitable slope to drain out rainwater outside the foundation.

## **6.0 DETAILING:**

### **6.1 MINIMUM REINFORCEMENT FOR WATER RETAINING MEMBER:**

- 6.1.1 The minimum reinforcement in walls, floors, roofs, in each of two directions at right angle shall have an area of 0.3% of the concrete selection in that direction for sections up to 100.00 mm thick. For section for thickness greater than 100 mm and less than 450 mm thick, minimum reinforcement each of two directions shall be nearly deducted from at 0.3% for 100 mm thick sections or greater two layers of reinforcing steel shall be place one near each face of the section to make up to minimum reinforcement specified in this clause.
- 6.1.2 The minimum reinforcement specified in this 6.1 above may be decrease by 20 % in case of high yield strength bars confirming to IS 1786-1976 or IS 139-1966.
- 6.2
- 6.2.1 Minimum clear cover to reinforcement under normal conditions shall be as per para 25.4 of IS 456-1978.
- 6.2.2 For liquid faces of parts of members either in contact with the liquid or enclosing the space above the liquid shall be as per para 7.2 IS 3370 (part-I 1965).
- 6.2.3 In case of Raft Foundation, the cover to reinforcement shall be as per 4.6.2 of IS 295 (part-I) 1973.

- 6.2.4 In case of "shaft" the cover to reinforcement shall be as under;  
         Vertical 25 mm  
         Horizontal 15 mm
- 6.3 For members of structure in contact with water, effective cover shall not be more than 60 mm. Even bars subjected to bending stress, or bars subjected to tension due pure tension in the member the effective cover shall not more than 75 mm.
- 6.4 Spacing of reinforcement :
- 6.4.1 Spacing of reinforcement shall be as per para 25.3 IS 456-1978.
- 6.4.2 Spacing of lateral ties for column shall satisfying provision of para 25.3.2 'C' of IS 456-1978.
- 6.4.3 The additional suggested criteria for reinforcing steel which accounts for existing moments, tension etc. i.e. other than temperature or binding steel shall comprise of minimum 8 mm for deformed or 10 mm mild steel bars.
- 6.4.4 The spacing between two para in main reinforcement shall distribution steel, stirrups, links etc. shall not exceed 30 cm.
- 6.5 For members of the container, the maximum diameter of reinforcement in tension shall not exceed as given below depending upon the geometrical percentage of reinforcement. (Ratio of tensile steel to gross is concrete.)
- |            |           |
|------------|-----------|
| Up to 1.0% | 16 mm dia |
| Up to 1.5% | 22 mm dia |
| Up to 2.0% | 25 mm dia |

**Note:**

- 1.0 In case of dispute regarding interpretation any above clause, the decision of the Superintending Engineer, Public Health Circle, Concerned will be binding to the Designer.
- In case of any clauses not included in the above criteria the decision of the Superintending Engineer, Public Health Design Circle will be final and binding to the Designer.

**INSTRUCTION FOR PREPARATION OF DESIGN OF RCC ESR/SUMPS  
(ONLY FOR SELF DESIGN BY CONTRACTOR)**

- 2.0 The design of RCC ESR supplied by the contractor in his own design shall be in accordance with the design criteria prepared by the Public Health Design Circle, Gandhinagar (copy of design criteria is attached). The design and drawing supplied by contractor should be accepted after the approval by the competent authority from the Department.
- The contractor should mention the name, qualification, experience etc. of the design engineer who will be the necessary design scrutiny work etc. The design Engineer should attend the office of the Department if required at any stage prior to the acceptance of design or drawing construction with reference books etc. It will be the duty of designer to submit the design drawings and compliance of remarks by the Department.

### 3.0 PAYMENT AS PER PAYMENT SCHEDULE

#### 4.0 COMMON CONDITIONS:

- 4.1 All petty items occurring if the work shall be carried out in workman like manner as per specification published by the Competent authority of Govt. and as per current general specification and as per instruction of the Engineer-in-charge from time to time.
- 4.2 Extra charge of claims in respect of extra work shall not be allowed unless such works are ordered in written by the Engineer-in-charge and are claimed for in specified manner before the work is taken in Hand.
- 4.3 The contractor shall engage on in experience and qualified supervisor as his authorized agent for the work. He shall be responsible to take from time to time such orders as may be given by the Engineer-in-charge to carry them.
- 4.4 As order book shall be maintained on the work site and the contractor shall sign the orders given by the Engineer-in-charge and he shall carry out them promptly. The order books shall be surrendered to the Department on completion of Work.
- 4.5 The contractor shall have to clear the site of work before it commences and after the work is completed for which separate claim shall not be entertained.
- 4.6 In addition in the required stores the contractor shall provide at his own cost the suitable temporary office shed with a covered area of about 20 sq mt. with necessary furniture for the use of Government staff while in works. The shed and furniture on completion of the work shall be removed by the contractor at his own cost.
- 4.7 The contractor shall provide at his own cost all labour charges setting out the as may be required for lining and setting out the as may be required for lining and setting up the works satisfactory and adequate facilities site scaffolding etc. for facility of checking his work or taking measurements etc.
- 4.8 Department shall give reasonable facilities to the contractor to enable him to obtain controlled materials at controlled rates as may be fixed from time to time. The contractor shall however not be entitled to time. The contractor shall however not be entitled to claim any compensation extra time limit to account of non-supply at controlled rates. The materials obtained shall be only used for the work in question. Any materials remaining surplus shall be neither disposed nor removed by the contractor without obtaining written permission of Department to that effect. Government shall have the right to take delivery of the surplus materials at the original purchase price of the receipt contractor shall be sue of such materials to the satisfaction of Engineer-in-charge and submit in monthly statement thereof.
- 4.9
  - 4.9.1 The contractor at his own cost expense shall provide necessary housing accommodation and the sanitary.
  - 4.9.2 Arrangement for his staff and labour and shall pay direct of the authorities concerned all rates. Taxes royalties and other charges.

The contractor shall also comply with the requirement of the Health Department as regards anti malarial measures etc.



- 4.10 Water require for the execution of work and for the water tightness test of the reservoir shall be supplied by the contractor at his own cost in manner satisfactory to the Engineer-in-charge of work.
- 4.11 The contractor shall not be entitled to claim compensation from the Government. For works suffered on account of delay where such delay is caused either by (i) Difficulties relating to the supply of Railway Wagons, (ii) Force majeure, (iii) Acts of the God, (iv) Any other reasonable caused beyond the control of the Department. In case of delay Govt. shall however grant such extension of time limit for the completion as may appear reasonable to the Engineer-in-charge and his decision shall be final.
- 4.12 The contractor shall be responsible to pay complete compensation to his staff and to his labours according to the labour compensation rules, on account of accidents and less of life or less of the life due to accident.

## **5.0 DECLARATION:**

The contractor shall made declaration as under:-

"I have made myself thoroughly conversant conditions as regards the availabilities or otherwise of all construction materials skilled and unskilled labour on which. I have quoted my rates for this work. The specifications, drawing and design of this work have been careful studies and are understood by me before the submission of this tender.

## DETAILED SPECIFICATION

Detailed specification given here shall be treated as extension or partial modifications to the specifications of respective items given in the volume of specification published by Gujarat Water Supply and Sewerage Board.

### **EXCAVATION FOR FOUNDATION:**

- 1.0 When the rates are to be quoted for a work based on "contractors own design" the word excavation for foundation shall mean excavation for foundation in all types strata such as soil soft murrum as well as hard rocks up to the designed depth at which foundation is to rest. No extra payment will be given for any change in strata at the same place. The rate shall also include dewatering and shoring strengthen if and where found necessary.
- 1.1 Excavation shall be carried out as per approved drawing. The excavation made deeper or wider than that required as per drawing shall not paid, but such deeper excavation if carried out shall have to be filled up using C.C. 1:4:8 by the contractor without extra cost. If the type of strata require wider excavation at top (GL) Then contractor shall excavate the trench accordingly but no extra payment for such wider excavation shall be made.
- 1.2 The rate shall include providing cured warnings lights during night time providing barricading consisting of metal ropes and bamboo for which no extra payment will be made.
- 1.3 The contractor shall make his own arrangements to obtain prior permission directly from relevant authorities for staking of excavated stuff near work side. If he fails to obtain such permission, then he will have to make his own arrangement with out claiming extra cost to transport and stack the excavated stuff at a suitable place approved by the Engineer-in-charge of work.
- 1.4 The excavated stuff shall be stacked at least 3.0 meter away from the edge of excavated trench, If enough space is not available at work site then the excavated stuff shall be stacked at suitable place situated away from site. Similarly the surplus stuff shall have to be disposed off at a suitable place for which contractor shall have to obtain permission directly from relevant authorities. No extra payment for transportation of excavated stuff or surplus stuff shall be made.
- 1.5 No excavated stuff shall be disposed off or used for any purpose other than refilling without prior permission of Engineer-in-charge of work.
- 1.6 Details shown in the data sheet regarding water table are approximate. The contractor should make his own arrangements for taking trial pots at his own cost more quoting his rates for as certain type of strata water table, quantity of seepage water etc.
- 1.7 Work at nighttime shall be carried out only with written permission of Engineer-in-charge.
- 1.8 Bottom of the excavated foundation trench shall be sprinkles with water ( If water table is not above foundation level) and wall rammed to obtain a reasonably firm and level bedding.

- 1.9 The rates shall include continuous dewatering of seepage water or rainwater from, trenches to keep the trench dry particularly during casting of base concrete. Concrete for footing and columns of shaft etc. till concrete fully sets etc.
- 1.10 Whenever collapsible types of strata are encountered pucca shoring and strutting shall be invariably claim shall be entertained.

**2.0 C.C. 1:4:8 FOR BASE / LEVELLING COARSE:**

- 2.1 Proportion size and type of crushed metal shall be as per item of schedule-B.
- 2.2 Common and standard specification for plain and R. C. C. works attached separately shall be followed.
- 2.3 After concrete has set, properly thick cement slurry shall be floated on the concrete and shall be finished & lined as per instruction if required.
- 2.4 If required necessary concrete cubes of size 15cm. x 15cm. shall be casted from concrete to be used for the work as per instruction of Engineer in charge and the same shall be tested by the contractor at his own cost. No. of cubes to be tested shall be as per relevant I. S. code.
- 2.5 The rate shall be paid per CUM. Basis as per item of schedule - B.

**3.0 C.C. M-100 BASE CONCRETE FOR LEVELLING COARSE:**

- 3.1 For all practical purpose and in absence of proportioning of concrete on base of preliminary tests, C.C. 1:3:6 may be provided as a leveling course i.e. one part of cement three parts of sand and six parts of black trap kapachi. Specification for various ingredients of concrete such as sand, cement, kapachi, water shall be as these given in specification for C.C.M. 15.
- 3.2 While laying base concrete for leveling course the concrete shall not be dumped from above but shall be carried out to the bottom and gently placed from a height not exceeding 1.5 meter. If concrete is transported by chutes, then the same shall be remixed at bottom of chutes to overcome any segregation that might have occurred.

**4.0 C.C. M-150:**

- 4.1 As far as possible the preparation of various ingredients of concrete shall be determined on the bases of preliminary tests as per ISS using the actual materials to be used on site. However in absence of such preliminary tests the volumetric proportion of 1:2:4 may be adopted i.e. one part of cement, two parts of sand and four parts of kapachi, water just sufficient to attain desired workability may be added. However the aim while proportioning should be to fix the proportion of aggregation and water cement ratio shall be always sufficiently low enough to get desired strength.

**4.2 Materials:**

- 4.2.1 Coarse aggregate shall consist of tough angular black trap kapachi. The kapachi shall be obtained from approved source only. Normally at least two stock piles of different size of 12 to 20 mm and 25 mm to 40 mm shall be

maintained. It will however, be preferably to maintain third stock pile of 6 mm to 12 mm also for better control on mix of concrete.

4.2.2 The maximum size of coarse aggregate to be used shall be as large as possible within the limits of requirements, based on size of member and spacing of reinforcement. But aggregate exceeding 40 mm shall not be used in concrete for ESR and Sumps.

4.2.3 Depending up on the size of member, spacing of reinforcement and degree of workability desired, the coarse aggregates from different stockpiles may be mixed in a suitable proportion to get a uniform mix that does not segregate.

4.2.4 The coarse aggregate shall not contain dust, clay or other such harmful material. If directed by the Engineer the same shall be washed with water and dried before being used.

#### **4.3 Fine Aggregates:**

Fine aggregates shall consist of coarse, angular river sand free dirt and other harmful organic materials. If directed the same shall be screened and washed before being used. Sand brought from approved source shall only be used.

#### **4.4 Cement:**

Contractor shall provide a temporary store with double lock arrangement for storage of this cement on work site without extra cost. Cement shall be stored in such a way that it is not affected by moisture.

#### **4.5 Water:**

Water to be used in concrete work shall be potable, free from injurious elements such as chloride or sulphate etc. and shall be obtained from approved source only. Contractor shall make his own arrangements to obtain and store sufficient quantity of water at all times.

#### **4.6 Reinforcement Steel:**

The TMT Fe 415 reinforcing bars to be provided & shall confirm to the Tender specifications and relevant IS specifications. In spite of producing test certificates by Contractor for the proper quality of reinforcing bars, the quality of steel could also be tested by checking coating firm at plant site for bend test before doing coating and that if the reinforcing bar fails in bend test, then it shall not be provided with FBEC and in that case, cost of conveyance of such steel to plant and removing from plant shall be of the Contractors. The rechecking quality of Steel, for bend test will be done by the coating agency in the presence of contractor provided the contractor choose to remain present.

Reinforcing bars to be used shall be fresh from rolling rails as far as possible. If the bars are very much rusted in quality before providing FBEC, such bars shall have a loss of weight at contractor's risk.

To ascertain the loss in weight of reinforcing bars on account of removal of rust during coating, random weight before and after coating shall be done and that loss in weight shall be borne by the contractor.

#### **4.7 Coating Bars with CRS:**

The CRS coating shall be done confirming relevant IS code.

- 4.8** The coated reinforcement bars shall be tested at plant by the contractor. Test reports shall be jointly signed by authorized representatives of Contractor and the coating agency. The tests on coated bars shall be as per I.S. for the following tests.

Thickness

Continuity

Adhesion

The frequency of tests shall be for the thickness of coating minimum; two bars of each size from each production shifts.

- 4.8.1 In spite of above tests and test certificates produced by the contractor and coating agency, the Department/ Owner reserves the rights to carry out independent tests at coating plant for cross checking. The contractor's agreement with coating agency shall include the provisions for Department's/ Owner's cross checking and that if the coating quality is not approved by the Department/ Owner the decision of the Department/ Owner to reject or repair the coating shall be final and binding on all parties.

- 4.8.2 Holidays in coating shall not be more than two holidays per linear foot (six holidays per meter) of coated bar.

#### **4.9 HANDLING:**

- 4.9.1 The coated bars shall be carefully handled in order not to drop them, not to rub them on hard surface or against another coated bar while conveying, stacking, placing or stacking of fabricated bars and that for this purpose wooden packing batons shall be used at spacing of not more than 60 cms. The coated bars shall be tied to make bundles with PVC wire so as to avoid damages to coating.
- 4.9.2 The coated bars shall be stacked with separation gap between ground and bars with wooden batons between rows of bars or bundles of such tied bars. Such wooden or padded contact shall be at spacing of not more than 60 Cms.
- 4.9.3 The cut ends of bars shall be touched up with special touch up materials of specifications as provided by coating agency. There shall be minimum time gap to repair the cut ends and damaged portions with touch up materials and that failure to do so may cause complete rejection of the coated bars. The cut ends and damaged portions shall be touched up with repair patch-up material within four hours time gap. All damages to coating in handling etc. shall be repaired irrespective of their size. This stipulation supersedes provision of I.S. Code.
- 4.9.4 No payment will be made for coated bars which are not used in the work and that if they were paid either on account of coating of the rejectable part of bars or doing extra fabrication etc., the amount paid will be recovered from contractor. The contractor will be paid for the same quantity of steel bars used in the work and paid under relevant item.
- 4.9.5 While bending the bars, the pins of workbenches shall be provided with PVC or Plastic sleeves. It is preferable that contractor install bar bending machines suitable for FBE coated bars and that each bending operation is done in a time of not less than 90 secs.

4.9.6 The coated steel shall not be directly exposed to sun rays and rains and shall be protected with opaque polythene sheets or such other approved materials. While doing concreting, the workmen or trolleys shall not directly.

4.9.7 Movement on coated bars shall not be allowed but can move on wooden planks placed on the bars by Contractor.

In spite of all test certificates, if the coated bars are roughly handled by contractor either during transport, fabrication, stacking, placing and concreting etc. or handled in such a manner as to damage the coating for area or portion more than reasonable, the Engineer-in-Charge or Department/Owner reserve the right to reject the CRS coated bars and that if rejected then such rejected bars shall be removed by contractor from work site within three days. The decision of Engineer-in-charge will be final as to reject the bars with damage coating or to allow repairing the coating, or to get it recoated at contractor's cost.

## **5.0 FORM WORK:**

Form work shall consist of steel plates or smooth timber planks to be joined by nuts, bolts, nails or pegs so as to have a reasonably water tight joints. Sufficient number of vertical and horizontal supports shall be provide when completed. Formwork shall be sufficiently sturdy & strong to absorb all stresses and movements. Before concrete is placed in position the formwork and steel shall be got checked through Engineer-in-charge of work. Advance intimation shall be given to the Engineer-in-charge for this purpose. The ultimate responsibility for safety and of lives of workmen and that of forms etc. from beginning of work till its completions shall always rest with the contractor proper ladders and plant forms for easy access shall be provided by the contractor without extra cost.

The faces of formwork coming in contact with concrete shall be cleaned and two coats of approved mould oil applied before fixing reinforcement. All rubbish, particularly chippings, shavings, sawdust, wire pieces dust etc. shall be removed from the interior of the forms before the concrete is placed. Where directed, cleaning of forms shall be done by blasting with a jet of compressed air at no extra cost.

Forms intended for reuse shall be treated with care. Forms that have deteriorated shall not be used. Before reuse, all forms shall be thoroughly scraped, cleaned, nails removed, holes suitably plugged, joints repaired and warped lumber replaced to the satisfaction of the Engineer In Charge. The Contractor shall equip himself with enough shuttering to allow for wastage so as to complete the job in time.

Permanent formwork shall be checked for its durability and compatibility with adjoining concrete before it is used in the structure. It shall be properly anchored to the concrete.

Wire ties passing through beams, columns and walls shall not be allowed. In their place bolts passing through sleeves shall be used. Formwork spacers left insitu shall not impair the desired appearance or durability of the structure by causing swelling, rust staining or allowing the passage of moisture.

For liquid retaining structures, sleeves shall not be provided for through bolts nor shall through bolts be removed if provided. The bolts, in the latter case,

shall be cut at 25 mm depth from the surface and the hole made good by cement mortar of the same proportion as the concrete just after striking the formwork.

The striking time for formwork shall be determined based on the following requirements:

- (a) Development of adequate concrete strength;
- (b) Permissible deflection at time of striking form work;
- (c) Curing procedure employed - its efficiency and effectiveness;
- (d) Subsequent surface treatment to be done;
- (e) Prevention of thermal cracking at re-entrant angles;
- (f) Ambient temperatures; and
- (g) Aggressiveness of the environment (unless immediate adequate steps are taken to prevent damage to the concrete).

Under normal circumstances (generally where temperatures are above 20°C) forms may be struck after expiry of the time period given in IS:456 unless approved otherwise by the Engineer In Charge. For Portland Pozzolana/slag cement the stripping time shall be suitably modified as approved by the Engineer In Charge. It is the Contractor's responsibility to ensure that forms are not struck until the concrete has developed sufficient strength to support itself, does not undergo excessive deformation and resist surface damage and any stresses arising during the construction period.

## **6.0 MIXING, TRANSPORTATION AND LAYING:**

- 6.1 For important works like ESR and sumps mixing of concrete shall be invariably done in approved machine mixer only. The mix obtained from the mixer shall be a uniform mass consisting of all aggregates coated with cement paste.
- 6.2 Fresh concrete shall be transported horizontally in ghamellas or wheelbarrows. Vertical transportation shall be done either by manual labour or using mechanical vertical lifts. When chutes are used for transportation, care should be exercised to avoid segregation and concrete may be remixed at bottom of chutes to get uniform mix. Before any concrete is placed in position all loose materials such as dirt, chips of stones, wood, steel etc. should be removed. Inner side of forms should be coated with thin layer of oil to get a good finished surface.  
Concrete should not be dumped from above in which case aggregate will segregates, but placed gently from a height not exceeding 1.5 meter. Compaction of concrete shall be done by vibrators till cream appears at top. Over vibration shall be avoided to avoid segregation.

## **7.0 CURING:**

After concrete is set in position it shall be kept continuously wet with water for 7 days either by using gunny bags(column and walls) by ponding (slab) or as directed by spraying of water.

Unless otherwise specified the rate shall include finishing the exposed surface to get good finished surface.

The forms shall be kept in position for period given below:-

1)	Vertical sides of walls, beams, columns	2	Days
2)	Slabs (props left under.)	4	"
3)	Bottom of beam (props left under)	7	"
4)	Removal of prop to slab spanning up to 4.5 m. spanning over 4.5 m.	7	"
5)	Removal of props to beams spanning up to 6.0 m.	14	"
6)	Spanning over 6.0 m.	21	"

#### **C. C. M - 250 :**

Specification for C.C.M. 250 shall be same as those for C.C.M 200 except that grade of concrete to be produced shall be M250. If arbitrary volumetric proportioning is to be followed then the proportion of cement, sand and kapachi shall be 1:1:2 respectively. Since M - 250 mix is normally used in water retaining parts of container where the aim is not to get dense, strong and watertight concrete, special care shall be exercised in controlling proportion of aggregate, water cement ratio, compaction and curing.

#### **C. C. M - 300 :**

Specification for C.C.M. 300 shall be same as those for C.C. M 200 except that grade of concrete to be produced shall be M 300.

### **8.0 PROVIDING AND PLACING IN POSITION STEEL REINFORCEMENT:**

- 8.1 Reinforcement bars to be used in RCC work shall have to be supplied by the contractor. The rates include providing, cutting, bending, binding, hooking and placing in position including cost of binding wire. The bars shall be fusion bonded and epoxy coated.
- 8.2 Depending upon the type of reinforcement steel proposed in design (i.e. M.S. or deformed etc.) the steel shall conform to relevant ISS codes in practice. Contractor shall produce necessary test certificate in absence of which the steel bars shall be get tested by the Department at the contractor's cost.
- 8.3 Steel bars shall be cut, bent up, hooked bound with wires and then placed in position as per approved drawing. The steel shall be got checked through Engineer-in-charge. Before any concrete is placed in formwork advance intimation shall be given to the Engineer-in-charge for this purpose. The steel shall be cleared of any dust or rust that might have been deposited on bars.
- 8.4 Reinforcement shall be accurately fixed and maintained firmly in the correct position by the use of blocks, spacers, chairs, binding wire etc. to prevent displacement during placing and compaction of concrete. The tied in place reinforcement shall be approved by the SPECIAL OFFICER & SUPERINTENDING ENGINEER prior to concrete placement. Spacers shall be of such materials and designs as will be durable, not lead to corrosion of the reinforcement and not cause scaling of the concrete cover.

Binding wire shall be 16 gauge soft annealed wires. Ends of the binding wire shall be bent away from the concrete surface and in no case encroach into the concrete cover.

Substitution of reinforcement, laps/splices not shown on drawing shall be subject to CIVIL ENGINEER approval.



#### **9.0 RCC STAIRCASE FROM GL. TO TOP OF CONTAINER:**

RCC Staircase shall be provided for easy access necessary to the top of ESR or sump. RCC staircase shall be either spiral with triangular steps fixed around RCC column rectangular steps along the periphery of circular shaft. Rise and trade of suitable dimension shall be provided to have a comfortable access. Width of staircase shall not be less than 90 cm. Separate RCC foundation shall be provided when RCC spiral stair with triangular steps is provided when cantilever steps are provided. In case of spiral staircase with triangular steps separate RCC cabin 10 cm. thick walls shall be provided with a steel door for entry of an authorized person to the top of ESR. However no such separate cabin need to be provided when the staircase is located inside hollow supporting shaft, but in that case enough provision for windows shall be made in addition a wooden door. The baluster and hand railing shall be made from 40 x 40 x 6 mm angles and 3/4 dia GI pipes by welding as directed by Engineer-in-charge and colored with three coats of paints.

#### **10.0 WOODEN WATER LEVEL INDICATOR:**

- 10.1 A wooden water level indicator of approved size and type shall be provided and fixed by the contractor. It shall consist of wooden plank of 250 mm x 40 mm.
- 10.2 The divisions on water level indicators shall show distance of 10 cm. clearly. A copper or PVC float of 500-mm dia and 50 mm height shall be provided along with steel wires pulleys etc. The entire arrangement shall be first got approved by the Engineer-in-charge of work. Letter and marking shall be painted with approved enamel paint.

#### **11.0 COPPER LIGHTENING CONDUCTOR:**

Copper lighting conductor with size of strip 20 mm x 3 mm with clamps and screw and copper plate of 600 mm x 600 mm x 6 mm and copper red as per specification no. 120 of PWD Hand book Vol I (ISS - 2309) shall be provided and fixed by the contractor. It shall consist of copper arrestor at top, copper conductor from top up to GL and copper Earthing plate shall be 1 m. deep below GL and filled with salt and charcoal to transmit the current to earth, minimum dimension of these part shall confirmed to relevant ISS. Heights of the arrestor shall be such as to enclose the entire structure with imaginary cone generated by a inclined at 60° degrees with vertical at top.

#### **12.0 Providing and fixing CI flanged pipes and special such as duck foot bends, crippling flanges bell mouthpiece etc. for inlet outlet overflow and wash out.**

- 12.1 Diameter and length of above pipes shall be as given in Appendix - A. CI flanged pipes shall be vertically cast double flanges and shall be confirm to relevant ISS. They shall be first get approved by the Engineer-in-charge of work.
- 12.2 Item shall include providing all specials such as crippling flanges, and duck feet bends etc. as may be required on site.
- 12.3 The Item shall also include cost of all jointing materials such as nuts, bolts, rubber packing, white zinc or pig lead or lead wool if required.
- 12.4 Pipes shall be fixed perfectly vertical and straight.
- 12.5 Before fixing in position pipes shall be coated with two coats of anticorrosive paint.
- 12.6 The pipes and specials shall be tested hydraulically. Leakage if found shall be repaired without extra cost.

**13.0 PROVIDING AND FIXING CI SLUICE VALVE:**

- 13.1 Diameter of CI sluice valve shall be as shown in Appendix - A. CI sluice valve shall be of class - I confirming to IS - 780-1980.
- 13.2 The rate includes providing and fixing CI sluice valves with tailpieces including jointing materials such as nuts, bolts, rubber packing zinc etc.
- 13.3 The rate includes giving hydraulic test to the satisfaction of Engineer-in-charge of work.
- 13.4 Sluice valve shall be supplied with necessary spindle or wheel for operating the same.

**14.0 PROVIDING AND FIXING C I M H FRAME AND COVER:**

One number of C I M H frame and cover shall be provide and fixed in top slab of container. The dimensions and weight shall be as shown in Appendix - A. The C I M H frame and cover shall be first got approved by the Engineer-in-charge. Two coats of anticorrosive paints shall be applied before fixing them in position.

**15.0 C.I. COWL TYPE VENTILATORS:**

The C I Cowl type ventilator should be of 100 mm dia shape with flanged and roughing screen shall be as per Appendix - A. The rate includes providing and fixing C I Cowl type ventilator as per Appendix - A including cost of all jointing materials such as nuts, bolts, white zinc rubber packing etc. Two coats of anticorrosive paints shall be applied to the surface before they are fixed in position. They shall be first for approved by the Engineer-in-charge.

**16.0 PROVIDING AND FIXING M.S. LADDER INSIDE CONTAINER:**

Contractor shall have to fabricate and fixed M.S. ladder. The ladder to be fixed shall be fabricated from M.S. flat of 10 mm x 65 mm or M.S. angle having equivalent modular of selection 20 mm dia. Bars shall be fixed at 30 mm c/c. to act as steps. The ladder shall be 45 cm. wide if length of ladder is more than 8.0 m. Three coats of approved anticorrosive paint shall be applied to the ladder. The design of M.S. ladder shall be got approved by the Engineer-in-charge before it is fabricated and fixed in position. Rate includes providing and fabricating, painting and fixing in position of M.S. ladder as above.

**17.0 CONSTRUCTION OF VALVE CHAMBER:**

Number and size of valve chamber shall be as per Appendix - A. Specification of various items such as B.B. masonry cement plaster, C.M. (1:3) and C.C. (1:3:6) at bottom. RCC 1:2:4 etc. shall be as these given in column of specification published by the Competent authority of Govt. and as those prevailing in force.

**18.0 PAINTING LETTER:**

Following words shall be painted on the container 40,000 liters capacity. The letters shall be 45 cm high and the black ground of suitable color shall be provided. Approved enameled paint shall only be used for painting letters and background. Entire work shall be carried out as per instruction of Engineer-in-charge.

**19.0 PROVIDING AND FIXING GI PIPE RAILING AROUND TOP SLAB:**

Railing shall consist of 3 raw of 25 mm dia GI pipes fixed in M.S. angles of 60 mm x 60 mm x 6 mm 0.9 m. height fixed at 2 m c/c. The materials shall be got approved by Engineer-in-charge before fabrication. Three coats of approved anticorrosive paint shall be applied to M.S. angle before they are fixed in position.

## **20.0 RCC CABIN:**

Constructing RCC cabin 2 m dia and 10 cm wall thickness with neat finishing etc. complete. The depth of excavation for foundation of cabin shall be 0.7 m deep and 0.65 m width. RCC (1:3:6) shall be of 15 cm thick. The cabin shall be constructed in C.C. (1:2:4) with 10-cm thick wall and 2.2 m height above GL. The wall shall be constructed with 10 mm dia vertical bar at 30 cm c/c. and 6 mm dia bars circle on temporally 30 cm c/c. A steel door made 4 mm thick and steel plaster and welded with flat and 25 mm x 25 x 5 mm M.S. angle from frame. The necessary iron fixtures and fastening shall be provided by contractor at his own cost. The contractor shall have to plaster the cabin if the cabin has not smooth finishing without any extra claim.

## **21.0 CEMENT PAINT:**

The work shall be carried out as per instruction of the Engineer-in-charge. The snowcem paint shall be waterproof cement paint and best quality shall be got approved before use.

The surface shall be prepared by removing all mortar dropping and foreign matter and thoroughly cleaned with wire or fiber brush or and suitable means and washing the surface. All loose pieces shall be scrapped out and hole shall be stopped with mortar. After cleaning the surface the watering hole surface and applied snowcem paint in three coats.

## **22.0 WATERPROOF CEMENT PLASTER:**

The cement mortar shall consist of two parts of fine river sand free from any dust and other organic matter and one part of approved quality of cement. The mortar shall be properly mixed on watertight platform. The mortar shall be used within half an hour after mixing. The water proofing materials weighting 1.5 kg of powder in one bag of cement shall be added.

The plaster shall be applied in uniform thickness of 20 mm and shall be properly smoothened with wooden & finished with cement finishing of required. The curing shall be done at least for week by sprinkling the water over the wall. The wall shall be tested for waterproof ness. The rate includes the cost of waterproofing materials. The test for waterproof ness shall be carried out by the contractor at his own cost by filling the contractor with water and it shall be checked out that there is no percolation of water from the wall. Payment shall be made per sq. m. of plaster done.

## **23.0 BRICK PITCHING:**

The brick shall be of proper quality, standard size, uniform in color, well-burnt and free from cracks. The work of brick pitching shall be carried out in C.M. 1:6. It shall be laid as per the drawing and directed by the Engineer-in-charge. The bricks shall properly soak before being using in work. No brickbats shall be use except the bricks. The joint shall be racked out 20mm depth. Every day at the end of the days work the cement pointing in C.M. 1:2 shall be carried out by line as directed by the Engineer-in-charge. The excavation required for brick pitching shall have to be carried out by the contractor as directed including necessary temping consolidation etc. complete.

After completion & testing of work the contractor shall have provide & fix the Marble 'Takti' of required size with necessary writings, as directed by the Engineer-in-charge.

**24.0** RCC work of shaft, container and staircase should be of well finished condition if the same is not satisfactory than contractor since have to finish the surface with 12 mm thick plaster C.M. without any extra cost.

**25.0** The contractor shall have to make arrangement for testing of steel bars brought on site and concrete cubes, for different mix at different stage like foundation, shaft, column, cube should be cast on site and send Govt. approved laboratory for compressive strength at 28 days. Results must be produced in office before taking payment of work done. Testing charge must bear by contractor.

## **26.0**

26.1. Conditions: The paint is supplied in two packs, fine zinc dust mixed with pox resin as base and liquid hardener. They are to be mixed in following ratio.

	By Volume	By Weight
Base	1.5	4.0
<b>Hardener</b>	1.0	1.0

## 26.2. Mixed Paint Properties

I)	Viscosity	20+3% seconds by flow
		Cup No.4 @ 30 °C
ii)	Specific Gravity	1.70+3%
iii)	Post life of mixture	6-8 hrs.
iv)	Zinc dust content on DFT basis	92+/-3%
v)	Finish	Smooth and Matt.
vi)	Drying time	
	Surface dry	5 minutes
	Hard Dry	Less than 1 hr.
vii)	Over coating after	Minimum 24 hrs.
		Maximum No limit
viii)	Flash point	Above 23 o C
ix)	D.F.T.	20-25 microns depending on blasting profile
x)	Compatibility	Compatible with all systems of paints like Bituminous, conventional, chlorubber vinyl and epoxy paints.
xi)	Toxicity	Non toxic

- 26.3. Application: By Brush/Spray (Air and Airless)
- 26.4. Thinner: Epoxy thinner shall be used if required.
- 26.5. Coverage: 10 Sq. m./liter at 25 microns.
- 26.6. High build black paint.

1)	Dry time	Surface dry not more than 4 hours Hard dry not more than 18 hours Film thickness per coat 75 micron.
2)	Consistency	Thixotropic liquid
3)	Covering Capacity	5 Sq.m./liter
4)	Color	Black/Brown/Black in alternative layer

**26.7 Characteristics:**

The coating shall be non-phenolic, non-toxic. It shall afford a highly durable protective air tight coating to prevent corrosion or rusting of iron and steel against air moisture/water and shall be of sufficient elasticity to prevent racing, blistering or peeling. It shall retain its consistency at the ordinary atmospheric temperatures when packed in suitable containers. After application of drying, the coating shall not show any surface cracks due to drying, weathering action or expansion and contraction. Its resistance to water must be perfect. It shall also be resistant to weak acid and alkalis, natural salts and to dry heat up to 150 centigrade. It should have good brush ability.

The primer as well as paint shall have to be applied as per the manufacturer's specification. The paints shall be tested in the laboratory by the owner at the cost of the contractor if found necessary. The manufacturer shall accompany each lot of primer and paint supplied. The entire procedure of applying the coating as specified shall be rigidly inspected right from cleaning stage to application of final coat.

**26.8 Stacking of bars:**

On receipt the pipes shall be stacked on wooden/concrete sleeper to ensure that they do not come in contact with earth. The contractor shall take necessary precaution for safety of bars so that no damage occurs during stacking.

- 26.9 Mode of measurement and payments: **Payment will be as per payment schedule.**

## **CONCRETE**

### **Applicable Codes**

#### **Materials**

- |     |           |  |
|-----|-----------|--|
| 1.  | IS.269    | Specification for 33 grade ordinary Portland cement.   |
| 2.  | IS.455    | Specification for Portland slag cement.  |
| 3.  | IS.1489   | Specification for Portland-Pozzolana cement (Part 1&2).  |
| 4.  | IS: 8112  | Specification for 43 grade ordinary Portland cement.   |
| 5.  | IS: 12269 | Specification for 53 grade ordinary Portland cement.   |
| 6.  | IS: 12330 | Specification for sulphate resisting Portland cement.  |
| 7.  | IS: 383   | Specification for coarse and fine aggregates from natural sources for concrete.  |
| 8.  | IS: 432   | Specification for mild steel and medium (tensile steel bars and hard-drawn steel) wires for concrete reinforcement. (Part 1 and 2) |
| 9.  | IS: 1786  | Specification for high strength deformed steel bars and wires for concrete reinforcement.  |
| 10. | IS: 1566  | Specification for hard-drawn steel wire fabric for concrete reinforcement.   |
| 11. | IS: 9103  | Specification for admixtures for concrete.   |
| 12. | IS: 2645  | Specification for integral cement water- proofing compounds.   |
| 13. | IS: 4990  | Specification for plywood for concrete shuttering work.  |

#### **Material Testing**

- |    |          |  |
|----|----------|--|
| 1) | IS.4031  | Methods of physical tests for hydraulic cement (Part 1 to 15)                        |
| 2) | IS: 4032 | Method chemical analysis of hydraulic cement.  |
| 3) | IS: 650  | Specification for standard sand for testing of cement.                               |
| 4) | IS: 2430 | Methods for sampling of aggregates for concrete.                                     |
| 5) | IS.2386  | Methods of test for aggregates for concrete (Parts 1 to 8)                           |
| 6) | IS: 3025 | Methods of sampling and test (physical and chemical) for water used in industry.     |
| 7) | IS: 6925 | Methods of test for determination of water-soluble chlorides in concrete admixtures. |

#### **Material Storage**

- |    |          |  |
|----|----------|--|
| 1) | IS: 4082 | Recommendations on stacking and storing of construction materials at site. |
|----|----------|--|

#### **Concrete Mix Design**

- |    |              |   |
|----|--------------|---|
| 1) | IS: 10262    | Recommended guidelines for concrete mix design. |
| 2) | SP: 23 (S&T) | Handbook on Concrete Mixes                      |

### **Concrete Testing**

- |    |          |   |
|----|----------|---|
| 1) | IS: 1199 | Method of sampling and analysis of concrete.  |
| 2) | IS: 516  | Method of test for strength of concrete.  |
| 3) | IS: 9013 | Method of making, curing and determining compressive Strength of accelerated cured concrete test specimens. |
| 4) | IS: 8142 | Method of test for determining setting time of concrete by penetration resistance.                          |
| 5) | IS: 9284 | Method of test for abrasion resistance of concrete.   |
| 6) | IS: 2770 | Methods of testing bond in reinforced concrete.   |

### **Equipments**

- |     |           |  |
|-----|-----------|--|
| 1)  | IS: 1791  | Specification for batch type concrete mixers.  |
| 2)  | IS: 2438  | Specification for roller pan mixer.  |
| 3)  | IS: 4925  | Specification for concrete batching and mixing plant.  |
| 4)  | IS: 5892  | Specification for concrete transit mixer and agitator.   |
| 5)  | IS: 7242  | Specification for concrete spreaders.  |
| 6)  | IS: 2505  | General Requirements for concrete vibrators: Immersion type.                                   |
| 7)  | IS: 2506  | General Requirements for screed board concrete vibrators.                                      |
| 8)  | IS: 2514  | Specification for concrete vibrating tables.   |
| 9)  | IS: 3366  | Specification for pan vibrators.   |
| 10) | IS: 4656  | Specification for form vibrators for concrete.   |
| 11) | IS: 11993 | Code of practice for use of screed board concrete vibrators.                                   |
| 12) | IS: 7251  | Specification for concrete finishers.  |
| 13) | IS: 2722  | Specification for portable swing weighs batchers for concrete (single and double bucket type). |
| 14) | IS: 2750  | Specification for steel scaffoldings.  |

### **Codes Of Practice**

- |    |          |   |
|----|----------|---|
| 1) | IS: 456  | Code of practice for plain and reinforced concrete.   |
| 2) | IS: 457  | Code of practice for general construction of plain and reinforced concrete for dams and other massive structures. |
| 3) | IS: 3370 | Code of practice for concrete structures for storage of liquids (Parts 1 to 4)                                    |
| 4) | IS: 3935 | Code of practice for composite construction.  |
| 5) | IS: 2204 | Code of practice for construction of reinforced concrete shell roof.  |
| 6) | IS: 2210 | Criteria for the design of reinforced concrete shell structures and folded plates.                                |
| 7) | IS: 2502 | Code of practice for bending and fixing of bars for concrete reinforcement.                                       |
| 8) | IS: 5525 | Recommendation for detailing of reinforcement in reinforced concrete works.                                       |
| 9) | IS: 2751 | Code of practice for welding of mild steel plain and deformed bars used for reinforced concrete construction.     |

- |     |          |   |
|-----|----------|---|
| 10) | IS: 9417 | Specification for welding cold worked bars for reinforced concrete construction.                            |
| 11) | IS: 3558 | Code of practice for use of immersion vibrators for consolidating concrete.                                 |
| 12) | IS: 3414 | Code of practice for design and installation of joints in buildings.  |
| 13) | IS: 4326 | Code of practice for earthquake resistant design and construction of building.                              |
| 14) | IS: 4014 | Code of practice for steel tubular scaffolding (Parts 1 & 2)  |
| 15) | IS: 2571 | Code of practice for laying inset cement concrete flooring.   |
| 16) | IS: 7861 | Code of practice for extreme weather concreting: Part 1<br>Recommended practice for hot weather concreting. |

### **Construction Safety**

- |    |          |   |
|----|----------|---|
| 1) | IS.3696  | Safety code for scaffolds and ladders. (Parts 1 &         |
| 2) | IS: 7969 | Safety code for handling & storage of building Materials. |
| 3) | IS: 8989 | Safety code for erection of concrete framed structures.   |

### **General**

The ENGINEER IN CHARGE shall have the right at all times to inspect all operations including the sources of materials, procurement, layout and storage of materials, the concrete batching and mixing equipment and the quality control system. Such an inspection shall be arranged and the ENGINEER IN CHARGE's approval obtained, prior to starting of concrete work. This shall, however, not relieve the Contractor of any of his responsibilities. All materials, which do not conform to the Specifications, shall be rejected.

strength, serviceability, safety, durability and finish with due regards to the functional requirements and the environmental conditions to which the structure will be subjected. Materials complying with codes/standards shall generally be used. Other materials may be used after approval of the ENGINEER IN CHARGE and after establishing their performance suitability based on previous data, experience or tests.

### **MATERIALS:**

#### **Cement:**

Unless otherwise called for by the ENGINEER IN CHARGE, cement shall be ordinary Portland cement conforming to IS: 269, IS: 8112 or IS: 12269.

Where Portland pozzolana or slag cements are used, it shall be ensured that consistency of quality is maintained, there will be no adverse interactions between the materials and the finish specified is not marred.

Only one type of cement shall be used in any one mix. The source of supply, type or brand of cement within the same structure or portion thereof shall not be changed without approval from the ENGINEER IN CHARGE.

Cement, which is not used within 90 days from its date of manufacture, shall be tested at a laboratory approved by the ENGINEER IN CHARGE and until the results of such tests are found satisfactory, it shall not be used in any work.



**Aggregates (General):**

Aggregates shall consist of naturally occurring stones (crushed or uncrushed), gravel and sand. They shall be chemically inert, strong, hard, clean, durable against weathering, of limited porosity, free from dust/silt/ organic impurities/deleterious materials and conform to IS: 383. Aggregates such as slag, crushed over burnt bricks, bloated clay ash, sintered fly ash and tiles shall not be used.

Aggregates shall be washed and screened before use where necessary or if directed by the ENGINEER IN CHARGE.

Aggregates containing reactive materials shall be used only after tests conclusively prove that there will be no adverse effect on strength, durability and finish, including long-term effects, on the concrete.

The fineness modulus of sand shall neither be less than 2.2 nor more than 3.2.

The maximum size of coarse aggregate shall be as stated on the drawings but in no case greater than 1/4 of the minimum thickness of the member.

Plums 160 mm and above of a reasonable size may be used in mass concrete fill where directed. Plums shall not constitute more than 20% by volume of the concrete.

**Water**

Water used for both mixing and curing shall conform to IS: 456. Potable waters are generally satisfactory. Water containing any excess of acid, alkali, sugar or salt shall not be used.

**Reinforcement**

All reinforcement steel shall be HYSD TMT steel grade – Fe 514 conforming to relevant I.S. 1786 for water retaining structure.

All reinforcement shall be clean, free from pitting, oil, grease, paint, loose mill scales, rust, dirt, dust, or any other substance that will destroy or reduce bond.

**Admixtures**

Accelerating, retarding, water reducing and air entraining admixtures shall conform to IS: 9103 and integral water proofing admixtures to IS: 2645.

Admixtures may be used in concrete as per manufacturer's instructions only with the approval of the ENGINEER IN CHARGE. An admixture's suitability and effectiveness shall be verified by trial mixes with the other materials used in the works. If two or more admixtures are to be used simultaneously in the same concrete mix, their interaction shall be checked and trial mixes done to ensure their compatibility. There should also be no increase in risk of corrosion of the reinforcement or other embedment.

Calcium chloride shall not be used for accelerating set of the cement for any concrete containing reinforcement or embedded steel parts. When calcium chloride is permitted such as in mass concrete works, it shall be dissolved in water and added to the mixing water by an amount not exceeding 1.5 percent of the weight of the cement in each batch of concrete. The designed concrete mix shall be corrected accordingly.

**Wastage**

Wastage allowance for cement and steel shall be considered in the item rate and no extra payment shall become payable to the Contractor on any account.

## **Samples and Tests**

All materials used for the works shall be tested before use.

Manufacturer's test certificate shall be furnished for each batch of cement/steel and when directed by the ENGINEER IN CHARGE samples shall also be got tested by the Contractor in a laboratory approved by the ENGINEER IN CHARGE at no extra cost to Employer. ENGINEER IN CHARGE may appoint separate third party inspection for the material testing to ensure the quality of the work. The Contractor shall replace the defective material as an outcome of these tests. Sampling and testing shall be as per IS: 2386 under the supervision of the ENGINEER IN CHARGE.

Water to be used shall be tested to comply with requirements of IS: 456.

The Contractor shall furnish manufacturer's test certificates and technical literature for the admixture proposed to be used. If directed, the admixture shall be got tested at an approved laboratory at no extra cost.

## **Storing of Materials**

All materials shall be stored in a manner so as to prevent its deterioration and contamination, which would preclude its use in the works. Requirements of IS: 4082 shall be complied with.

The Contractor will have to make his own arrangements for the storage of adequate quantity of cement. If such cement is not stored properly and has deteriorated, the material shall be rejected. Cement bags shall be stored in dry weatherproof shed with a raised floor, well away from the outer walls and insulated from the floor to avoid moisture from ground. Not more than 15 bags shall be stacked in any tier. Storage arrangement shall be approved by the ENGINEER IN CHARGE. Storage under tarpaulins shall not be permitted. Each consignment of cement shall be stored separately and consumed in its order of receipt.

Each size of coarse and fine aggregates shall be stacked separately and shall be protected from leaves and contamination with foreign material. The stacks shall be on hard, clean, free draining bases, draining away from the concrete mixing area.

The Contractor shall make his own arrangements for storing water at site in tanks to prevent contamination.

The reinforcement shall be stacked on top of timber sleepers to avoid contact with ground/water. Each type and size shall be stacked separately.

## **Concrete:**

### **General**

Concrete grade shall be as designated on drawings. In concrete grade M15, M20 etc. the number represents the specified characteristic compressive strength of 150 mm cube at 28 days, expressed in N/sq.mm as per IS: 456. Concrete in the works shall be "DESIGN MIX CONCRETE" or "NOMINAL MIX CONCRETE". All concrete works of grade M5, M7.5 and M10 shall be NOMINAL MIX CONCRETE whereas all other grades, M15 and above, shall be DESIGN MIX CONCRETE.

## Design Mix Concrete

### (a) Mix Design & Testing

For Design Mix Concrete, the mix shall be designed according to IS: 10262 and SP: 23 to provide the grade of concrete having the required workability and characteristic strength not less than appropriate values given in IS: 456. The design mix shall be cohesive and does not segregate and should result in a dense and durable concrete and also capable of giving the finish as specified. For liquid retaining structures, the mix shall also result in watertight concrete. The Contractor shall exercise great care while designing the concrete mix and executing the works to achieve the desired result.

The minimum cement content for Design Mix Concrete shall be as per Appendix-A of IS: 456 or as given below, whichever is higher.

Grade of Concrete	Minimum Cement Content in Kg/Cu. m of Concrete
M15	260
M20	315
M25	360
M30	380

The minimum cement content stipulated above should be adopted irrespective of whether the Contractor achieves the desired strength with less quantity of cement. The Contractor's quoted rates for concrete shall provide for the above eventuality and nothing extra shall become payable to the CONTRACTOR in this account. Even in the case where the quantity of cement required is higher than that specified above to achieve desired strength based on an approved mix design, nothing extra shall become payable to the CONTRACTOR.

It shall be the Contractor's sole responsibility to carry out the mix designs at his own cost. He shall furnish to the ENGINEER IN CHARGE at least 30 days before concreting operations, a statement of proportions proposed to be used for the various concrete mixes and the strength results obtained. The strength requirements of the concrete mixes ascertained on 150 mm cubes as per IS: 516 shall comply with the requirements of IS: 456.

Grade of Concrete	Minimum Compressive Strength N/sq.mm at 7 days	Specified Characteristic Compressive Strength N/sq.mm at 28 days
M 15	10.0	15.0
M 20	13.5	20.0
M 25	17.0	25.0
M 30	20.0	30.0
M 35	23.5	35.0
M 40	27.0	40.0

A range of slumps which shall generally be used for various types of construction unless otherwise instructed by the ENGINEER IN CHARGE is given below:

Structure/Member	Slump in millimeters	
	Maximum	Minimum
Reinforced foundation walls and footings	75	25
Plain footings, caissons and substructure walls	100	25
Slabs, Beams and reinforced walls	75	25
Pump & miscellaneous Equipment Foundations	100	25
Building columns	50	25
Pavements	50	25
Heavy mass construction	50	25

**(b) Batching & Mixing of Concrete:**

Proportions of aggregates and cement, as decided by the concrete mix design, shall be by weight. These proportions shall be maintained during subsequent concrete batching by means of weigh batchers capable of controlling the weights within one percent of the desired value.

Amount of water added shall be such as to produce dense concrete of required consistency, specified strength and satisfactory workability and shall be so adjusted to account for moisture content in the aggregates. Water- cement ratio specified for use by the ENGINEER IN CHARGE shall be maintained. Each time the work stops, the mixer shall be cleaned out, and while recommencing; the first batch shall have 10% additional cement to allow for sticking in the drum.

Arrangement should be made by the Contractor to have the cubes tested in an approved laboratory or in field with prior consent of the ENGINEER IN CHARGE. Sampling and testing of strength and workability of concrete shall be as per IS: 1199, IS: 516 and IS: 456, IS 3370.

Nominal Mix Concrete

**(c) Mix Design & Testing**

Mix design and preliminary tests are not necessary for Nominal Mix Concrete. However works tests shall be carried out as per IS: 456. Proportions for Nominal Mix Concrete and w/c ratio may be adopted as per Table 3 of IS: 456. However it will be the Contractor's sole responsibility to adopt appropriate nominal mix proportions to yield the specified strength.

**(d) Batching & Mixing of Concrete**

Based on the adopted nominal mixes, aggregates shall be measured by volume. However cement shall be by weight only.

## **Formwork**

Formwork shall be all inclusive and shall consist of but not be limited to shores, bracings, sides of footings, walls, beams and columns, bottom of slabs etc. including ties, anchors, hangers, inserts, false work, wedges etc.

The design and engineering of the formwork as well as its construction shall be the responsibility of the Contractor. However, if so desired by the ENGINEER IN CHARGE, the drawings and calculations for the design of the formwork shall be submitted to the ENGINEER IN CHARGE for approval.

Formwork shall be designed to fulfill the following requirements:

- (a) Sufficiently rigid and tight to prevent loss of grout or mortar from the concrete at all stages and appropriate to the methods of placing and compacting.
- (b) Made of suitable materials.
- (c) Capable of providing concrete of the correct shape and surface finishes within the specified tolerance limits.
- (d) Capable of withstanding without deflection the worst combination of self weight, reinforcement and concrete weight, all loads and dynamic effects arising from construction and compacting activities, wind and weather forces.
- (e) Capable of easy striking out without shock, disturbance or damage to the concrete.
- (f) Soffit forms capable of imparting a camber if required.
- (g) Soffit forms and supports capable of being left in position if required.
- (h) Capable of being cleaned and/or coated if necessary immediately prior to casting the concrete; design temporary openings where necessary for these purposes and to facilitate the preparation of construction joints.

The formwork may be of timber, plywood, steel, plastic or concrete depending upon the type of finish specified. Sliding forms and slip form may be used with the approval of the ENGINEER IN CHARGE. Timber for formwork shall be well seasoned, free from sap, shakes, loose knots, worm holes, warps and other surface defects. Joints between formwork and formwork and between formwork and structures shall be sufficiently tight to prevent loss of slurry from concrete, using seals if necessary.

The faces of formwork coming in contact with concrete shall be cleaned and two coats of approved mould oil applied before fixing reinforcement. All rubbish, particularly chippings, shavings, sawdust, wire pieces dust etc. shall be removed from the interior of the forms before the concrete is placed. Where directed, cleaning of forms shall be done by blasting with a jet of compressed air at no extra cost.

Forms intended for reuse shall be treated with care. Forms that have deteriorated shall not be used. Before reuse, all forms shall be thoroughly scraped, cleaned, nails removed, holes suitably plugged, joints repaired and warped lumber replaced to the satisfaction of the ENGINEER IN CHARGE. The Contractor shall equip himself with enough shuttering to allow for wastage so as to complete the job in time.

Permanent formwork shall be checked for its durability and compatibility with adjoining concrete before it is used in the structure. It shall be properly anchored to the concrete.

Wire ties passing through beams, columns and walls shall not be allowed. In their place bolts passing through sleeves shall be used. Formwork spacers left insitu shall not impair the desired appearance or durability of the structure by causing spalling, rust staining or allowing the passage of moisture.

For liquid retaining structures, sleeves shall not be provided for through bolts nor shall through bolts be removed if provided. The bolts, in the latter case, shall be cut at 25 mm depth from the surface and the hole made good by cement mortar of the same proportion as the concrete just after striking the formwork.

Where specified all corners and angles exposed in the finished structure shall have chamfers or fillets of 20 mm x 20 mm size.

Forms for substructure may be omitted when, in the opinion of the ENGINEER IN CHARGE, the open excavation is firm enough (in hard non-porous soils) to act as a form. Such excavations shall be larger, as approved by the ENGINEER IN CHARGE, than that required as per drawing to compensate for irregularities in excavation.

The Contractor shall provide adequate props carried down to a firm bearing without overloading any of the structures.

The shuttering for beams and slabs shall be so erected that the side shuttering of beams can be removed without disturbing the bottom shuttering. If the shuttering for a column is erected for the full height of the column, one side shall be built up in sections as placing of concrete proceeds or windows left for placing concrete from the side to limit the drop of concrete to 1.0m or as approved by the ENGINEER IN CHARGE. The Contractor shall temporarily and securely fix items to be cast (embedment/ inserts) in a manner that will not hinder the striking of forms or permit loss of grout.

Formwork showing excessive distortion, during any stage of construction, shall be repositioned and strengthened. Placed concrete affected by faulty formwork, shall be entirely removed and formwork corrected prior to placement of new concrete at Contractor's cost.

The striking time for formwork shall be determined based on the following requirements:

- (a) Development of adequate concrete strength;
- (b) Permissible deflection at time of striking form work;
- (c) Curing procedure employed - its efficiency and effectiveness;
- (d) Subsequent surface treatment to be done;
- (e) Prevention of thermal cracking at re-entrant angles;
- (f) Ambient temperatures; and
- (g) Aggressiveness of the environment (unless immediate adequate steps are taken to prevent damage to the concrete).

Under normal circumstances (generally where temperatures are above 20°C) forms may be struck after expiry of the time period given in IS: 456 unless approved otherwise by the ENGINEER IN CHARGE. For Portland Pozzolana/slag cement the stripping time shall be suitably modified as approved by the ENGINEER IN CHARGE. It is the

Contractor's responsibility to ensure that forms are not struck until the concrete has developed sufficient strength to support itself, does not undergo excessive deformation and resist surface damage and any stresses arising during the construction period.

### **Reinforcement Workmanship**

Reinforcing bars supplied bent or in coils shall be straightened cold without damage. No bending shall be done when ambient temperature is below 5°C. Local warming may be permitted if steel is kept below 10° C.

All bars shall be accurately bent gradually and according to the sizes and shapes shown on the drawings/ schedules or as directed by ENGINEER IN CHARGE.

Re-bending or straightening incorrectly bent bars shall not be done without the approval of the ENGINEER IN CHARGE.

Reinforcement shall be accurately fixed and maintained firmly in the correct position by the use of blocks, spacers, chairs, binding wire etc. to prevent displacement during placing and compaction of concrete. The tied in place reinforcement shall be approved by the ENGINEER IN CHARGE prior to concrete placement. Spacers shall be of such materials and designs as will be durable, not lead to corrosion of the reinforcement and not cause spalling of the concrete cover.

Binding wire shall be 16-gauge soft annealed wire. Ends of the binding wire shall be bent away from the concrete surface and in no case encroach into the concrete cover.

Substitution of reinforcement, laps/splices not shown on drawing shall be subject to ENGINEER IN CHARGE's approval.

### **Tolerances**

Tolerance for formwork and concrete dimensions shall be as per IS: 456 unless specified otherwise.

Tolerances specified for horizontal or vertical building lines or footings shall not be construed to permit encroachment beyond the legal boundaries.

The formwork shall be designed and constructed to the shapes, lines and dimensions shown on the drawings within the tolerances given below:

(a) Deviation from specified dimensions of cross section of columns and beams	- 6 mm + 12 mm
(b) Deviations from dimensions of footings (Tolerances apply to concrete dimensions only, not to positioning of vertical reinforcing steel or dowels)	
1) Dimension in plan	- 12 mm + 50 mm

2) Eccentricity	0.02 times the width of the footing in the direction of deviation but not more than 50 mm
3) Thickness	$\pm 0.05$ times the specified thickness

### **Preparation Prior to Concrete Placement**

Before concrete is actually placed in position, the inside of the formwork shall be cleaned and mould oil applied, inserts and reinforcement shall be correctly positioned and securely held, necessary openings, pockets, etc. provided.

All arrangements-formwork, equipment and proposed procedure, shall be approved by the ENGINEER IN CHARGE. Contractor shall maintain separate Pour Card for each pour as per the format enclosed.

### **Transporting, Placing and Compacting Concrete**

Concrete shall be transported from the mixing plant to the formwork with minimum time lapse by methods that shall maintain the required workability and will prevent segregation, loss of any ingredients or ingress of foreign matter or water.

In all cases concrete shall be deposited as nearly as practicable directly in its final position. To avoid segregation, concrete shall not be rehandled or caused to flow. For locations where direct placement is not possible and in narrow forms the Contractor shall provide suitable drops and "Elephant Trunks". Concrete shall not be dropped from a height of more than 1.0m.

Concrete shall not be placed in flowing water. Under water, concrete shall be placed in position by tremies or by pipeline from the mixer and shall never be allowed to fall freely through the water.

While placing concrete the Contractor shall proceed as specified below and also ensure the following:

- (a) Continuously between construction joints and pre- determined abutments.
- (b) Without disturbance to forms or reinforcement.
- (c) Without disturbance to pipes, ducts, fixings and the like to be cast in; ensure that such items are securely fixed. Ensure that concrete cannot enter open ends of pipes and conduits etc.
- (d) Without dropping in a manner that could cause segregation or shock.
- (e) In deep pours only when the concrete and formwork designed for this purpose and by using suitable chutes or pipes.
- (f) Do not place if the workability is such that full compaction cannot be achieved.
- (g) Without disturbing the unsupported sides of excavations; prevent contamination of concrete with earth. Provide sheeting if necessary. In supported excavations, withdraw the linings progressively as concrete is placed.
- (h) If placed directly onto hardcore or any other porous material, dampen the surface to reduce loss of water from the concrete.
- (i) Ensure that there is no damage or displacement to sheet membranes.
- (j) Record the time and location of placing structural concrete.



Concrete shall normally be compacted in its final position within thirty minutes of leaving the mixer. Concrete shall be compacted during placing with approved vibrating equipment without causing segregation until it forms a solid mass free from voids thoroughly worked around reinforcement and embedded fixtures and into all corners of the formwork. Immersion vibrators shall be inserted vertically at points not more than 450 mm apart and withdrawn slowly till air bubbles cease to come to the surface, leaving no voids. When placing concrete in layers advancing horizontally, care shall be taken to ensure adequate vibration, blending and melding of the concrete between successive layers. Vibrators shall not be allowed to come in contact with reinforcement, formwork and finished surfaces after start of initial set. Over-vibration shall be avoided.

Concrete may be conveyed and placed by mechanically operated equipment after getting the complete procedure approved by the ENGINEER IN CHARGE. The slump shall be held to the minimum necessary for conveying concrete by this method. When concrete is to be pumped, the concrete mix shall be specially designed to suit pumping. Care shall be taken to avoid stoppages in work once pumping has started.

Except when placing with slip forms, each placement of concrete in multiple lift work, shall be allowed to set for at least 24 hours after the final set of concrete before the start of subsequent placement. Placing shall stop when concrete reaches the top of the opening in walls or bottom surface of slab, in slab and beam construction, and it shall be resumed before concrete takes initial set but not until it has had time to settle as approved by the ENGINEER IN CHARGE. Concrete shall be protected against damage until final acceptance.

### **Mass Concrete Works**

Sequence of pouring for mass concrete works shall be as approved by the ENGINEER IN CHARGE. The Contractor shall exercise great care to prevent shrinkage cracks and shall monitor the temperature of the placed concrete if directed.

### **Curing**

Curing and protection shall start immediately after the compaction of the concrete to protect it from:

- (a) Premature drying out, particularly by solar radiation and wind;
- (b) Leaching out by rain and flowing water;
- (c) Rapid cooling during the first few days after placing;
- (d) High internal thermal gradients;
- (e) Low temperature or frost;
- (f) Vibration and impact which may disrupt the concrete and interfere with its bond to the reinforcement.

All concrete, unless approved otherwise by the ENGINEER IN CHARGE, shall be cured by use of continuous sprays or ponded water or continuously saturated coverings of sacking, canvas, hessian or other absorbent material for the period of complete hydration with a minimum of 7 days. The quality of curing water shall be the same as that used for mixing.

Where a curing membrane is approved to be used by the ENGINEER IN CHARGE, the same shall be of a non-wax base and shall not impair the concrete finish

in any manner. The curing compound to be used shall be approved by the ENGINEER IN CHARGE before use and shall be applied with spraying equipment capable of a smooth, even textured coat.

Curing may also be done by covering the surface with an impermeable material such as polyethylene, which shall be well sealed and fastened.

### **Construction Joints and Keys**

Construction joints will be as shown on the drawing or as approved by the ENGINEER IN CHARGE. Concrete shall be placed without interruption until completion of work between construction joints. If stopping of concreting becomes unavoidable anywhere, a properly formed construction joint shall be made with the approval of the ENGINEER IN CHARGE.

Dowels for concrete work, not likely to be taken up in the near future, shall be coated with cement slurry and encased in lean concrete as indicated on the drawings or as approved by the ENGINEER IN CHARGE.

Before resuming concreting on a surface, which has hardened all laitance and loose stone, shall be thoroughly removed by wire brushing/hacking and surface washed with high pressure water jet and treated with thin layer of cement slurry for vertical joints and horizontal layers.

When concreting is to be resumed on a surface, which has not fully hardened, all laitance shall be removed by wire brushing, the surface wetted, free water removed and a coat of cement slurry applied. On this, a layer of concrete not exceeding 150 mm thickness shall be placed and well rammed against the old work. Thereafter work shall proceed in the normal way.

### **Foundation Bedding**

All earth surfaces upon which or against which concrete is to be placed, shall be well compacted and free from standing water, mud or debris. Soft or spongy areas shall be cleaned out and back filled with either soil-cement mixture, lean concrete or clean sand compacted as approved by the ENGINEER IN CHARGE. The surfaces of absorptive soils shall be moistened.

Concrete shall not be deposited on large sloping rock surfaces. The rock shall be cut to form rough steps or benches by picking, barring or wedging. The rock surface shall be kept wet for 2 to 4 hours before concreting.

### **Finishes**

#### **General**

The formwork for concrete works shall be such as to give the finish as specified. The Contractor shall make good any unavoidable defects as approved consistent with the type of concrete and finish specified; defects due to bad workmanship (e.g. damaged or misaligned forms, defective or poorly compacted concrete) will not be accepted. The Contractor shall construct the formwork using the correct materials and to meet the requirements of the design and to produce finished concrete to required dimensions, plumbs, planes and finishes.

#### **Surface Finish Type F1**

The main requirement is that of dense, well-compacted concrete. No treatment is required except repair of defective areas, filling all form tie holes and cleaning up of

loose or adhering debris. For surfaces below grade, which will receive waterproofing treatment, the concrete shall be free of surface irregularities, which would interfere with proper and effective application of waterproofing material specified for use.

#### Surface Finish Type F2

The appearance shall be that of a smooth dense, well-compacted concrete showing the slight marks of well fitted shuttering joints. The Contractor shall make good any blemishes.

#### Surface Finish Type F3

This finish shall give an appearance of smooth, dense, well-compacted concrete with no shutter marks, stain free and with no discolouration, blemishes, arises, airholes etc. Only lined or coated plywood with very tight joints shall be used to achieve this finish. The panel size shall be uniform and as large as practicable. Any minor blemishes that might occur shall be made good by the Contractor.

#### Integral Cement Finish on Concrete Floor

In all cases where integral cement finish on a concrete floor has been specified, the top layer of concrete shall be screeded off to proper level and tamped with tamper having conical projections so that the aggregate shall be forced below the surface. The surface shall be finished with a wooden float and a trowel with pressure. The finish shall be continued till the concrete reaches its initial set. No cement or cement mortar finish shall be provided on the surface. Where specified, a floor hardener as approved by the ENGINEER IN CHARGE shall be supplied and used as recommended by the manufacturer.

#### **Repair and Replacement of Unsatisfactory Concrete**

Immediately after the shuttering is removed, all the defective areas such as honey-combed surfaces, rough patches, holes left by form bolts etc. shall be inspected by the ENGINEER IN CHARGE who may permit patching of the defective areas or reject the concrete work.

All through holes for shuttering shall be filled for full depth and neatly plugged flush with surface.

Rejected concrete shall be removed and replaced by the Contractor at no additional cost to the Employer.

For patching of defective areas all loose materials shall be removed and the surface shall be prepared as approved by the ENGINEER IN CHARGE.

Bonding between hardened and fresh concrete shall be done either by placing cement mortar or by applying epoxy. The decision of the ENGINEER IN CHARGE as to the method of repairs to be adopted shall be final and binding on the Contractor. The surface shall be saturated with water for 24 hours before patching is done with 1:5 cement sand mortar. The use of epoxy for bonding fresh concrete shall be carried out as approved by the ENGINEER IN CHARGE.

#### **Vacuum Dewatering of Slabs**

Where specified floor slabs, either grade or suspended, shall be finished by vacuum dewatering including all operations such as poker vibration, surface vibration, vacuum processing, floating and trowelling as per equipment manufacturers recommendation. The equipment to be used shall be subject to the ENGINEER IN CHARGE's approval.

### **Hot Weather Requirements**

Concreting during hot weather shall be carried out as per IS: 7861 (Part I).

Adequate provisions shall be made to lower concrete temperatures, which shall not exceed 40° C at the time of placement of fresh concrete.

Where directed by the ENGINEER IN CHARGE, the Contractor shall spray non-wax based curing compound on unformed concrete surfaces at no extra costs.

### **Cold Weather Requirements**

Concreting during cold weather shall be carried out as per IS: 7861 (Part II).

The ambient temperature during placement and up to final set shall not fall below 5 Deg.C. Approved antifreeze/accelerating additives shall be used where directed.

For major and large scale concreting works the temperature of concrete at times of mixing and placing, the thermal conductivity of the formwork and its insulation and stripping period shall be closely monitored.

### **Liquid Retaining Structures**

The Contractor shall take special care for concrete for liquid retaining structures, underground structures and those others specifically called for to guarantee the finish and water tightness.

The minimum level of surface finish for liquid retaining structures shall be Type F2. All such structures shall be hydro-tested.

The Contractor shall make all arrangements for hydro-testing of structure, all arrangements for testing such as temporary bulk heads, pressure gauges, pumps, pipe lines etc.

The Contractor shall also make all temporary arrangements that may have to be made to ensure stability of the structures during construction.

Any leakage that may occur during the hydro-test or subsequently during the defects liability period or the period for which the structure is guaranteed shall be effectively stopped either by cement/epoxy pressure grouting, guniting or such other methods as may be approved by the ENGINEER IN CHARGE. All such rectification shall be done by the CONTRACTOR to the entire satisfaction of the ENGINEER IN CHARGE at no extra cost to the EMPLOYER.

### **Testing Concrete Structures for Leakage**

Hydrostatic test for water tightness shall be done at full storage level or soffit of cover slab, as may be directed by the ENGINEER IN CHARGE, as described below:

In case of structures whose external faces are exposed, such as elevated tanks, the requirements of the test shall be deemed to be satisfied if the external faces show no sign of leakage or sweating and remain completely dry during the period of observation of seven days after allowing a seven day period for absorption after filling with water.

In the case of structures whose external faces are buried and are not accessible for inspection, such as underground tanks, the structures shall be filled with water and after the expiry of seven days after the filling, the level of the surface of the water shall

be recorded. The level of water shall be recorded again at subsequent intervals of 24 hrs. Over a period of seven days. Backfilling shall be withheld till the tanks are tested. The total drop in surface level over a period for seven days shall be taken as an indication of the water tightness of the structure. The ENGINEER IN CHARGE shall decide on the actual permissible nature of this drop in the surface level, taking into account whether the structures are open or closed and the corresponding effect it has on evaporation losses. Unless specified otherwise, a structure whose top is covered shall be deemed to be water tight if the total drop in the surface level over a period of seven days does not exceed 40 mm.

Each compartment/segment of the structure shall be tested individually and then all together.

For structures such as pipes, tunnels etc. the hydrostatic test shall be carried out by filling with water, after curing as specified, and subjecting to the specified test pressure for specified period. If during this period the loss of water does not exceed the equivalent of the specified rate, the structure shall be considered to have successfully passed the test.

### Optional Tests

If the ENGINEER IN CHARGE feels that the materials i.e. cement, sand, coarse aggregates, reinforcement and water are not in accordance with the Specifications or if specified concrete strengths are not obtained, he may order tests to be carried out on these materials in laboratory, to be approved by the ENGINEER IN CHARGE, as per relevant IS Codes. Contractor shall have to pay for these tests. In the event of any work being suspected of faulty material or workmanship requiring its removal or if the works cubes do not give the stipulated strengths, the ENGINEER IN CHARGE reserves the right to order the Contractor to take out cores and conduct tests on them or do ultrasonic testing or load testing of structure, etc. The ENGINEER IN CHARGE also reserves the right to ask the Contractor to dismantle and re-do such unacceptable work, at no cost to the Employer. Alternately ENGINEER IN CHARGE also reserves the right to ask the CONTRACTOR to dismantle and re-do such unacceptable work at the cost of CONTRACTOR.

### Grouting

#### Standard Grout

Grout shall be provided as specified on the drawings.

The proportion of Standard Grout shall be such as to produce a flowable mixture consistent with minimum water content and shrinkage. Surfaces to be grouted shall be thoroughly roughened and cleaned. All structural steel elements to be grouted, shall be cleaned of oil, grease, dirt etc. The use of hot, strong caustic solution for this purpose will be permitted. Prior to grouting, the hardened concrete shall be saturated with water and just before grouting, water in all pockets shall be removed. Grouting once started shall be done quickly and continuously. Variation in grout mixes and procedures shall be permitted if approved by the ENGINEER IN CHARGE. The grout proportions shall be limited as follows:

Use	Grout Thickness	Mix Proportions	W/C Ratio (max)
a) Fluid mix	Under 25mm	One part Portland	0.44

		Cement to one part sand	
b) General mix	25mm and over but less than 50mm	One part Portland Cement to 2 parts of sand	0.53
c) Stiff mix	50mm and over	One part Portland Cement to 3 parts of sand	0.53

**Non-Shrink Grout:** Non –shrink grout where required shall be provided in strict accordance with the manufacturer’s instructions / specifications on the drawings

#### **General**

**Inspection:** All materials, workmanship and finished construction shall be subject to continuous inspection and approval of ENGINEER IN CHARGE. Materials rejected by ENGINEER IN CHARGE shall be expressly removed from site and shall be replaced by Contractor immediately.

**Clean-Up:** Upon the completion of concrete work, all forms, equipment, construction tools, protective coverings and any debris, scraps of wood, etc. resulting from the work shall be removed and the premises left clean.

**Acceptance Criteria:** Any concrete work shall satisfy the requirements given below individually and collectively for it to be acceptable.

- a) properties of constituent materials;
- b) characteristic compressive strength;
- c) specified mix proportions;
- d) minimum cement content;
- e) maximum free-water/cement ratio;
- f) workability;
- g) temperature of fresh concrete;
- h) density of fully compacted concrete;
- i) cover to embedded steel;
- j) Curing;
- k) tolerances in dimensions;
- l) tolerances in levels;
- m) durability;
- n) surface finishes;
- o) special requirements such as;
  - i) water tightness
  - ii) resistance to aggressive chemicals
  - iii) resistance to freezing and thawing
  - iv) very high strength
  - v) improved fire resistance
  - vi) wear resistance
  - vii) resistance to early thermal cracking

The ENGINEER IN CHARGE's decision as to the acceptability or otherwise of any concrete work shall be final and binding on the Contractor.

For work not accepted, the ENGINEER IN CHARGE may review and decide whether remedial measures are feasible so as to render the work acceptable. The ENGINEER IN CHARGE shall in that case direct the Contractor to undertake and execute the remedial measures. These shall be expeditiously and effectively implemented by the Contractor. Nothing extra shall become payable to the Contractor by the Employer for executing the remedial measures.

### Water stops

**Material:** The material for the PVC waterstops shall be a plastic compound with the basic resin of polyvinyl chloride and additional resins, plasticizers, inhibitors, which satisfies the performance characteristics specified below as per IS:12200. Testing shall be in accordance with IS:8543.

a)	Tensile strength	:	3.6 N/mm <sup>2</sup> minimum
b)	Ultimate elongation	:	300% minimum
c)	Tear resistance	:	4.9 N/mm <sup>2</sup> minimum
d)	Stiffness in flexure	:	2.46 N/mm <sup>2</sup> minimum
e)	Accelerated extraction		
	i) Tensile strength	:	10.50 N/mm <sup>2</sup> minimum
	ii) Ultimate elongation	:	250% minimum
(f)	Effect of Alkali	:	7 days
	i) Weight increase	:	0.10% maximum
	ii) Weight decrease	:	0.10% maximum
	iii) Hardness change	:	± 5 points
(g)	Effect of Alkali	:	28 days
	i) Weight increase	:	0.40% maximum
	ii) Weight decrease	:	0.30% maximum
	iii) Dimension change	:	±1%

PVC water stops shall be either of the bar type, serrated with centre bulb and end grips for use within the concrete elements or of the surface (kicker) type for external use.

PVC water stops shall be of approved manufacture. Samples and the test certificate shall be got approved by the ENGINEER IN CHARGE before procurement for incorporation in the works. Alternatively G.I. sheet of 18 gage (1.3mm) thick and 200mm wide can be used by the contractor as construction joints.

Alternatively contractors can use G.I sheet 200mm wide and 18 gauge thick as constructions joints

### Workmanship

Water stops shall be cleaned before placing them in position. Oil or grease shall be removed thoroughly using water and suitable detergents.

Water stops shall be procured in long lengths as manufactured to avoid joints as far as possible. Standard L or T type of intersection pieces shall be procured for use depending on their requirement. Any non-standard junctions shall be made by cutting

the pieces to profile for jointing. Lapping of water stops shall not be permitted. All jointing shall be of fusion welded type as per manufacturer's instructions.

Water stops shall be placed at the correct location/level and suitably supported at intervals with the reinforcement to ensure that it does not deviate from its intended position during concreting and vibrating. Care shall also be taken to ensure that no honey-combing occurs because of the serrations/end grips, by placing concrete with smaller size aggregates in this region. Projecting portions of the waterstops embedded in concrete shall be thoroughly cleaned of all mortar/ concrete coating before resuming further concreting operations. The projecting waterstop shall also be suitably supported at intervals with the reinforcement to maintain its intended position during concreting so as to ensure that it does not bend leading to formation of pockets. In addition, smaller size aggregates shall be used for concreting in this region also.

### **Preformed Fillers and Joint Sealing Compound**

**Materials:** Preformed filler for expansion/isolation joints shall be non-extruding and resilient type of bitumen impregnated fibres conforming to IS:1838 (Part I).

Bitumen coat to concrete/masonry surfaces for fixing the preformed bitumen filler strip shall conform to IS:702. Bitumen primer shall conform to IS:3384. Sealing compound for filling the joints above the preformed bitumen filler shall conform to Grade 'A' as per IS:1834.

#### Workmanship

The thickness of the preformed bitumen filler shall be 25mm for expansion joints and 50mm for isolation joints around foundation supporting rotatory equipment's. Contractor shall procure the strips of the desired thickness and width in lengths as manufactured. Assembly of small pieces/thicknesses of strips to make up the specified size shall not be permitted.

The concrete/masonry surface shall be cleaned free from dust and any loose particles. When the surface is dry, one coat of industrial blown type bitumen of grade 85/25 conforming to IS:702 shall be applied hot by brushing at the rate of 1.20 kg/sq.m. When the bitumen is still hot the preformed bitumen filler shall be pressed and held in position till it completely adheres. The surface of the filler against which further concreting/masonry work is to be done shall similarly be applied with one coat of hot bitumen at the rate of 1.20 kg/sq.m.

Sealing compound shall be heated to a pouring consistency for enabling it to run molten in a uniform manner into the joint. Before pouring the sealing compound, the vertical faces of the concrete joint shall be applied hot with a coat of bitumen primer conforming to IS: 3384 in order to improve the adhesive quality of the sealing compound.

Expansion joints between beams/slabs shall be provided with 100mm wide x 4mm thick mild steel plate at the soffit of RCC beams/slabs to support and prevent the preformed joint filler from dislodging. This plate shall be welded to an edge angle of ISA 50 x 50 x 6mm provided at the bottom corner, adjacent to the expansion joint of one of the beams/slabs, by intermittent fillet welding. Steel surfaces shall be provided with 2 coats of red oxide zinc chrome primer and 3 coats of synthetic enamel paint finish.



## STRUCTURAL STEEL WORK

### Applicable Codes and Specifications

The supply, fabrication, erection and painting of structural steel works shall comply with the following specifications, standards and codes unless otherwise specified herein. All standards, specifications and codes of practices referred to herein shall be the latest editions including all applicable official amendments and revisions.

IS : 808	Dimensions for Hot Rolled Steel sections
IS : 814	Covered Electrodes for Manual Metal Arc Welding of Carbon and Carbon Maganese Steel
IS : 800	Code of Practice for General Construction in Steel
IS : 801	Code of Practice for Use of Cold Formed Light Gauge Steel Structural Members in General Building Construction
IS : 806	Code of Practice for Use of Steel Tubes in General Building Construction
IS : 7205	Safety Code for Erection of Structural Steel Work
IS : 7215	Tolerances for Fabrication of Steel Structures
IS : 4000	High Strength Bolts in Steel Structure – Code of Practice
AISC	Specifications for Design, Fabrication and Erection of Buildings
IS : 1161	Steel Tubes for structural purposes
IS:10 IS:102	Ready Mixed paint, Brushing, Red Lead, Non-setting, Priming.
IS:110	Ready Mixed paint, brushing, grey filler for enamels for use over primers.
IS:117	Ready Mixed paint, Brushing, Finishing, and Exterior Semigloss for general purposes, to Indian Standard colours.
IS:158	Ready Mixed paint, Brushing, Bituminous, Black, Lead free, Acid, Alkali and heat resisting.
IS:159	Ready Mixed paint, Brushing, Acid resisting for protection against acid fumes, colour as required.
IS:341	Black Japan, Types A, B and C
IS:2339	Aluminum paint for general purposes, in Dual container
IS:2932	Specification for enamel, synthetic, exterior, type 1, (a) Undercoating, (b) finishing
IS:2933	Specification for enamel, exterior, type 2, (a) Undercoating, (b) finishing
IS:5905	Sprayed aluminum and zinc coatings on Iron and Steel.
IS:6005	Code of practice for phosphating of Iron and Steel.
IS:9862	Specification for ready mixed paint, brushing, bituminous, black, lead free, acid, alkali, water & chlorine resisting.
IS:13183	Aluminum paint, Heat resistant.
SIS-05-5900	(Swedish Standard)
IS : 1239	Mild steel tubes, tubulars and other Wrought steel fittings
	Part 1 – Mild steel tubes
	Part 2 – Mild steel tubulars and other wrought steel pipe fittings
IS : 1363 (Parts 1 to 3)	Hexagon Head Bolts, Screws and Nuts of product Grade C (Size range M5 to M64)
IS : 1367 (All parts)	Technical Supply Conditions for Threaded Fasteners
IS : 1852	Rolling and Cutting Tolerances for Hot Rolled Steel Products
IS : 1977	Structural Steel (Ordinary Quality)
IS : 2062	Steel for General Structural Purposes
IS : 2074	Ready Mixed Paint, Air drying, Red Oxide Zinc Chrome and Priming

IS : 3502	Steel Chequered Plate
IS : 3757	High Strength Structural Bolts
IS : 5369	General Requirements for Plain Washers and Lock Washers
IS : 5372	Taper Washers for Channels
IS : 5374	Taper Washer for 1 Beams
IS : 6610	Heavy Washers for Steel Structures
IS : 8500	Structural Steel-microalloyed (medium and high strength qualities)
IS : 803	Code of practice for design, fabrication and erection of vertical mild steel cylindrical welded storage tanks
IS : 816	Code of Practice for use of Metal Arc Welding for General construction in Mild Steel
IS : 822	Code of Procedure for Inspection of Welds
IS : 1182	Recommended Practice for Radiographic examination of Fusion – Welded Butt Joints in Steel Plates
IS : 1200	Method of Measurement in Building Civil Works
IS : 1477	Code of Practice for Painting of (Parts 1&2) Ferrous Metals in Buildings
IS : 2595	Code of Practice for Radiographic Testing
IS : 3658	Code of Practice for Liquid Penetrant Flaw Detection
IS : 5334	Code of Practice for Magnetic Particle Flaw Detection of Welds
IS : 9595	Recommendations for Metal Arc Welding of Carbon and Carbon Manganese Steel

### Steel Materials

Steel materials shall comply with the referred to in **Sub-Clause 4.1**.

All materials used shall be new, unused and free from defects.

Steel conforming to IS: 1977 shall be used only for the following:

Fe310-0 (St 32-0)	For general purposes such as door/window frames, grills, steel gates, handrails, fence posts, tee bars and other non-structural use.
Fe410-0 (St 42-0)	For structures not subjected to dynamic loading other than wind loads such as: Platform roofs, foot over bridges, building, factory sheds etc.
Fe510-0 (St 42-0)	Grade steel shall not be used
	<ul style="list-style-type: none"> <li>a) If welding is to be employed for fabrication</li> <li>b) If site is in severe earthquake zone</li> <li>c) If plastic theory of design is used</li> </ul>

### Drawings prepared by the VENDOR/CONTRACTOR

The VENDOR/CONTRACTOR shall prepare all 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.

All fabrication drawings shall be submitted to the ENGINEER IN CHARGE for approval.

No fabrication drawings will be accepted for Engineer In Charge's approval unless checked and approved by the VENDOR/Contractor's qualified structural engineer and accompanied by an erection plan showing the location of all pieces detailed. The VENDOR/CONTRACTOR shall ensure that connections are detailed to obtain ease in erection of structures and in making field connections.

Fabrication shall be started by the VENDOR/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 VENDOR/CONTRACTOR from the responsibility for

correctness of engineering and design of connections, workmanship, fit of parts, details, material, errors or omissions or 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.

The drawings prepared by the VENDOR/CONTRACTOR and all subsequent revisions etc. shall be at the cost of the VENDOR/CONTRACTOR for which no separate payment will be made.

## **Fabrication**

### **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 approved by the ENGINEER IN CHARGE, 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.

### **Connections**

Shop/field connections shall be as per approved fabrication drawings. 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 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, except in case of high strength friction grip bolts where this projection shall be at least three times the pitch of the thread.

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.

All connections and splices shall be designed for full strength of members or loads. Column splices shall be designed for the full tensile strength of the minimum cross section at the splice.

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.

All members likely to collect rainwater shall have drain holes provided.

### **Straightening**

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.

### **Rolling and Forming**

Plates, channels, R.S.J. etc., for circular bins, bunkers, hoppers, gantry girders, etc., shall be accurately laid off and rolled or formed to required profile/shape as called for on the drawings. Adjacent sections shall be match-marked to facilitate accurate assembly, welding and erection in the field.

### **High Strength Friction Grip Bolting**

Inspection after tightening of bolts shall be carried out as stipulated in the appropriate standards depending upon the method of tightening and the type of bolt used.

### **Welding**

Welding procedure shall be submitted to the ENGINEER IN CHARGE for approval. Welding shall be entrusted to qualified and experienced welders who shall be tested periodically and graded as per IS 817, IS: 7310 (Part 1) and IS: 7318 (Part 1).

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 off welding, these welds shall be ground flush prior to assembly.

Approval of the welding procedure 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.

No welding shall be done when the surface of the members is wet nor during periods of high wind.

Each layer of a multiple layer weld except root and surfaces runs may be moderately panned with light blows from a blunt tool. Care shall be exercised to prevent scaling or flaking of weld and base metal from overweening.

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.

Electrodes other than low-hydrogen electrodes shall not be permitted for thickness of 32 mm and above.

All welds shall be inspected for flaws by any of the methods described under **Sub-clause 4.6.3**. The choice of the method adopted shall be agreed with the ENGINEER IN CHARGE.

The correction of defective welds shall be carried out in a manner approved 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 approved 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. The cost of all such tests and operations incidental to correction shall be borne by the Contractor.

### **Tolerances**

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

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

### **End Milling**

Where compression joints are specified to be designed for bearing, the bearing surfaces shall be milled true and square to ensure proper bearing and alignment.

### **Inspection**

#### **General**

The Contractor shall give due notice to the ENGINEER IN CHARGE in advance of the works being made ready for inspection. All rejected material shall be promptly removed from the shop and replaced with new material for the Engineer In Charge's 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 prevent proper assembly nor shall it invalidate any claim which the Employer may make because of defective or unsatisfactory materials and/or workmanship.

No materials shall be painted or dispatched to site without inspection and approval by the ENGINEER IN CHARGE unless such inspection is waived in writing by the ENGINEER IN CHARGE.

The Contractor shall provide all the testing and inspection services and facilities for shop work except where otherwise specified.

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.

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 tested by the Contractor to the Employer's Representative's satisfaction to demonstrate conformity with the relevant specification.

### Tests on Welds

- (a) **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.
- (b) **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.
- (c) **Radiographic Inspection**  
All full strength butt welds shall be radiographed in accordance with the recommended practice for radiographic testing as per relevant IS code.

### 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.

### Test Failure

In the event of failure of any member to satisfy inspection or test requirement, the Contractor shall notify the ENGINEER IN CHARGE. The Contractor must obtain permission from the ENGINEER IN CHARGE before any 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 he deems necessary, and the additional cost of such testing shall be borne by the Employer, only in case of successful testing.

The Contractor shall maintain records of all inspection and testing which shall be made available to the ENGINEER IN CHARGE.

## **Shop Matching**

For structures like bunkers, tanks, etc. Shop assembly is essential. For other 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 the Contractor.

## **Drilling Holes for other works**

As a part of this Contract, holes in members required for installing equipment or steel furnished by other manufacturers or other contractors shall be drilled by the VENDOR/CONTRACTOR at no extra cost of the EMPLOYER. The information for such extra holes will be supplied by the EMPLOYER/ENGINEER IN CHARGE.

## **Marking of Members**

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.

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.

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.

#### **Errors**

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. Where the ENGINEER IN CHARGE rejects such material or defective workmanship, the same shall be replaced by materials and workmanship conforming to the Specifications by the Contractor, at no cost to the Employer.

#### **Painting of Steel Work**

All fabricated steel material, except those galvanised shall receive protective paint coating as specified in specification, which is described below.

#### **Materials**

- Red-oxide – zinc chrome primer shall conform to IS:2074.
- Synthetic enamel paint shall conform to IS : 2932.
- Aluminum paint shall conform to IS:2339.

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 color/shade. All the materials shall be brought to the site in sealed containers.

#### **Workmanship**

Painting work shall be carried out only on thoroughly dry surfaces. Painting shall be applied either by brushing or by spraying. Contractor shall procure the appropriate quality of paint for this purpose as recommended by the manufacturer. The workmanship shall generally conform to the requirement of IS:1477 (Part 2).

The type of paint, number of coats etc. shall be as specified in the respective items of work.

Primer and finish paint shall be compatible with each other to avoid cracking and wrinkling. Primer and finish paint shall be from the same manufacturer.

All the surfaces shall be thoroughly cleaned of oil, grease, dirt, rust and scale. The methods to be adopted using solvents, wire brushing, power tool cleaning etc., shall be as per IS:1477 (Part – I) and as indicated in the item of work.

It is essential to ensure that immediately after preparation of the surfaces, the first coat of red oxide-zinc chrome primer 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'.

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 synthetic enamel paint of optimum thickness shall be applied by brushing 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.

The first finishing coat of paint shall be applied by brushing and allowed to hard dry. The gloss from the entire surface shall then be gently removed and the surface dusted off. The second finishing coat shall then be applied by brushing.

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.

#### **Acceptance of Steel, its Handling & Storage**

The Contractor shall carefully check the steel to be erected at the time of acceptance. Any fabrication defects observed should be brought to the notice of the ENGINEER IN CHARGE.

No dragging of steel shall be permitted. All steel 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 the Contractor. Steel shall not be stored in the vicinity of areas where excavation or grading will be done and, if so stored temporarily, this shall be removed by the Contractor well before such excavation and/or grading commences to a safe distance to avoid burial under debris.

- a) Scratched or abraded steel shall be given a coat of primer in accordance with the Specifications 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 damage.

### **Anchor Bolts & Foundations**

The Contractor shall carefully check the location and layout of anchor bolts embedded in foundations constructed, to ensure that the structures can be properly erected as shown on the drawings. Any discrepancy in the anchor bolts/foundation shall be reported to the ENGINEER IN CHARGE.

Leveling of column bases to the required elevation may be done either by providing shims or three nuts on the upper threaded portion of the anchor bolt. All shim stock required for keeping the specified thickness of grout and in connection with erection of structures on foundations, crane brackets or at any other locations shall be of good M.S. plates and shall be supplied by the Contractor at his cost.

A certain amount of cleaning of foundations and preparing the area is considered normal and shall be carried out by the Contractor at no extra cost. Here beams bear in pockets or on walls, bearing plates shall be set and leveled as part of the work. All grouting under column base plates or beam bearing plates will be carried out by the Contractor.

### **Assembly & connections**

Field connections may be effected by riveting, bolting, welding or by use of high strength friction grip bolts as shown on the design and erection drawings.

All field connection work shall be carried as per the drawings. All bolts, nuts, washers, rivets, electrodes required for field connections shall be supplied by the Contractor free of cost.

All assembling shall be carried on a level platform.

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 normal diameter of hole shall not be used. Any damaged holes or burrs must be rectified to the satisfaction of the ENGINEER IN CHARGE.

Corrections of minor misfits and reasonable amount of reaming and cutting of excess stock from rivets shall be considered as a part of erection. 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 the ENGINEER IN CHARGE.

### **Erection**

All structural steel shall be erected as shown on the drawings prepared by the Contractor. Proper size steel cable slings, etc., shall be used for hoisting. Guys shall not be anchored to existing structures, foundations, etc., unless so permitted by the ENGINEER IN CHARGE in writing. Care shall be taken to see that ropes in use are always in good condition.

Steel columns in the basement, if any, are to be lowered and erected carefully with the help of a crane and/or derrick without damaging the basement walls or floor.

Structural steel frames shall be erected plumb and true. Frames shall be lifted at points such that they are not liable to buckle and deform. Trusses shall be lifted only at node points. In the case of trusses, roof girders, all of the purlins and wind bracing shall be placed simultaneously and the columns shall be erected truly plumb on screed bars over the pedestals. All steel columns and beams shall be checked for plumb and level individually before and after connections are made. 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.

Chequered plates shall be fixed to supporting members by tack welding or by countersunk bolts as shown/specified in relevant drawings and/or as approved by the ENGINEER IN CHARGE. The edges shall be made smooth and no burrs or jagged ends shall be left. While splicing, care should be taken so that there is continuity in pattern between the two portions. Care should also be taken to avoid distortion of the plate while welding. The erection of chequered plates shall include:

- a) Welding of stiffening angles/vertical stiffening ribs
- b) Cutting to size and making holes to required shape wherever necessary to allow service piping and/or cables to pass through
- c) Splicing as shown in relevant drawings
- d) Smoothing of edges
- e) Fixing of chequered plates by tack welding or by countersunk bolts
- f) Providing lifting hooks for ease of lifting.

As erection progresses, the work shall be securely bolted to take care of all dead load, wind, seismic and erection stresses.

No riveting or welding or final bolting shall be done until the structure has been properly aligned and approved by the ENGINEER IN CHARGE. No cutting, heating or enlarging of the holes shall be carried out without the prior written approval of the ENGINEER IN CHARGE. The Contractor shall furnish test certificates.

### **Inspection**

The ENGINEER IN CHARGE shall have free access to all parts of the job during erection and all erection shall be subjected to his approval. In case of faulty erection, all dismantling and re-erection required will be at the Contractor's cost. No paint shall be applied to rivet heads or field welds or bolts until these have been approved by the ENGINEER IN CHARGE.

### **Tolerances**

#### **General**

Tolerances mentioned below shall be achieved after the entire structure or part thereof is in line, level and plumb.

#### **Columns**

Deviation of column axes at foundation top level with respect to true axes:

- |     |                           |       |
|-----|---------------------------|-------|
| (a) | In longitudinal direction | ±5 mm |
| (b) | In lateral direction      | ±5 mm |

Deviation in the level of bearing surface of columns at foundation top with respect to true level ±5mm.

Out of plumbness (verticality) of column axis from true vertical axis, as measured at column top:

- |     |   |   |
|-----|---|---|
| (a) | For columns up to and including 15 m in ht. | ±1/1000 of column height in mm<br>or ±15 mm whichever is less |
| (b) | For columns exceeding 15 m in ht.           | ±1/1000 of column height in mm<br>or ±20 mm whichever is less |

Deviation in straightness in longitudinal And transverse planes of column at any Point along the height	±1/1000 of column height in mm or ±10 mm whichever is less
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Difference in erected position of adjacent Pairs of columns along length or across Width of building prior to connecting trusses/beams with respect to true distance	±10mm
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Deviation in any bearing or seating level with respect to true level	±5 mm
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Deviation in differences in bearing level of a member on adjacent pair of columns both across and along the building	±10 mm
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### Trusses And Beams

Shift at the centre of span of top chord member with respect to the vertical plane passing through the centre of bottom chord	$\pm 1/250$ of height of truss in mm or $\pm 15$ mm whichever is less
Lateral shift of top chord of truss at the centre of span from the vertical plane passing through the center of supports of the truss	$\pm 1/1500$ of span of truss in mm or $\pm 15$ mm whichever is less
Lateral shift in location of truss from its true vertical position	$\pm 10$ mm
Lateral shift in location of purlin true position	$\pm 5$ mm
Deviation in difference of bearing levels of trusses or beams from	i) $\pm 20$ mm for trusses ii) For beams : the true difference
Depth < 1800mm :	$\pm 6$ mm
Depth > 1800mm :	$\pm 10$ mm
Deviation in sag in chords and diagonals	$1/1500$ of length in mm or of truss between node points 10 mm whichever is smaller
Deviation in sweep of trusses beams etc.	$1/1000$ of span in mm subject in the horizontal plan to a maximum of 10 mm

### Crane Girders & Rails

Shift in the centre line of crane rail with respect to centre line of web of crane girder	$\pm 5$ mm
Shift in plan of alignment of crane rail with	$\pm 5$ mm
<b>Crane Girder &amp; Rails</b>	
Shift in the centre line of crane rail with Respect to centre line of web of crane girder	$\pm 5$ mm
Shift in plan of alignment of crane rail with respect to true axis of crane rail at any point	$\pm 1$ mm
Difference in alignment of crane rail in plan measured between any two points 2 meters Apart along rail	$\pm 1$ mm
Deviation in crane track with respect to Time gauge	
For track gauges Upto and Including 15 meters	$\pm 5$ mm
For track gauges more than 15 meters	$\pm [5 + 0.25 (S-15)]$ where S in meters is true gauge
Deviation in the crane rail level at any Point from true level	$\pm 1/1200$ of the gauge distance or $\pm 10$ mm whichever is less
Difference in the crane rail actual levels Between any two points 2 meters apart Along the rail length	$\pm 2$ mm
Difference in levels between crane track Rails at	
(a) Supports of crane girders	$\pm 15$ mm
(b) Mid span of crane girders	$\pm 20$ mm
Relative shift of crane rail surfaces at a Joint in plane and elevation surfaces for smooth transition	2 mm subject to grinding of

Relative shift in the location of crane  $1/1000$  of track gauge S in stops (end buffers) along the crane tracks mm subject to maximum with track gauge S in mm of 20 mm

**Painting**

After steel has been erected, all bare and abraded spots, rivet heads, 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 paint before erection.

**Clean up of Work site**

During erection, the Contractor shall 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 the ENGINEER IN CHARGE.

## BUILDING DETAILS

### Applicable Codes and Specifications

The following codes and standards are included in this section, as part of these specifications. However, respective IS codes for the works not mentioned here shall also be applicable for those particular items of work.

- IS:110 - Ready mixed paint, brushing, gray filler, for Enamels for use over primers
- IS:269 - Specification for 33 grade ordinary portland cement
- IS:280 - Specification for mild steel wire for general Engineering purposes
- IS:287 - Recommendations for maximum permissible Moisture content of timber used for different purposes
- IS:304 - High Tensile Brass Ingots and Castings.
- IS:337 - Varnish, finishing interior
- IS:348 - French polish
- IS:383 - Specification for coarse and fine aggregates from natural sources for concrete
- IS:412 - Expanded metal steel sheets for general purposes
- IS:419 - Specification for putty for use on window frames
- IS:428 - Distemper, oil emulsion, color as required
- IS:459 - Specification for unreinforced corrugated and semi-corrugated asbestos cement sheets
- IS:702 - Specification for industrial bitumen
- IS:710 - Specification for marine plywood
- IS:712 - Specification for building limes
- IS:730 - Specification for hook bolts for corrugated sheet Roofing
- IS:733 - Wrought aluminum and aluminum alloys, bars, Rods and sections for general engineering purposes
- IS:777 - Specification for glazed earthenware tiles
- IS:1003 - Specification for timber panelled and glazed shutters (Parts 1 & 2)
- IS:1038 - Specification for steel doors, windows and ventilators
- IS:1077 - Specification for common burnt clay building bricks
- IS:1081 - Code of practice for fixing and glazing of metal (steel & aluminium) doors, windows and ventilators
- IS:1124 - Method of test for determination of water absorption, apparent specific gravity and porosity of natural building stones
- IS:1237 - Specification for cement concrete flooring tiles
- IS:1322 - Bitumen felts for water proofing and damp proofing
- IS:1346 - Code of practice for water proofing of roofs with bitumen felts
- IS:1361 - Specification for steel windows for industrial buildings
- IS:1397 - Specification for kraft paper
- IS:1443 - Code of practice for laying and finishing of cement concrete flooring tiles
- IS:1477 - Code of practice for painting of ferrous metals in buildings (Parts 1 & 2)
- IS:1542 - Specification for sand for plaster
- IS:1580 - Specification for bituminous compounds for water-proofing and caulking purposes
- IS:1597 - Code of practice for construction of stone masonry : Part 1 Rubble stone masonry
- IS:1659 - Specification for block boards
- IS:1661 - Code of practice for application of cement and cement-lime plaster finishes
- IS:1834 - Specification for hot applied sealing compound for joint in concrete
- IS:1838 - Specification for preformed fillers for expansion joint in concrete pavements and structures (non extruding and resilient type) : Part 1 Bitumen impregnated fibre

IS:1948	- Specification for aluminum doors, windows and ventilators
IS:1949	- Specification for aluminum windows for industrial buildings
IS:2074	- Ready mixed paint, air drying, red oxide- zinc chrome, priming
IS:2098	- Asbestos cement building boards
IS:2114	- Code of practice for laying in-situ terrazzo floor finish
IS:2116	- Specification for sand for masonry mortars
IS:2185	- Specification for concrete masonry units (Parts 1,2 & 3)
IS:2202	- Specification for wooden flush door shutters (Solidcore type) : Parts 1& 2
IS:2212	- Code of practice for brickwork
IS:2250	- Code of practice for preparation and use of masonry mortars
IS:2338	- Code of practice for finishing of wood and wood based materials (Parts 1 & 2)
IS:2339	- Aluminum paint for general purposes, in dual container
IS:2395	- Code of practice for painting concrete, masonry and plaster surfaces (Parts 1 & 2)
IS:2402	- Code of practice for external rendered finishes
IS:2571	- Code of practice for laying in-situ cement concrete flooring
IS:2572	- Code of practice for construction of hollow concrete block masonry
IS:2645	- Specification of integral cement waterproofing compounds
IS:2690	- Specification for burnt clay flat terracing tiles : Part 1 Machine made
IS:2691	- Specification for burnt clay facing bricks
IS:2750	- Specification for steel scaffoldings
IS:2835	- Flat transparent sheet glass
IS:2932	- Specification for enamel, synthetic, exterior type (a) undercoating, (b) finishing
IS:3007	- Code of practice for laying of asbestos cement sheets - corrugated and (Part 1 & 2) semi-corrugated sheets
IS:3036	- Code of practice for laying lime concrete for a water-proofed roof finish
IS:3067	- Code of practice of general design details and preparatory work for damp-proofing and water- proofing of buildings
IS:3068	- Specification for broken brick (burnt clay) coarse aggregates for use in lime concrete
IS:3384	- Specification for bitumen primer for use in water-proofing and damp-proofing
IS:3461	- Specification for PVC-asbestos floor tiles
IS:3462	- Specification for unbacked flexible PVC flooring
IS:3495	- Method of test for burnt clay building bricks: Part 1 to 4
IS:3536	- Specification for ready mixed paint, brushing, wood primer, pink
IS:3564	- Specification for door closures (hydraulically regulated)
IS:3696	- Safety code of scaffolds and ladders (Parts 1 & 2)
IS:4020	- Methods of test for wooden flush door : Type test
IS:4021	- Specification for timber door, window and ventilator frames
IS:4351	- Specification for steel door frames
IS:4443	- Code of practice for use of resin type chemical resistant mortars
IS:4457	- Specification for ceramic unglazed vitreous acid resisting tile
IS:4631	- Code of practice for laying epoxy resin floor toppings
IS:4832	- Specification for chemical resistant mortars (Part II)
IS:4860	- Specification for acid resistant bricks
IS:4948	- Specification for welded steel wire fabric for general use
IS:5318	- Code of practice for laying of flexible PVC sheet and tile flooring
IS:5410	- Cement paint, colour as required
IS:5411	- Specification for plastic emulsion paint (Parts 1 & 2)
IS:5437	- Wired and figured glass
IS:5491	- Code of practice for laying of in-situ granolithic concrete floor topping

IS:6041	- Code of practice construction of autoclaved cellular concrete block masonry
IS:6042	- Code of practice for construction of light weight concrete block masonry
IS:6248	- Specification for metal rolling shutters and rolling grilles
IS:7193	- Specification for glass fibre base coal tar pitch and bitumen felts
IS:7452	- Specification for hot rolled steel sections for doors, windows and ventilators
IS:8042	- Specification for white portland cement
IS:8543	- Methods of testing plastics
IS:8869	- Specification for washers for corrugated sheet roofing
IS:9197	- Specification for epoxy resin, hardeners and epoxy resin composites for floor topping
IS:9862	- Specification for ready mixed paint, brushing, bituminous, black, lead- free, acid, alkali, water and chlorine resisting
IS:12200	- Code of practice for provision of waterstops at transverse contraction joints in masonry and concrete dams

### **Brickwork:**

**Materials:** Bricks used in the works shall conform to the requirements laid down in IS: 1077. The class of the bricks shall be as specifically indicated in the respective items of work prepared by the Contractor.

The nominal size of the modular brick shall be 200mmx100mmx100mm with the permissible tolerances over the actual size of 190mmx90mmx90mm as per IS: 1077. The nominal thickness of one brick and half brick walls using modular bricks shall be considered as 200 mm and 100 mm respectively. In the event of use of traditional bricks of nominal size 230 mmx115mmx75mm with tolerance upto  $\pm 3$  mm in each dimension, one brick and half brick walls shall be considered as 230 mm and 115 mm respectively.

Bricks shall be sound, hard, homogenous in texture, well burnt in kiln without being vitrified, hand/machine moulded, deep red, cherry or copper coloured, of regular shape and size & shall have sharp and square edges with smooth rectangular faces. The bricks shall be free from pores, cracks, flaws and nodules of free lime. Hand moulded bricks shall be moulded with a frog and those made by extrusion process may not be provided with a frog. Bricks shall give a clear ringing sound when struck and shall have a minimum crushing strength of 3N/sq.mm unless otherwise specified in the Items of work prepared by the Contractor.

The average water absorption shall not be more than 20 percent by weight up to class 12.5 and 15 percent by weight for higher classes. Bricks which do not conform to this requirement shall be rejected. Over or under burnt bricks are not acceptable for use in the works.

Sample bricks shall be submitted to the GWSSB for approval and bricks supplied shall conform to approved samples. If demanded by GWSSB, brick samples shall be got tested as per IS: 3495 by Contractor. Bricks rejected by GWSSB shall be removed from the site of works within 24 hours.

Mortar for brick masonry shall consist of cement and sand and shall be prepared as per IS: 2250. Mix shall be in the proportion of 1:5 for brickwork of thickness one brick or above and 1:4 for brickwork of thickness half brick or below, unless otherwise specified in the respective items of work prepared by the Contractor. Sand for masonry mortar shall conform to IS:218. The sand shall be free from clay, shale, loam, alkali and organic matter and shall be of sound, hard, clean and durable particles. Sand shall be approved by GWSSB. If so directed by the GWSSB, sand shall be screened and washed till it satisfies the limits of deleterious materials.

For preparing cement mortar, the ingredients shall first be mixed thoroughly in dry condition. Water shall then be added and mixing continued to give a uniform mix of required consistency. Mixing shall be done thoroughly in a mechanical mixer, unless hand mixing is specifically permitted by the GWSSB. The mortar thus mixed shall be used as soon as possible, preferably within 30 minutes from the time water is added to cement. Incase, the mortar has stiffened due to evaporation of water, this may be re-tempered by adding water as required to

restore consistency, but this will be permitted only up to 30 minutes from the time of initial mixing of water to cement. Any mortar which is partially set shall be rejected and shall be removed forthwith from the site. Droppings of mortar shall not be re-used under any circumstances. The Contractor shall arrange for test on mortar samples if so directed by the GWSSB.

### **Workmanship:**

Workmanship of brick work shall conform to IS: 2212. All bricks shall be thoroughly soaked in clean water for at least one hour immediately before being laid. The cement mortar for brick masonry work shall be as specified in the respective item of work prepared by the Contractor. Brick work 200mm/230mm thick and over shall be laid in English Bond unless otherwise specified. 100mm/115mm thick brickwork shall be laid with stretchers. For laying bricks, a layer of mortar shall be spread over the full width of suitable length of the lower course. Each brick shall be slightly pressed into the mortar and shoved into final position so as to embed the brick fully in mortar. Only full size bricks shall be used for the works and cut bricks utilised only as closers to make up required wall length or for bonding. Bricks shall be laid with frogs on top.

All brickwork shall be plumb, square and true to dimensions shown. Vertical joints in alternate courses shall come directly one over the other and be in line. Horizontal courses shall be leveled. The thickness of brick courses shall be kept uniform. In case of one brick thick or half brick thick wall, at least one face should be kept smooth and plane, even if the other is slightly rough due to variation in size of bricks. For walls of thickness greater than one brick both faces shall be kept smooth and plane. All interconnected brickwork shall be carried out at nearly one level so that there is uniform distribution of pressure on the supporting structure and no portion of the work shall be left more than one course lower than the adjacent work. Where this is not possible, the work shall be raked back according to bond (and not saw toothed) at an angle not exceeding 45 deg. But in no case the level difference between adjoining walls shall exceed one meter. Brickwork shall not be raised more than one meter per day.

Bricks shall be so laid that all joints are well filled with mortar. The thickness of joints shall not be less than 6 mm and not more than 10 mm. The face joints shall be raked to a minimum depth of 10mm/15mm by raking tools during the progress of work when the mortar is still green, so as to provide a proper key for the plastering/ pointing respectively to be done later. When plastering or pointing is not required to be done, the joints shall be uniform in thickness and be struck flush and finished at the time of laying. The face of brickwork shall be cleaned daily and all mortar droppings removed. The surface of each course shall be thoroughly cleaned of all dirt before another course is laid on top.

During inclement weather conditions, newly built brick masonry works shall be protected by tarpaulin or other suitable covering to prevent mortar being washed away by rain.

Brickwork shall be kept constantly moist on all the faces for at least seven days after 24 hrs of lying. The arrangement for curing shall be got approved from the GWSSB.

Double scaffolding having two sets of vertical supports shall be provided to facilitate execution of the masonry works. The scaffolding shall be designed adequately considering all the dead, live and possible impact loads to ensure safety of the workmen, in accordance with the requirements stipulated in IS:2750 and IS:3696 (Part I). Scaffolding shall be properly maintained during the entire period of construction. Single scaffolding shall not be used on important works and will be permitted only in certain cases as decided by the GWSSB. Where single scaffolding is adopted, only minimum number of holes, by omitting a header shall be left in the masonry for supporting horizontal scaffolding poles. All holes in the masonry shall be carefully made good before plastering/pointing.

In the event of usage of traditional bricks of size 230 mm x115mm x75mm, the courses at the top of the plinth and sills as well as at the top of the wall just below the roof/floor slabs and at the top of the parapet shall be laid with bricks on edge.

All brickwork shall be built tightly against columns, floor slabs or other structural members.

To overcome the possibility of development of cracks in the brick masonry following measures shall be adopted.

For resting RCC slabs, the bearing surface of masonry wall shall be finished on top with 12 mm thick cement mortar 1:3 and provided with 2 layers of Kraft paper Grade 1 as per IS:1397 or 2 layers of 50 micron thick polyethylene sheets.

RCC/ steel beams resting on masonry wall shall be provided with reinforced concrete bed blocks of 50 mm thickness, projecting 50mm on either sides of the beam, duly finished on top with 2 layers of Kraft paper Grade 1 as per IS:1397 or 2 layers of 50 micron thick polyethylene sheets.

Steel wire fabric shall be provided at the junction of brick masonry and concrete before taking up plastering work.

Bricks for partition walls shall be stacked adjacent to the structural member to pre-deflect the structural member before the wall is taken up for execution. Further, the top most course of half or full brick walls abutting against either a deshuttered slab or beam shall be built only after any proposed masonry wall above the structural member is executed to cater for the deflection of the structural element.

Reinforced cement concrete transoms and mullions of dimensions as indicated in the construction Drawings to be prepared by the Contractor are generally required to be provided in the half brick partition walls.

Where the drawings prepared by the Contractor indicate that structural steel sections are to be encased in brickwork, the brickwork masonry shall be built closely against the steel section, ensuring a minimum of 20mm thick cement-sand mortar 1:4 over all the steel surfaces. Steel sections partly embedded in brickwork shall be provided with bituminous protective coating to the surfaces at the point of entry into the brick masonry.

Facing bricks of the type specified conforming to IS: 2691 shall be laid in the positions indicated on the Drawings prepared by the Contractor and all facing brickwork shall be well bonded to the backing bricks/RCC surfaces. The level of execution of the facing brickwork shall at any time be lower by at least 600 mm below the level of the backing brickwork.

Facing bricks shall be laid over 10 mm thick backing of cement mortar. The mortar mix, thickness of joint and the type of pointing to be carried out shall be as specified in the item of works prepared by the Contractor. The pattern of laying the bricks shall be as specifically indicated in the Drawings prepared by the Contractor. For facing brickwork, double scaffolding shall be used. Faced works shall be kept clean and free from damage, discoloration etc., at all times.

### **Uncoursed Random Rubble Masonry, in Foundation, Plinth and Superstructure**

#### **Materials:**

Stones for the works shall be of the specified variety, which are hard, durable, fine grained and uniform in colour (for superstructure work) free from veins, flaws and other defects. Quality and work shall conform to the requirements specified in IS: 1597 (Part-I). The percentage of water absorption shall not exceed 5 percent as per test conducted in accordance with IS: 1124. The Contractor shall supply sample stones to the GWSSB for approval. Stones shall be laid with its grains horizontal so that the load transmitted is always perpendicular to the natural bed.

Cement-sand mortar for stone masonry works shall be in the proportion of 1:6. Materials and preparation of mortar shall be as specified in clause 7.2.1.

#### Workmanship

For All Works below ground level the masonry shall be random rubble uncoursed with ordinary quarry dressed stones for the hearting and selected quarry dressed stones for the facing.

For all works above ground level and in superstructure the masonry shall be random rubble uncoursed, well bonded, faced with hammer dressed stones with squared quoins at corners. The bushings on the face shall not be more than 40 mm on an exposed face and on the

face to be plastered it shall not project by more than 12 mm nor shall it have depressions more than 10 mm from the average wall surface.

Face stones shall extend back sufficiently and bond well with the masonry. The depth of stone from the face of the wall inwards shall not be less than the height or breadth at the face. The length of the stone shall not exceed three times the height and the breadth on base shall not be greater than three-fourths the thickness of wall nor less than 150 mm. The height of stone may be upto a maximum of 300 mm. Face stones or hearting stones shall not be less than 150 mm in any direction.

Chips and spalls shall be used wherever necessary to avoid thick mortar joints and to ensure that no hollow spaces are left in the masonry. The use of chips and spalls in the hearting shall not exceed 20 percent of the quantity of stone masonry. Spalls and chips shall not be used on the face of the wall and below hearting stones to bring them to the level of face stones.

The maximum thickness of joints shall not exceed 20 mm. All joints shall be completely filled with mortar. When plastering or pointing is not required to be done, the joints shall be struck flush and finished as the work proceeds. Otherwise, the joints shall be raked to a minimum depth of 20 mm by a raking tool during the progress of the work while the mortar is still green.

Through or bond stones shall be provided in walls up to 600 mm thick and in case of walls above 600 mm thickness, a set of two or more bond stones overlapping each other by at least 150 mm shall be provided in a line from face to back. In case of highly absorbent types of stones (porous lime stone and sand stone, etc.) the bond stone shall extend about two-thirds into the wall and a set of two or more bond stones overlapping each other by at least 150 mm shall be provided. Each bond stone or a set of bond stones shall be provided for every 0.5 sq.m of wall surface.

All stones shall be sufficiently wetted before laying to prevent absorption of water from the mortar. All connected walls in a structure shall be normally raised uniformly and regularly. However if any part of the masonry is required to be left behind, the wall shall be raked back (and not saw toothed) at an angle not exceeding 45deg. Masonry work shall not be raised by more than one metre per day.

Green work shall be protected from rain by suitable covering. Masonry work shall be kept constantly moist on all the faces for a minimum period of seven days for proper curing of the joints.

Type of scaffolding to be used shall be as specified in clause 7.2.2.

### **Coursed Rubble Masonry (First Sort) for Superstructure**

#### **Materials**

The Material specification for the work shall be as per clause 7.3.1.

#### **Workmanship**

All Courses shall be laid truly horizontal and shall be of the same height in any course. The height of course shall not be less than 150 mm and not more than 300 mm. The width of stone shall not be less than its height.

Face stones shall tail into the work for not less than their height and at least 1/3rd the number of stones shall tail into the work for a length not less than twice their height but not more than three-fourths the thickness of the wall whichever is smaller. These should be laid as headers and stretchers alternately to break joints by at least 75 mm.

The face stones shall be squared on all joints and beds; the bed joints being hammer or chisel dressed true and square for at least 80 mm back from the face and the side joints for at least 40 mm. The face of the stone shall be hammer dressed so that the bushing shall not be more than 40 mm on an exposed face and 10 mm on a face to be plastered. No portion of the dressed surface shall show a depth of gap more than 6 mm from a straight edge placed on it. The remaining unexposed portion of the stone shall not project beyond the surface of bed and side joints.



No spalls or pinnings shall be allowed on the face. All bed joints shall be horizontal and side joints shall be vertical and no joints shall be more than 10 mm in thickness. When plastering or pointing is not required to be done, the joints shall be struck flush and finished as the work proceeds. Otherwise, the joints shall be raked to a minimum depth of 20 mm by a raking tool, during the progress of the work while the mortar is still green.

Hearting shall consist of flat bedded stones carefully laid on their proper beds and solidly bedded in mortar. The use of chips shall be restricted to the filling of interstices between the adjacent stones in hearting and these shall not exceed 10 percent of the quantity of the stone masonry. Care shall be taken so that no hollow spaces are left anywhere in the masonry.

The requirement regarding through or bond stones shall be as specified in clause 7.3.2 with the further stipulation that these shall be provided at 1.5 m to 1.8m apart clear in every course but staggered at alternate courses.

The quoins which shall be of the same height as the course in which they occur, shall not be less than 450 mm in any direction. Quoin stones shall be laid as stretchers and headers alternately. They shall be laid square on their beds, which shall be rough chisel dressed to a depth of at least 100 mm from the face. These stones shall have a minimum uniform chisel drafts of 25mm width at four edges, all the edges being in the same plane.

Type of scaffolding to be used shall be as per Clause 7.2.2. Requirements of execution of the work and curing shall be as stipulated in clause 7.3.2 .

### **Concrete Block Masonry**

#### **Materials**

Masonry units of hollow and solid concrete blocks shall conform to the requirements of IS : 2185 (Part I).

Masonry units of hollow and solid light-weight concrete blocks shall conform to the requirements of IS : 2185 (Part 3).

Masonry units of autoclaved cellular concrete blocks shall conform to the requirements of IS:2185 (Part 3).

The height of the concrete masonry units shall not exceed either its length or six times its width.

The nominal dimensions of concrete block shall be as under.

Length 400, 500 or 600 mm

Height 100 or 200 mm

Width 100 to 300 mm in 50 mm increments

Half blocks shall be in lengths of 200, 250 or 300mm to correspond to the full length blocks.

Actual dimensions shall be 10mm short of the nominal dimensions.

The maximum variation in the length of the units shall not be more than  $\pm 5$  mm and maximum variation in height or width of the units shall not be more than  $\pm 3$ mm.

Concrete blocks shall be either hollow blocks with open or closed cavities or solid blocks.

Concrete blocks shall be sound, free of cracks, chipping or other defects which impair the strength or performance of the construction. Surface texture shall as specified. The faces of

the units shall be flat and rectangular, opposite faces shall be parallel and all arises shall be square.

The bedding surfaces shall be at right angles to the faces of the block.

The concrete mix for the hollow and solid concrete blocks/light weight concrete blocks shall not be richer than one part of cement to six parts of combined aggregates by volume. Concrete blocks shall be of approved manufacture, which satisfy the limitations in the values of water absorption, drying shrinkage and moisture movement, as specified for the type of block as per relevant IS code. Contractor shall furnish the test certificates and also supply the samples for the approval of GWSSB.

### Workmanship

The type of the concrete block, thickness and grade based on the compressive strength for use in load bearing and/or non-load bearing walls shall be as specified. The minimum nominal thickness of non-load bearing internal walls shall be 100mm. The minimum nominal thickness of external panel walls in framed construction shall be 200 mm.

The workmanship shall generally conform to the requirements of IS:2572 for concrete block masonry, IS:6042 for light weight concrete block masonry and IS:6041 for autoclaved cellular concrete block masonry works.

From considerations of durability, generally concrete block masonry shall be used in superstructure works above the damp-proof course level.

Concrete blocks shall be embedded with a mortar which is relatively weaker than the mix of the blocks in order to avoid the formation of cracks. Cement mortar of proportion 1:6 shall be used for the works. Preparation of mortar shall be as specified in clause 7.2.1.

The thickness of both horizontal and vertical joints shall be 10mm. The first course shall be laid with greater care, ensuring that it is properly aligned, levelled and plumb since this will facilitate in laying succeeding courses to obtain a straight and truly vertical wall. For the horizontal (bedding) joint, mortar shall be spread over the entire top surface of the block including front and rear shells as well as the webs to a uniform layer of 10mm. For vertical joints, the mortar shall be applied on the vertical edges of the front and rear shells of the blocks. The mortar may be applied either to the unit already placed on the wall or on the edges of the succeeding unit when it is standing vertically and then placing it horizontally, well pressed against the previously laid unit to produce a compacted vertical joint. In case of two cell blocks with slight depression on the vertical sides these shall also be filled up with mortar to secure greater lateral rigidity. To assure satisfactory bond, mortar shall not be spread too far ahead of actual laying of the block as the mortar will stiffen and lose its plasticity Mortar while hardening shrinks slightly and thus pulls away from the edges of the block. The mortar shall be pressed against the units with a jointing tool after it has stiffened to effect intimate contact between the mortar and the unit to obtain a weather tight joint. The mortar shall be raked to a depth of 10mm as each course is laid to ensure good bond for the plaster.

Dimensional stability of hollow concrete blocks is greatly affected by variations of moisture content in the units. Only well dried blocks should be used for the construction. Blocks with moisture content more than 25% of maximum water absorption permissible shall not be used. The blocks should not be wetted before or during laying in the walls. Blocks should be laid dry except slightly moistening their surfaces on which mortar is to be applied to obviate absorption of water from the mortar.

As per the design requirements and to effectively control cracks in the masonry, RCC bound beams/studs, joint reinforcement shall be provided at suitable locations. Joint reinforcement shall be fabricated either from mild steel wires conforming to IS:280 or welded wire fabric/high strength deformed basis.

For jambs of doors, windows and openings, should concrete blocks shall be provided. If hollow units are used, the hollows shall be filled with concrete of mix 1:3:6. Hold fasts of doors/windows should be arranged so that they occur at block course level.

At intersection of walls, the courses shall laid up at the same time with a true masonry bond between atleast 50% of the concrete blocks. The sequence for construction of partition walls and treatment at the top of load bearing walls for the RCC slab shall be as detailed under clause 7.2 for the brick work.

Curing of the mortar joints shall be carried out for atleast 7 days. The walls should only be lightly moistened and shall not be allowed to become excessively wet.

Double scaffolding as per clause 7.2.2 shall be adopted for execution of block masonry work.

Cutting of the units shall be restricted to a minimum. All horizontal and vertical dimensions shall be in respectively, adopting modular co-ordination for walls, opening locations for doors, windows etc.

Concrete blocks shall be stored at site suitably to avoid any contact with moisture from the ground and covered to protect against wetting.

### **Damp - Proof Course**

#### **Materials and Workmanship**

Where Specified, all the walls in a building shall be provided with damp-proof course cover plinth to prevent water from rising up the wall. The damp-proof course shall run without a break throughout the length of the wall, even under the door or other openings. Damp-proof course shall consist of 50 mm thick cement concrete of 1:2:4 nominal mix with approved water-proofing compound admixture conforming to IS: 2645 in proportion as directed by the manufacturer. Concrete shall be with 10 mm down graded coarse aggregates.

The surface of brick work/stone masonry work shall be levelled and prepared before laying the cement concrete. Side shuttering shall be properly fixed to ensure that slurry does not leak through and is also not disturbed during compaction. The upper and side surface shall be made rough to afford key to the masonry above and to the plaster.

Damp-proof course shall be cured properly for atleast seven days after which it shall be allowed to dry for taking up further work.

### **Miscellaneous Inserts, Bolts etc.**

All the miscellaneous inserts such as bolts, pipes, plate embedments etc., shall be accurately installed in the building works at the correct location and levels, all as detailed in the construction Drawings to be prepared by the Contractor prepared by the Contractor. Contractor shall prepare and use templates for this purpose, if so directed by the GWSSB. In the event, of any of the inserts are improperly installed, Contractor shall make necessary arrangements to remove and reinstall at the correct locations/levels, all as directed by the GWSSB.

### **Wood Work for Doors, Windows, Ventilators & Partitions**

#### **Materials**

Timber To be used shall be first class Teak wood as per IS:4021. Timber shall be of the best quality and well seasoned by a suitable process before being planed to the required sizes. The maximum permissible moisture content shall be from 10 to 16 percent for timber 50mm and above in thickness and 8 to 14 percent of timber less than 50mm in thickness for different regions of the country as stipulated in IS:287. Timber shall be close grained, of uniform colour and free from decay, fungal growth, boxed heart, pitch pockets or streaks on the exposed edges, borer holes, splits and cracks.

Flush door shutters of the solid core type with plywood face panels shall conform to IS:2202 (Part1) and with particle board/hard board face panels shall conform to IS:2202 (Part2).

Transparent sheet glass shall conform to the requirements of IS:2835. Wired and figured glass shall be as per IS:5437.

Builder's hardware for fittings and fixtures shall be of the best quality from approved manufacturers.

### Workmanship

The workmanship and finish of wood work in doors, windows, ventilators and partitions shall be of a very high order. Contractor shall ensure that work is executed in a professional manner by skilled carpenters for good appearance, efficient and smooth operation of the shutters.

All works shall be executed as per the detailed Drawings prepared by the Contractor and/or as directed by the GWSSB.

All members of the door, window, and ventilator shall be straight without any warp or bow and shall have smooth well planed faces. The right angle shall be checked from the inside surfaces of the respective members of the frame. Frames shall have mortice and tenon joints which shall be treated with an approved adhesive and provided with metal or wood pins. The vertical members of the door frame shall project 50 mm below the finished floor level. The finished dimension of frames shall be rebated on the solid for keying with the plaster and for receiving the shutters. The depth of rebate for housing the shutter shall be 15 mm. The size of the frames shall be as specified in the respective items of work prepared by the Contractor. The workmanship shall generally conform to the requirements specified in IS:4021.

The face of the frames abutting the masonry or concrete shall be provided with a coat of coal tar.

Three hold fasts using 25 mm x 6 mm mild steel flats 225 mm long with split ends shall be fixed on each side of door and window frames, one at the centre and the other two at 300 mm from the top and bottom of the frame. For window and ventilator frames less than 1 m in height, two hold fasts on each side shall be fixed at quarter points.

Timber panelled shutters for doors, windows and ventilators shall be constructed in the form of framework of stiles and rails with panel insertion. The panels shall be fixed by either providing grooves in the stiles and rails or by beading. Glazing bars shall be as detailed in the Drawings prepared by the Contractor. The stiles and rails shall be joined by mortice and tenon joints at right angles. All members of the shutter shall be straight without any warp or bow and shall have smooth, well planed faces at right angles to each other. The right angle for the shutter shall be checked by measuring the diagonals and the difference shall not be more than  $\pm 3$  mm. Timber panels made from more than one piece shall be jointed with a continuous tongued and grooved joint, glued together and reinforced with metal dowels. The workmanship shall generally conform to the requirements specified in IS:1003 (Parts 1 & 2). The thickness of the shutter, width/thickness of the stiles/rails/panel type shall be as specified. Marine plywood panels conforming to IS:710 shall be used for doors where specified.

Details of the wooden flush door shutters, solid core type with specific requirement of the thickness, core, face panels, viewing glazed panel, venetian louvre opening, teak wood lipping etc. shall be as specified. Panels of shutter shall be of marine plywood conforming to IS:710. Flush door shutters shall be from reputed manufacturers and Contractor shall submit test results as per IS:4020, if so desired by the GWSSB.

Glazing of door, window, ventilator and partitions shall be with either flat transparent sheet glass, wired or figured glass. Transparent sheet glass shall be of 'B' quality as per IS:2835. The thickness and type of glazing to be provided shall be as specified.

The material of the fittings and fixtures either of chromium plated steel, cast brass, copper oxidized or anodized aluminum shall be as specified. The number, size and type of the fittings and fixtures shall be as specified.

Woodwork shall not be provided with the finishes of painting/varnishing etc. unless it has been approved by the GWSSB. The type of finish and the number of coats shall be as stipulated in the respective items of work prepared by the Contractor. Preparation of the wood surfaces and application of the finishes shall be in accordance with clause 7.32.

Wooden hand railing and architrave's shall be of the size and shape with the fixing arrangement as indicated in the Drawings prepared by the Contractor.

The framework of the partitions with mullions and transoms shall be with the sections of dimensions as specified. Panels of double/single glazing/plywood shall be fixed as per details specified. Partitions shall be fixed rigidly between the floor and structural columns/beams including provision of necessary shims for wedging etc. Finished work shall be of rigid construction, erected truly plumb to the lines and levels, at locations as per the construction Drawings prepared by the Contractor.

Any carpentry work which shows defects due to inadequate seasoning of the timber or bad workmanship shall be removed and replaced by Contractor with work as per Specifications.

### **Steel Doors, Windows and Ventilators**

#### **Materials**

Hot rolled steel sections for the fabrication of steel doors, windows and ventilators shall conform to IS: 7452, which are suitable for, single glazing.

Pressed steel door frames for steel flush doors shall be out of 1.25mm thick mild steel sheets of profiles as per IS : 4351.

Transparent sheet glass shall conform to the requirements of IS : 2835. Wired and figured glass shall be as per IS : 5437.

Builder's hardware of fittings and fixtures shall be of the best quality from the approved manufacturers.

#### **Workmanship**

All steel doors, windows and ventilators shall be of the type as specified in the respective items of work prepared by the Contractor and of sizes as indicated in the Drawings prepared by the Contractor prepared by the Contractor. Steel doors, windows and ventilators shall conform to the requirements as stipulated in IS : 1038. Steel windows shall conform to IS : 1361, if so specified.

Doors, windows and ventilators shall be of an approved manufacture. Fabrication of the unit shall be with rolled section, cut to correct lengths and metered. Corners shall be welded to form a solid fused welded joint conforming to the requirements of IS : 1038. Tolerance in overall dimensions shall be within  $\pm 1.5\text{mm}$ . The frames and shutters shall be free from warp or buckle and shall be square and truly plain. All welds shall be dressed flush on exposed and contact surfaces. Punching of holes, slots and other provisions to install fittings and fixtures later shall be made at the correct locations as per the requirements. Samples of the units shall be got approved by the GWSSB before further manufacture/purchase by the Contractor.

Type and details of shutters, hinges, glazing bar requirement, couplings, locking arrangement, fittings and fixtures shall be as described in the respective items of work and / or as shown in the Drawings prepared by the Contractor for single or composite units.

For windows with fly proof mesh as per the item of work prepared by the Contractor, rotor operator arrangement, for the operation of the glazed shutters from the inside shall be provided.

Pressed steel door frames shall be provided with fixing lugs at each jamb, hinges, lock-strike plate, mortar guards, angle threshold, shock-absorbers of rubber or similar material as per the requirements of IS : 4351. Pressed steel doorframes shall be fixed as 'built-in' as the masonry work proceeds. After placing it plumb at the specified location, masonry walls shall be built up solid on either side and each course grouted with mortar to ensure solid contact with the doorframe, without leaving any voids. Temporary struts across the width shall be fixed, during erection to prevent bow/sag of the frame.

Door shutters of flush welded construction shall be 45mm thick, fabricated with two outer skins of 1.25mm thick steel sheets, 1mm thick steel sheet stiffeners and steel channels on all four edges. Double shutters shall have meeting stile edge beveled or rebated. Provision of glazed viewing panel, louvers shall be made as per the items of works and/or Drawings prepared by the Contractor. Shutters shall be suitably reinforced for lock and other surface hardware and to prevent sagging/twisting. Single sheet steel door shutters shall be fabricated out of 1.25mm thick steel sheets, mild steel angles and stiffeners as per the Drawings prepared by the Contractor.

Doors, windows and ventilators shall be fixed into the prepared openings. They shall not be 'built-in' as the masonry work proceeds, to avoid distortion and damage of the units. The dimensions of the masonry opening shall have 10mm clearance around the overall dimensions of the frame for this purpose. Any support of scaffolding members on the frames/glazing bars is prohibited.

Glazing of the units shall be either with flat transparent glass or wired / figured glass of the thickness as specified in the items of works prepared by the Contractor. All glass panels shall have properly squared corner and straight edges. Glazing shall be provided on the outside of the frames.

Fixing of the glazing shall be either with spring glazing clips and putty conforming to IS:419 or with metal beads. Pre-formed PVC or rubber gaskets shall be provided for fixing the beads with the concealed screws. The type of fixing the glazing shall be as indicated in the items of work and/or in Drawings prepared by the Contractor.

Steel doors, windows and ventilators shall be provided with finish of either painting as specified or shall be hot dip galvanised with thickness of the zinc coating as stipulated all as described in the respective items of works prepared by the Contractor.

The material of the Builders hardware of fittings and fixtures of chromium plated steel, cast brass, brass copper oxidised or anodised aluminium shall be as specified in the items of works prepared by the Contractor. The number, size and type of fittings and fixtures shall be as in the Drawings /items of works prepared by the Contractor.

Installation of the units with fixing lugs, screws, mastic caulking compound at the specified locations shall generally conform to the requirements of IS:1081. Necessary holes etc required for fixing shall be made by the Contractor and made good after installation. Workmanship expected is of a high order for efficient and smooth operation of the units.

## **Aluminum Doors, Windows, Ventilators & Partitions**

### Materials

Aluminum alloy used in the manufacture of extruded sections for the fabrication of doors, windows, ventilators shall conform to designation HE9-WP of IS:733.

Transparent sheet glass shall conform to the requirements of IS:2835. Wired and figured glass shall be as per IS:5437.

Builder's hardware of fittings & fixtures shall be of the best quality from approved manufacturers.

### Workmanship

All aluminum doors, windows, ventilators and partitions shall be of the type and size as specified. The doors, windows, ventilators shall conform to the requirements of IS:1948. Aluminum windows, shall conform to IS:1949, if so specified.

All aluminum units shall be supplied with anodized finish. The minimum anodic film thickness shall be 0.015 mm.

Doors, windows and ventilators shall be of an approved manufacture. Fabrication of the units shall be with the extruded sections, cut to correct lengths, mitred and welded at the corners to a true right angle conforming to the requirements of IS:1948. Tolerance in overall dimensions shall be within  $\pm 1.5\text{mm}$ . The frames and shutters shall be free from warp or buckle and shall be square and truly plane. Punching of holes, slots and other provisions to install fittings or fixtures later shall be made at the correct locations, as per the requirements.

Aluminium swing type doors, aluminum sliding windows, partitions shall be as specified.

IS:1948 and IS:1949 referred to incorporates the sizes, shapes, thicknesses and weight per running metre of extruded sections for the various components of the units. However, new sizes, shapes, thicknesses with modifications to suit snap-fit glazing clips etc. are being continuously being added by various leading manufacturers of extruded sections, which are available in the market. As such, the sections of the various components of the unit proposed by the Contractor, will be reviewed by the GWSSB and will be accepted only if they are equal to or marginally more than that given in the codes/as specified.

The framework of the partitions with mullions and transomes shall be with anodised aluminium box sections. Anodised aluminium box sections shall be in-filled with timber of class 3 (silver oak or any other equivalent) as per IS:4021. Panels of double/single glazing/plywood shall be fixed as per details indicated in the Drawings to be prepared by the Contractor. Partitions shall be fixed rigidly between the floor and the structural columns/beams including provision of necessary shims for wedging etc. Finished work shall be of rigid construction, erected truly plumb to the lines and levels, at locations as per the construction Drawings to be prepared by the Contractor.

Specific provisions as stipulated for steel doors, windows, ventilators under clause 7.9.2 shall also be applicable for this item work. Glazing beads shall be of the snap-fit type suitable for the thickness of glazing proposed as indicated in the items of works prepared by the Contractor. A layer of clear transparent lacquer shall be applied on aluminium sections to protect them from damage during installation. This lacquer coating shall be removed after the installation is completed.

## **Steel Rolling Shutters**

### Materials and Workmanship

Rolling shutters shall be of an approved manufacture, conforming to the requirements specified in IS:6248.

The type of rolling shutter shall be self coiling type (manual) for clear areas upto 12 sq.m, gear operated type (mechanical) for clear areas upto 35 sq.m and electrically operated type for areas upto 50 sq.m. Mechanical type of rolling shutters shall be suitable for operation from both inside and outside with the crank handle or chain gear operating mechanism duly considering the size of wall/column. Electrical type of rolling shutter shall also be provided with a facility for emergency mechanical operation.

Rolling shutters shall be supplied duly considering the type, specified clear width/height of the opening and the location of fixing as indicated in the Drawings prepared by the Contractor.

Shutters shall be built up of interlocking laths 75 mm width between rolling centres formed from cold rolled steel strips. The thickness of the steel strip shall not be less than 0.90 mm for shutters upto 3.50m width and not less than 1.20 mm for shutters above 3.50 m width. Each lath section shall be continuous single piece without any welded joint.

The guide channels out of mild steel sheets of thickness not less than 3.15 mm shall be of either rolled, pressed or built up construction. The channel shall be of size as stipulated in IS:6248 for various clear widths of the shutters.

Hood covers shall be of mild steel sheets not less than 0.90 mm thick and of approved shape.

Rolling shutters shall be provided with a central hasp and staple safety device in addition to one pair of lever locks and sliding locks at the ends.

All component parts of the steel rolling shutter (excepting springs and insides of guide channels) shall be provided with one coat of zinc chrome primer conformity to IS:2074 at the shop before supply. These surfaces shall be given an additional coat of primer after erection at the site along with the number of coats and type of finish paint as specified in the respective items of works prepared by the Contractor. Painting shall be carried out as per clause 7.33.

In case of galvanised rolling shutter, the lath sections, guides, lock plate, bracket plates, suspension shaft and the hood cover shall be hot dip galvanised with a zinc coating containing not less than 97.5 percent pure zinc. The weight of the zinc coating shall be atleast 610gms/sq.m.

Guide channels shall be installed truly plumb at the specified location. Bracket plate shall be rigidly fixed with necessary bolts and holdfasts. Workmanship of erection shall ensure strength and rigidity of rolling shutter for trouble free and smooth operation.

## **Rubble Sub-Base**

### Materials

Stones used for rubble packing under floors on grade, foundations etc., shall be clean, hard, durable rock free from veins, flaws, laminations, weathering and other defects. Stones shall generally conform to the requirements stipulated in IS: 1597 (Part I).

Stones shall be as regular as can be obtained from quarries. Stones shall be of height equal to the thickness of the packing proposed with a tolerance of  $\pm 10$  mm. Stones shall not have a base area less than 250 sq cm nor more than 500 sq.cm, and the smallest dimension of any



stone shall not be less than half the largest dimension. The quality and size of stones shall be subject to the approval of the GWSSB.

#### Workmanship

Stones shall be hand packed carefully and laid with their largest base downwards resting flat on the prepared sub-grade and with their height equal to the thickness of the packing. Stones shall be laid breaking joints and in close contact with each other. All interstices between the stones shall be wedged-in by small stones of suitable size, well driven in by crow bars and hammers to ensure tight packing and complete filling-in of the interstices. The wedging shall be carried out simultaneously with the placing in position of rubble packing and shall not lag behind. After this, any interstices between the smaller wedged stones shall be infilled with clean hard sand by brooming so as to fill the joints completely.

The laid rubble packing shall be sprinkled with water and compacted by using suitable rammers.

#### **Base Concrete**

The thickness and grade of concrete and reinforcement shall be as specified in items of works prepared by the contractor.

Before placing the blinding concrete, the sub-base of rubble packing shall be properly wetted and rammed. Concrete for the base shall then be deposited between the forms, thoroughly tamped and the surface finished level with the top edges of the forms. Two or three hours after the concrete has been laid in position, the surface shall be roughened using steel wire brush to remove any scum or laitance and swept clean so that the coarse aggregates are exposed. The surface of the base concrete shall be left rough to provide adequate bond for the floor finish to be provided later.

#### **Terrazzo and Plain Cement Tiling Work**

##### **Materials**

Terrazzo tiles and cement tiles shall generally conform in all respects to standards stipulated in IS:1237. Tiles shall be of the best quality manufactured adopting hydraulic pressure of not less than  $14\text{N/mm}^2$ .

The type, quality, size, thickness colour etc, of the tiles for flooring/dado/skirting shall be as specified.

The aggregates for terrazzo topping shall consist of marble chips which are hard, sound and dense. Cement to be used shall be either ordinary portland cement or white cement with or without colouring pigment. The binder mix shall be with 3 parts of cement to 1 part of marble powder by weight. The proportion of cement shall be inclusive of any pigments. For every one part of cement-marble powder binder mix, the proportion of aggregates shall be 1.75 parts by volume, if the chips are between 1mm to 6mm and 1.50 parts by volume if the chips are between 6mm to 25mm.

The minimum thickness of wearing layer of terrazzo tiles shall be 5mm for tiles with chips of size varying from 1mm upto 6mm or from 1mm upto 12mm. This shall be 6mm for tiles with chips varying from 1mm upto 25mm. The minimum thickness of wearing layer of cement/coloured cement tiles shall be 5mm. This shall be 6mm for heavy duty tiles. Pigment used in the wearing layer shall not exceed 10 percent of the weight of cement used in the mix.

#### Workmanship

Laying and finishing of tiles shall conform to the requirements of workmanship stipulated in IS:1443.

Tiling work shall be commenced only after the door and window frames are fixed and plastering of the walls/ ceiling is completed. Wall plastering shall not be carried out upto about 50mm above the level of proposed skirting/dado.

The base concrete shall be finished to a reasonably plane surface about 40 to 45mm below the level of finished floor. Before the tiling work is taken up, the base concrete or structural slab shall be cleaned of all loose materials, mortar droppings, dirt, laitance etc. using steel wire brush and well wetted without allowing any water pools on the surface.

A layer of 25mm average thickness of cement mortar consisting of one part of cement to 6 parts of sand shall be provided as bedding for the tiles over the base concrete. The thickness of bedding mortar shall not be less than 10mm at any place. The quantity of water to be added for the mortar shall be just adequate to obtain the workability for laying. Sand for the mortar shall conform to IS:2116 and shall have minimum fineness modulus of 1.5. The surface shall be left rough to provide a good bond for the tiles. The bedding shall be allowed to harden for a day before laying of the tiles.

Neat cement slurry using 4.4 kg of cement per sq.m of floor area shall be spread over the hardened mortar bedding over such an area at a time as would accommodate about 20 tiles. Tiles shall be fixed in this slurry one after the other, each tile being gently tapped with a wooden mallet till it is properly bedded and in level with the adjoining tiles. The joints shall be in straight lines and shall normally be 1.5mm wide. On completion of laying of the tiles in a room, all the joints shall be cleaned and washed fairly deep with a stiff broom/wire brush to a minimum depth of 5mm. The day after the tiles have been laid, the joints shall be filled with cement grout of the same shade as the colour of the matrix of the tile. For this purpose white cement or grey cement with or without pigments shall be used. The flooring should be kept moist and left undisturbed for 7 days for the bedding/joints to set properly. Heavy traffic shall not be allowed on the floor for atleast 14 days after fixing of the tiles.

About a week after laying the tiles, each and every tile shall be lightly tapped with a small wooden mallet to find out if it gives a hollow sound; if it does, such tiles along with any other cracked or broken tiles shall be removed and replaced with new tiles to proper line and level. The same procedure shall be followed again after grinding the tiles and all damaged tiles replaced, properly jointed and finished to match. For the purpose of ensuring that such replaced tiles match with those laid earlier, it is necessary that the Contractor shall procure sufficient quantity of extra tiles to meet this contingency.

Wherever a full tile cannot be provided, tiles shall be cut to size and fixed. Floor tiles adjoining the wall shall go about 10mm under the plaster, skirting or dado.

Tile skirting and dado work shall be executed only after laying tiles on the floor. For dado and skirting work, the vertical wall surface shall be thoroughly cleaned and wetted. Thereafter it shall be evenly and uniformly covered with 10mm thick backing of 1:4 cement sand mortar. For this work the tiles as obtained from the factory shall be of the size required and practically full polished. The back of each tile to be fixed shall be covered with a thin layer of neat cement paste and the tile shall then be gently tapped against the wall with a wooden mallet. Fixing shall be done from the bottom of the wall upwards. The joints shall be in straight lines and shall normally be 1.5mm wide. Any difference in the thickness of the tiles shall be evened out in the backing mortar or cement paste so that the tile faces are in conformity & truly plumb. Tiles for use at the corners shall be suitably cut with bevelled edges to obtain a neat and true joint. After the work has set, hand polishing with carborundum stones shall be done so that the surface matches with the floor finish.

Wall plastering of the strip left out above the level of skirting/dado shall be taken up after the tiles are fixed.

Chequered terrazzo tiles for flooring and for stair treads shall be delivered to site after the first machine grinding.

Machine grinding and polishing shall be commenced only after a lapse of 14 days of laying. The sequence and three numbers of machine grinding operations, usage of the type of carborundum stones, filling up of pin holes, watering etc. shall be carried out all as specified in IS:1443.

Tiles shall be laid to the levels specified. Where large areas are to be tiled the level of the central portion shall be kept 10mm higher than that at the walls to overcome optical illusion of a depression in the central portion. Localised deviation of  $\pm 3\text{mm}$  in any 3m length is acceptable in a nominally flat floor.

### **In-Situ Terrazzo Work**

#### **Materials**

The requirements of marble aggregates for terrazzo topping shall be as per clause 7.14.1.

Cement shall first be mixed with the marble powder in dry state. The mix thus obtained shall be mixed with the aggregates in the specified proportions. Care shall be taken not to get the materials into a heap which results in the coarsest chips falling to the edges and cement working to the centre at the bottom. Materials shall be kept, as far as possible, in an even layer during mixing. After the materials have been thoroughly mixed in the dry state, water shall be added, just adequate to obtain plastic consistency for the desired workability for laying. The mix shall be used in the works within 30 minutes of the addition of water to the cement.

#### Workmanship

The thickness, type, quality, size and colour of chips etc. for the in-situ terrazzo finish for flooring/dado/ skirting shall be as specified in the respective items of works prepared by the Contractor. Laying and finishing of in-situ work shall conform to the requirements of workmanship stipulated in IS: 2114.

In-situ terrazzo finish shall be laid over hardened concrete base. The finish layer consists of an under layer and terrazzo topping. The underlayer shall be of cement concrete of mix 1:2:4 using 10mm down graded coarse aggregates. The combined thickness of under layer and topping shall not be less than 30 mm for flooring and 20mm for dado/skirting work.

The minimum thickness of topping shall be 6mm if chips used are between 1mm to 4mm, 9mm if chips are between 4mm to 7mm and 12mm if chips are between 7mm to 10mm. If chips larger than 10mm size are used, the minimum thickness shall be one and one third the maximum size of chips.

Both the underlayer and later the topping shall be divided into panels not exceeding 2 sq.m for laying so as to reduce the possibility of development of cracks. The longer dimension of any panel shall not exceed 2m. Dividing strips shall be used to separate the panels. When the dividing strips are not provided, the bays shall be laid alternately, allowing an interval of at least 24 hours between laying adjacent bays.

Dividing strips shall be either of aluminium, brass or other material as indicated in the items of works prepared by the Contractor. Aluminum strips should have a protective coating of bitumen. The thickness of the strips shall be not less than 1.5mm and width not less than 25mm for flooring work.

Concrete base shall be finished to a reasonably plane surface to a level below the finished floor elevation equal to the specified thickness of terrazzo finish. Before spreading the underlayer, the base concrete surface shall be cleaned of all loose materials, mortar droppings, dirt, laitance etc. and well wetted without allowing any water pools on the surface. Dividing strips or screed strips, if dividing strips are not provided shall be fixed on the base and levelled to the correct height to suit the thickness of the finish. Just before spreading the underlayer the surface shall be smeared with cement slurry at 2.75 Kg/sq.m. Over this slurry, the underlayer

shall be spread and levelled with a screeding board. The top surface shall be left rough to provide a good bond for the terrazzo topping.

Terrazzo topping shall be laid while the underlayer is still plastic and normally between 18 to 24 hours after the underlayer is laid. Cement slurry of the same colour as the topping shall be brushed on the surface immediately before laying is commenced. The terrazzo mix shall be laid to a uniform thickness and compacted thoroughly by tamping and with a minimum of troweling. Straight edge and steel floats shall be used to bring the surface true to the required level in such a manner that the maximum amount of marble chips come up and spread uniformly all over the surface.

The surface shall be left dry for air-curing for a period of 12 to 18 hours. Thereafter it shall be cured by allowing water to stand in pools for a period of not less than 4 days.

Machine grinding and polishing shall be commenced only after a lapse of 7 days from the time of completion of laying. The sequence and four numbers of machine grinding operations, usage of the type of carborundum stones, filling up of pinholes, wet curing, watering etc shall be carried out all as specified in IS: 2114.

### **Shahabad / Tandur/ Kota Stone Slab work**

#### **Materials**

The slabs shall be of approved selected quality, hard, sound, dense and homogenous in texture, free from cracks, decay, weathering and flaws. The percentage of water absorption shall not exceed 5 percent as per test conducted in accordance with IS : 1124.

The slabs shall be hand or machine cut to the required thickness. Tolerance in thickness for dimensions of tile more than 100mm shall be  $\pm 5\text{mm}$ . This shall be  $\pm 2\text{mm}$  on dimensions less than 100mm.

Slabs shall be supplied to the specified size with machine cut edges or fine chisel dressed to the full depth. All angles and edges of the slabs shall be true and square, free from any chipping giving a plane surface. Slabs shall have the top surface machine polished (first grinding) before being brought to site. The slabs shall be washed clean before laying.

#### **Workmanship**

The type, size, thickness and colour/shade etc. of the slabs for flooring/dado/skirting shall be as specified in the respective items of works prepared by the Contractor.

Preparation of the concrete base, laying and curing shall be as per clause 7.14.2.

Dado / skirting work shall be as per clause 7.14.2. The thickness of the slabs for dado/skirting work shall not be more than 25mm. Slabs shall be so placed that the back surface is at a distance of 12mm. If necessary, slabs shall be held in position temporarily by suitable method. After checking for verticality, the gap shall be filled and packed with cement sand mortar of proportion 1:3. After the mortar has acquired sufficient strength, the temporary arrangement holding the slab shall be removed.

Grinding and polishing shall be as per clause 7.14.2 except that first grinding with coarse grade carborundum shall not be done and cement slurry with or without pigment shall not applied before polishing.

### **Carborundum Tile Finish**

#### **Materials**

Carborundum tiles shall generally conform in all respects to the standards stipulated in IS:1237 for heavy duty tiles. Tiles shall be of the best quality manufactured adopting hydraulic pressure of not less than  $14 \text{ N/mm}^2$ .

The topping shall be uniform and of thickness not less than 6mm. The quantity of carborundum grit shall be not less than  $1.35 \text{ kg/sq.m}$  used with cement with or without pigment. The carborundum grit shall pass through 1.18mm mesh and shall be retained on 0.60 mm mesh.

### Workmanship

Requirements as detailed for terrazzo/cement tile finish under clause 7.14.2 shall be applicable for carborundum tile flooring.

### **Glazed Tile Finish**

#### Materials

Glazed earthenware tiles shall conform to the requirements of IS: 777. Tiles shall be of the best quality from an approved manufacturer. The tiles shall be flat, true to shape and free from flaws such as crazing, blisters, pinholes, specks or welts. Edges and underside of the tiles shall be free from glaze and shall have ribs or indentations for a better anchorage with the bedding mortar. Dimensional tolerances shall be as specified in IS: 777.

### Workmanship

The total thickness of glazed tile finish including the bedding mortar shall be 20 mm in flooring/dado/skirting. The minimum thickness of bedding mortar shall be 12mm for flooring and 10mm for dado/skirting work.

The bedding mortar shall consist of 1 part of cement to 3 parts of sand mixed with just sufficient water to obtain proper consistency for laying. Sand for the mortar shall conform to IS: 2116 and shall have minimum fineness modulus of 1.5.

Tiles shall be soaked in water for about 10 minutes just before laying. Where full size tiles cannot be fixed, tiles shall be cut to the required size using special cutting device and the edges rubbed smooth to ensure straight and true joints.

Coloured tiles with or without designs shall be uniform and shall be preferably procured from the same batch of manufacture to avoid any differences in the shade.

Tiles for the flooring shall be laid over hardened concrete base. The surface of the concrete base shall be cleaned of all loose materials, mortar droppings etc well wetted without allowing any water pools on the surface. The bedding mortar shall then be laid evenly over the surface, tamped to the desired level and allowed to harden for a day. The top surface shall be left rough to provide a good bond for the tiles. For skirting and dado work, the backing mortar shall be roughened using a wire brush.

White cement slurry using 3.3 kg cement per sq.m of floor area shall be spread over the hardened mortar bed over such an area as would accommodate about 20 tiles. Tiles shall be fixed in this slurry one after the other, each tile being gently tapped with a wooden mallet till it is properly bedded and in level with the adjoining tiles. For skirting and dado work, the back of the tiles shall be smeared with cement slurry for setting on the backing mortar. Fixing of tiles shall be done from the bottom of the wall upwards. The joints shall be in perfect straight lines and as thin as possible but shall not be more than 1mm wide. The surface shall be checked frequently to ensure correct level/required slope. Floor tiles near the walls shall enter skirting/dado to a minimum depth of 10mm. Tiles shall not sound hollow when tapped.

All the joints shall be cleaned of grey cement with wire brush to a depth of atleast 3mm and all dust, loose mortar etc. shall be removed. White cement with or without pigment shall then be used for flush pointing the joints. Curing shall then be carried out for a minimum period of 7 days for the bedding and joints to set properly. The surface shall then be cleaned using a suitable detergent, fully washed and wiped dry.

Specials consisting of coves, internal and external angles, cornices, beads and their corner pieces shall be of thickness not less than the tiles with which they are used.

### **In-Situ Cement Concrete Floor Topping**

#### Materials

The mix proportion for the in-situ concrete floor topping shall be 1:2.5:3.5 (one part cement : two and half parts sand : three and half parts coarse aggregates) by volume unless otherwise specified.

The aggregates shall conform for the requirements of IS:383.

Coarse aggregates shall have high hardness surface texture and shall consist of crushed rock of granite, basalt, trap or quartzite. The aggregate crushing value shall not exceed 30 percent. The grading of the aggregates of size 12.5mm and below shall be as per IS:2571.

Grading of the sand shall be within the limits indicated in IS:2571.

#### Workmanship

The thickness of the floor topping shall be as specified in the items of work prepared by the Contractor. The minimum thickness of the floor topping shall be 25mm.

Preparation of base concrete/structural slab before laying the topping shall be as per clause 7.13. The surface shall be rough to provide adequate bond for the topping.

Mixing of concrete shall be done thoroughly in a mechanical mixer unless hand mixing is specifically permitted by the GWSSB. The concrete shall be as stiff as possible and the amount of water added shall be the minimum necessary to give just sufficient plasticity for laying and compacting. The mix shall be used in the work within 30 minutes of the addition of water for its preparation.

Floor finish shall be laid in suitable panels to reduce the risk of cracking. No dimension of a panel shall exceed 2 meters and the length of a panel shall not exceed one and a half times its breadth. Topping shall be laid in alternate panels, the intermediate panels being cast after a gap of at least one day. Construction joints shall be plain vertical butt joints.

Screed strips shall be fixed dividing the area into suitable panels. Immediately before depositing the concrete topping, neat cement slurry at 2.75 kg/sq.m of area shall be thoroughly brushed into the prepared surface. Topping shall then be laid, very thoroughly tamped, struck off level and floated with wooden float. The surface shall then be tested with a straight edge and mason's spirit level to detect any inequalities and these shall be made good immediately.

Finishing of the surface by troweling shall be spread over a period of one to six hours depending upon the temperature and atmospheric conditions. The surface shall be trowelled 3 times at intervals so as to produce a smooth uniform and hard surface. Immediately after laying, the first trowelling just sufficient to give a level surface shall be carried out avoiding excessive trowelling at this stage. The surface shall be re-trowelled after sometime to close any pores and to scrap off excess water or laitance, which shall not be trowelled back into the topping. Final trowelling shall be done well before the concrete has become too hard but at a time when considerable pressure is required to make any impression on the surface. Sprinkling of dry cement or cement-sand mixture for absorbing moisture shall not be permitted.

Immediately after the surface is finished, it shall be protected suitably from rapid drying due to wind/ sunlight. After the surface has hardened sufficiently to prevent any damage to it, the topping shall be kept continuously moist for a minimum period of 10 days.

It is preferable to lay the topping on hardened base concrete, as against being laid monolithically with a lesser thickness, since proper levels and slopes with close surface tolerances is achievable in practice, owing to its greater thickness. Further, as this would be laid after all other building operations are over, there will be no risk of any damages or discoloration to the floor finish which are difficult to repair satisfactorily.

### **In-Situ Granolithic Concrete Floor Topping**

#### Materials and Workmanship

The Requirements of materials and workmanship shall be all as per clause 7.19 for in-situ cement concrete floor topping except that the mix proportion of the concrete shall be 1:1:2 (cement:sand:coarse aggregates) by volume.

The minimum thickness of granolithic floor topping on hardened concrete base shall be 40mm.

## **Floor Hardener Topping**

### **Materials & Workmanship**

Floor Hardener topping shall be provided either as integrally finished over the structural slab/grade slab or laid monolithically with the concrete/granolithic floor finish on top of hardened concrete base.

Floor hardener of the metallic or non-metallic type suitable for the performance of normal / medium/ heavy duty function of the floor, the quantum of ingredients and the thickness of topping shall be as specified in the respective items of work prepared by the Contractor.

For monolithic application with the floor finish/slab the thickness of the layer shall be 15mm. The topping shall be laid within 2 to 3 hours after concrete is laid when it is still plastic but stiffened enough for the workmen to tread over it by placing planks. The surface of the concrete layer shall be kept rough for providing adequate bond for the topping. Laitance shall be removed before placing the topping. The topping shall be screeded and thoroughly compacted to the finished level. Trowelling to a smooth finish shall be carried out as per clause 7.19.2. After the surface has hardened sufficiently, it shall be kept continuously moist for atleast 10 days.

The procedure for mixing the floor hardener topping shall be as per manufacturer's instructions.

Surface shall be prevented from any damages due to subsequent building operations by covering with 75 mm thick layer of sand.

## **PVC Sheet/Tile Flooring**

### **Materials**

PVC floor covering shall be of either unbacked homogeneous flexible type in the form of sheets/tiles conforming to IS:3462 or homogeneous PVC asbestos tiles conforming to IS:3461.

Surface of the sheets/tiles shall be free from any physical defects such as pores, blisters, cracks etc. which affects the appearance and serviceability. Tiles/ sheets shall meet with the tolerance limits in dimensions specified in the IS. Contractor shall submit the test certificates, if so desired by the GWSSB.

Each tile/sheet shall be legibly and indelibly marked with the name of the manufacturer or his trade mark, IS certificate mark, and batch number.

The adhesive to be used for laying the PVC flooring shall be rubber based and of the make as recommended and approved by the manufacturer of PVC sheets/tiles.

The type, size, colour, plain or mottled and the pattern shall be as specified in the respective items of work prepared by the Contractor .

### **Workmanship**

PVC Floor covering shall be provided over an underbed of cement concrete floor finish over the base concrete or structural slab. It is essential that the sub-floor and the underbed are perfectly dry before laying the PVC flooring. This shall be ensured by methods of testing as stipulated in Appendix-A of IS:5318.

The surface of the underbed shall have trowelled finish without any irregularities, which creates poor adhesion. Surface shall be free of oil or grease and thoroughly cleaned of all dust, dirt and wiped with a dry cloth.

PVC sheets/tiles shall be brought to the temperature of the area in which they are to be laid by stacking in a suitable manner within or near the laying area for a period of about 24 hours. Where air-conditioning is installed, the flooring shall not be laid on the underbed until the A/C units have been in operation for atleast 7 days. During this period, the temperature range shall be between 20deg.C and 30deg.C and this shall be maintained during the laying operations and also for 48 hours thereafter.

Layout of the PVC flooring shall be marked with guidelines on the underbed and PVC tiles/sheets shall be first laid for trial, without using the adhesive, according to the layout.

The adhesive shall be applied by using a notched trowel to the surface of the underbed and to the backside of PVC sheets/tiles. When the adhesive has set sufficiently for laying, it will be tacky to the touch, which generally takes about 30 minutes. The time period need be

carefully monitored since a longer interval will affect the adhesive properties. Adhesive shall be uniformly spread over only as much surface area at one time which can be covered with PVC flooring within the stipulated time.

PVC sheet shall be carefully taken and placed in position from one end onwards slowly so that the air will be completely squeezed out between the sheet and the background surface and no air pockets are formed. It shall then be pressed with a suitable roller to develop proper contact. The next sheet shall be laid edge to edge with the sheet already laid, so that there is minimum gap between joints. The alignment shall be checked after each row of sheet is completed and trimmed if considered necessary.

Tiles shall be laid in the same manner as sheets and preferably, commencing from the centre of the area. Tiles should be lowered in position and pressed firmly on to the adhesive with minimum gap between the joints. Tiles shall not be slid on the surface. Tiles shall be rolled with a light wooden roller of about 5kg to ensure full contact with the underlay. Work should be constantly checked to ensure that all four edges of adjacent tiles meet accurately.

Any excess adhesive which may squeeze up between sheets/tiles shall be wiped off immediately with a wet cloth. Suitable solvents shall be used to remove hardened adhesive.

A minimum period of 24 hours shall be given after laying for the development of proper bond of the adhesive. When the flooring is thus completed, it shall be cleaned with a wet cloth soaked in warm soap solution.

Metallic edge strips shall be used to protect the edges of PVC sheets/tiles which are exposed as in doorways/ stair treads.

Hot sealing of joints between adjacent PVC sheet flooring to prevent creeping of water through the joints shall be carried out, using special equipment as per manufacturer's instructions.

### **Acid Resisting Brick/Tiling Work**

#### **Materials**

The ceramic unglazed vitreous acid resisting tiles shall conform to the requirements of IS:4457. Acid resistant bricks shall conform to the requirements of IS:4860.

The finished tile/brick when fractured shall appear fine grained in texture, dense and homogeneous. Tile/brick shall be sound, true to shape, flat, free from flaws and any manufacturing defects affecting their utility. Tolerance in dimensions shall be within the limits specified in the respective IS.

The tiles/bricks shall be bedded and jointed using chemical resistant mortar of the resin type conforming to IS:4832 (Part II). Method of usage shall generally be as per the requirements of IS:4443.

#### **Workmanship**

The resin shall have viscosity for readily mixing with the filler by manual methods. The filler shall have graded particles which permit joint thickness of 1.5 mm.

The base concrete surface shall be free from dirt and thoroughly dried. The surface shall be applied with a coat of bitumen primer conforming to IS:3384. The primed surface shall then be applied with a uniform coat of bitumen conforming to IS:1580. Tiles or bricks shall be laid directly without the application of bitumen, if epoxy or polyester resin is used for the mortar.

Just adequate quantity of mortar which can be applied within the pot life as specified by the manufacturer shall be prepared at one time for bedding and jointing. Rigid PVC/Stainless steel/chromium plated tools shall be used for mixing and laying.

For laying the floor 6 to 8 mm thick mortar shall be spread on the back of the tile/brick. Two adjacent sides of the tile/brick shall be smeared with 4 to 6 mm thick mortar. Tile/brick shall be pressed into the bed and pushed against the floor and with the adjacent tile/ brick, until the joint in each case is 2 to 3 mm thick. Excess mortar shall then be trimmed off and allowed to harden fully. Similar procedure shall be adopted for the work on walls by pressing the tile/brick against the prepared wall surfaces and only one course shall be laid at a time until the initial setting period.



The mortar joints shall be cured for a minimum period of 72 hours with 20 to 25% hydrochloric acid or 30 to 40% sulphuric acid. After acid curing, the joints shall be washed with water and allowed to thoroughly dry. The joints shall then be filled with mortar to make them smooth and plane. Acid curing is not required to be carried out if epoxy or polyester resin is used for the mortar.

Resin mortars are normally self curing. The area tiled shall not be put to use before 48 hours in case epoxy, polyester and furane type of resin is used for the mortar. If phenolic or cashewnut shell liquid resin is used for the mortar, the area tiled shall not be put to use for 7 to 28 days respectively, without heat treatment. This period shall be 2 to 6 days respectively, if heat treatment is given with infrared lamp.

## **Epoxy Lining Work**

### **Materials**

The epoxy resin and hardener formulation for laying of jointless lining work in floors and walls of concrete tanks/trenches etc shall be as per the requirements of IS:9197.

The epoxy composition shall have the chemical resistance to withstand the following conditions of exposure :

Hydrochloric acid upto 30% concentration

Sodium hydroxide upto 50% concentration

Liquid temperature upto 60deg.C

Ultraviolet radiation

Alternate wetting and drying

Sand shall conform to grading zone III or IV of IS:383.

The hardener shall be of the liquid type such as Aliphatic Amine or an Aliphatic/Aromatic Amine Adduct for the epoxy resin. The hardener shall react with epoxy resin at normal ambient temperature.

Contractor shall furnish test certificates for satisfying the requirements of the epoxy formulation if so directed by the GWSSB.

### **Workmanship**

The minimum thickness of epoxy lining shall be 4 mm. It is essential that the concrete elements are adequately designed to ensure that water is excluded to permeate to the surface, over which the epoxy lining is proposed.

The epoxy lining shall be of the trowel type to facilitate execution of the required thickness for satisfactory performance.

The concrete surfaces over which epoxy lining is to be provided shall be thoroughly cleaned of oil or grease by suitable solvents, wire brushed to remove any dirt/dust and laitance. The surfaces shall then be washed with dilute hydrochloric acid and rinsed thoroughly with plenty of water or dilute ammonia solution. The surfaces shall then be allowed to dry. It is essential to ensure that the surfaces are perfectly dry before the commencement of epoxy application.

Just adequate quantity of epoxy resin which can be applied within the pot life as specified by the manufacturer shall be prepared at one time for laying and jointing.

Rigid PVC/stainless steel/chromium plated tools shall be used for laying. Trowelling shall be carried out to obtain uniformly the specified thickness of lining.

Lining shall be allowed to set without disturbance for a minimum period of 24 hours. The facility shall be put to use only after a minimum period of 7 days of laying of the lining.

## **Water-Proofing**

### **General**

The work shall include waterproofing for the building roofs, terraces, toilets, floor slabs, walls, planters, chajjas, sills and any other areas and at any other locations and situations as directed by the Employers Representative.

The waterproofing treatment shall be carried out on top of lime concrete (brick bat coba) laid to slope on roof surfaces. The brick bat coba shall be covered as specified below.

The work shall be carried out by an experienced specialist Sub-Contractor who shall be appointed only after prior approval of the GWSSB.

#### Modified Bituminous Membrane

Modified Bituminous Membrane shall be "SUPER THERMOLAY" 4 mm thick weighing 4 Kg/sqm, manufactured using APP Polymer modified bitumen with a central core of non-woven polyester reinforcement (200 gms/sqm) and with top and bottom layers of thermofusible film (top layer could also be sand finished) made by STP Limited in collaboration with Bitumat Company Limited. "PLYFLEX" of Bitumat Company Limited, Saudi Arabia supplied by STP Limited shall also be acceptable or other equivalent specification.

#### Waterproofing of Roofs with Lime Concrete

##### Materials

Broken brick coarse aggregates prepared from well/over burnt bricks shall be well graded having a maximum size of 25mm and shall generally conform to IS:3068.

Lime shall be class C lime (fat lime) or factory made hydrated lime conforming to IS:712.

##### Workmanship

Lime concrete shall be prepared by thoroughly mixing the brick aggregates inclusive of brick dust obtained during breaking with the slaked lime in the proportions of 2 1/2 (two and a half) parts of brick aggregates to 1 part of slaked lime by volume. Water shall be added just adequate to obtain the desired workability for laying. Washing soap and alum shall be dissolved in the water to be used. The quantity of these materials required per cum of lime concrete shall be 12kg of washing soap and 4kg of alum. Brick aggregates shall be soaked thoroughly in water for a period of not less than six hours before use in the concrete mix. Lime concrete shall be used in the works within 24 hours after mixing.

The roof surface over which the water-proof treatment is to be carried out shall be cleaned of all foreign matter by wire brushing, dusting and made thoroughly dry. Preparation of surfaces shall be as stipulated in IS:3067.

The slope of the finished waterproofing treatment shall be not less than 1 in 60 for efficient drainage. This shall be achieved either wholly in the lime concrete layer.

The average thickness of lime concrete, slope and the finish on top of machine made burnt clay flat terracing tiles conforming to IS:2690 (part I) shall be as specified in the items of work to be prepared by the Contractor. Cement concrete flooring tiles in lieu of clay terracing tiles shall be provided if so specified in the items of work prepared by the Contractor, duly considering the traffic the terrace will be subjected to.

The minimum compacted thickness of lime concrete layer shall be 75mm and average thickness shall not be less than 100mm. In case, the thickness is more than 100mm, it shall be laid in layers not exceeding 100mm to 125mm.

Laying of lime concrete shall be commenced from a corner of the roof and proceeded diagonally towards centre and other sides duly considering the slopes specified for effectively draining the rain-water towards the downtake points.

Lime concrete fillet for a minimum height of 150mm shall be provided all along the junction of the roof surface with the brick masonry wall/parapet/column projections. These shall then be finished on top with provision of clay terracing tiles/cement concrete tiles.

After the lime concrete is laid it shall be initially rammed with a rammer weighing not more than 2 Kg and the finish brought to the required evenness and slope. Alternatively, bamboo strips may be used for the initial ramming. Further consolidation shall be done using wooden THAPIES with rounded edges. The beating will normally have to be carried on for at least seven days until the THAPI makes no impression on the surface and rebounds readily from it when struck. Special care shall be taken to properly compact the lime concrete at its junction with parapet walls or column projections.

During compaction by hand-beating, the surface shall be sprinkled liberally with lime water (1 part of lime putty and 3 to 4 parts of water) and a small proportion of sugar solution for obtaining improved water-proofing quality of the lime concrete. On completion of beating, the mortar that comes on the top shall be smoothened with a trowel or float, if necessary, with the addition of sugar solution and lime putty. The sugar solution may be prepared in any one of the following ways as directed by the GWSSB.

- a) By mixing about 3 Kg of Jaggery and 1.5 Kg of BAEL fruit to 100 litres of water.
- b) By mixing about 600 gm of KADUKAI (the dry nuts shall be broken to small pieces and allowed to soak in water), 200 gm of jaggery and 40 litres of water for 10 sq.m of work. This solution shall be brewed for about 12 to 24 hours and the resulting liquor decanted and used for the work.

The lime concrete after compaction shall be cured for a minimum period of seven days or until it hardens by covering with a thin layer of straw or hessian which shall be kept wet continuously.

Machine made flat terracing tiles shall be of the size and thickness as specified. Tiles shall be soaked in water for at least one hour before laying. Bedding for the tiles shall be 12mm thick in cement mortar 1:3. Tiles shall be laid, open jointed with 4 to 6 mm wide joints, flat on the mortar and lightly pressed and set to plane surface true to slope, using a trowel and wooden straight edge. They shall be laid with their longitudinal lines of joints truly parallel and generally at right angles to the direction of run-off gradient. Transverse joints in alternate rows shall come directly in line with each other. Transverse joints in adjacent courses shall break joints by at least 50 mm. The joints shall be completely filled and flush pointed with cement mortar 1:2 mixed with water proofing compound as per manufacturer's instructions. Curing shall be carried out for a minimum period of seven days.

Finishing on top with cement concrete tiles or in-situ cement concrete floor topping shall be carried out in similar fashion as described for clay tiles in above paragraph. Tiles to be used shall be supplied after the first machine grinding of the surface.

#### Waterproofing of Roofs/Terraces etc.

##### (A) Water proofing of Horizontal Surfaces

The waterproofing shall be applied as follows :

A coat of Blown Bitumen 85/25 shall be applied at the rate of 1.45 kg/sq.km

A roll of Modified Bituminous Membrane shall be unrolled over the primed surface and completely bonded to the substrate by pressing down evenly for the full width of the roll using a wooden roller. Torching shall be done, where recommended by the manufacturer and where directed by the GWSSB, as the unrolling progresses.

The side overlaps shall be minimum 100 mm whereas the end overlaps shall be minimum 150 mm; both shall be bonded and sealed by flame torching.

Care shall be taken that the membrane is lapped with the treatment along the vertical surface and roof gutter treatment for at least 500 mm.

The membrane shall be properly overlapped/terminated at all openings, rainwater down takes etc. to ensure that such junctions do not become sources of leakage.

Top of membrane finally shall be painted with antiglouse reflective paint.

##### (B) Waterproofing of Vertical Surfaces at Roof Level and Gutters

The Water proofing shall be applied as described in (a) above.

Modified Bituminous membrane shall be unrolled and bonded to the substrate after applying a coat of bitumen and by pressing down evenly for the full width of the roll. Light torching shall be done to ensure complete bonding.

The membrane shall be overlapped with treatment for the horizontal surface by at least 500 mm.

The membrane shall be taken up to a pre-cut chase anchored and sealed.

#### Khurras and Rainwater Down Pipes

Down pipes shall be isolated from RCC work with 6 mm polyethylene foam fixed with adhesive (Araldite) and sealed with silicone sealant prior to laying membrane. A water proofing flashing composed of one layer of Hessian based self finished felt Type 3 Grade 1 and two layers of aluminum foil of 0.075 mm thickness shall be provided. This flashing shall be carried into the down take pipes for at least 150 mm and sealed with hot bitumen. The Contractor shall closely coordinate the work with the agency providing and fixing the rainwater down take pipes.

#### Testing

The treated area (flat and horizontal only) shall be tested by allowed water to stand on the treated areas to a depth of 150 mm for a minimum period of 72 hours.

The treated area (flat and horizontal) shall have continuous slope towards the rainwater outlets and no water shall pond any where on the surface.

#### **Cement Plastering Work**

##### Materials

The proportions of the cement mortar for plastering shall be 1:3 (one part of cement to three parts of sand). Cement and sand shall be mixed thoroughly in dry condition and then just enough water added to obtain a workable consistency. The quality of water and cement shall be as per relevant IS standards. The quality and grading of sand for plastering shall conform to IS:1542. The mixing shall be done thoroughly in a mechanical mixer unless hand mixing is specifically permitted by the GWSSB. If so desired by the GWSSB sand shall be screened and washed to meet the Specifications. The mortar thus mixed shall be used as soon as possible preferably within 30 minutes from the time water is added to cement. In case the mortar has stiffened due to evaporation of water this may be re-tempered by adding water as required to restore consistency but this will be permitted only upto 30 minutes from the time of initial mixing of water to cement. Any mortar which is partially set shall be rejected and removed forthwith from the site. Droppings of plaster shall not be re-used under any circumstances.

##### Workmanship

Preparation of surfaces and application of plaster finishes shall generally conform to the requirements specified in IS:1661 and IS:2402.

Plastering operations shall not be commenced until installation of all fittings and fixtures such as door/window panels, pipes, conduits etc. are completed.

All joints in masonry shall be raked as the work proceeds to a depth of 10mm/20mm for brick/stone masonry respectively with a tool made for the purpose when the mortar is still green. The masonry surface to be rendered shall be washed with clean water to remove all dirt, loose materials, etc., Concrete surfaces to be rendered shall be roughened suitably by hacking or bush hammering for proper adhesion of plaster and the surface shall be evenly wetted to provide the correct suction. The masonry surfaces should not be too wet but only damp at the time of plastering. The dampness shall be uniform to get uniform bond between the plaster and the masonry surface.

Interior plain faced plaster - This plaster shall be laid in a single coat of 13mm thickness. The mortar shall be dashed against the prepared surface with a trowel. The dashing of the coat shall be done using a strong whipping motion at right angles to the face of the wall or it may be applied with a plaster machine. The coat shall be trowelled hard and tight forcing it to surface depressions to obtain a permanent bond and finished to smooth surface. Interior plaster shall be carried out on jambs, lintel and sill faces, etc. as shown in the drawing and as directed by the GWSSB.

Plain Faced Ceiling plaster - This plaster shall be applied in a single coat of 6mm thickness. Application of mortar shall be as stipulated in above paragraph.

Exterior plain faced plaster - This plaster shall be applied in 2 coats. The first coat or the rendering coat shall be approximately 14mm thick. The rendering coat shall be applied as stipulated above except finishing it to a true and even surface and then lightly roughened by

cross scratch lines to provide bond for the finishing coat. The rendering coat shall be cured for atleast two days and then allowed to dry. The second coat or finishing coat shall be 6 mm thick. Before application of the second coat, the rendering coat shall be evenly damped. The second coat shall be applied from top to bottom in one operation without joints and shall be finished leaving an even and uniform surface. The mortar proportions for the coats shall be as specified in the respective item of work. The finished plastering work shall be cured for atleast 7 days.

Interior plain faced plaster 20mm thick if specified for uneven faces of brick walls or for random/coursed rubble masonry walls shall be executed in 2 coats similar to the procedure stipulated in above paragraph.

Exterior Sand Faced Plaster- This plaster shall be applied in 2 coats. The first coat shall be approximately 14mm thick and the second coat shall be 6mm thick. These coats shall be applied as stipulated above. However, only approved quality white sand shall be used for the second coat and for the finishing work. Sand for the finishing work shall be coarse and of even size and shall be dashed against the surface and sponged. The mortar proportions for the first and second coats shall be as specified in the respective items of work.

Wherever more than 20mm thick plaster has been specified, which is intended for purposes of providing beading, bands, etc. this work shall be carried out in two or three coats as directed by the GWSSB duly satisfying the requirements of curing each coat (rendering/floating) for a minimum period of 2 days and curing the finished work for atleast 7 days.

In the case of pebble faced finish plaster, pebbles of approved size and quality shall be dashed against the final coat while it is still green to obtain as far as possible a uniform pattern all as directed by the GWSSB.

Where specified in the Drawings to be prepared by the Contractor prepared by the Contractor, rectangular grooves of the dimensions indicated shall be provided in external plaster by means of timber battens when the plaster is still in green condition. Battens shall be carefully removed after the initial set of plaster and the broken edges and corners made good. All grooves shall be uniform in width and depth and shall be true to the lines and levels as per the Drawings to be prepared by the Contractor prepared by the Contractor.

Curing of plaster shall be started as soon as the applied plaster has hardened sufficiently so as not to be damaged when watered. Curing shall be done by continuously applying water in a fine spray and shall be carried out for at least 7 days.

For waterproofing plaster, the Contractor shall provide the water-proofing admixture as specified in manufacturers instruction while preparing the cement mortar.

For external plaster, the plastering operations shall be commenced from the top floor and carried downwards. For internal plaster, the plastering operations for the walls shall commence at the top and carried downwards. Plastering shall be carried out to the full length of the wall or to natural breaking points like doors/windows etc. Ceiling plaster shall be completed first before commencing wall plastering.

Double scaffolding to be used shall be as specified in clause 7.2.2.

The finished plaster surface shall not show any deviation more than 4mm when checked with a straight edge of 2m length placed against the surface.

To overcome the possibility of development of cracks in the plastering work following measures shall be adopted.

Plastering work shall be deferred as much as possible so that fairly complete drying shrinkage in concrete and masonry works takes place.

Steel wire fabric shall be provided at the junction of brick masonry and concrete to overcome reasonably the differential drying shrinkage/thermal movement.

Ceiling plaster shall be done, with a trowel cut at its junction with wall plaster. Similarly trowel cut shall be adopted between adjacent surfaces where discontinuity of the background exists.

### **Cement Pointing**

#### **Material**

The cement mortar for pointing shall be in the proportion of 1:3 (one part of cement to three parts of fine sand). Sand shall conform to IS: 1542 and shall be free from clay, shale, loam, alkali and organic matter and shall be of sound, hard, clean and durable particles. Sand

shall be approved by GWSSB and if so directed it shall be washed/screened to meet specification requirements.

#### Workmanship

Where pointing of joints in masonry work is specified, the joints shall be raked at least 15mm/20mm deep in brick/stone masonry respectively as the work proceeds when the mortar is still green.

Any dust/dirt in the raked joints shall be brushed out clean and the joints shall be washed with water. The joints shall be damp at the time of pointing. Mortar shall be filled into joints and well pressed with special steel trowels. The joints shall not be disturbed after it has once begun to set. The joints of the pointed work shall be neat. The lines shall be regular and uniform in breadth and the joints shall be raised, flat, sunk or 'V' as may be specified in the respective items of work. No false joints shall be allowed.

The work shall be kept moist for atleast 7 days after the pointing is completed. Whenever coloured pointing has to be done, the colouring pigment of the colour required shall be added to cement in such proportions as recommended by the manufacturer and as approved by the GWSSB.

#### **Water-Proofing Admixtures**

Water-proofing admixture shall conform to the requirements of IS:2645 and shall be of approved manufacture. The admixture shall not contain calcium chloride. The quantity of the admixture to be used for the works and method of mixing etc. shall be as per manufacturer's instructions and as directed by the GWSSB.

#### **Painting of Concrete, Masonry & Plastered Surfaces**

##### Materials

Oil bound distemper shall conform to IS:428. The primer shall be alkali resistant primer of the same manufacture as that of the distemper.

Cement paint shall conform to IS:5410. The primer shall be a thinned coat of cement paint.

Lead free acid, alkali and chlorine resisting paint shall conform to IS:9862.

Colour wash shall be made by addition of a suitable quantity of mineral pigment, not affected by lime, to the prepared white wash to obtain the shade/tint as approved by the GWSSB.

All the materials shall be of the best quality from an approved manufacturer. Contractor shall obtain prior approval of the GWSSB for the brand of manufacture and the colour/shade. All materials shall be brought to the site of works in sealed containers.

#### Workmanship

Contractor shall obtain the approval of the GWSSB regarding the readiness of the surfaces to receive the specified finish, before commencing the work on painting.

Painting of new surfaces shall be deferred as much as possible to allow for thorough drying of the sub- strata.

The surfaces to be treated shall be prepared by thoroughly brushing them free from dirt, mortar droppings and any loose foreign materials. Surfaces shall be free from oil, grease and efflorescence. Efflorescence shall be removed only by dry brushing of the growth. Cracks shall be filled with Gypsum. Workmanship of painting shall generally conform to IS:2395.

Surfaces of doors, windows etc. shall be protected suitably to prevent paint finishes from splashing on them.

#### White Wash

The prepared surfaces shall be wetted and the finish applied by brushing. The operation for each coat shall consist of a stroke of the brush first given horizontally from the right and the other from the left and similarly, the subsequent stroke from bottom upwards and the other from top downwards, before the first coat dries. Each coat shall be allowed to dry before the next coat is applied. Minimum of 2 coats shall be applied unless otherwise specified. The dry surface shall present a uniform finish without any brush marks.

### Colour Wash

Colour wash shall be applied in the same way as for white wash. A minimum of 2 coats shall be applied unless otherwise specified. The surface shall present a smooth and uniform finish without any streaks. The finished dry surface shall not show any signs of peeling/powdery and come off readily on the hand when rubbed.

### Cement Paint

The prepared surfaces shall be wetted to control surface suction and to provide moisture to aid in proper curing of the paint. Cement paint shall be applied with a brush with stiff bristles. The primer coat shall be a thinned coat of cement paint. The quantity of thinner shall be as per manufacturer's instructions. The coats shall be vigorously scrubbed to work the paint into any voids for providing a continuous paint film free from pinholes for effective water proofing in addition to decoration. Cement paint shall be brushed in uniform thickness and the covering capacity for two coats on plastered surfaces shall be 3 to 4 kg/sq.m. A minimum of 2 coats of the same colour shall be applied. Atleast 24 hours shall be left after the first coat to become sufficiently hard before the second coat is applied. The painted surfaces shall be thoroughly cured by sprinkling with water using a fog spray at least 2 to 3 times a day. Curing shall commence after about 12 hours when the paint hardens. Curing shall be continued for atleast 2 days after the application of final coat. The operations for brushing each coat shall be as detailed above.

### Oil bound Distemper

The prepared surfaces shall be dry and provided with one coat of alkali resistant primer by brushing. The surface shall be finished uniformly without leaving any brush marks and allowed to dry for atleast 48 hours. A minimum of two coats of oil bound distemper shall be applied, unless otherwise specified. The first coat shall be of a lighter tint. Atleast 24 hours shall be left after the first coat to become completely dry before the application of the second coat. Broad, stiff, double bristled distemper brushes shall be used for the work. The operations for brushing each coat shall be as detailed above.

### Acid, Alkali Resisting Paint

A minimum of 2 coats of acid/alkali resisting paint shall be applied over the prepared dry surfaces by brushing. Primer coat shall be as per manufacturer's instructions.

### Plastic Emulsion Paint

The prepared surface shall be dry and provided with one coat of primer which shall be a thinned coat of emulsion paint. The quantity of thinner shall be as per manufacturer's instructions. The paint shall be laid on evenly and smoothly by means of crossing and laying off. The crossing and laying off consists of covering the area with paint, brushing the surface hard for the first time over and then brushing alternately in opposite directions two or three times and then finally brushing lightly in a direction at right angles. In this process, no brush marks shall be left after the laying off is finished. The full process of crossing and laying off constitutes one coat. The next coat shall be applied only after the first coat has dried and sufficiently become hard which normally takes about 2 to 3 hours. A minimum of 2 finishing coats of the same colour shall be applied unless otherwise specified. Paint may also be applied using rollers. The surface on finishing shall present a flat velvety smooth finish and uniform in shade without any patches.

### Acrylic Emulsion Paint

Acrylic emulsion paint shall be applied in the same way as for plastic emulsion paint. A minimum of 2 finishing coats over one coat of primer shall be provided unless otherwise specified.

## **Painting & Polishing of Wood Work**

### Materials

- Wood primer shall conform to IS:3536.
- Filler shall conform to IS:110.
- Varnish shall conform to IS:337.
- French polish shall conform to IS:348.
- Synthetic enamel paint shall conform to IS:2932.

All the materials shall be of the best quality from an approved manufacturer. Contractor shall obtain prior approval of the GWSSB for the brand of manufacture and the colour/shade. All materials shall be brought to the site of works in sealed containers.

### Workmanship

The type of finish to be provided for woodwork of either painting or polishing, the number of coats, etc. shall be as specified in the respective items of work to be prepared by the Contractor.

Primer and finish paint shall be compatible with each other to avoid cracking and wrinkling. Primer and finish paint shall be from the same manufacturer.

Painting shall be either by brushing or spraying. Contractor shall procure the appropriate quality of paint for this purpose as recommended by the manufacturer. The workmanship shall generally conform to the requirements of IS:2338 (Part I).

All the wood surfaces to be painted shall be thoroughly dry and free from any foreign matter. Surfaces shall be smoothened with abrasive paper using it across the grains and dusted off. Wood primer coat shall then be applied uniformly by brushing. The number of primer coats shall be as specified in the item of work to be prepared by the Contractor. Any slight irregularities of the surface shall then be made up by applying an optimum coat of filler conforming to IS:110 and rubbed down with an abrasive paper for obtaining a smooth surface for the undercoat of synthetic enamel paint conforming to IS:2932. Paint shall be applied by brushing evenly and smoothly by means of crossing and laying off in the direction of the grain of wood. After drying, the coat shall be carefully rubbed down using very fine grade of sand paper and wiped clean before the next coat is applied. At least 24 hours shall elapse between the application of successive coats. Each coat shall vary slightly in shade and this shall be got approved by the GWSSB. The number of coats of paint to be applied shall be as specified in the item of work to be prepared by the Contractor.

All the wood surfaces to be provided with clear finishes shall be thoroughly dry and free from any foreign matter. Surfaces shall be smoothened with abrasive paper using it in the direction of the grains and dusted off. Any slight irregularities of the surface shall be made up by applying an optimum coat of transparent liquid filler and rubbed down with an abrasive paper for obtaining a smooth surface. All dust and dirt shall be thoroughly removed. Over this prepared surface, varnish conforming to IS:337 shall be applied by brushing. Varnish should not be retouched once it has begun to set. Staining if required shall be provided as directed by the GWSSB. When two coats of varnish is specified, the first coat should be a hard-drying undercoat or flattening varnish which shall be allowed to dry hard before applying the finishing coat. The number of coats to be applied shall be as specified. For works where clear finish of French polish is specified the prepared surfaces of wood shall be applied with the polish using a pad of woolen cloth covered by a fine cloth. The pad shall be moistened with polish and rubbed hard on the surface in a series of overlapping circles to give an even finish over the entire area. The surface shall be allowed to dry before applying the next coat. Finishing shall be carried out using a fresh clean cloth over the pad, slight dampening with methylated spirit and rubbing lightly and quickly in circular motions. The finished surface shall have a uniform texture and high gloss. The number of coats to be applied shall be as specified.

### **Painting of Steel Work**

#### Materials

- Red-oxide – zinc chrome primer shall conform to IS:2074.
- Synthetic enamel paint shall conform to IS : 2932.
- Aluminum paint shall conform to IS:2339.

All the materials shall be of the best quality from an approved manufacturer. Contractor shall obtain prior approval of the GWSSB for the brand of manufacture and the colour/shade. All the materials shall be brought to the site in sealed containers.



### Workmanship

Painting work shall be carried out only on thoroughly dry surfaces. Painting shall be applied either by brushing or by spraying. Contractor shall procure the appropriate quality of paint for this purpose as recommended by the manufacturer. The workmanship shall generally conform to the requirement of IS:1477 (Part 2).

The type of paint, number of coats etc. shall be as specified in the respective items of work.

Primer and finish paint shall be compatible with each other to avoid cracking and wrinkling. Primer and finish paint shall be from the same manufacturer.

All the surfaces shall be thoroughly cleaned of oil, grease, dirt, rust and scale. The methods to be adopted using solvents, wire brushing, power tool cleaning etc., shall be as per IS:1477 (Part – I) and as indicated in the item of work.

It is essential to ensure that immediately after preparation of the surfaces, the first coat of red oxide-zinc chrome primer 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'.

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 synthetic enamel paint of optimum thickness shall be applied by brushing 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.

The first finishing coat of paint shall be applied by brushing and allowed to hard-dry. The gloss from the entire surface shall then be gently removed and the surface dusted off. The second finishing coat shall then be applied by brushing.

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 GWSSB.

### **Flashing**

#### Materials

Anodised Aluminum sheets shall be 1.00mm thick with anodic film thickness of 0.025 mm.

Galvanised mild steel sheets shall be 1.00mm thick with zinc coating of 800 gms/sq.m.

Bitumen felt shall be either Hessian base self finished bitumen felt Type-3 Grade I conforming to IS:1322 or glass fibre base self finished felt Type-2 Grade 1 conforming to IS:7193.

### Workmanship

The type of the flashing and method of fixing shall be as specified.

Flashing shall be of the correct shape and size as indicated in the construction Drawings to be prepared by the Contractor and they shall be properly fixed to ensure their effectiveness.

Flashing shall be of long lengths so as to provide minimum number of joints. The minimum overlap at joints shall be 100mm.

Fixing of the flashing shall be either by bolting with bitumen washers or by tucking into the groove 75 mm wide x 65 mm deep in masonry/concrete along with cement mortar 1:4 filletting as indicated in the Drawings to be prepared by the Contractor. Curing of the mortar shall be carried out for a minimum period of 4 days.

Bitumen felt flashing of the type as specified shall be provided with 2 coats of bituminous paint at the rate of 0.10 litre/sq.m after the installation.

### **Thermal Insulation For Ceiling**

Thermal insulation shall be "Thermo Cole" TF type or similar approved or Resin bonded fiber glass boards.

### Fixing

#### "Thermocole" Boards

Soffit of R.C.C. Slab shall be thoroughly cleaned with wire brush and 85/25 industrial grade hot bitumen conforming to IS:702 shall be applied uniformly over the surface at the rate of 1.5 Kg/m<sup>2</sup>.

Thermo Cole boards (T.F. variety) of 50mm thickness shall be stuck by means of the same grade of hot bitumen.

The boards shall be further secured with screws, washers and plugs.

The joints of the boards shall be sealed with bitumen.

#### Fibre Glass Boards

Timber pegs 50mm x 50mm x 50mm shall be fixed to the slab at 600mm centres with 6mm x 65mm long wood screws. 20 gauge G.I. lacing wire shall be tied to the pegs.

'Crown' 200 fibreglass boards 50mm thick shall be stuck to the pegs with CPRX compound or any other suitable adhesive and be held in position by the 20 gauge G.I. lacing wires.

The insulation boards shall be covered with 20mm – 24 gauge hexagonal G.I. chicken wire mesh, nailed to the timber pegs and 30 gauge aluminium sheets shall be fixed over the chicken wiremesh with 50mm overlap and secured to the timber pegs by screws.

If the insulation is specified to rest on top of the false ceiling, it shall be properly installed and anchored to the framework. In case additional battens are required for proper installation, Contractor shall include its cost in the rate for insulation.

#### **Plaster of Paris Board for False Ceiling**

##### Materials

##### *Plaster of Paris Boards*

- The plaster of paris boards to be used in the false ceiling shall be of an approved manufacture or manufactured at site by methods and materials approved by GWSSB.
- The plaster of paris shall be of the calcium-sulphate hemi-hydrate variety and shall contain not less than 35 percent sulphur trioxide and other requirements as per IS:2547 (Part I) However, its fineness shall be such that the residue, after drying, and sieving on I.S. sieve designation 3.35mm for 5 minutes shall not be more than 1 percent by weight. Initial setting time shall not be less than 13 minutes. The average compressive strength of plaster determined by testing 5 cm cubes 24 hours after removal from moulds and drying in an oven at 40 Deg. C till the weight of the cubes is constant, shall not be less than 84 Kg per sq.cm.
- The plaster of paris boards reinforced with hessian cloth or coir shall be prepared in suitable sizes as shown on the drawings or as directed by GWSSB. Wooden forms of height equal to the thickness of boards shall be placed on truly level and smooth surface such as a glass sheet. The edges of the boards shall be truly square. The glass sheet or surface on which form is kept and the form sides shall be given a thin coat of non-staining oil to facilitate the easy removal of the board. Plaster of paris shall be evenly spread into the form upto about half the depth and hessian cloth or coir shall be pressed over the plaster of paris layer. The weight of hessian cloth or coir in the board shall be 250 gm per sq.m. The ends of the hessian/coir reinforcement shall be turned over at all edges to form a double layer for a width of 50mm. The hessian cloth shall be of an open web texture so as to allow the plaster below and above to intermix with each other and form an integral board. The form shall then be filled with plaster of paris which shall be uniform pressed and then wire cut to an even and smooth surface. The board shall then be allowed to set initially for an hour or so and then removed from the form and allowed to dry and harden for about a week. The board after drying and hardening shall give a ringing sound when struck. The boards shall be true and exact to shape and size and the exposed face shall be truly plane and smooth.
- The size of boards shall generally be 600mm x 600 mm x 12 mm thick. Boards shall be kept dry in transit and stored flat in a clean dry place and shall not be exposed to moisture. The boards shall always be carried on edges.

### Timber Frame Work

Timber for frame work of false ceiling grid and hangers shall be of good quality and well seasoned. It shall have uniform colour, reasonably straight and close grains and shall be free from knots, cracks and sapwood. It shall be treated with approved anti-termite preservative as directed by the GWSSB. Extreme care shall be taken so that the preservative treatment does not stain the ceiling boards. In case metal hangers are used, these shall be M.S. flats or bars, having two coats of red oxide zinc chromate paint primer, as shown on drawings or as approved by GWSSB.

### Metal FrameWork

The metal frame work may be made of sections of light metal, such as anodised aluminium, mild steel or as shown on the drawings. The shape of cross-section shall be such as to facilitate proper suspension and proper fixing of the ceiling boards covering them and shall be structurally sound and rigid.

### **Construction**

- Contractor shall ensure that the frame to support the ceiling is designed for structural strength and the sizes, weight and strength of ceiling boards to be fixed and other loads due to live load, air-conditioning ducts, grills, electrical wiring and lighting fixtures, thermal insulation, etc. as shown on the drawings. Contractor shall also submit a detailed drawing to show the grid work, sizes of grid members, method of suspension, position of openings for air-conditioning and lighting, access doors, etc.
- Structural design of timber member for the frame shall be in accordance with IS : 883, and metal sections shall be of appropriate size and thickness and shall be of approved manufacture, all as approved by GWSSB.
- The false ceiling grid work shall be carried out as per the approved drawings or as directed by GWSSB. In case of timber grid work, the grid work shall consist of teak wood runners of minimum size 60mm deep x 40mm wide along one direction at 1.2m centre to centre and secondary runners of size 50mm deep x 40 mm wide at 60mm centre to centre perpendicular to the main runners.
- The timber grid work shall be suspended with the help of wooden hangers or metal hangers at 1.2m centre to centre in both the directions. Wooden hangers shall be adopted for flat R.C. roof slab structures whereas metal hangers for flat R.C. roof or structural steel floors / tresses. Metal hangers shall be fabricated from mild steel / galvanised flats of 35mm x 6mm size or bars of 10mm dia. Threaded at the lower end and anchored securely in the roof concrete or welded to inserts provided on the underside of slabs, beams etc. All M.S. hangers shall be given two coats of red oxide zinc chromate paint primer. In case the roof work is of A.C. sheeting supported on purlins and trusses, hangers shall be suspended from roof steel work. The arrangement of metal hangers shall be such that the level of false ceiling can be adjusted during fixing of the ceiling frame work. The ceiling frame work shall be secured to hangers by means of washers and nuts. The ends of main runners shall preferably be embedded into the masonry work.
- The metal frame work when it is anodised aluminium false ceiling grid system shall consist of aluminium main member of special T-Profile of 38mm x 38mm x 1.5mm thick, interlocking with each other to form frames of various sizes, 600mm x 600 mm or as shown on the drawing. The main members shall be suspended from the roof structures by means of steel hangers as described for timber frame work and supported at the walls by means of anodised aluminium wall angles.
- In the case of timber frame work, all the edges of the plaster of paris board shall be fixed to frame members by means of counter sunk and rustless screws of 2.74 mm size, 40mm long at a spacing of 100mm to 150 mm c/c and 12mm from the edge of the board. Holes for screws shall be drilled and screws slightly countersunk into the boards. The boards shall be fixed to wooden framework with a joint clearance of about 3mm. The joints shall always be in perfect line and plane.

- In case of aluminium grid system, boards shall be just placed into the frames formed by the main 'T' members and the cross members fitted with the clips for locking boards. Contractor shall take utmost care so as not to force the boards in position and a slight gap shall be provided so as not to make a tight joint. The boards shall be cut with a saw, if required, to any shape and size.
- As the work of false ceiling may be inter-connected with the work of air-conditioning ducts and lighting, Contractor shall fully co-operate with the other agencies entrusted with the above work, who may be working simultaneously. Contractor shall provide necessary openings in the false ceiling work for air-conditioning, lighting and other fixtures. Additional framing, if required, for the above opening shall also be provided at no extra cost to Employer. Removable or hinged type inspection or access trap doors shall be provided at locations specified by GWSSB.

### Finishing

It is essential that false ceiling work should be firm and in perfect line and level and all boards free from distortion, bulge, and other defects. All defective boards and other material shall be removed from site immediately and replaced, and ceiling restored to original finish to the satisfaction of GWSSB.

The workmanship shall be of highest order and all joinery work for timber work shall be in the best workmanship manner. The joints for aluminium frame work shall be of inter-locking type so that when the cross member is in place, it cannot be lifted out.

The countersunk heads of screws and all joints shall be filled with plaster of paris and finished smooth. After filling the joints, a thick skin of the finishing material shall be spread about 50mm wide on either side of the joint and on to it shall be trowelled dry a reinforcing scrim cloth about 10mm wide. If metal scrim is used, a stiffer plaster will be necessary to enable the trowelling of the scrim down to the board.

### Fire Stopping

In case of fire protective ceilings, fire resisting barriers at suitable intervals shall be provided. These shall completely close the gap between the false ceiling and soffit of the structural slab. The material of the barrier shall be as indicated by GWSSB (Reference may be made to the British Standards Institutions CP 290: Code of Practice for suspended ceiling and lining of dry construction using metal fixing system, for guidance).

### **False or Cavity Floor**

#### Frame Work

The false floor shall consist of a framework of suitable structural member designed to carry the loads specified. This frame work shall be supported on suitably designed stools placed at 600mm centre to centre in both directions. The stools shall consist of a mild steel base plate with a mild steel stud having adjustable lock nut and coupling at the centre and another mild steel plate at top serving as a prophead. The above framework shall be suitably designed to accommodate 35mm thick, 600mm square panels. The base plate shall be fixed to the reinforced concrete floor with an approved adhesive compound or with 4 Nos. 6mm dia. anchor fasteners. Bedding of 1:2 or richer cement sand mortar shall be provided locally under the base plates of stools to provide a level surface.

The prophead shall be provided with mild steel lugs welded on top and each placed perpendicular to the other for proper positioning and supporting the main and cross members. The stools shall be capable of adjustment to accommodate concrete floor level irregularities upto plus or minus 15mm. The framing members shall be completely removable and shall remain in position without screwing or bolting to the propheads. All steel framework including steel stools shall be given a coat of zinc chromate primer and two coats of enamel paint of approved colour and shade.

### Floor Panels

The floor panels shall be made of 600mm x 600mm x 35 mm thick medium density unveneered/ non-prelaminated teak wood particle boards having a density of not more than 800 kg/cu.m bonded with boiling water proof phenol formaldehyde synthetic resin and shall be of fire resistant, termite resistant and moisture proof quality, generally conforming to IS:3087-specification for wood particle boards (Medium Density )for general purposes.

The thermal conductivity of the boards shall not exceed 0.12 kCal/hr/sq.m/deg./C/m.

The panel size given above may be suitably modified near electrical panel/equipment and also to suit room dimensions with panel size not more than 600mm under any circumstances. Exposed 2mm thick vinyl edging shall be provided on all edges of individual panels. Each panel shall be given a coat or primer and two coats of approved fire resistant paint from underside.

The particle boards shall be faced with 600mm x 600 mm x 2mm thick approved make flooring tiles conforming to IS:3462 – “Specification for unbacked flexible PVC flooring” and of approved colour and shade. The completed panel shall be completely removable and shall remain in position without screwing or bolting to the on the inner side with stickers for easy identification and reassembly whenever required.

Suitable backing material shall be provided on the underside of the particle board to prevent warping and / or to cater to specified loading.

Suitable removable covers shall be provided to serve as outlets for the cables.

### Imposed Loading

The finished floor shall be capable of supporting a uniformly distributed loads of 500 to 1000 Kg. per sq.metre of floor area as specified in data sheet. A point load of 450 Kg on 600 sq.mm on any part of the panel or a line load of 725 Kg on 100mm strip across the panel length shall not result in a deflection greater than 2.5mm.

### Finish

The finished floor shall be true to lines and levels and present a neat flush surface.

### Vendor Drawing

Vendor shall prepare and submit a layout drawing for false floor giving all details including supporting system for approval. If so called for, vendor shall also submit his calculations for the supporting system with all relevant data assumed, to the GWSSB for his approval. Work shall be carried out on approved drawings only.

### **Fire Proof Doors**

#### Material and Workmanship

The design of fire proof doors and the materials to be used in their fabrication have to be such that they shall be capable of providing the effective barrier to the spread of fire. The materials, fabrication and erection of fire proof doors shall confirm to IS:3614 (Part – I) . The fire proof doors shall be obtained from an approved manufacturer. Specific approval for such purchase shall be obtained before hand. Sample approval shall also be obtained from testing authority as per the standard IS : 3614 (Part – 2) for the specified degree of fire rating in hours. All fire proof doors shall have specified sizes and confirm to the description in the respective items of work.

Fire proof door shutters shall be of zinc coated weldable steel (confirming to BS:6687) or stainless steel (conforming to IS:304) sheet (18G minimum) fixed in a frame work of rolled channel. The shutter shall consist of an insulating material like mineral wool in required thickness to satisfy the specified fire rating. Normally the thickness of door shutter shall not be less than 35mm for two hour fire rating and 46 mm for four hour fire rating.

The shutter with the required insulating material shall be mounted on angle iron frame or the special made frame from zinc coated (16G minimum) weldable steel sheet. The shutter shall be fixed to frame by means of suitable hinges and shall have a three way latching system. All the doors shall be provided with a coat of primer and one coat of synthetic enamel paint to attain the specified fire rating. All other accessories like hinges, door lock, hold fasts, etc. shall be provided as approved by TAC (Tariff Advisory Committee). All these accessories shall be compatible with the material used for door and shutter.

## WATER SUPPLY AND SANITARY WORKS

### Applicable Codes

The following standards and codes are made a part of this Employer's Requirement. All standards, codes of practice referred to herein shall be the latest editions including all official amendments and revisions.

IS: 210	:	Specification for grey iron castings
IS: 269	:	Specification for ordinary and low heat portland cement
IS: 383	:	Specification for coarse and fine aggregates from natural sources for concrete
IS: 432	:	Specification for mild steel and medium tensile steel bars and hard drawn steel wire for concrete reinforcement
IS: 456	:	Code of Practice for plain and reinforced concrete
IS: 458	:	Concrete Pipes (with and without reinforcement).
IS: 516	:	Methods of tests for strength of concrete
IS: 554	:	Dimensions for pipe threads where pressure tight joints are required on the threads.
IS: 651	:	Salt glazed stoneware pipes and fittings.
IS: 774	:	Flushing Cisterns for water closets and urinals (valueless siphonic type)
IS: 775	:	Cast iron brackets and supports for wash basins and sinks.
IS: 781	:	Sand-cast brass screw-down bib taps and stop taps for water services.
IS: 783	:	Code of practice for laying of concrete pipes.
IS: 1068	:	Electroplated coatings of nickel and chromium of iron and steel.
IS: 1077	:	Specification for common burnt clay building bricks
IS: 1786	:	Specification for high strength deformed steel bars and wires for concrete reinforcement
IS: 1239	:	Mild steel tubes (Part I) and mild steel tubulars and other wrought steel pipe fittings (Part II)
IS : 1536	:	Centrifugally cast (spun) iron pressure pipes for water, gas and sewage.
IS : 1626	:	Asbestos cement building pipes, gutters and fittings (spigot and socket types).
IS : 1703	:	Copper Alloy float valves (horizontal plunger type) for water supply purposes.
IS : 1726	:	Cast iron manhole covers and frames.
IS : 1729	:	Sand cast iron spigot and socket soil, waste and ventilating pipes, fittings and accessories.
IS : 1742	:	Code of practice for buildings drainage
IS : 2116	:	Specification for sand for masonry mortars
IS : 2212	:	Code of practice for brickwork
IS : 2250	:	Code of practice for preparation and use of masonry mortars
IS : 2326	:	Automatic flushing cisterns for urinals
IS : 2470	:	Code of practice for design and construction of septic tanks (Parts I & II)
IS : 2556	:	Vitreous sanitary appliances (Part I to Part XV)
IS : 2963	:	Specification for copper alloy waste fittings for wash basins and sinks
IS : 3006	:	Specification for chemically resistant glazed stoneware pipes and fittings
IS : 3311	:	Waste plug and its accessories for sinks and wash basins
IS : 5455	:	Specification for cast iron steps for manholes
IS : 4127	:	Code of Practice for laying of glazed stoneware pipes
IS : 3495	:	Methods of tests of burnt clay building bricks
IS : 4111	:	Code of practice for ancillary structures in sewerage system manholes
IS : 5382	:	Specification for rubber sealing rings for gas mains, water mains and sewers
IS : 5329	:	Code of practice for sanitary pipe work above ground for buildings
IS : 5434	:	Non-ferrous alloy bottle traps for marine use

## **Sanitary Installation**

The work shall be carried out complying in all respects with any specific requirements of the local body in whose jurisdiction the work is situated, and as approved by the Employer's Representative.

Any damage caused to the building, or to installations therein, either due to negligence on the part of the Contractor, or due to actual requirements of the work, shall be made good and the building or the installation shall be restored to its original condition by the Contractor.

All sanitary and plumbing work shall be carried out by licensed plumbers.

All sanitary appliances including sanitary fittings, fixtures, toilet requisites shall be of size, and design as approved by the Employer's Representative.

All white glazed porcelain fixtures, such as wash basin, sink drain board, water closet pan, urinal, 'P' trap etc. shall have hard durable white glazed finish. They shall be free from cracks and other glazing defects. No chipped porcelain fixtures shall be used.

Joints between iron and earthenware pipes shall be made perfectly air and water tight by caulking with neat cement mortar.

### **A) Indian Type Water Closet**

This shall be the long pan pattern with separate footrests made of white glazed earthenware, white glazed vitreous china or of white glazed fire clay. The general requirements shall conform to IS:2556 (Parts III and X). Each pan shall have an integral flushing rim of suitable type. It shall also have an inlet or supply horn for connecting the flush type. The flushing rim and inlet shall be of the self draining type. It shall have a weephole at the flushing inlet to the pan. The flushing inlet shall be in the front, unless otherwise approved by the Employer's Representative. The inside of the bottom of pan shall have sufficient slope from the front towards the outlet and the surface shall be uniform and smooth enable easy and quick disposal while flushing. The exterior surface shall be unglazed and sufficiently rough or grooved at right angles to the axis of the outlet. Pans shall be provided with a trap 'P' or 'S' type with a minimum 50 mm water seal and 50 mm dia. vent horn. Pan shall be laid at the correct location and level over a bed of lime concrete using brick aggregates (1 part lime mortar to 2 parts brick bats with lime mortar to 2 parts of sand) or cement-sand admixture as specified in the drawings.

### **B) European Type Water Closet**

Water closets shall be either of white glazed earthenware, white glazed vitreous china or white glazed fire clay as specified and shall be of "Siphonic Wash down type" conforming to IS.2556 (Part VIII). The closets shall be of one piece construction with approved plastic/bakelite seat and cover. Each water closet shall have 4 fixing holes having a minimum diameter of 6.5 mm for fixing to floor and shall have an integral flushing rim of suitable type. It shall also have an inlet of supply horn for connecting the flush pipe. The flushing rim and inlet shall be of the self-draining type. The water closet shall have a weephole at the flushing inlet. Each water closet shall have an integral trap with either "S" or "P" outlet with at least 50 mm water seal. The water closets shall have an antisiphonage 50 mm dia. vent horn on the outlet side of the trap. The inside of water closets and traps shall be uniform and smooth in order to ensure in efficient flush. The serrated part of the outlet shall not be glazed externally. The water closet when sealed at the bottom of the trap in line with the back plate, shall be capable of holding not less than 10 litres of water between the normal water level and the highest possible water level of the water closet installed.

## **Urinals**

Urinals shall be of the bowl pattern, either flat back or angle back type lipped in front. They shall be of white glazed earthenware, white glazed vitreous china or white glazed fire clay, and of size as specified conforming to IS.2556 (Part VI). The urinals shall be of one piece construction. Each urinal shall be provided with not less than two fixings holes of a minimum dia. of 6.5 mm on each side. Each urinal shall have an integral flushing box rim of suitable type and inlet or supply horn for connecting the flush pipe. The flushing rim and inlet shall be of the self

draining type. It shall have a weephole at the flushing inlet of the urinal. At the bottom of the urinal, an outlet horn for connecting to an outlet pipe shall be provided. The exterior of the outlet horn shall not be glazed and the surface shall be provided with grooves at right angles to the axis of the outlet to facilitate fixing to the uniform and smooth throughout to ensure efficient flushing. The bottom of pan shall have sufficient slope from the front, towards the outlet such that there is efficient draining of the urinal. The waste fittings shall be chromium plated.

### **Wash Basins**

Wash basins shall be of white glazed earthenware, white glazed vitreous china or white glazed fire clay as approved by the Employer's Representative and conforming to IS.2556

<b>Type</b>	<b>Size</b>
Flat Back	630 x 450 mm
Flat Back	550 x 400 mm

- (a) Wash basins shall be of one piece construction, including a combined overflow. All internal angles shall be designed so as to facilitate cleaning. Each shall have a rim sloping inside towards the bowl on all sides except skirting at the back. Basins shall be provided with single or double tap holes as approved. The tap holes shall be square. A suitable tap hole button shall be supplied if one tap hole is not required in installation. Each basin shall have a circular waste hole to which the interior of basin shall drain. The waste hole shall be either rebated or bevelled internally with diameter of 65 mm at top and a depth of 10 mm to suit a waste plug having 64 mm diameter. Each basin shall be provided with a non-ferrous 32 mm waste fittings. Stud slots to receive the brackets on the under side of the wash basins shall be suitable for a bracket with stud not exceeding 13 mm diameter, 5 mm high and 305 mm from the back of basin to the centre of the stud. The stud slots shall be of depth sufficient to take 5 mm stud. Every basin shall have an integral soap holder recess or recesses which shall fully drain into the bowl. The position of the chain stay-hole shall not be lower than the overflow slot. A slot type of overflow having an area of not less than 5 sq.cm. shall be provided and shall be so designed as to facilitate cleaning of the overflow. The Employer's Requirements for waste plug, chain and stay shall be the same as given for sinks.
- (b) All the waste fittings shall be chromium plated. Bottle trap shall conform to IS. 5434. The chromium plating shall be of service grade No. 2 conforming to IS.1068.

### **Sinks**

- (a) The sinks shall be of white glazed earthenware, white glazed vitreous china or white glazed fire clay as approved by the Employer's Representative conforming to IS.2556 (Part V) and shall be of the following sizes:
- 450 x 300 x 150 mm  
600 x 450 x 200 mm
- (b) They shall be of one piece construction, including a combined overflow. The floor of the sink shall gently slope towards the outlet. The outlet shall in all cases be suitable for waste fittings having flange of 64 mm diameter and the waste hole shall have a minimum diameter of 65 mm at the bottom to suit the waste fittings. The waste hole shall be either rebated or bevelled having a depth of 10 mm. Each sink shall be provided with a non-ferrous 40 mm dia. waste fitting. The sink shall have overflow of the weir type and the inverts shall be 30 mm below the top edge. Each sink shall be provided with a waste plug, of suitable dia. chain and stay. The plug shall be of rubber or other equally suitable material and shall be water tight when fitted. Plug chains shall be of brass wire chromium plated. It shall have an overall length from the collar to the stay of not less than 300 mm. There shall be a triangular or D shackle at each end, one of which shall be brazed to the plug and the other securely fixed to the stay. The 150 mm long shank of the waste shall be threaded conforming to the requirements of IS.2556 for sinks only. The waste fittings and plug fittings shall be chromium plated. The chromium plating shall be of service grade No.2 conforming to IS.1068.



### **Flushing Cisterns**

The flushing cisterns shall be automatic or manually operated, high level or low level, as approved by the Employer's Representative. For water closets and urinals high level cistern is intended to operate with minimum height of 125 cm and a low level cistern a maximum height of 30 cm between the top of the pan and the underside of the cistern. They shall be of cast iron, glazed earthenware, or pressed steel complying iron, glazed requirement of IS.774. Automatic flushing cistern for urinals shall conform to IS.2326.

### **Cast Iron Soil Waste and Vent Pipes and Fittings**

All cast iron pipes and fittings shall be of uniform thickness with strong and deep sockets, free from flaws, air holes, cracks, sand holes and other defects and conform to IS.1536 . The diameter approved shall be internal diameter of pipe. The pipes and fittings shall be true to shape, smooth and cylindrical and shall ring clearly when struck over with a light hand hammer. All pipes and fittings shall be properly cleaned of all foreign material before being fixed.

All plug bends of drainage pipes shall be provided with inspection and cleaning caps, covers, which shall be fixed with nuts and screws. Pipes shall be fixed to the wall by W.I. or M.S. holder bat clamps, unless projecting ears with fixing holes are provided at socket end of pipe. The pipes shall be installed, truly vertical or to the lines and slopes as indicated. The clamps shall be fixed to the walls by embedding their hooks in cement concrete blocks (1:2:4) 10 cm x 10 cm making necessary holes in the walls at proper places. All holes and breakages shall be made good. The clamps shall be kept 25 mm clear of the finished face of the walls to facilitate cleaning and painting of pipes.

The annular space between the socket and spigot shall be filled with a gasket of hemp or spun yarn soaked in neat cement slurry. The joint shall then be filled with stiff cement mortar 1:2 (1 cement : 2 fine sand) well pressed with caulking tool and finished smooth on top at an angle of 45°. The joint shall be kept wet for not less than 7 days by tying a piece of gunny bag kept moist. Joints shall be perfectly air tight as well as water tight.

C.I. pipes and fittings which are exposed shall be first cleaned and then painted with a coat of red lead primer. Two coats of zinc paint with white base and mixed with pigment of required colour to get the approved shade shall be given over the base primer coat.

The thickness of fittings and their socket and spigot dimensions shall conform to the thickness and dimensions approved for the corresponding sizes of straight pipes.

The connection between the main pipe and branch pipes shall be made by using branches and bends with access for cleaning. Floor traps shall be provided with 25 mm dia. puff pipe where the length of the waste is more than 1800 mm or the floor trap is connected to a waste stack through bends.

All cast iron pipes and fittings including joints shall be tested by a smoke test to the satisfaction of the Employer's Representative and left in working condition after completion. The smoke test shall be carried out as stated under :

Smoke shall be pumped into the pipe at the lowest and from a smoke machine which consists of a bellow and a burner. The material usually burnt is greasy cotton waste which gives out a clear pungent smoke which is easily detectable by sight as well as by smell if there is a leak at any point of the pipeline.

Water test and air test shall be conducted as stipulated in IS.5329.

### **Galvanized Mild Steel (G.I) Pipe**

The pipes shall be galvanized mild steel welded pipes and seamless screwed and sockets tubes conforming to the requirements of IS.1239, for medium grade. They shall be of the diameter (nominal bore) approved. The sockets shall be designated by the respective nominal bores of the pipes for which they are intended. The pipes and sockets shall be finished neatly, well galvanized on both inner and outer surfaces, and shall be free from cracks, surface flaws, laminations and other defects. All screws, threads shall be clean and well cut. The ends shall be cut cleanly and square with the axis of the tube.

All screwed tubes and sockets shall have pipe threads conforming to the requirements of IS.554. Screwed tubes shall have taper threads while the sockets shall have parallel threads.

The fittings shall be of malleable cast iron or mild steel tubes complying with all the appropriate requirements as approved for pipes. The fittings shall be designated by the respective nominal bores of the pipes for which they are intended. The fittings shall have screw threads at the ends conforming to the requirements of IS.554. Female threads on fittings shall be parallel and male threads (except on running nipples and collars of unions) shall be tapered.

The pipes and fittings shall be inspected at site before use to ascertain that they conform to the specification. The defective pipes shall be rejected. Where the pipes have to be cut or rethreaded, the ends shall be carefully filled out so that no obstruction to bore is offered. The ends of the pipes shall then be threaded conforming to the requirements of IS.554 with pipe dies and taps carefully in such a manner as will not result in slackness of joints when the two pieces are screwed together. The taps and dies shall be used only for straightening bent and damaged screw threads and shall not be used for turning of the threads so as to make them slack, water tight joint. The screw- thread of pipes and fittings shall be protected from damage until they are fitted.

The pipes shall be cleaned and cleared of all foreign matter before being laid. In jointing the pipes, the inside of the socket and the screwed end of the pipes shall be oiled and rubbed over with white lead and a few turns of spun yarn wrapped around the screwed end of the pipe. The end shall then be screwed in the socket, tee, etc., with the pipe wrench. Care should be taken that all pipes and fittings are properly jointed so as to make the joints completely water tight and pipes are kept at all times free from dust and dirt during fixing. Burrs from the joint shall be removed after screwing. After laying, the open ends of the pipes shall be temporarily plugged to prevent access of soil or any other foreign matter.

Any threads exposed after jointing shall be painted or in the case of underground piping thickly coated with approved anticorrosive paint to prevent corrosion.

For internal work the galvanised iron pipes and fittings shall run on the surface of the walls or ceiling (not in chase) unless otherwise specified. The fixing shall be done by means of standard pattern holder bat clamps, keeping the pipes about 1.5 cm clear of the wall. Pipes and fittings shall be fixed truly vertical/horizontal. When it is found necessary to conceal the pipes, chasing may be adopted or pipes fixed in the ducts of recesses etc. provided there is sufficient space to work on the pipes with the usual tools. The pipes shall not ordinarily be buried in walls or solid floors. Where unavoidable, pipes may be buried for short distances provided adequate protection is given against damage, but the joints in pipes shall not be buried. M.S. pipe sleeve shall be fixed at a place where a pipe is passing through a wall or floor for reception of the pipe and to allow freedom for expansion/contraction and other movements/maintenance. In case the pipe is embedded in walls or floors it should be painted with anti-corrosive bitumastic paint of approved quality. The pipe should not come in contact with lime mortar or lime concrete as the pipe is affected by lime. Under the floors the pipes shall be laid in layer of sand filling or as approved by the Employer's Representative.

G.I. pipes with socket and spigot ends shall be provided with lead caulked joints wherever specified and the joints shall conform to the requirements of IS.3114.

The work of excavation and backfilling shall be done true to line and gradient in accordance with general Employer's Requirements for earthworks in trenches for pipes laid underground.

The pipes shall be laid on a layer of 10.0 cm sand and filled upto 15 cm above the pipes. A sand cushion of 15cm on either side of the pipe shall also be provided. The remaining portion of the trench shall then be filled with excavated earth. The surplus earth shall be got rid of as directed. when excavation is done in rock the bottom shall be cut deep enough to permit the pipes to be laid on a cushion of sand 75 mm minimum.

The pipes and fittings after they are laid and jointed shall be subjected to hydrostatic pressure test as approved by the Employer's Representative and shall satisfactorily pass the test. Pipe line system shall be tested in sections as the work proceeds, keeping the joints exposed for inspection. Pipes shall be slowly and carefully charged with water allowing all air to escape. All draw off taps shall then be closed and water pressure gradually raised to test pressure. Care shall be taken to ensure that pressure gauge is accurate and preferably should have been recalibrated before the test. Pump used having been stopped, the section of the

pipeline shall maintain the test pressure for at least half an hour. Any joints or pipes found leaking shall be removed and replaced by the Contractor.

The G.I. pipe line shall be cut to the required length at the position where the meter and stop cock are required to be fixed. The ends of the pipes shall be threaded. The meter and stop cock shall be fixed in position by means of connecting pipe, G.I. nuts, sockets, etc. The stop cock shall be fixed near the inlet of the water meter. The paper disc inserted in the ripples of the meter shall be removed and meter installed exactly horizontally or vertically and with the arrow cast on the body of the meter pointing in the direction of flow. Care shall be taken that the factory seal of the meter is not disturbed. Whenever the meter is to be fixed to a newly fitted pipe line, the pipe line will have to be completely washed before fixing the meter. For this purpose, a connecting piece of pipe equal to the length of the meter is to be fixed on the new pipe line. The water shall be allowed to flow completely to wash the pipe line and then the meter installed as described above by replacing the connecting piece.

### **Stoneware pipes and Fittings**

All pipes with spigot and socket ends shall conform to IS.651/3006 and shall be of grade 'A'. These shall be sound, free from visible defects such as fine cracks or hair cracks. The glaze of the pipes shall be free from crazing. The pipes shall give a sharp clear note when struck with a light hammer.

The following information shall be clearly marked on each pipe and fitting :

- (a) Internal diameter;
- (b) Grade;
- (c) Date of manufacture;
- (d) Name of manufacturer or his registered trade-mark or both.

All pipes and fittings shall have ISI mark.

Jointing of GSW pipes and fittings shall be done as per the requirements of the following Employer's Requirements and the relevant IS. After jointing, extraneous material if any, shall be removed from the inside of the pipes and fittings and the newly made joints shall be thoroughly cured. In case, rubber sealing rings are used for jointing, these shall conform to IS : 5382.

### **Spigot and Socket Joint (Cement Joint)**

The spigot of each pipe shall be slipped home well into the socket of the pipe previously laid and adjusted in the correct position. In each joint, spun yarn soaked in neat cement slurry or tarred gasket shall be passed around the joint and inserted in it by means of a caulking tool. More skeins of yarn or gasket shall be added if necessary and shall be well caulked. Yarn or gasket so rammed shall not occupy more than one-fourth of the depth of socket.

Cement mortar (1:1) shall be slightly moistened and carefully inserted by hand into the remaining space of the joint after caulking of yarn or gasket. The mortar shall then be caulked into the joint with a caulking tool. More cement mortar shall be added until the space of joint has been completely filled with tightly caulked mortar. The joint shall then be finished off neatly outside the socket at an angle of 45 degrees.

The cement mortar joints shall be cured at least for seven days before testing.

The approximate quantity of cement required for each joint for certain common sizes of pipes are given below for guidance :

<b>Nominal diameter of pipe (mm)</b>	<b>Cement (kg)</b>
150	1.5
200	2.0
250	2.5
300	3.25
350	4.5
400	5.5
450	6.5

#### Spigot and Socket Joint (Bituminous Joint)

The general requirements for this type of joint shall be as specified in 5.12.1 The material for jointing shall consist of composition of asphalt and sand in the ratio of 1:7. Asphalt and sand shall be boiled together and filled into the socket in a molten state with the aid of special moulds.

#### Spigot and Socket Joint (Rubber Ring Joint)

- a) The pipe with the rubber ring accurately positioned on the spigot shall be pushed well home into the socket of the previously laid pipe by means of uniformly applied pressure with the aid of a jack or similar appliance. The rubber rings conforming to IS : 5382 shall be used, and the manufacturer's instructions shall be deemed to form a part of this Employer's Requirements. The rubber rings shall be lubricated before making the joint and the lubricant shall be soft soap water or an approved lubricant supplied by the manufacturer.

#### Cleaning of Pipes

As soon as a stretch of GSW pipes has been laid complete from manhole to manhole or for a length as approved by the Employer's Representative, the Contractor shall run through the pipes both backward and forward a double disc or solid or closed cylinder 50 mm less in diameter than the internal diameter of pipes. The open end of an incomplete stretch of pipeline shall be securely closed as approved by the Employer's Representative to prevent entry of mud or silt etc.

If as a result of the removal of any obstruction the Employer's Representative considers that damages may have been caused to the pipe lines, he shall be entitled to order the length to be tested immediately. Should such test prove unsatisfactory the Contractor shall repair the pipeline and carry out such further tests as are required by the Employer's Representative.

It shall also be ascertained by the Contractor that each length from manhole to manhole or the length as approved by the Employer's Representative is absolutely clear and without any obstruction by means of visual examination of the interior of the pipeline suitably illuminated by projected sunlight or otherwise.

After laying and jointing of GSW pipes is completed the pipe line shall be tested as per the following Employer's Requirements and as approved by the Employer's Representative. All equipment for testing at work site shall be supplied and erected by the Contractor. Water for testing of pipeline shall be arranged by him. Damage during testing shall be the Contractor's responsibility and shall be rectified by him to the full satisfaction of the Employer's Representative. Water used for test shall be removed from pipes and not released to the excavated trenches.

After the joints have thoroughly set and have been checked by the Employer's Representative and before backfilling the trenches, the entire section of the sewer or storm water drain shall be proved by the Contractor to be water tight. Before commencing the hydraulic test, the pipelines shall be filled with water and maintained full for 24 hours by adding water, if necessary, under a head of 0.6 m of water. The test shall be carried out by suitably plugging the low end of the drain and the ends of connections, if any, and filling the system with water. A knuckle bend shall be temporarily jointed at the top end and a sufficient length of vertical pipe jointed to it so as to provide the required test head; or the top end may be plugged with a connection to a hose ending in a funnel which could be raised or lowered till the required head is obtained and fixed suitably for observation. The pipeline shall be subjected to a test pressure of at least 2.5 m head of water at the highest point of the section under test. The tolerance of two litres per centimeter of diameter per kilometer may be allowed during a period of 10 minutes. Any leakage including excessive sweating which causes a drop in the test water level will be visible and the defective part of the work should be removed and made good.

If any damage is caused to the pipeline during the execution of work or while cleaning/testing the pipeline as specified. The Contractor shall be held responsible for the same and shall replace the damaged pipeline and re-test the same to the full satisfaction of the Employer's Representative.

Water for testing of pipeline shall be arranged by the Contractor.

## **Stop Cock and Bib Cock**

A bibcock (bib tap) is a draw off tap with a horizontal inlet and free outlet and stopcock (stop tap) is a valve with a suitable means of connections for insertion in a pipe line for controlling or stopping the flow. They shall be of specified size and shall be of the screw down type. The closing device should work by means of a disc carrying a renewable non-metallic washer, which shuts against water pressure on a seating at right angles to the axis of the threaded spindle which operates it. The handle shall be either crutch or butterfly type securely fixed to the spindle. The cocks shall open in anti-clockwise direction. When the bib cocks and stop cocks are required to be chromium plated, the chromium plating shall be of service Grade No. 2 conforming to IS.1068. in finish and appearance, the plated articles shall be free from plating defects such as blisters, pits, roughness and shall not be stained or discoloured.

These fittings shall be of brass heavy class, chromium plated (C.P) and of approved manufacture and pattern with screwed or flanged ends as specified. The fittings shall in all respects comply with the requirements of IS.781. The standard size of brass fittings shall be designated by the nominal bore of the pipe to which the fittings are attached. A sample of each kind of fitting shall be approved by the Employer's Representative and all supplies made according to the approved samples.

All cast fittings shall be sound and free from laps, blow holes and fittings, both internal and external surfaces shall be clean, smooth and free from sand etc. Burning, plugging stopping or patching of the casting shall not be permitted. The bodies, bonnets, spindles and other parts shall be truly machined and when assembled the parts shall be axial, parallel and cylindrical with surfaces smoothly finished. The area of the waterway of the fittings shall not be less than the area of the nominal bore.

The fittings shall be fully examined and cleared of all foreign matter before being fixed. The fittings shall be fitted in the pipe line in a workman like manner. The joints between fittings and pipes shall be made leak- proof. The joints and fittings shall be leak proof when subjected to a pressure test approved by the Employer's Representative and the defective fittings and joints shall be replaced or redone.

## **Soak Pit**

Soak pit shall be constructed at the location specified by the Employer's Representative. Earthwork excavation shall be carried out to the exact dimensions. Brick masonry lining with open joints shall be constructed in the pit upto 150 mm below the outlet pipeline. Brick masonry in cement mortar 1:6 shall be constructed above this level upto ground. Well burnt brick aggregates of nominal size 40 mm to 80 mm and coarse sand shall be filled within the chamber. Construction of pit lining and filling of the brick ballast shall progress simultaneously.

## **Manholes**

### Location

Manholes shall be constructed at places approved by the Employer's Representative.

### Excavation

Excavation, shoring, dewatering etc. for the pits of manholes, laying of pipes and fittings/specials shall be done in accordance with Employer's Requirements described elsewhere in the document.

### Bed Concrete

The bed concrete for manholes shall be done in accordance with Employer's Requirements described elsewhere in the document.

### Bricks

Bricks used for construction of manholes shall conform to the relevant Indian Standards. They shall be sound, hard, homogeneous in texture, well burnt in kiln without being vitrified, table moulded, deep red, cherry or copper coloured, of regular shape and size and shall have sharp and square and parallel faces. The bricks shall be free from pores, chips, flaws or humps of any kind. Bricks containing ungrounded particles and/or which absorb water more than 1/6th of their weight when soaked in water for twenty-four hours shall be rejected. Overburnt or underburnt bricks shall be liable to rejection. The bricks shall give a clear ringing sound when

struck and shall have a minimum crushing strength of 50 kg/sq.cm. unless otherwise noted in drawings. The class and quality requirements of bricks shall be as laid down in IS : 1077.

The size of the brick shall be 23.0 x 11.5 x 7.5 cm. unless otherwise specified; but tolerance upto  $\pm 3$  mm in each direction shall be permitted. Only full size brick shall be used for masonry work. Brick bats shall be used only with the permission of Employer's Representative to make up required wall length or for bonding. Sample bricks shall be submitted to the Employer's Representative for approval and bricks supplied shall conform to approved samples. If required by the Employer's Representative, brick sample shall be tested as per IS : 3495 by Contractor. Bricks rejected by the Employer's Representative shall be removed from the Site within 24 hours.

#### Cement Mortar

Mortar for brick masonry shall be prepared as per IS : 2250. Manholes shall be constructed in brick masonry with cement mortar (1:2) unless otherwise specified. Gauge boxes for sand shall be of such dimensions that one bag containing 50 kg. of cement forms one unit. The sand shall be free from clay, shale, loam, alkali and organic matter and shall be of sound, hard, clean and durable particles. Sand shall be as approved by the Employer's Representative. If required by the Employer's Representative sand shall be thoroughly washed till it is free of any contamination.

For preparing cement mortar, the ingredients shall first be mixed thoroughly in dry conditions. Water shall then be added and mixing continued to give a uniform mix of required consistency. Cement mortar shall be used within 25 minutes of mixing. Mortar left unused in the specified period shall be rejected.

The Contractor shall arrange for tests on mortar samples if so required by Employer's Representative. Retempering of mortar shall not be permitted.

#### Brick Masonry

All bricks shall be thoroughly soaked in clean water for atleast one hour immediately before being laid. The cement mortar for brick masonry work of manholes shall be in the proportion specified in 5.15.5. Brick work 230 mm thick and over shall be laid in English Bond unless otherwise specified. 115 mm thick brick work shall be laid with stretchers. For laying bricks, a layer of mortar shall be spread over the full width of suitable length of the lower course. Each brick shall be pressed into the mortar and shoved into final position so as to embed the brick fully in mortar. Bricks shall be laid with frogs uppermost.

All brickwork shall be plumb and square unless otherwise shown on drawing and true to dimensions shown. Vertical joints in alternate courses shall come directly one over the other and be in line. Horizontal courses shall be levelled. The thickness of brick courses shall be kept uniform. For walls of thickness greater than 230 mm both faces shall be kept in vertical planes unless otherwise specified. All interconnected brickwork shall be carried out at nearly one level (so that there is uniform distribution of pressure on the supporting structure) and no portion of the work shall be left more than one course lower than the adjacent work. Where this is not possible, the work shall be raked back according to bond (and not saw toothed) at an angle not exceeding 45 degrees. But in no case the level difference between adjoining walls shall exceed 1.25 M. Workmanship shall conform to IS : 2212.

Brick shall be so laid that all joints are well filled with mortar. The thickness of joints shall not be less than 6 mm and not more than 10 mm. The face joints shall be raked to a minimum depth of 12 mm by raking tools daily during the progress of work when the mortar is still green, so as to provide a proper key for the plastering to be done. When plastering is not required to be done, the joints shall be uniform in thickness and be struck flush and finished at the time of laying. The face of brickwork shall be cleaned daily and all mortar droppings removed. The surface of each course shall be thoroughly cleaned of all dirt before another course is laid on top. If mortar in the lower courses has begun to set, the joints shall be raked out to a depth of 12 mm before another course is laid.

### Cement Plaster

All joints in masonry shall be raked to a depth of 12 mm with hooked tool made for the purpose when the mortar is still green and in any case within 48 hours of its laying. The surface to be rendered shall be washed with fresh clean water free from all dirt, loose material, grease etc. and thoroughly wetted for 6 hours before plastering work is commenced. Concrete surfaces to be rendered will however be kept dry. The wall should not be too wet but only damp at the time of plastering. The damping shall be uniform to get uniform bond between the plaster and the wall.

The proportion of the cement mortar shall be as approved on relevant drawings. Cement shall be mixed thoroughly in dry condition and then just enough water added to obtain a workable consistency. The quality of water, sand and cement shall be as per relevant I.S. The mortar thus mixed shall be used immediately and in no case shall the mortar be allowed to remain for more than 25 minutes after mixing with water.

Curing of plaster shall be started as soon as the applied plaster has hardened enough so as not to be damaged. Curing shall be done by continuously applying water in a fine spray and shall be carried out for at least 7 days.

Plastering shall be done on both faces of brick masonry in cement mortar (1:2) and 20 mm thick unless otherwise specified.

Plastering work shall be carried out in two layers, the first layer being 14 mm thick and the second layer being 6 mm thick. The first layer shall be dashed against the prepared surface with a trowel to obtain an even surface. The second layer shall then be applied and finished leaving an even and uniform surface, trowel finished unless otherwise approved by the Employer's Representative.

### Cement Concrete Channel

The channel for the manhole shall be constructed in cement concrete of M15 grade. Both sides of the channel shall be taken up to the level of the crown of the outgoing sewer. They shall be benched up in concrete and rendered in cement mortar (1:1) of 20 mm thickness and formed to a slope of 1 in 12 towards the channel.

### Pipe Entering or Leaving Manhole

Whenever a pipe enters or leaves a manhole, bricks on edge must be cut to a proper form and laid around the upper end of the pipe so as to form an arch. All around the pipes, there shall be a joint of cement mortar (1:2) 13 mm thick between it and the bricks.

### Cast Iron Steps

Cast iron steps shall be as per IS : 5455. The steps shall be of grey cast iron of grade 15 as per IS : 210. The steps shall be clean, well cast and they shall be free from air and sand holes, cold shuts and warpings. The portion of the step which projects from the wall of the manhole shall have a raised chequered design to provide an adequate non-slip grip. C.I. steps shall weigh not less than 4.5 kg each and shall be of 150 mm x 375 mm overall dimensions. These steps shall be coated with a black bituminous composition. The coating shall be smooth and tenacious. It shall not flow when exposed to a temperature of 63 degrees C and shall not be brittle as to chip off at temperature of 0 degree C.

Where the depth of invert of manhole exceeds 800 mm, cast iron steps of approved pattern shall be fixed in the brick work at the interval of 300 mm vertically and staggered at 380 mm horizontally centre to centre. In case of pipe diameter greater than 600 mm, box type C.I. steps weighing 19 kg each shall be provided at 300 mm vertically in channel of manhole.

### Frame and Covers

Frame and covers for manholes shall be of required type and dimensions as per the relevant drawings prepared by the Contractor. Following information shall be clearly marked on each cover.

- Year of manufacture,
- Identification mark of the Employer: Project Director and Superintending Engineer
- Arrow showing direction of flow

#### (a) Cast Iron Frame and Cover

The cast iron frame and cover shall be of grey cast iron as per IS : 1726. The general requirements for casting and coating of CI frame and cover shall be as specified for CI steps in Clause 5.15.10. The covers shall have a raised chequered design to provide an adequate non-slip grip. The rise of the chequer shall be not less than 4 mm. The locking device for the cover shall be provided as approved by the Employer's Representative. The CI covers for the load test shall be selected at one for every lot of fifty or part thereof for each type and size manufactured and as approved by the Employer's Representative. The frame shall be fixed in cement concrete of M15 grade all round and finished with neat cement. The manhole frame shall have 560 mm diameter clear opening and shall weigh not less than 208 kg. including cover. In case of rectangular CI frame and cover of 900 mm x 600 mm clear opening, the total weight shall not be less than 275 kg. In case of scraper manhole the frame shall have clear opening of 1200 mm x 900 mm and shall weigh not less than 900 kg including cover. The manhole cover and frame shall be painted with three coats of anti-corrosive paint after fixing in position.

#### (b) Fibre Reinforced Concrete Frame and Cover

Fibre reinforced concrete frame and cover shall be capable of withstanding load of 35 tonnes. The frame shall be fixed in cement concrete of M15 grade all around and finished with neat cement. The fibre reinforced frame shall have clear opening of 560 mm diameter and weighing 102 kg. The cover shall have a minimum thickness of 100 mm and weighing 78 kg. The fibres shall constitute 1% of the weight of the concrete in the form of 50 mm to 100 mm long high tensile steel wires. For the cover, MS sheet lapping of 18 gauge shall be provided to avoid damage to the edges. Similarly for frame, MS angle/flat shall be provided along the edge. Both MS sheet and angle shall be painted with black bituminous paint. The cover should have suitable lifting arrangement. The fibre reinforced frame and cover shall be manufactured as approved.

#### (c) Reinforced Cement Concrete Frame and Cover

Reinforced cement concrete frame and cover for manholes shall be of required dimensions and shape as shown on the drawing prepared by the Contractor. The frame and cover shall be cast in cement concrete of M25 grade. Minimum cover to the reinforcement shall be 40 mm. The edges of frame and covers shall be provided with mild steel angles to avoid damages to the corners. These angles shall be painted with black bituminous paint. The covers should have suitable lifting arrangement.

### Drop Manhole

When a sewer connects a main sewer, and where the difference in level between water line (peak flow levels) of main line and the invert level of branch lines is more than 600 mm or a drop of more than 600 mm is required to be given in the same sewer line and it is uneconomical or impractical to arrange the connection within 600 mm, a drop connection shall be provided for which a manhole shall be constructed as per relevant drawing, incorporating a vertical drop pipe from the higher sewer to the lower one. This pipe shall be provided outside the shaft and encased in concrete. A continuation of the branch sewer should be built through the shaft wall to form a rodding and inspection eye, which should be provided with a half blank flange. The diameter of the back drop should be at least as large as that of the incoming pipe. The drop pipe should terminate at its lower end with a plain or duck-foot bend turned so as to discharge its flow



at 45 degrees or less to the direction of the flow in the main sewer. The pipe unless of cast iron should be surrounded with 150 mm thick concrete.

In the case of sewers over 450 mm in diameter the drop in level may be accomplished by one of the following approved methods:

- (a) A cascade;
- (b) A ramp;
- (c) By drops in previous manholes.

#### **RCC Manhole**

M25 grade of concrete used for construction of RCC manhole shall have minimum cement content of 360 kg/cum of concrete. Minimum cover to the reinforcement shall be 50 mm.

#### **Vent Shafts**

- (a) General

Vent shafts shall be erected at such places as approved by the Employer's Representative.

- (b) Mild Steel Vent Shaft

Mild steel vent shaft shall be of 150 mm diameter and 12.17 m height from ground level with C.I. ornamental cap. This shall be fixed firmly and encased in cement concrete of M15 grade as shown on relevant drawing with necessary mild steel bolts, plates etc. for foundation. The vent shaft shall be painted with one coat of silver paint over one coat of red lead oxide paint. The vent shaft shall be connected to manhole by 150 mm diameter glazed stoneware pipe encased by M10 concrete of 150 mm thickness all around as approved by the Employer's Representative.

- (c) RCC Vent Shaft

Reinforced cement concrete vent shaft shall be of M25 grade concrete, 200 mm diameter at bottom and tapered to 100 mm diameter at top (both inside clear openings) and 6 m height from ground level. The vent shaft shall be embedded in concrete of M10 grade and anchored by 2 nos. of 16 mm diameter and 600 mm long MS bars. The vent shaft shall be connected to manhole as specified in (b) above through a brick masonry flue chamber.

#### **Miscellaneous**

If any damage is caused to the other services such as water supply pipeline, sewer, cable, etc. during the construction of manholes and erection of vent shafts, the Contractor shall be held responsible for the same and shall replace the damaged services to the full satisfaction of the Employer's Representative.

## EARTHWORKS

### Applicable Codes

The following Indian Standard Codes, unless otherwise specified herein, shall be applicable. In all cases, the latest revision of the codes shall be referred to.

IS 783 - 1985	-	Code of practice for laying of concrete pipes.
IS 3764 - 1992	-	Excavation work - Code of Safety.
IS 2720	-	Methods of test for soils:
(Part-1) - 1983	-	Part 1 Preparation of dry soil samples for various tests.
(Part-2) - 1986	-	Part 2 Determination of Water Content.
(Part-4) - 1985	-	Part 4 Grain size analysis.
(Part-5) - 1985	-	Part 5 Determination of liquid and plastic limit.
(Part-7) - 1980	-	Part 7 Determination of water content - dry density relation using light compaction.
(Part-9) - 1971	-	-Part 9 Determination of dry density - moisture content by constant weight of soil method.
(Part-14) – 1983	-	Part 14 Determination of density index (relative density) of cohesionless soils.
(Part-22) – 1978	-	Part 22 Determination of organic matter.
(Part-26) – 1987	-	Part 26 Determination of pH Value.
(Part-27) – 1987	-	Part 27 Determination of total soluble sulphates.
(Part-28) – 1974	-	Part 28 Determination of dry density of soils in place, by the sand replacement method.
(Part-33) – 1971	-	Part 33 Determination of the density in place by the ring and water replacement method.
(Part-34) – 1972	-	Part 34 Determination of density of soil in place by rubber balloon method.
(Part-38) – 1976	-	Part 38 Compaction control test (Hilf Method).

### General

The Contractor shall furnish all tools, plant, instruments, qualified supervisory personnel, labour, materials, any temporary works, consumables, any and everything necessary, whether or not such items are specifically stated herein for completion of the work in accordance with the Employer's Requirements.

The Contractor shall survey the site before excavation and set out all lines and establish levels for various works such as grading, basement, foundations, plinth filling, roads, drains, cable trenches, pipelines etc. Such survey shall be carried out by taking accurate cross sections of the area perpendicular to established reference/grid lines at 8m intervals or nearer, if necessary, based on ground profile and thereafter properly recorded.

The excavation shall be carried out to correct lines and levels. This shall also include, where required, proper shoring to maintain excavations and also the furnishing, erecting and maintaining of substantial barricades around excavated areas and warning lamps at night.

Excavated material shall be dumped in regular heaps, bunds, riprap with regular slopes within the lead specified and leveling the same so as to provide natural drainage. Rock/soil excavated shall be stacked properly as approved by the Employer's Representative. As a rule, all softer material shall be laid along the center of heaps, the harder and more weather resisting materials forming the casing on the sides and the top. Rock shall be stacked separately.

Topsoil shall be stock piled separately for later re-use.

## **Clearing**

The area to be excavated/filled shall be cleared of fences, trees, plants, logs, stumps, bush, vegetation, rubbish, slush, etc. and other objectionable matter. If any roots or stumps of trees are encountered during excavation, they shall also be removed. The material so removed shall be disposed off as approved by the Employer's Representative. Where earth fill is intended, the area shall be stripped of all loose/ soft patches, top soil containing objectionable matter/ materials before fill commences.

## **Excavation**

All excavation work shall be carried out by mechanical equipment unless, in the opinion of Employer's Representative, the work involved requires it to be carried out by manual methods.

Excavation for permanent work shall be taken out to such widths, lengths, depths and profiles as are shown on the drawings provided by the Contractor or such other lines and grades as may be agreed with the Employer's Representative. Rough excavation shall be carried out to a depth of 150mm above the final level. The balance shall be excavated with special care.

Soft pockets shall be removed below the final level and extra excavation filled up with lean concrete as approved by the Employer's Representative. The final excavation should be carried out just prior to laying the blinding course.

To facilitate the permanent works the Contractor may excavate, and also backfill later, outside the lines shown on the drawings provided by the Contractor as agreed with the Employer's Representative. Should any excavation be taken below the specified elevations, the Contractor shall fill it up with concrete of the same class as in the foundation resting thereon, upto the required elevation at no cost to the Employer.

All excavations shall be to the minimum dimensions required for safety and ease of working. Prior approval of the Employer's Representative shall be obtained by the Contractor in each individual case, for the method proposed for the excavation, including dimensions, side slopes, dewatering, disposal, etc. This approval, shall not in any way relieve the Contractor of his responsibility for any consequent loss or damage. The excavation must be carried out in the most expeditious and efficient manner. Side slopes shall be as steep as will stand safely for the actual soil conditions encountered. Every precaution shall be taken to prevent slips. Should slips occur, the slipped material shall be removed and the slope dressed to a modified stable slope.

## **Rock**

General:

'Rock' means a natural aggregate of mineral crystals, which for its excavation would normally require the use of heavy pneumatic/hydraulic breaker and/or cutting equipment or explosives. the term shall exclude any material that can be removed by ordinary excavating machinery and which in any individual mass has a volume not exceeding  $1\text{m}^3$  or  $0.25\text{m}^3$  where the net width of excavation is less than 2 m. Ordinary excavating machinery means a hydraulic back hoe with rated output of 50 kW or less.

Before classification of material as rock the Contractor shall demonstrate to the satisfaction of the Employer's Representative his inability to excavate it without resort to heavy percussion tools complete with rock bits, hydraulic wedges or blasting. Excavation by the use of explosive will not normally be permitted except for pipeline.

Material shall not be classified as rock unless the Employer's Representative has agreed to such classification on the basis of such a demonstration before its excavation. Excavations where rock has been encountered and classified as such shall not be backfilled before examination of the excavated faces by the Employer's Representative to enable the extent of the rock excavation to be determined.

## **Excavation by the Use of Explosives**

Unless otherwise stated herein, I.S. Specification " IS:4081: Safety Code for Blasting and related Drilling Operations" shall be followed. As far as possible all blasting shall be completed

prior to commencement of construction. At all stages of excavation, precautions shall be taken to preserve the rock below and beyond the lines specified for the excavation, in the soundest possible condition. The quantity and strength of explosives used, shall be such as will neither damage nor crack the rock outside the limits of excavation. All precautions, as directed by Employer's Representative, shall be taken during the blasting operations and care shall be taken that no damage is caused to adjoining buildings or structures as a result of blasting operations. In case of damage to permanent or temporary structures, Contractor shall repair the same to the satisfaction of Employer's Representative at his cost. As excavation approaches its final lines and levels, the depth of the charge holes and amount of explosives used shall be progressively and suitably reduced.

The contractor shall obtain a valid Blasting License from the authorities concerned. No explosive shall be brought near the work in excess of quantity required for a particular amount of firing to be done; and surplus left after filling the holes shall be removed to the magazine. The magazine shall be built as away as possible from the area to be blasted. Employer's Representative's prior approval shall be taken for the location proposed for the magazine.

In no case shall blasting be allowed closer than 30 meters to any structure or to locations where concrete has just been placed. In the latter case the concrete must be at least 7 days old.

For blasting operations, the following points shall be observed.

- i) Contractor shall employ a competent and experienced supervisor and licensed blaster in-charge of each set of operation, who shall be held personally responsible to ensure that all safety regulations are carried out.
- ii) Before any blasting is carried out, Contractor shall intimate Employer's Representative and obtain his approval in writing for resorting to such operations. He shall intimate the hours of firing charges, the nature of explosive to be used and the precautions taken for ensuring safety.
- iii) Contractor shall ensure that all workmen and the personnel at site are excluded from an area within 200 m radius from the firing point, at least 15 minutes before firing time by sounding warning whistle. The area shall also be given a warning by sounding a distinguishing whistle.
- iv) The blasting of rock near any existing buildings, equipments or any other property shall be done under cover and Contractor has to make all such necessary muffling arrangements. Covering may preferably be done by MS plates with adequate dead weight over them. Blasting shall be done with small charges only and where directed by Employer's Representative; a trench shall have to be cut by chiseling prior to the blasting operation, separating the area under blasting from the existing structures.
- v) The firing shall be supervised by a Supervisor and not more than 6 (six) holes at a time shall be set off successively. If the blasts do not tally with the number fired, the misfired holes shall be carefully located after half an hour and when located, shall be exploded by drilling a fresh hole along the misfired hole (but not nearer than 600 mm from it) and by exploding a new charge.
- vi) A wooden tamping rod with a flat end shall be used to push cartridges home and metal rod or hammer shall not be permitted. The charges shall be placed firmly into place and not rammed or pounded. After a hole is filled to the required depth, the balance of the hole shall be filled with stemming, which may consist of sand or stone dust or similar inert material.
- vii) Contractor shall preferably detonate the explosives electrically.
- viii) The explosives shall be exploded by means of a primer, which shall be fired by detonating a fuse instantaneous detonator (F.I.D) or other approved cables. The detonators with F.I.D. shall be connected by special nippers.
- ix) In dry weather and normal dry excavation, ordinary low explosive gunpowder may be used. In damp rock, high explosive like gelatin with detonator and fuse wire may be used. Underwater or for excavation in rock with substantial accumulated seepage electric detonation shall be used.

- x) Holes for charging explosives shall be drilled with pneumatic drills, the drilling pattern being so planned that rock pieces after blasting will be suitable for handling without secondary blasting.
- When excavation has almost reached the desired level, hand trimming shall have to be done for dressing the surface to the desired level.
- Any rock excavation beyond an over break limit of 75 mm shall be filled up as instructed by Employer's Representative, with concrete of strength not less than M10. Stopping in rock excavation shall be done by hand trimming.
- xii) Contractor shall be responsible for any accident to workmen, public or Employer's property due to blasting operations. Contractor shall also be responsible for strict observance of rules, laid by Inspector of explosives, or any other Authority duly constituted under the State and / or Union Government as applicable at the place of excavation.

### **Stripping Loose Rock**

All loose boulders, detached rocks partially and other loose material which might move therewith not directly in the excavation but so close to the area to be excavated as to be liable, in the opinion of Employer's Representative, to fall or otherwise endanger the workmen, equipment, or the work shall be stripped off and removed from the area of the excavation. The method used shall be such as not to render unstable or unsafe the portion, which was originally sound and safe.

Any material not requiring removal in order to complete the permanent works, but which, in the opinion of Employer's Representative, is likely to become loose or unstable later, shall also be promptly and satisfactorily removed.

### **Classification of Strata :**

The decision regarding, classification of strata shall rest with the Engineer In Charge and his decision shall be final and binding to the contractor.

All the materials encountered in the excavation shall be classified as under :-

### **ORDINARY SOIL AND SOFT MURRUM :**

These will include all materials of an earthy or sandy nature, which can be easily ploughed or small shingle, and gravel, which can be easily removed.

### **HARD MURRUM :**

This shall include all kinds of disintegrated rock or shale or inundated clay which can be removed with a shovel without difficulty and which do not require blasting.

### **SOFT ROCK :**

This shall includes all materials which is rock or hard conglomerate, all decomposed and whether rock, highly fissured rock old masonry and also soft rock boulders bigger than 1/2 cubic meter and other varieties of rock. Which do not require blasting and which can be removed with the pie crowbars wedges and hammer.

### **HARD ROCK :**

This shall includes rocks, occurring in masses, which could best be removed by chiseling.

### **Fill, Backfilling and Site Grading**

General:

All fill material shall be subject to the Employer's Representative's approval. If any material is rejected by Employer's Representative, the Contractor shall remove the same forthwith from the site. Surplus fill material shall be deposited/disposed off as directed by Employer's Representative after the fill work is completed.

No earth fill shall commence until surface water discharges and streams have been properly intercepted or otherwise dealt with to the approval of the Employer's Representative.

### **Material**

To the extent available, selected surplus spoil from excavations shall be used as backfill. Backfill material shall be free from lumps, organic or other foreign material. All lumps of earth

shall be broken or removed. Where excavated material is mostly rock, the boulders shall be broken into pieces not larger than 150 mm size, mixed with properly graded fine material consisting of murrum or earth to fill the voids and the mixture used for filling.

If fill material is required to be imported, the Contractor shall make arrangements to bring such material from outside borrow pits. The material and source shall be subject to the prior approval of the Employer's Representative. The approved borrow pit areas shall be cleared of all bushes, roots of trees, plants, rubbish, etc. Topsoil containing foreign material shall be removed. The materials so removed shall be disposed of as directed by Employer's Representative. The Contractor shall provide the necessary access roads to borrow areas and maintain the same if such roads do not exist.

Filling in pits and trenches around foundations of structures, walls, etc.

As soon as the work in foundations has been accepted and measured, the spaces around the foundations, structures, pits, trenches, etc., shall be cleared of all debris, and filled with earth in layers not exceeding 15 cm, each layer being watered, rammed and properly consolidated, before the succeeding one is laid. Each layer shall be consolidated to the satisfaction of Employer's Representative. Earth shall be rammed with approved mechanical compaction machines. Usually no manual compaction shall be allowed unless the Employer's Representative is satisfied that in some cases manual compaction by tampers cannot be avoided. The final backfill surface shall be trimmed and leveled to a proper profile to the approval of the Employer's Representative.

#### **Plinth Filling**

Plinth filling shall be carried out with approved material as described hereinbefore in layers not exceeding 15cm, watered and compacted with mechanical compaction machines. The Employer's Representative may, however, permit manual compaction by hand tampers where he is satisfied that mechanical compaction is not possible. The finished level of the filling shall be trimmed to the level/slope specified.

The thickness of each unconsolidated fill layer can in this case be upto a maximum of 300mm. The Contractor will determine the thickness of the layers in which fill has to be consolidated depending on the fill material and equipment used and the approval of the Employer's Representative obtained prior to commencing filling.

The compacted surface shall be properly shaped, trimmed and consolidated to an even and uniform gradient. All soft spots shall be excavated, then filled and consolidated.

#### **Sand Filling in Plinth and Other Places**

Where backfilling is required to be carried out with local sand it shall be clean, medium grained and free from impurities. The filled-in-sand shall be kept flooded with water for 24 hours to ensure maximum consolidation. The surface of the consolidated sand shall be dressed to required level or slope. Construction of floors or other structures on sand fill shall not be started until the Employer's Representative has inspected and approved the fill.

#### **Filling in Trenches**

Filling in trenches for pipes and drains shall be commenced as soon as the joints of pipe and drains have been tested and passed. The backfilling material shall be properly consolidated taking due care so that no damage is caused to the pipes.

Where the trenches are excavated in soil, the filling from the bottom of the trench to the level of the center line of the pipe shall be done by hand compaction with selected approved earth in layers not exceeding 8 cm; backfilling above the level of the center line of the pipes shall be done with selected earth by hand compaction, or other approved means in layers not exceeding 15 cm.

In case of excavation of trenches in rock, the filling upto a level 30 cm above the top of the pipe shall be done with fine materials such as earth, murrum, etc. The filling up to the level of the centerline of the pipe shall be done by hand compaction in layers not exceeding 8 cm whereas the filling above the centerline of the pipe shall be done by hand compaction or approved means in layers not exceeding 15 cm. The filling from a level 30 cm above the top of the pipe to the top of the trench shall be done by hand or other approved mechanical methods

with broken rock filling of size not exceeding 15 cm mixed with fine material as available to fill up the voids.

Filling of the trenches shall be carried out simultaneously on both sides of the pipe to avoid unequal pressure on the pipe.

### **General Site Grading**

ite grading shall be carried out as indicated in the drawings and as approved by the Employer's Representative. Excavation shall be carried out as specified in the Employer's Requirements. Filling and compaction shall be carried out as specified under Clause 2.7 and elsewhere unless otherwise indicated below.

If no compaction is called for, the fill may be deposited to the full height in one operation and leveled. If the fill has to be compacted, it shall be placed in layers not exceeding 225 mm and leveled uniformly and compacted as indicated in Clause 2.7 before the next layer is deposited.

To ensure that the fill has been compacted as specified, field and laboratory tests shall be carried out by the Contractor.

Field compaction tests shall be carried out in each layer of filling until the fill to the entire height has been completed. This shall hold good for embankments as well. The fill will be considered as incomplete if the desired compaction has not been obtained.

The Contractor shall protect the earth fill from being washed away by rain or damaged in any other way. Should any slip occur, the Contractor shall remove the affected material and make good the slip.

If so specified, the rock as obtained from excavation may be used for filling and leveling to indicated grades without further breaking. In such an event, filling shall be done in layers not exceeding 50 cms approximately. After rock filling to the approximate level, indicated above has been carried out, the void in the rocks shall be filled with finer materials such as earth, broken stone, etc. and the area flooded so that the finer materials fill up the voids. Care shall be taken to ensure that the finer fill material does not get washed out. Over the layer so filled, a 100 mm thick mixed layer of broken material and earth shall be laid and consolidation carried out by a 12-ton roller. No less than twelve passes of the roller shall be accepted before subsequent similar operations are taken up.

### **Fill Density**

The compaction, under the plant road area and building plinths shall comply with minimum 95% compaction by Standard Proctor at moisture content differing not more than 4% from the optimum moisture content. The Contractor shall demonstrate adequately by field and laboratory tests that the specified density has been obtained. In other areas the soil should be backfilled and compacted suitably as specified by the Engineer.

### **Timber Shoring**

Close timbering shall be done by completely covering the sides of the trenches and pits generally with short, upright members called 'polling boards'. These shall be of minimum 25 cm x 4 cm sections or as approved by the Employer's Representative. The boards shall generally be placed in position vertically side by side without any gap on each side of the excavation and shall be secured by horizontal walling of strong wood at maximum 1.2 meter spacing, strutted with ballies or as approved by the Employer's Representative. The length of the ballie struts shall depend on the width of the trench or pit. If the soil is very soft and loose, the boards shall be placed horizontally against each side of the excavation and supported by vertical walling, which in turn shall be suitably strutted. The lowest boards supporting the sides shall be taken into the ground and no portion of the vertical side of the trench or pit shall remain exposed, so as to render the earth liable to slip out.

Timber shoring shall be 'close' or 'open' type, depending on the nature of soil and the depth of pit or trench. The type of timbering shall be as approved by the Employer's Representative. It shall be the responsibility of the Contractor to take all necessary steps to prevent the sides of excavations, trenches, pits, etc. from collapsing.

Timber shoring may also be required to keep the sides of excavations vertical to ensure safety of adjoining structures or to limit the slope of excavations, or due to space restrictions or for other reasons. Such shoring shall be carried out, except in an emergency, only under instructions from the Employer's Representative.

The withdrawal of the timber shall be done carefully to prevent the collapse of the pit or trench. It shall be started at one end and proceeded with, systematically to the other end. Concrete or masonry shall not be damaged during the removal of the timber.

In the case of open timbering, the entire surface of the side of trench or pit is not required to be covered. The vertical boards of minimum 25 cm x 4 cm sections shall be spaced sufficiently apart to leave unsupported strips of maximum 50 cm average width. The detailed arrangement, sizes of the timber and the spacing shall be subject to the approval of the Employer's Representative. In all other respects, the Employer's Requirements for close timbering shall apply to open timbering.

In case of large pits and open excavations, where shoring is required for securing safety of adjoining structures or for any other reasons and where the planking across sides of excavations/pits cannot be strutted against, suitable inclined struts supported on the excavated bed shall be provided. The load from such struts shall be suitably distributed on the bed to ensure no yielding of the strut.

### **Dewatering**

The Contractor shall ensure that the excavation and the structures are free from water during construction and shall take all necessary precautions and measures to exclude ground/rain water so as to enable the works to be carried out in reasonably dry conditions in accordance with the construction programme. Sumps made for dewatering must be kept clear of the excavations/trenches required for further work. The method of pumping shall be approved by Employer's Representative, but in any case, the pumping arrangement shall be such that there shall be no movement of subsoil or blowing in due to differential head of water during pumping. Pumping arrangements shall be adequate to ensure no delays in construction. The dewatering shall be continued for at least (7) seven days after the last pour of the concrete. The Contractor shall, however, ensure that no damage to the structure results on stopping of dewatering.

The Contractor shall study the sub-soil conditions carefully and shall conduct any tests necessary at the site with the approval of the Employer's Representative to test the permeability and drainage conditions of the sub-soil for excavation, concreting etc., below ground level.

The scheme for dewatering and disposal of water shall be approved by the Employer's Representative. The Contractor shall suitably divert the water obtained from dewatering from such areas of site where a build up of water in the opinion of the Employer's Representative obstructs the progress of the work, leads to unsanitary conditions by stagnation, retards the speed of construction and is detrimental to the safety of men, materials, structures and equipment.

When there is a continuous inflow of water and the quantum of water to be handled is considered in the opinion of Employer's Representative, to be large, a well point system- single stage or multistage, shall be adopted. The Contractor shall submit to the Employer's Representative, details of his well point system including the stages, the spacing, number and diameter of well points, headers etc., and the number, capacity and location of pumps for approval.

### **Rain Water Drainage**

Grading in the vicinity of excavation shall be such as to exclude rain/ surface water draining into excavated areas. Excavation shall be kept clean of rain and such water as the Contractor may be using for his work by suitably pumping out the same. The scheme for pumping and discharge of such water shall be approved by the Employer's Representative.



## **EXCAVATION FOR PIPE LINE TRENCHES**

Excavation for pipeline trenches including all type of strata including hard rock and Bhath rock, including all safety provisions using the site rails, stacking the excavated stuff up to a lead of 90 mt. Clearing the site, jungle cutting etc. the earth cover over the pipe shall be Average 1.0 mt. However not less than 0.90 mt. The minimum width of trench should be 25 CM on each side of the pipe the rate includes cost of extra excavation for working space at joints, dewatering blasting if required and as per detailed specification etc complete ( For HDPE pipe trench width shall be 0.60 mt ) for lift and all strata as specified.

- a) In all sorts of soil, soft murrum, hard murrum, soft rock including hard rock with blasting or / chiselling.

### **1. GENERAL**

- 1.1 The excavation for trenches will generally, refer to open excavation for trenches in wet / dry conditions for pipe laying work.

### **2.0 CLEARING OF SITES:**

- 2.1 The site on which the pipelines are to be laid and shown on plan and the area required for setting out and other operations shall be cleared and all obstruction loose stones and materials, rubbish of all kinds, stumps, brushwood as trees shall be removed as directed the roots shall be entirely grubbed up.
- 2.2 The products of the clearing to restocked in such a place and in such a manner, as directed by the Engineer In Charge.
- 2.3 In jungle clearings, all trees not specially marked for preservation, bamboo's jungle wood and brushwood shall be cut down their roots grubbed up. All wood and materials from the clearing shall be the property of the Board shall be arranged as directed by the Board Engineer or his authorized agent, the material pronounced as useful by the Engineer will be conveyed and properly stacked as directed within the specified limit. Unless materials will be burnt or otherwise disposed off as directed.
- 2.4 All holes or hollows whether originally existing or produced by digging up roots, shall be carefully filled up with earth, well earth, well rammed leveled off, as may be directed.

### **3.0 SETTING OUT:**

The centre lines of all pipe trenches etc. shall be given by the Engineer-in-charge and it will be the responsibility of the contractor to install substantial reference marks, bench marks, etc. and maintain them as long as required true to line, level curve and slopes. The contractor shall assure full responsibility for alignment, and dimension of trench.

The labor materials etc. required for setting out and establishing benchmarks and other reference marks shall be arranged by the contractor at his own cost.

## **4 EXCAVATION**

- 4.1 The excavation incl. Bailing out of water for the pipe trenches shall also incl. Removal of all materials of whatever nature and whether wet or dry condition necessary for laying of pipelines exactly in accordance with alignment, levels grades and curves shown on the plans or as directed by the Engineer-in-charge. Trenches shall be excavated to the exact width and depth according to the size of pipe and the sides shall be left vertical as far as possible or according to the angle of repose various soils. Unless there is a specific extra provision in the contract for shoring and strutting or for cutting side slopes the contractor shall at his own cost do the necessary shoring and strutting or cutting of slopes to a safe of repose or both approved by the Engineer-in-charge. The contractor shall notify the Engineer before starting excavation to enable him to take cross sectional levels for

purpose of measurements before the ground is disturbed. The bottom of the trenches shall be leveled both longitudinally and transversely or slopped as directed by the Engineer. The contractor shall at his own cost to remove such portions of boulders or rocks, as are rectified to make the bottom of the trench level. No filling shall be allowed to bring the trench to level. If by contractor's mistake excavation is made deeper than shown on the plans and if ordered by the Engineer the extra depth shall have to be made with selected excavated stuff only with watering, remedying etc. as directed, by the Engineer and at the cost of the contractor. Other hard excavation shall be cleared of all sorts and loose materials and cut to firm surface, either level, stepped as directed by the Engineer. The Engineer may order such charges in the dimensions and alignment of pipe trench as may be deemed necessary to secure satisfactory cover over pipeline. The contractor shall, at his own expense, make provision for bailing out of draining water and the trenches shall be kept free of water, during laying work.

After each excavation is completed, the contractor shall notify the Engineer to that effect and no laying of pipeline will be allowed to laid until Engineer has approved the depth and dimensions of trenches level and measurements.

#### **5.0 SHORING AND STRUTTING:**

- 5.1 Shoring & strutting and dewatering if required shall have to be carried out by the contractor, for which any extra charge will not be paid.
- 5.2 During excavation if water connections, sewage connections, telephone lines, khalkuva (soak pits) etc. are damaged by the contractor, the same shall have to be restored by the contractor without any extra payment.

#### **6.0 PROTECTION**

- 6.1 The trenches shall be strongly fenced and red light signal shall be kept at night and arrangement of watchman to prevent accidents should be done, sufficient care protective measure shall be taken to see that the excavation shall not affect or damage the adjoining structure. The contractor shall be entirely responsible for any injury to life and damage to the properties etc. Necessary protection work such as guide ropes, crossing places, barricades, caution boards etc. shall be provided by the contractor.

- 7.0 The excavation in all sorts of soil, hard murram, soft rock or hard rock or any type of soil shall have to be carried out up to the required depth by the agency

#### **8 DISPOSAL OF EXCAVATED STUFF**

- 8.1 No excavated stuff from trench are to be placed even temporarily nearer than 1.5 meter or greater distance up to 90 meter or as prescribed by the Engineer from the outer edge of trench. All excavated material will be the property of the board. The rate of excavated includes sorting out of useful materials and stacking then separately as directed within specified lead. The excavated stuff suitable and useful for refilling or for other use shall be stacked at convenient places. The materials not useful in any wet shall be disposal off as directed by the Engineer from the outer edge of trench.
- 8.2 The site should be cleared off on completion of work.

#### **9.0 ADDITIONAL REQUIREMENTS**

- 9.1 At the joints of pipes, the trench shall be excavated to an additional depth of 15 cm. and width of 30 cm. And length of 15 cm. beyond the edge of collar on both the sides or as directed. The rate include for such extra excavation made at the joints. The trenches shall be excavated perfectly in straight line. The bottom of the trench shall be kept as per invert level or as directed. To maintain the proper slop the usual method of site rails and boning rods shall be adopted. The contractor shall have to provide and fix and maintain sight rails and boning rod without any extra cost.

If the contractor fails or makes delay to give hydraulic test of the pipe line laid in any of the section, without any genuine reason, he shall be responsible to get any part of the length trenches refill in such case i.e. before testing for safety of pedestrian and/or vehicular traffic as found necessary by the engineer-in-charge without any extra cost. If found necessary any directed by the Engineer-in-charge. The contractor shall have to excavate the refilled trenches, during hydraulic test without any extra cost.

At all road crossings, trenches shall be excavated only for half width of the road and pipe shall be laid. The other half shall be excavated only after back filling over the laid pipeline is done so as to make it suitable for the traffic. The contractor shall provide direction when the pipeline is to be laid along the road as required and shall maintain the diversion or any part of it, without any extra cost. At all road crossings, the pipe shall be laid below the crest of road.

- 9.2 The contractor shall break the road surface by excavation chiseling to the exact width and length as shown on the drawing or as directed by the Engineer-in-charge. The excavated stuff shall be deposited in uniform layers to avoid mixing with other kind of materials at non-objectionable place or as directed by the Engineer-in-charge.

## **10.0 MEASUREMENT AND PAYMENT**

- 10.1 The payment of excavation shall be made as per the rate for actual strata met per cubic meter for the quantity actually excavated and accepted by the Engineer In Charge limited to dimensions shown in the sanctioned plans or as directed by the Engineer. Excavation in excess of the sanctioned dimensions shall not be measured not paid for and if an ordered by the Engineer the contractor shall have to fill up the excess depth with excavated stuff with watering ramming etc. (Completed as specified) for trench without any extra payment to the contractor.
- 10.2 Dimension shall be correct to two places of decimals of a meter and individual quantity shall of decimals of a meter and individual quantity shall be calculated to two places of decimals of a cubic meter.
- 10.3 The rate for the item of excavation shall include unless and otherwise mentioned.
- (a) Clearing of site
  - (b) Setting out work including all materials and labour.
  - (c) Providing and subsequently removing, shoring and strutting outing slopes etc.
  - (d) Excavation and removal and staking of all excavated stuff as directed.
  - (e) Necessary protection including labour materials equipment etc. to ensure safety and protection against risk or accident.
  - (f) Providing facilities for inspection and damage to property if caused during progress of work.
  - (g) Compensation for injury to life and damage to property if caused during progress of work.
  - (h) Restoring of water supply connections, sewer connections, telephone lines, khalkuva soapiest etc. if damaged by contractor without extra payment.
  - (i) Dewatering of excavated pit trench during the progress of work.
  - (j) Clearing the site on completion of works directed by the Engineer.

## **HDPE PIPE**

**Providing and Supplying in standard length ISI mark high density Polyethylene H.D.P.E. pipes suitable for potable water as per IS specification no. 4984/1995 incl. all local central taxes, transportation, freight charges, octroi, inspection charges, loading, unloading conveyance to the departmental store etc comp.**

**H.D.P.E. Pipe line of 6kg/cm<sup>2</sup>**

### **HDPE PIPES.**

#### **SPECIFICATION FOR MANUFACTURE, SUPPLY & DELIVERY OF HDPE PIPES:**

##### **A. General technical specifications:**

##### **1. Scope of Item:**

The item shall be covering manufacturing, supplying, and delivery of HDPE pipes having pressure rating PN-6 & material grade PE –100 bearing IS 4984/1995 and its latest version or amendments. The HDPE pipes shall be supply in standard length or as per GWSSB requirements. Pipes suitable to Lowering laying, jointing the HDPE pipes with technique of BUTT FUSION WELDING method with the help of electric heat (mirror) and hydraulically operated welding jack and push fit joints Up to 110 mm dia.

##### **2. Standard:**

The HDPE pipes is to be procured, supplied under the scope of this item and which shall be meet the requirement of pressure rating of PN 6 and material grade PE-100 in accordance and confirming to IS:4984/1995 or its latest version or amendments with IS certification mark.

##### **3. Temperature Variation:**

All the pipes to be supplied and delivered shall be subject to weather condition like sun, dust, rain, wind as available in the state of Gujarat. They shall also be subject to carry and convey drinking water under available temperature condition ranging from 4 Deg. Centigrade to 40 Deg. Centigrade.

##### **4. Marking:**

The method of marking to all the pipes to be used under the scope of contract shall ensure that all the information as mentioned in clause 10 of IS:4984/1995 and/or its latest amendments. The marking will remain legible even after transportation, storage in open space etc. In general the legible and indelible marking upon the pipes shall indicate the following:

- a) Manufacturer's name or trade mark.
- b) Grade of material.
- c) Class of pipes and pressure rating.
- d) Nominal dia meter.
- e) Lot number / Batch number of manufacturer.
- f) ISI certification mark.
- g) Purchasers mark as " GWSSB ".
- h) Any other important matter that the manufacturer of purchaser deems fit to be inscribed.

## 5. Packing and handling:

When the pipes are transported at railway risk, special packing as per IRCA rules are absolutely necessary for which the extra cost if any shall be borne in total by bidders only. The bidder shall have proper handling instrument / equipment and shall follow suitable method of handling of pipes as may be approved by Engineer while unloading, and stacking material.

## 6. Material and workman ship:

- 6.1. General requirement of material and workmanship shall mean any material or articles either raw material or additives or finished are required to be used in the manufacturing process of pipes.
- 6.2. The material used for manufacturing of pipes should not constitute any toxic hazards should not support micro biological growth and should not give rise to unpleasant test or odor, cloudiness or discoloration of water. The bidder shall have to produce Pipe manufacturer's certificate, that the material meets the PE 100 requirements as per IS 4984/1995 and its latest revision / amendments. All other quality parameters like density, MFR, carbon black content, anti oxidant and reworked material of raw material use for manufacturing of pipes shall be strictly as per IS:4984 /1995 or its latest revision or amendment. The original invoice of raw material required to manufacture ordered length of HDPE pipes and batch wise test certificate of raw material will be verified and certified by GWSSB or third party inspecting agency fixed by GWSSB. The carbon black master batch if used shall be certified by the master batch seller as fit for the purpose of standard for which the HDPE pipe are under order.
- 6.3. The HDPE pipe shall be manufactured from the certified raw material of PE-100 grade and suppliers has to submit the certificate from raw material manufacturer.
- 6.4. For PE-100 pipes those who have no valid BIS at present shall furnish the BIS license.
- 6.5. Up to 110 mm dia pipes only push fit joints shall be used for joining of pipes. these fittings shall carry the necessary international approvals for leak proof jointing. The following quantity per Km. and part thereof the pipe shall be supplied free of cost along with the pipe as per the following table:

Size mm Coupler Threaded

Adopter	Bend	Tee	Flange	Joint
63	2	2	2	3
75	3	3	2	3
90	5	5	2	3
110	7	7	2	3

## Technical specification:

1. Supply of material and manufacture of pipe: The general requirement relating to supply of material and manufacture of HDPE pipe shall be confirming to the relevant IS specification.
  - 1.1 The dimensions, material compositions, test etc. shall be as per IS 4984/1995 or its latest revision / amendment.
  - 1.2 HDPE pipe shall be marked with the ISI certification mark.
  - 1.3 The minimum and maximum wall thickness of pipe shall be as per specification in IS 4984/1995 or its latest revision / amendment.
  - 1.4 The color of pipe shall be black as per IS 4984/1995 or its latest revision / amendment. for the identification purpose each pipe shall contain minimum three equal spaced longitudinal strips of width 3 mm (min) in blue color. These strips shall be co-extruded during pipe manufacturing itself and shall not be more than 0.2 mm in depth. The material of the strips shall be of the same types of resin as used in based compound for the pipe.
  - 1.5 100 % virgin material shall allow no rework is to be used for the production of pipes.

#### **1.6 For laying and jointing**

The bidder shall have to arrange demonstration of the installation and testing of pipe by manufacturer including fixing all specials and valves properly at least up to 10 % of total quantity to be supplied by them at any place of the site of work under the bid. The bidder shall have to arrange for random testing of pipes brought on site, in CIPET in the presence of GWSSB representative and on satisfactory report from the CIPET the payment of pipes will be made. The payment shall be paid after completion of whole item as mentioned in price bid.

### **Lowering, laying and jointing of HDPE Pipe**

**Lowering, laying & jointing HDPE pipe and specials of following class & diameter (by butt fusion welding method) incl. cost of convey. from stores to site of works incl. cost of labour, material, giving satisfactory hydraulic testing as per ISI code etc comp.**

#### **1.0 WELDING**

HDPE pipes are jointed by BUTT Fusion welding method with the help of electric heat (Mirror) and hydraulically operated welding jack.

#### **1.1 PRECAUTIONS**

Since critical parameters for sound welding joint are temperature and pressure, welding methods should insure proper temperature and pressure by using proper equipments. The welding area has to be protected from adverse weather condition like rain water, moisture, rough wind, dust and low ambient temperature (less than 5<sup>o</sup> C. Primary inspection of pipes should be done for ensuring defect free pipe before starting welding.

#### **1.2 WELDING PROCEDURE**

Two ends of pipes to be welded are to be cut perpendicular to the pipe axis and then cleaned and planed by using proper planning tool. The pipes are fixed in welding jack and aligned properly in axial direction. The pipes then are pressed against a hot plate (called heating mirror or simply mirror) till a bead of molten material is formed. The mirror is electrically heated by inbuilt electric resistance heating coil. The heating should be uniform all around mirror plate on both sides. The mirror should be provided with a temperature control device so that during welding the surface temperature is automatically maintained within the required limit i.e. 200 + 10<sup>o</sup> C. Proper Teflon cloth covering should be provided on mirror surface to avoid sticking of melted HDPE material on plate surface. After attaining the welding temperature of 200 c. on mirror surface the pipe ends are simultaneously brought in contact with the heating surfaces of mirror. This is done by using hydraulically operated welding jack. Initial contact pressure is applied which is maintained till the uniform ring of molten bead is achieved. Then the contact pressure is reduced until proper fusion takes place. After proper fusion, the welding mirror is removed carefully without damaging the head. The time of removal of the mirror should be as short as possible. After removal of mirror, pipe ends are brought immediately to contact with each other under initial welding pressure, which is gradually increased to final welding pressure. This pressure depends on the total welding surface of pipe. The final welding pressure is maintain to be applied till the joint is cooled down to ambient temperature naturally. Artificial cooling such as wrapping with wet cloth, spraying of water etc. are not allowed.

#### **2.0 INSPECTION OF JOINTS:**

The visual inspection of each joint should be done to ensure correct bead formation. Weld joint should be checked for axial alignment of welded pipes.

#### **3.0 LAYING OF PIPES**

- 3.1 The required length of HDPE pipes is made alongside the trench. The pipe is lowered into the trench carefully avoiding damage to pipe and joints.

### **3.2 TRENCH**

Since the welding of pipe is done outside of trench, the width of trench should be kept as minimum as possible, Normally 600 mm width should be sufficient for laying. The depth of trench will be as per the requirement of client depending on level survey (L.S). However earth cover of average 1.0 mtr. on top of pipe or as directed by Engineer-in-charge is to be provided. The trench should be made as straight as possible. Wherever necessary, the trench can be made with smooth curve but not below allowed bending radius of HDPE pipe, which is 25 times of O.D. The bottom of trench should be properly dressed and made free from any sharp objects.

### **3.3 LAYING & BACKFILLING:**

Laying of pipe lengths to be done carefully from one end without giving any impact on pipe. After laying of pipe, trench should backfilled with the layers of good earth of dug soil as available. extra soil will be embedded on trench, which will be compacted by curing with water.

### **3.4 HYDRO TESTING:**

The pipeline to be tested with fitted with metal blind flange at both ends with the help of stub end (pipe end). These blind flanges are fitted with necessary arrangement for supplying water into pipeline, air valve for air drain and pressure gauge. After filling the water into pipeline, pressurized water is supplied with the help of pressure pump. When the required test pressure (i.e. 6 Kg./cm<sup>2</sup> in our case) is achieved, pressure pump is stopped and valve is closed. This pressure will be kept for 30 minutes and there should not be any drastic drop in pressure whole pipeline route under test is inspected for checking any leakage. If there is no leakage, the pressure of 6Kg./cm<sup>2</sup> will remain it and it test is believed to be satisfactory. Please note that there could be slight deep in pressure due to leakage from flange/ valve or due to expansion of HDPE pipe under pressure. This drop up to 0.5 Kg./cm<sup>2</sup> is normally not considered.

### **4.0 CONNECTION OF HDPE TO M.S.PIPE**

This connection will be made by using metal flange. We shall provide flange at the end of HDPE pipe by using HDPE stub end. Matching flange connection from M.S. pipe will be made by M.S. pipe agency to which flange of HDPE pipeline will be connected by bolting and proper rubber gasket packing.

### **5.0 AIR VALVE FIXING:**

Suitable size of air valve will be installed on HDPE pipe with the help of metallic saddle. Metallic flange for air valve will be provided on upper part of saddle for fixing air valve. Valve chamber of suitable size with top cover will be made for each air valve.

### **THE SCOPE FOR THE ITEM COVER**

Cost of additional excavation required for jointing clearing the site of all scrubs, bushes, and trees and dewatering where necessary. Labour for laying pipes in trenches to correct alignment at required depth with tools, including cutting of pipes and specials if required for laying of pipes including connecting pipes to specials and appurtenances. Cost of the scaffolding, tools and plants, ropes etc. Protection of existing works from damage and cost of repair to the damages carried out to the existing structure, sewer line telephone/electricity cables, electric cables, electric lines, gas pipeline, irrigation pipe line etc. The pipe laying across the state highways, national highways etc. will have to be done either through open cut method or through push through method depending upon the requirement to be prescribed by the sanctioning authority. However, mostly it would be push through method. GWSSB will not be able to provide water for testing of the pipelines & water containers of the project. This shall have to be managed by the contractor at his costs and risk. Labor for making joints including jointing material for joints, tools as well as tests. Testing of pipes for leakage under water pressure and flushing the

pipes after testing and construction work shall have to be arranged by the contractor at his own cost.

**METHOD OF MEASUREMENT AND PAYMENT**

The measurement shall be recorded in running meter of pipe length laid along the centerline of axis of pipeline including tees, enlarges, reducers and bends, correct up to 0.01 m length. No payment shall be made for overlaps etc. The payment shall be paid after completion of whole item as mentioned in price bid on Running Meter basis and 10% shall be withheld for satisfactory hydraulic testing”.

**Mode of measurement and payments**

The payment shall be made as mentioned in price bid.



## **Providing, supplying, Lowering laying and jointing D I – pipe**

Providing and Supplying DI K-9 & K-7 grade pipes with internal cement mortar lining as per IS specification no. 8329/1994 incl.all local and central taxes, transporation, freight, octroi, inspection charges, loading, unloading conveyance to the departmental stores etc comp.

**Note: Wherever International Standards or Indian standards / specifications are mentioned, their equivalent or higher standards / specifications are also acceptable**

Supply and Delivery of **Ductile Iron Pipe as per IS : 8329-2000** or its latest revision or amendments if any including jointing material as EPDM ring as per IS 5382-1985 and ISO: 4633-1996 or its latest revision or amendments if any

### **Standards**

The following standards, specifications and codes are part of this specification. In all cases, the latest revision of the including all applicable official amendments and revisions shall be referred to. In case of discrepancy between this specification and those referred to herein, this specification shall govern.

- 1) ISO: 10803-1997 Design method for ductile iron pipes
- 2) IS:8329-2000 Centrifugally Cast (spun) ductile iron pressure pipes for water, gas and sewage
- 3) ISO:2531-1991 Ductile iron pipes, fittings and accessories for pressure pipelines.
- 4) ISO:4179-1985 Ductile iron pipes for pressure and non pressure-Centrifugal cement mortar lining – General requirements.
- 5) IS:8112 Specification for 43 Grade ordinary Portland cement.
- 6) BS:3416 Bitumen based coatings for cold application, suitable for use in contact with potable water.
- 7) ISO:8179-1995 Ductile iron pipes-External coating-Part-1 Metallic Zinc with finishing layer.
- 8) IS:638 Sheet rubber jointing and rubber insertion jointing.
- 9) ISO:4633-1996 Rubber seals-Joint rings.
- 10) IS:5382-1985 Specification for Rubber sealing rings for gas mains, water mains and sewers.
- 11) AWWA C600 Installation of ductile iron water mains and their appurtenances.

### **1.0 Internal Diameter:**

The nominal values of the internal diameters of pipe, expressed in millimeters are approximately equal to the number indicating their nominal sizes DN.

## 2.0 Length:

The working length of socket and spigot pipes shall be 5 m ,5.5 m, or 6 metres.

## 3.0 Thickness:

The wall thickness of pipe 'e' in mm shall be calculated as a function of the nominal diameter by the following equation with minimum of 5 mm

$$e = K(0.5 + 0.001 \text{ DN})$$

where : e = wall thickness in mm, DN = the nominal diameter, K = the whole number coefficient

## 4.0 EPDM Rubber Gasket:

Rubber Gasket shall be suitably for Push-on-Joint.

The spigot ends shall be suitably chamfered or rounded off to facilitate smooth entry of pipe in the socket fitted with the rubber gasket

Rubber Gasket shall confirm to IS 5382-1985 and ISO : 4633-1996 its latest revision or amendments if any

## 5.0 Sampling Criteria:

Sampling criteria for various tests, unless specified in IS 8329-2000, shall be as laid down in IS 11606. Mechanical test, Brinell Hardness test, Hydrostatic test etc are shall be as per IS 8329-2000

## 6.0 Tolerances on External Diameter:

The nominal external diameter (DE) of the spigot end of socket and spigot pipes and when measured circumferentially using a diameter tape shall confirm to the requirements specified as follow. The positive tolerance is +1 mm and applies to all thickness classes of pipes. The maximum negative tolerance of the external diameter are specified as follow:

DN	Nominal	Positive Tolerance	Negative Tolerance
80	98	+1	-2.2
100	118	+1	-2.8
125	144	+1	-2.8
150	170	+1	-2.9
200	222	+1	-3.0
250	274	+1	-3.1
300	326	+1	-3.3
350	378	+1	-3.4
400	429	+1	-3.5
450	480	+1	-3.6
500	532	+1	-3.8
600	635	+1	-4.0

### 7.0 Tolerance on Ovality:

Pipes shall be as far as possible circular internally and externally. The tolerance for out-of-roundness of the socket and spigot ends is given below:

Nominal Diameter in mm	Allowable Difference Between Minor Axis and DE in mm
80 to 300	1.0
350 to 600	1.75
700	2.0
750 to 800	2.4
900 to 1000	3.5

### 8.0 Tolerance in thickness

The tolerance on wall thickness (e) and the flange thickness (b) of the pipes shall be as below:

Dimensions	Tolerance in mm
Wall thickness (e)	$-(1.3 + 0.001 \text{ DN})^{(1)}$
Flange thickness (b)	$+(2+0.05b) \text{ \& } -(2+0.05b)$

### 9.0 Coating

Pipe shall be delivered internally and externally coated.

#### External Coating:

Pipe shall be metallic zinc coated and after that it shall be given a finishing layer of bituminous paint as per IS - 8329-2000

Zinc coating shall comply with IS:8329/EN 545/ ISO 8179. Only molten zinc spray coating shall be acceptable. The average mass of sprayed metal shall not be less than 130 g/sqm with a local minimum of 110 g/sqm.

Bitumen overcoat shall be of normal thickness of 70 microns unless otherwise specified. It shall be a cold applied compound complying with the requirements of BS 3416 Type II suitable for tropical climates factory applied preferably through an automatic process.

Damaged areas of coating shall be repainted on site after removing any remaining loose coating and wire brushing any rusted areas of pipe.

#### Internal lining:

Internally pipe shall be Portland Cement mortar lined (as per IS - 8329-2000). The mortar shall contain by mass at least one part of cement to 3.5 part of sand.

All pipes and fittings shall be internally lined with cement mortar using high speed centrifugal process in accordance with IWO 4179/IS 8329. Cement mortar lining shall be applied at the pipe manufacturing shop in conformity with the aforesaid standards. No admixtures in the mortar shall be used without the approval of the Engineer. The sand to cement proportion of sand if justified by the sieve analysis.

Pipe lining shall be inspected on site and any damage or defective areas shall be made good to the satisfaction of the Engineer.

Lining shall be uniform in thickness all along the pipe. The minimum thickness of factory applied cement mortar lining shall be as per IS: 8329 Annex-B or ISO 4179. This is given below.

Nominal Pipe Size (mm)	Nominal lining thickness (mm)
Up to 300	3
350-600	5
700-1200	6
1400-2000	9

## 10.0 Joint

Joining of DI pipes and fittings shall be push-on type

### ***Push-on-joints***

The Contractor shall source the push-on-joint gaskets only from the pipe manufactures. In turn the pipe manufacturer shall supply at least 10% additional quantity of gaskets over and above the requirement to the Contractor at no extra cost.

The gasket used for joints shall be suitable for natural and purified water conveyance. In joining DI pipes and fittings, the Contractor shall take into account the manufacturer's recommendations as to the methods and equipments to be used in assembling the joints. In particular the Contractor shall ensure that the spigot end of the pipe to be jointed is smooth and has been properly chamfered, so that once the rubber ring is correctly positioned before the joint is made, does not get damaged by friction or sharp edges of the spigot Chamfer. The rubber rings and the recommend lubricant shall be obtained only through the pipe manufacturer.

Rubber ring bundles form every lot shall carry with them manufacturers test certificate for the following mechanical properties.

1. Hardness
2. Tensile strength
3. Compression set
4. Accelerated again test
5. Water absorption test
6. Stress relaxation test

Rubber rings shall be clearly labeled in bundles to indicate the type of ring, the type of joint, the size of the pipe with which they are to be used, the manufacturer's name and trade mark, the month and year of manufacture and the shelf life.

## 11.0 Testing of Pipe:

The main test among others to be conducted shall be as per IS:8329-2000 or with its latest revision/amendments.

### ***[a] Mechanical Tests***

Mechanical tests shall be carried out during manufacture of pipes as specified in the Standards. The frequency and sampling of tests for each batch of pipes shall be in accordance with IS 11606-1986. The test results so obtained for all the pipes and fittings of different sizes shall be submitted to Engineer. The method for tensile tests and the minimum tensile strength requirement for pipes and fittings shall be as per IS:8329/EN 545 for pipes and IS:9523/EN 545 for fittings.

**[b] Brinell Hardness Test**

For checking the Brinell hardness the test shall be carried out on the test ring or bars cut from the pipes used for the ring test and tensile test in accordance with IS:1500. The test shall comply with the requirements specified in IS:1500/ISO 6506.

**[c] Re-tests**

If any test piece representing a lot fails in the first instance, two additional tests shall be made on test pieces selected from two other pipes from the same lot. If both the test results satisfy the specified requirements the lot shall be accepted. Should either of these additional test pieces fail to pass the test, the lot shall be liable for rejection.

**[d] Hydraulic Testing**

For hydrostatic test at works, the pipes and fittings shall be kept under test pressure as specified in the standard for a period of minimum 15 seconds during which the pipes shall be struck moderately with a 700 g hammer for conformation of satisfactory sound. They shall withstand the pressure test without showing any leakage, sweating or other defect of any kind. The hydrostatic test shall be conducted before surface coating and lining.

**12.0 Quality Assurance**

The manufacturer shall have a laid down Quality Assurance Plan for the manufacture of the products offered which shall be submitted along with the tenders.

**Lowering, Laying & Jointing D.I. Pipe :**

**Lowering, laying and jointing D.I. pipes and ms/di specials of various class and following diameter including cost of conveyance from store to site of works inc. cost of labour, material, except cement solvent, giving satisfactory hydraulic testing as per ISI code etc. comp.**

The pipes & joints shall be procured, supplied by the Contractor at work site at his own cost. Every care shall be taken in carting them to site. During transportation any damage shall be occurring to pipes for fittings the replacement of pipes given by the contractor at his own cost.

The trenches shall be well leveled so that pipes are laid evenly along them. The pipes shall be fixed within two rubber rings to be supplied by department at the place shown in schedule A, if directed by the Engineer-in-charge or mentioned in item of schedule B. The specification for titan joints i.e. Rubber Rings shall be as per details specification material section Item No-37.

The contractor shall make his own arrangement for obtaining permission for storing & stacking of pipes etc. from land boards whether they are Government, Municipal Local Bodies or Private land owner.

Every pipes before lowering into the trenches shall be got checked and thoroughly cleaned and the beds of the trenches shall be properly graded and leveled as required on the line, without any claim for extra cost whether it is required. The pipe shall be carefully lowered into the trenches with the help of a suitable type of chain pulley blocks, which shall first be approved by the Engineer-in-Charge. Each pipe shall be properly jacked and the spigot perfectly fixed into the socket. No jointing operation shall be started unless the gradients levels are approved by the Engineer-in-Charge or his representatives.

The pipes shall be laid complete in centerline ranged accurately by means of a string attached to both marked center of site rails and no deviation shall be permissible without the permission of Engineer-in-Charge. The pipe shall be laid in reasonably dry trenches and no circumstances on slushy bedding.

The pipes shall be brushed before lowering any laying or remove any soil or dirt etc. that may have accumulated.

The inside socket and outside of the spigot shall be carefully cleaned. The pipe shall be lowered carefully with socket and toward and the flow of water or up till or as directed and spigot and should be carefully inserted into the socket and the space shall be filled with the joint.

DI specials shall be conforming to IS 9523-2000 and flanges shall be of PN-10 class.

#### **TESTING OF WATER PIPES:**

After each section of the pipeline has been completed it shall be tested for water tightness before being covered. The contractor shall at his own cost fill up water in pipe line and given necessary hydraulic test section by section and the pipe line shall stand the pressure which shall exceed the working pressure by (a) the highest pressure in the section. (b) 30m whichever is more without showing any leakage or sweating any where in the pipes joints specials valves etc. if any defect are found the contractor shall be made good the same at his own cost.

Any leaking joints shall be made good and above test pressure in to be lowered gradually after satisfactory test is & over.

GWSSB will not be able to provide water for testing of the pipelines & water containers of the project. This shall have to be managed by the contractor at his costs and risk.

The hydraulic test shall be given again if considered necessary by the Executive Engineer or his representative to show that no further leakages or sweating is there. The contractor shall have to make necessary arrangements for water testing as well as plugging the opened of pipes etc. as directed without claiming any extra cost. The pipelines shall be kept filled with water for a work lines shall be kept filled with water for a week or till it is situated for testing is done.

If the pipe lines are laid in detached sanctioned & not in continuous length due to any reasons such as non availability of specials or due to obstacle etc. The contractor shall see that no end of pipes length is kept open-ends are immediately covered up either by suitable blank flange or cap slug or by means of double layer gunny bags clothes tied properly by mild steel wire without any claim for extra-cost.

The pipe laying across the state highways, national highways etc. will have to be done either through open cut method or through push through method depending upon the requirement to be prescribed by the sanctioning authority. However, mostly it would be push through method.

#### **Mode of measurement and payments**

The payment shall be made as mentioned in price bid.

## Providing, Supplying, Lowering, Laying & Jointing M.S. Pipe

Providing, supplying & delivery of ISI marked Submerged Arc Welded M.S. Pipe manufacture from FE-410 grade B (as per IS 3589-2001) with inside cement mortar lining "shop lined" of thickness as per specified in specification and specification as per AWWA-C-205-89 and outside gunnitting with wire mesh of 3.1 mm dia in C.M. 1:3 with 25 mm thick coating as per IS: 1916-1989 OR its latest revision & detailed specification with necessary materials, labour, equipment, etc. including all taxes, insurance, transportation, freight, charges, octroi & excise duty, inspection charges, loading, unloading, Transportation to sites of work etc. complete (incl. Tees, bends, reducers etc.) and, Lowering, laying and jointing Mild Steel Pipe Outside Coated Fe-410 Pipes of various thickness and classes with specials of following diameters in proper position, grade and alignment as directed by Engineer-in-charge including Marginal Cutting Wherever required assembling and tack/butt welding ,Transportation to site of work, labour, giving hydraulic testing as per ISI code, etc. complete. This item includes:.

1. Including job connection with existing line.
2. 15% of field joint shall be tested subject to radiography.
3. Including Extra outside gunnitting on welded joints on field.

This specification covers the general requirements for supply, fabrication, delivery at stores of welded M.S. pipes, including loading, unloading, carting and stacking etc. complete.

The pipes manufactured with Submerged Arc Welding both longitudinal and spirally welded will be acceptable provided welding is done by automatic welding machines.

### APPLICABLE CODES & SPECIFICATIONS

The following specifications, standards and codes are made a part of the specification. All standards, tentative specifications, specifications, codes of practice referred to herein shall be the latest editions including all applicable official amendments and revisions. In case of discrepancy between this specification and those referred to herein, this specification shall govern.

1. IS : 2062 - Steel for general structural purposes.
2. IS : 808 - Dimensions for hot rolled steel beam, column, channel and angle sections.
3. IS : 814 - Covered Electrodes for manual Metal Arc Welding of carbon and C - Mn steel.
4. BS EN 499 - Welding Consumables. Covered Electrodes for Manual Metal Arc Welding of Non Alloy and Fine Grain Steel. Classification.
5. AWS : A-5.1 - Specification for Mild Steel Covered Arc Welding Electrodes.
6. IS : 3613 - Acceptance Tests for Wire Flux combinations for Submerged - Arc Welding.

- |     |                   |   |   |
|-----|-------------------|---|---|
| 7.  | AWS:A-5.17        | - | Specification for Bare Mild Steel Electrodes and Fluxes for Submerged Arc Welding. IS : 1367          |
| 8.  | IS : 1367         | - | Technical Supply Conditions for Threaded Fasteners (Parts 1 to 3).                                    |
| 9.  | IS : 2016         | - | Plain Washers.  |
| 10. | IS : 2074         | - | Ready Mixed Paint, Red Oxide Zinc Chrome and Priming.   |
| 11. | IS : 102          | - | Ready Mixed Paint, Brushing, Red Lead, nonsetting, Priming.   |
| 12. | IS : 816          | - | Code of practice for use of Metal Arc Welding for General Construction in mild steel.                 |
| 13. | IS : 4353         | - | Submerged Arc Welding of Mild Steel & Low Alloy Steels Recommendations.                               |
| 14. | IS : 817          | - | Code of practice for Training and Testing of Metal Arc Welders.                                       |
| 15. | IS : 5334         | - | Code of practice for Magnetic Particle Flaw Detection of welds.                                       |
| 16. | IS : 3600         | - | Methods of Testing Fusion Welded Joints and weld metal in steel (Parts 1 to 9)                        |
| 17. | IS : 3589         | - | Seamless or Electrically welded steel pipes for Water Gas and Sewage (168.3 to 2032 Outside Diameter) |
| 18. | IS : 7343         | - | Code of practice for ultrasonic Testing of Ferrous Welded Pipes and Tubular Products                  |
| 19. | IS : 1608         | - | Mechanical testing of Metals.   |
| 20. | IS:5504 & IS:3589 | - | Code for SW PIPES   |
| 21. | IS:10748          | - | Requirement for Weldable Hot Rolled Carbon Steel Strip in Coils.                                      |
| 22. | API-1104          | - | Welding of pipeline & related facilities  |

## **MATERIALS**

Mild Steel Plate conforming to IS : 2062, Fe410. Grade B. and M.S. Coil conforming to IS 10748 with Fe410 grade B Welding Consumables - such as electrodes, filler rods and wires shall conform to IS : 814, IS 3613, IS : 6419 and IS : 7280.

When requested by the Purchaser, the Bidder shall supply free of charge to the Employer, for testing suitable samples of the materials to be used/used in the Works. The cost of such tests shall be borne by the Bidder and shall be included in his item rates

## **INSPECTION**

GWSSB will appoint a third party agency for quality testing and quality assurance of pipes to be supplied under this contract. The agency so appointed by GWSSB shall have access, right and authority to inspect and

test the pipes, both at the place of manufacturer and also post delivery at the locations mentioned in the tender. Pipes conforming to such test requirements will only be accepted.



All works and material under specification will be rigidly inspected during all phases of manufacture and testing and such inspection shall not relieve the Bidder of his responsibility to furnish materials and performed work in accordance with this specification.

The Bidder shall notify the Purchaser, in advance of the production of materials and fabrication thereof, in order that the Employer may arrange for mill and shop inspection.

The Purchaser may reject any or all materials or work that do not meet with any of the requirements of this specification. The Bidder shall rectify or replace such rejected material/performed work at his own cost, to the satisfaction of the Purchaser.

The Purchaser shall have free access to those parts of all plants or any other premises and sites that are concerned with the furnishing of materials or the performance of work under this specification.

The Bidder shall furnish to the Employer's inspector reasonable facilities and space without charge for inspection, testing and obtaining of any information he desires in respect of the character of material used and the progress and manner of the work.

The Bidder shall supply free of cost and required specimen of materials for testing by the Owner at any time during the progress of work and shall bear the cost of all such tests or retests to the satisfaction of Purchaser.

The Bidder shall provide 2 (two) sets of accurate 'Go' and 'No Go' ring gauges to measure the diameter of pipes specials and fitting for the use of the Purchaser at no extra cost.

## **FABRICATION OF PIPE**

### **General**

All pipes and specials shall be manufactured out of new mild steel plates, which shall be free from any cracks, surface flaws, laminations, excessive pitting or any other defects. The pipes shall be truly cylindrical, and straight in axis. The ends shall be accurately cut and prepared for field welding. The external circumference of the pipe pieces, which are to be fixed adjacent to flange adapter with fixed outer diameter, shall not deviate from theoretical one by more than 1 mm. To obtain this accuracy the pipe shall be rolled several times, if necessary, as pipe pieces should be truly cylindrical. The external longitudinal welding of this pipe shall be ground smooth flush with surface to the satisfaction of the Purchaser, for a length of 200 mm. No extra cost shall be charged by the Bidder for this grinding work..

Minor repair by welding or otherwise shall be permitted at the discretion of the Purchaser, but such repairs shall be done only after obtaining the previous permission of the Purchaser. Any pipe or part thereof, which develops injurious defects during shop welding or other operations, shall be rejected.

## **Permissible Stress**

The permissible stress in the pipe shell shall be related to yield stress ( $f_y$ ) of pipe material making due allowance for weld efficiency of the joint. working stress for combined bending and direct tensile stress shall not exceed 60% of yield stress of the material making due allowance for efficiency of welded joint (as per IWWA M-1). working stress for combined bending and direct compressive stress shall not exceed 50% of yield stress making due allowance for weld efficiency (as per IWWA M-1). it is also

necessary to check the shell thickness for adequate factor of safety against failure by buckling (as per IWWA M-11).

For field-welded joint, efficiency factor of 80% is generally adopted, whilst for shop welding joint 90% efficiency is allowed (as per IS 5822 – 1994).

## **Fabrication**

The Bidder shall get the fabrication work done in a duly valid licensed factory of his own or that of an approved nominated Sub-Contractor. This factory meant for fabrication of pipes, specials etc. should also be involved with testing etc., machining as well as painting. For completing the work under the present contract within the contract period, the factory shall be equipped with adequate number of various equipment and plant such as :

Plate bending machines for rolling of pipe drums

Automatic welding machines (suitable for circumferential as well as longitudinal welding)

Hydraulic Testing Machines

Traveling gantry or crane of capacity 10 Tonnes or above.

Mobile cranes for loading/unloading of plates, pipes etc. 15 tonnes capacity each

Lathe for machining of the flanges rings, plates etc.

Equipment for sand blasting and applying paint by spray gun.

Equipment for cold pressing of plates up to 25 mm thick to the required curvature (specials, plug plates etc.)

Bending machine of adequate capacity for manufacturing ring girders and other necessary equipments.

The factory shall have adequate area, and shall also have stacking yard for the stacking of plates, structural, fabricated pipes etc. and the scrap.

## **Cutting Plates or from plates rolled as coil to the required sizes**

The plates shall be indented in such length as to have minimum wastage and so as to make the pipe as far as possible with one longitudinal joint.

Before cutting, all the edges of the plates shall be cleaned by brushing/grinding on both the sides.

After the plates are cut, the edges shall be made smooth and even by polishing with an electrical or pneumatic grinder to remove all inequalities. Care shall be taken to see that the cut edges of the plate are perfectly straight. Jigs to be used for this purpose shall depend upon the types of cutting machine used. The plates cut to the required shape shall be checked for correctness before they are rolled into pipe drums. If any corrections are required, the Bidder shall do the same by re-cutting, if necessary. If any plate or flat is found to be warped, to have corrugations, the defects shall be removed by putting the plate or flat into a roller press, and no extra payment for this rectification work shall be made. The laminated or heavily corroded plate shall not be used in the manufacturing of the pipe.

## **Rolling of Plates**

The plates prepared as mentioned above are cut to the exact size shall be put into a rolling machine to form a pipe of the required diameter as under:

The Bidder shall adjust the rolling machine so as to give a uniform curvature to the pipe throughout its circumference.

The curvature obtained shall be checked by the Bidder's foreman during the process of rolling and if proper curvature is not obtained at any place including the ends, the rolling operation shall be repeated at this stage or even after the longitudinal welding of the drum where directed.

Heating of plates to obtain the desired curvature shall not be permitted.

## **Tacking the Drums**

The rolled drums shall be kept on an assembly platform for tacking, care being taken to ensure that the tacked drums have their end faces at right angles to the axis of the pipe. While tacking the drum, a gap of 2mm to 4mm shall be maintained, where hand welding is permitted. However, where the welding is to be done on automatic welding machine, there is no need of maintaining such gap depending on the penetration through complete thickness of the welding required. To achieve these objective, clamp spiders, tightening rings and or any other approved gadgets shall be used. Each such drum, before being taken to the assembly platform, shall be numbered on the inside with oil paint, stating the plate thickness as well.

## **Assembly of Drums Into Pipes**

The tacked drums shall then be transported to an assembly platform where they shall be tack-welded together to form suitable pipe-lengths. Plate shall be bent in the maximum possible width to reduce the number of circumferential joints.

The longitudinal joints shall be staggered at 90 deg. The drums when tacked together shall have no circumferential gap when the welding is done on automatic welding machine. But when hand welding is adopted as gap of 2mm to 4mm shall be maintained to obtain a good butt-welded joint.

The assembly shall be truly cylindrical and without any kinks. The faces shall be at right angles to the axis of the cylinder. A suitable arrangement for testing the correctness of the face shall be provided by the Bidder at the assembly platform.

## **Welding**

All components of a standard shell, either straight or bent etc. shall be welded, wherever possible by use of automatic arc welding machine by Submerged Arc welding process with alternating current. Generally hand welding shall not be permitted except specific cases, where it is absolutely necessary. This should be done in consent with client's representative. Hand welding shall also not be permitted except for sealing runs and such other minor works at the discretion of the Purchaser. The strength of the joint shall be at least equal to that of the parent material.

The Bidder shall use electrodes of standard make bearing ISO 9001 – 2000 certification. The size of electrodes depending on the thickness of plate and the type of joint. It shall also be used with standard current and arc voltage required for the machine in use with such modifications as may be found necessary after experimental welding. For this purpose, samples of welded joints shall be prepared and tested in the presence of the Purchaser. The values once determined shall be maintained throughout the work and if any modifications are to be made, a written permission of the Purchaser shall be obtained. In the case of thin sheets, electric arc welding may not give satisfactory results and gas welding shall be resorted to. Gas welding shall be subject to the same specifications and tests as those for electric welds. Welding should be carried out inside as well as outside.

All the shop and field joints shall be welded, all welding shall conform to the requirements of IS 9595 and IS 4353.

All longitudinal and circumferential joints shall be double welded butt joints. End preparation for such welding shall conform to IS : 2825.

All circumferential welds involving plates of unequal thickness shall be so kept that the inside surfaces of plates match to provide stream lined joints without alteration in the internal diameter. As far as practicable, welding of dissimilar thickness of shells shall be carried out in the shops.

The welding shall be of the best workmanship free from flaws, burns, etc. and the Bidder shall provide for his own electrodes and equipments, ovens to keep the electrodes at the desired temperatures and dry. In order to maintain a good standard in welding, welders shall be tested by the Bidder with prior intimation to the client before they are entrusted with the job. Qualification standard for welding procedures, welders and welding operation shall conform to the requirements of IS : 7307 and IS : 7310 (latest). Periodical tests as regards their efficiency shall also be taken at intervals of about 6 months and those found inefficient shall be removed from the job. Only those who pass the test, shall be posted on the job. If an incompetent welder has already welded some pipes, all welding done by him previously shall be fully checked by X-ray in addition to the regular X-ray inspections. The defects if any, shall be set right to the satisfaction of the Purchaser. All such check tests and rectification of defects shall be entirely at the cost of the Bidder. No pipes or steel sections shall be erected unless the work of the welder concerned has been proved to be satisfactory. Specially selected welders shall do site welds.

A record shall be maintained showing the names of welders and operators who have worked on each individual joint. Hand welding shall preferably be carried out by a pair of welders (parallel welding putting two welders at a time both will be working in diametrically opposite side of the curvature. Welding shall be divided into 4 quadrants shall be welded simultaneously, so that by observing proper sequence, distortion can be avoided. A joint entrusted to a particular individual or a pair shall be as far as possible, completed by them in all respects, including sealing run. No helper or other unauthorized person shall be permitted to do any welding whatsoever. In case of infringement of above, the persons shall be punished as directed by the Purchaser.

The welded joint after welding should not become brittle or sensitive to blows and there should be no loss of toughness due to welding or heat treatment. The material after welding and heat treatment is to be tougher than the base metal and is to retain its original ductility. No allowance will be made for thinning of weld and the weld should in no point be less than the nominal thickness of plate.

Upon receipt of the order and prior to the start of fabrication, the Bidder shall submit to the Purchaser for his approval the "welding procedure" he intends to use in the shop work. Similarly, prior to the start of the field welding, procedure for the field welding must be submitted to the Purchaser for his approval. Manual welding shall be adopted only when machine welding is not possible.

### **Ultrasonic and Radiographic tests of Welded Joints**

For the mild steel pipes manufactured in site factory/workshop, fabricated from mild steel plates / coil, **15 % of the welded joints shall be subjected to ultrasonic test.**

### **Tolerance**

The shell in the completed work shall be substantially round. The difference between maximum and minimum inside diameters at any cross section shall not exceed 1% of the nominal diameter of the cross section under consideration subject to a maximum of 10 mm.

Machined parts shall be within the limits specified by IS 3589.

Straight pipes shall have their faces perpendicular to the axis of the section with a maximum deviation of 2 mm on either side of the plane. Pipe ends shall be beveled as per IS : 3589.

For the shell thickness, no negative tolerances are acceptable:

The length of each pipe shall not be less than 11.5 mtr.

Prior to starting manufacturing of pipes, the Quality Assurance and Quality Controls plan shall have to be got approved from purchaser.

The pipes shall have to be manufactured and supplied in accordance with the BIS specification No 3589 – 2001.

In case of International manufacturers, manufacturing pipes out side India, the pipes conforming to the International Standards or the standards of the country of origin, which are equivalent or higher, the BIS specification will be accepted.

For Indian manufacturers certification marks issued by BIS standard is mandatory requirement.

For the entire Indian as well as foreign supplier the international ISO 9001 – 2000 certification is also mandatory.

For manufacturers out side India, quality mark of applicable quality institutions will be required.

### **Shop Testing**

After fabrication, but before application of protective coatings all pipes and specials shall be subjected to a shop hydraulic test. Standard lengths of pipes shall be directly subjected to test and non-standard pipe and elbows can be tested as standard pipe before being cut to size.

The test pressure shall ensure that the plate material works is stressed to 40% of the specified minimum tensile strength, which will give test pressure as per IS-3589.

Each pipe shall be filled with water and the pressure slowly and uniformly increased until the required test pressure is reached.

The pipe to be tested shall be given a serial no. which shall be painted on its inside together with details such as pipe No. Shell thickness, diameter, length etc. as directed. It shall be entered in the register to be maintained by the Bidder.

Prior to testing, the pipe shall be inspected thoroughly and all the apparent defects in welding such as jumps, porosity etc. shall be repaired by gouge and re-welding.

The hydraulic test shall be carried out under cover at the fabrication shop, in the presence of and to the satisfaction of the Purchaser or the inspection agency appointed by the Employer.

For indicating the pressure inside the pipe an accurate pressure gauge of approved make duly tested and calibrated for the accuracy of readings shall be mounted on one of the closures which close the pipe ends.

The pressures shall be applied gradually by approved means and shall be maintained for at least 10 seconds or till the inspection of all welded joints is done during which time the pipe shall be hammered throughout its length with sharp blows, by means of a 1 kg. hand hammer.

The pipe shall withstand the test without showing any sign of weakness, leakage, oozing or sweating. If any leak or sweating is observed in the welded joints, the same shall be repaired by gouging and re-welding after dewatering the pipe. The repaired pipe shall be re-tested to conform to the specified pressure.

If any leak or sweating is observed in pipe shell the pipe under test shall be rejected temporarily. The Bidder shall stack such rejected pipes separately in his yard. The Purchaser, shall inspect the same and after taking cuts if necessary, shall determine the nature of repairs to be carried out thereon and shall then decide as to how and where they shall be used. No payment shall be made for handling or carrying out repairs, but, payment for the fabrication and hydraulic testing of the pipe shall be released only after acceptance of the pipe with necessary repairs and subsequent testing etc. are carried out by the Bidder to the satisfaction of the Purchaser. **The Purchaser shall be supplied with two copies of the results of all the tests carried out.**

#### **Destructive Test Of Welded Joints**

The welded joints shall be tested for Tensile test, Bend test & Tre-panned plug in accordance with procedure laid down in as per the latest edition of IS No. 3600 "code of procedure for testing of fusion welded joints and weld metals in steel".

Test pieces shall be taken by the Bidders from the welded joints at the position on fabricated pipes pointed out by the Purchaser in-charge.

The sample so taken shall then be cut to the exact shape and dimensions and machined as described below and handed over to the Purchaser for testing. All the work unto and including machining and arranging for test shall be done by the Bidders.

#### **Submission of Daily Progress Report**

**The Bidder shall submit to the Purchaser a daily progress report in the Performa approved by the Purchaser, wherein all the details of the work carried out in the factory shall be fully recorded. Similarly, works done in the various units in the factory shall be separately mentioned. The Bidder shall maintain a register of all the finished materials giving dates of carrying out important operations such as testing, transport, etc. The register shall be presented at least once a week to the Purchaser who shall initial the entries after verification.**

#### **TRANSPORTING OF PIPES.**

All pipes and specials fabricated in the site factory / workshop and temporarily stacked in the Bidder's yard shall be transported to the site of laying after cleaning them internally etc. **The loading in the factory shall be carried out by means of either a crane, gantry or shear legs, so as not to cause any damage to the finished material. Similarly, while unloading and stacking, great care shall be taken to ensure that the material is not damaged or dented.** The contrivances to be used for unloading will be different in different situations and in each case the one approved by the Purchaser shall be adopted. **The material stacked at site shall be jointly inspected by the Purchaser and the Bidder and defect or damage noticed shall be repaired to the satisfaction of the Purchaser before payment is admitted.**

**Props of approved designs for maintaining circularity having wooden planks at both ends to avoid metal to metal contact shall be fixed to the pipes during transit to avoid undue sagging and consequent distortion. After the pipes are carefully stacked, props should be retained till pipes are joined in trenches and then props are re-used for subsequent similar operations. The stacking ground, both in the**

Bidder's yard and at the site of laying shall be selected in such a way as not to get waterlogged during monsoon. If this cannot be done, **the pipes shall be supported on sleepers to avoid contact with wet earth and subsequent rusting. In order to prevent sagging during transit, savings of steel plates** can be utilized by cutting to the required length and tacking the same to the **pipe ends**, in place of props, if approved by the Purchaser.

As explained in earlier paragraphs, materials such as pipes, tapers, etc. may be transported to the site of laying as soon as the material is finished in all respects with the permission of the Purchaser to avoid congestion in the Bidder's yard. However, materials such as expansion joints, composite bends, 'T' branches and other complicated materials shall be stacked in the Bidder's yard until they are required for laying in the field. In view of this, the work of fabrication of such materials shall be properly synchronized as far as possible with the laying operations.

Fabricated materials such as specials, appurtenances, bolts, nuts, distance pipes, flanges, saddles, collars bypass arrangements etc. shall be transported to the site of laying from the fabrication shop according to the needs of the laying operations only. In regards access roads, the Bidder shall note that access road may lead up to some points on the alignment the Bidder shall have to make his own arrangement for connecting approaches to transport the pipes cross country to the actual site of laying at his own cost. Whatever may be the mode of transport he uses it shall be incumbent on the Bidder to carry and stack the pipes and specials along the alignment as close as possible to the site of laying.

## **PROCEDURE FOR RECEIVING STEEL PIPES**

### **General**

To ensure that the work of erecting pipes is not held up at any stage and place, the Bidder shall maintain an adequate stock of standard specials, flange rings, plug plates, manhole covers, etc. and short length of smaller diameter pipelines, etc. at site in his field stores, in consultation with the Purchaser. Wherever possible, the Bidder shall arrange one full month's requirement of pipes, specials, etc. stacked along the alignment.

### **Stacking of pipes, etc. and inspection**

The Bidder shall keep in each section a responsible representative to take delivery of the pipes, specials and appurtenances, etc. transported from the fabricating stockyard or received from any other work site to the site of laying and to stack along the route on timber skids. Padding shall be provided between coated pipes and timber skids to avoid damage to the coating. Suitable gaps in the pipes stacked shall be left at intervals to permit access from one side to the other. The pipes, specials, appurtenances so received on site shall be jointly inspected and defects recorded, if any, such as protrusions, grooves, dents, notches, damage to the internal coating etc. shall be pointed out immediately to the Purchaser at the site and in the acknowledgement challans. Such defects shall be rectified or repaired to the satisfaction of the Purchaser entirely at the Bidder's risk and cost.

**Handling of Pipes.**

It is essential to avoid damage to the pipes at all stages during handling. The pipes shall be handled in such a manner as not to distort their circularity or cause any damage to their surface treatment. Pipes shall not be thrown down from the trucks nor shall they be dragged or rolled along hard surfaces. Slings of canvas or equally non-abrasive materials of suitable width of special attachment shaped to fit the pipe ends shall be used to lift and lower coated pipes to prevent damage to the coating.

Great care shall be taken in handling the pipe right from the first operation of manufacture until they are laid and jointed. The Bidder will provide temporary props as described earlier in order to prevent any sagging of the pipes while they are stacked in their yard and while transporting to the site of delivery, i.e. laying. The props shall be retained until the pipes are laid and welded. If at any time these props are found to be dislodged or disturbed, the Bidder shall immediately reinstate them in such a way that the true shape of the pipe shell or specials is maintained to the satisfaction of the Purchaser. No defective or damaged pipe or special shall be allowed to be used in the work without rectification to the satisfaction of the Purchaser. Any damage to the coating shall be repaired by the Bidder at his own cost to the satisfaction of the Purchaser.

**Dents**

Whenever any dent, i.e. a significant alteration of the curvature of the pipe shell is noticed, the depth of the dent shall be measured between the lowest point of the dent and the pipe shell curvature line. All dents exceeding 2 percent of the outer diameter of the pipe shall be removed by cutting out a cylindrical portion of the pipe and replacing the same by an undamaged piece of the pipe. The Purchaser may permit insert patching if the diameter of the patch is less than 25 percent of the nominal diameter of the pipe. Repairs by hammering with or without heating shall not be permitted. Any damage to the coating shall also be carefully examined and rectified.

**Marking**

The component parts of the pipes shall be carefully marked for identification in the field. The marking shall be on the side, which will be the inside of the pipe after bending.

The marking operation shall be conducted with full size rulers and templates. Only blunt nose punches should be used.

The plates used for fabrication of pipes shall be laid out in such a way that when the shells are completed one set of original identification markings for the material will be plainly visible. In case these markings are unavoidably cut out, they shall be accurately transferred by the Bidder to a location where these markings will be visible on the completed work.

The method of marking all the pipes to be delivered under scope of contract shall ensure that all the information will remain legible even after transportation, storage in open space etc. In general the legible and marking upon the goods shall indicate the followings:

Certification mark on each pipe, if any (like ISI).

Manufacturer's brand name and/or trade mark.

Purchaser's mark as "GWSSB" be embossed on each pipe.

Diameter and wall thickness.

Inspector's mark on each pipe.



**A) TECHNICAL SPECIFICATION FOR CEMENT MORTAR LINING :**

The Cement mortar lining of required thickness inside the pipe shall be carried out as per AWWA-C-205-89. The details specification for the lining work is as under;

**1. SCOPE :**

The standard covers the requirements for the materials and application of a cement mortar lining to the inside surface of 406.4 mm OD to 2032 mm OD new M.S. Pipes. The applications requirements are (1) that the lining of all straight pipes shall be accomplished by a machine that progresses uniformly through the pipe, applies cement mortar against the pipe surfaces, and is provided with an attachment for mechanically toweling the mortar to obtain a smooth lining of uniform thickness with smooth transitions. The inside of all pipe shall receive a cement mortar lining applied by centrifugally spinning or by a method known to provide equivalent result.

**2. DEFINATION :**

**2.1 Workmanship :**

All work shall be performed in a through & workman like manner by trained personnel under the supervision of experienced persons skilled in the applications of cement mortar lining to pipeline at factory site.

**2.2 Equipment :**

The contractor's equipment for cleaning, applying & trowelling cement mortar in the pipe & for curing the cement mortar lining shall be so designed & manufactured & in such a condition as to permit the workers to follow the procedure & obtain the results prescribed in this standard.

**2.3 The following definitions shall apply in this standard.**

1. **Accelerated curing:** The process of maintaining a constantly moist surface by creating a humid atmosphere at an elevated temperature.
2. **Autogenously healing:** The process by which cracks in concrete or cement mortar are healed by the formation of calcium carbonate in the presence of moisture.
3. **Mechanical placement:** The process of applying mortar by projecting the mortar at a high velocity against the surface or by any mechanically operated compaction system.
4. **Pneumatic placements:** The process of applying mortar by propelling the mortar against any surface using compressed air or steam.
5. **Spinning:** The process of applying mortar to the inside surface of pipe in which the mortar introduced into the pipe is spread on the surface of the pipe and compacted thereon by the centrifugal force resulting from spinning the pipe about its longitudinal axis until the mortar has consolidated sufficiently to allow removal of the pipe from the equipment.

### 3. MATERIALS AND WORKMANSHIP :

#### 3.1 Materials and workmanship :

Material furnished shall meet the provision of this standard. Work or materials that fails to conform to this standard may be rejected at any time before final acceptance thereof.

#### 3.2 Portland Cement :

Portland Cement shall conform to the requirements of latest IS:269.

#### 3.3 Pozzolanic Material :

Pozzolanic materials shall consist of siliceous or a combination of siliceous and aluminous material in a finely divided form that in the presence of moisture will react with calcium hydroxide, at ordinary temperatures, to form compounds possessing cementing properties. IS:1489-1976.

#### 3.4 Admixtures :

To improve workability, density and strength in the mortar, admixtures conforming to ASTM C494 may be used at the option of the contractor, unless otherwise required by the owner's specifications, provided that the ratio of admixture to Portland Cement does not exceed that used in the qualification tests of ASTM C494. No admixtures shall be used that would have a deleterious effect on potable water flowing in the pipe after the lining has been placed.

#### 3.5 Sand :

Sand shall consist of inert granular material. The grains shall be hard strong, durable and uncoated. The sand shall be well graded and shall pass a No. 16 mesh screen with not more than 5 percent passing a No.100 sieve. (For screen and sieve sizes, refer to ASTM E11 or IS-460-Part-I-1985.)

3.5.1 Deleterious substances in sand. Sand shall be clean and free from injurious amounts of dust, clay, lumps, shale, soft or flaky particles, mica, loam, oil, alkali and other deleterious substances. The total weight of such substances shall not exceed 3 percent of the combined weight of the substances and the sand that contains them. In addition, the following limitations shall apply to specific substances:

Substance	Minimum Allowable percentage by weight
Shale	1
Clay Lumps	1
Mica and deleterious substances other than shale and clay lumps	2

3.5.2 Organic impurities. Sand shall not show a color value darker than the "Reference standard color solution" prepared as required in IS:2386(part-2)-1963.

##### 3.5.3 Water

Water for mixing mortar shall be clean and free of Mud, oil, and injurious amounts of organic materials or other deleterious substances. Alkali salt or other impurities that might reduces the strength durability or other desirable qualities of the mortar Potable water shall be used.

#### 4. GENERAL CEMENT MORTAR LINING DESIGN :

##### 4.1 Composition

Mortar for the lining shall be composed of cement, sand and water that have been well mixed and are of such consistency as to produce a dense, homogeneous lining. Unless otherwise specified by the purchaser, the mortar may also include admixtures and pozzolanic materials.

##### 4.2 Proportions

The approximate proportions of cement and sand in the mortar for the lining shall be 1 part of Portland Cement to 1-1 $\frac{1}{2}$  parts of sand by volume. The exact proportions shall be determined by the characteristics of the sand used. Pozzolanic material, if used, shall be substituted for a part of Portland Cement in a proportion of approximately 1 part pozzolanic material to 5 parts Portland Cement by volume. Admixtures if added, shall be used in strict compliance with the manufacturer's recommendations.

##### 4.3 Water Content

The water content shall be the minimum quantity that produces a workable mixture, with full allowance made for moisture collecting on the interior of the pipe surfaces. Slump tests should be made periodically on freshly mixed mortar immediately before the mortar is conveyed to the lining machine. The test shall be made in accordance with ASTM C143. Nominal slumps of cement mortar mixes for application of lining are as per AWWA-C-602-89.

##### 4.4 Mixing

Mortar shall be mixed long enough to obtain maximum plasticity. The mortar shall be used before initial set.

##### 4.5 Thickness of Lining

General requirement. The lining shall be uniform in thickness within the allowance tolerance, except at joints or deformations in the pipeline. Cement mortar lining thickness shall be in accordance with Table-1,

**Table – 1**  
**Recommended Thickness of Cement – Mortar Lining**  
**for pipelines in Place – New Steel**

Nominal diameter in mm	Nominal thickness of lining in mm
406.4 mm to 580 mm outside dia	8 mm
600 mm outside dia to 900 mm outside dia	10 mm
More than 900 mm dia	13 mm

\* In all instance, tolerance for lining thickness shall be +3.2 mm with no minus tolerance.

## 5. METHODS FOR CONSTRUCTION NEW STEEL PIPE :

### 5.1 Preparation of pipes surfaces

The interior surface of the pipeline shall be cleaned before placement of cement mortar lining. The pipe interior surface shall be free of oil, grease, and accumulation of water. All loss mill, scale, dirt, rust, and construction debris shall be removed from the interior surface of the new steel pipeline. This may be accomplished by use of a stiff street broom in large pipe or a drag brush in small pipe. Shot or sandblasting shall not be required.

### 5.2 Machine application of Mortar Lining:

5.2.1 **Cleanup ahead of machine:** Immediately before the travel of the lining machine through a pipeline, all foreign material, such as sand, loose, mortar, dirt, and debris shall be removed.

5.2.2 **Lining procedure:** The lining shall be applied in one or more courses by a machine traveling through the pipe and discharging the mortar over all pipe. The discharge shall be from the rear of the machine so that the newly applied mortar will not be marked. The rate of travel for the machine and the rate of mortar discharge shall be mechanically regulated to produce a smooth surface and uniform thickness throughout. The mortar shall be densely packed and adhere wherever applied. There shall be no injurious rebound.

### 5.3 Surface Finish

The mortar lining in all pipe of the diameters covered by this standard shall be mechanically troweled except for the places where hand troweling or the placement or an untroweled lining is expressly allowed by this standard.

5.3.1 **Troweled linings:** The lining machine shall be provided with attachments for mechanically troweling the mortar. Both the application and troweling of the mortar shall take place at the rear of the machine so that the freshly placed and troweled mortar will not be damaged. The trowel attachment shall be such that the pressure applied to the lining will be uniform and produce a lining of uniform thickness with a smooth, finished surface, free of spiral shoulders. The finished surface of machine placed troweled lining in pipe shall be examined according to the procedure as under.

In the reach of pipe that has been lined & troweled in each day's run 10 places shall be selected in straight sections of the pipe according to a predetermined sampling method agreed on by the owner & Contractor. In each of the 10 places a 300 mm straight edge shall be laid parallel to the axis of the pipe. In 9 of the 10 places the space between the lined surface and the straight edge shall at no point be greater than 1.6 mm for smooth bore pipe in good condition and 3.2 mm for pipe with a rough or irregular interior. This test shall not apply in places where the unlined pipe is too rough or irregular for the required tolerance to be met by machine lining.

- 5.3.2 **Untroweled lining:** The finished surface shall be smooth and regular except that it may exhibit a slightly dimpled appearance similar to the surface of orange. Ridges or uneven buildup caused by irregularity in the trowel rate of the machine shall not be allowed.

#### 5.4 Curing of lining :

- 5.4.1 **General:** Immediately after completion of spinning, the pipe sections may be moved to a curing area. Care shall be exercised at all times to prevent damage to the lining. At the option of the contractor, linings shall be accelerated cured or moist cured. Accelerated curing or moist curing may be used interchangeably on a time ratio basis of 5 1/3 h of moist curing to 1 j of accelerated curing, except that moist curing may be used only if the minimum ambient temperature exceeds 40°F (50°C) continuously during the required minimum curing period. In any case, lining shall be kept continually moist until the completion of the minimum specified curing period.
- 5.4.2 **Moist curing:** On arrival at the curing area, but later than 30 min after completion of the lining operation, pipe ends shall be covered with plastic or wet burlap for a minimum period of 24 Hrs. before applying the exterior coating, if such coating is specified. No credit shall be allowed for any time during which the temperature drops below 50°F (10°C). If a cement-mortar exterior coating is not specified, the lining shall be kept moist for seven days before shipment. In either case, the lining shall be cured for a total period of four days before shipment. The ends of the pipe sections shall be kept closed during the curing period, with plastic end caps except when sprinkling heads are used, the reinforcement and outside coatings are being applied, or accelerated curing is being substituted. The contractor shall exercise care and diligence to avoid drying out or cracking of the lining.
- 5.4.3 **Accelerated curing:** Accelerated curing may being immediately on arrival of the pipe at the curing area, but the temperature of the pipe shall not exceed 90°F (32°C) for 3 hrs. or until the mortar has taken its initial set, whichever occurs first.
- The ambient vapor shall then be maintained at a temperature between 110°F and 150°F (43°C and 66°C) at a relative humidity of not less than 85 percent for a minimum curing period of 6 hrs., after which the exterior coating may be applied, if such coating is specified. If cement-mortar coating is not specified, the lining shall be cured for 18 hrs. before shipment. In either case, the lining shall be cured for a total period of 18 hrs. before shipment.
- 5.4.4 Alternative curing methods. When allowed by the purchaser, alternative-curing methods may be substituted providing the method used by the contractor produces a cured lining equivalent to that set forth in Sec. 5.4.2 and 5.4.3.

## 5.5 Mortar Lining Test Cylinders

- 5.5.1 **Mortar test cylinders:** A set of at least two standard test cylinders, 6 in (150 mm) in diameter by 12 in. (300 mm) in length, shall be made each day from the mortar lining for each shift to satisfy the 7-day and 28-day strength quality control requirements of Sec. 5.5.4 the mortar shall be removed from the mix in accordance with ASTM C172 or samples may be prepared by omitting sufficient water from the production mix to obtain a 1-in. to 3-in (25 mm to 75 mm) slump. Test cylinders shall be made in conformance with ASTM C31. The test cylinders shall be cured with the pipe at the same temperature and for the same total length of time. Other sized cylinders, such as 2 in x 4 in. (50 mm x 100 mm), may be used to test compressive strength. If the 7-day test attains 28-day test requirements, then the 28-days test need not be completed (Sec. 5.5.4).
- 5.5.2 **Centrifugal test cylinders:** Centrifugally spun test cylinders may be substituted for mortar test cylinders, at the option of the contractor. Test cylinders shall be spun about their longitudinal axes in 6-in. (150 mm) diameter by 12-in. (300 mm) long steel molds at a speed that will simulate the compaction of mortar in the lining to produce a spun cylinder wall thickness of at least 1 ½ in (38 mm). The net cross sectional area of the hollow cylinder shall be used to determine its compressive strength. Damaged cylinders shall not be tested.
- 5.5.3 **Test cylinders:** All test cylinders shall be tested in accordance with ASTM C39 by an approved testing laboratory unless the contractor has approved testing facilities at the work site. In such an event, the tests shall be made by the contractor. All cylinder tests shall be made at the expense of the contractor. Certified test reports will be submitted by the contractor. Retest are the contractor's responsibility.
- 5.5.4 **Strength of mortar lining:** Mortar test cylinders shall attain a minimum compressive strength of 2600 psi (18 Mpa) in 7 days and 4500 psi (31 Mpa) in 28 days. Pipe made with mortar lining that does not meet the strength requirements set forth herein shall be subject to rejection. The average of any 10 consecutive strength tests of cylinders representing each mortar mix shall be equal to or greater than the specified strength, and not more than 20 percent of the strength tests shall have values less than the specified strength. No cylinder test result shall be less than 80 percent of the specified strength.

### 6.1 All phases Accessible to Owner:

The owner shall have free access to all areas, places, of facilities concerned with the furnishing of material or the performance of work under the provisions of this standard.

### 6.2 Contractor to Assist Owner:

The contractor shall furnish the purchaser reasonable assistance, at no additional cost in carrying out the inspection duties and specifically in obtaining information with respect to the character of material used and the progress and manner of the work.

### 6.3 Large pipe inspection procedure:

In pipe 406.4 mm OD and Larger a manual, visual inspection of the lined pipe interior should be made by the purchaser to determine the quality of the lining and to identify defective areas in the lining for repair.

### 6.4 Performance criterion surface finish. The Hazan-Williams “C” factor (Chw) is a generally accepted criterion for determining the acceptability of surface finish of cement mortar lining in pipelines as under :

Table as under is given to acceptable performance for smoothness of pipe.

Diameter of pipe	Guaranteed “C” factor (Chw)
Above 660 mm	130

Based on nominal inside pipe diameter before cement mortar lining.

## B) EPOXY PAINTING :

The inside Epoxy painting with required base and hardener shall be provided as per instruction of Engineer-in-charge/Consultants. The detailed specifications for epoxy painting are as under;

### I) The inside lining shall consist of 1 coat of 25 micron of Zinc rich epoxy primer and three coats each of 25 micron of non toxic high build black paint.

The inside surface of the pipes and specials is to be provided with lining with anticorrosive paint before applying paint to the surface, the surface shall be made free from rust, mill scale, dust, grease, old paint and other loose particles. The surface shall be cleaned by sand/short blasting as per IS:1477/1971 (Part-I). Cleaning shall be followed by immediate application of Zinc rich primer. The primer shall be applied by spray or brush. The application of the primer shall be as per the recommendation of the manufacturer. After application of primer in 1 coat, 3 coats of high build black non toxic paint of reputed make like Asian, Burger, Shalimar Tar Product, Goodlass, Sigma, Goa paints etc. to be approved by Engineer-in-charge consultant shall have to be applied after 24 hours minimum. The technical specifications of primer and paint shall be as under;

### II) Epoxy Zinc Rich Primer (2 packs) :

#### Types and purpose :

A two component heavy duty prefabricated primer based on Zinc Dust and Polyamide cured epoxy resins. This paint generally conforming to specification DGS-175, Type-A. the primer shall be non phenolic.

### III) Conditions :

The paint is supplied in two packs, fine Zinc dust mixed with epoxy resin as base and liquid hardener. They are to be mixed in following ratio.

	By Volume	By weight
Base	1.5	4.0
Hardener	1.0	1.0

**IV) Mixed Paint Properties :**

i)	Viscosity	20+3% seconds by flow Cup No.4 @ 30 <sup>0</sup> C
ii)	Specific Gravity	1.70 + 3%
iii)	Pot life of mixture	6-8 hours
iv)	Zinc dust content on DFT basis	92 %
v)	Finish	Smooth and Matt.
vi)	Drying time	
	Surface Dry	5 minutes
	Hard Dry	Less than 1 Hour
Vii)	Over coating after	Minimum 24 hours
		Maximum No limit.
Viii)	Flash point	Above 23 <sup>0</sup> C
ix)	D.F.T.	20-25 microns depending on blasting profile.
x)	Compatibility	Compatible with all systems of paints.
		Like Bituminous, conventional, chlorubber vinyl and epoxy paints.
xi)	Toxicity	Non toxic.

**V) Application by**

Brush/Spray (Air and Airless)

**VI) Thinner**

Epoxy thinner shall be used if required.

**VII) Coverage :**

10 sq.m./liter at 25 microns.

**VIII) High build black paint :**

1)	Dry time	Surface dry not more than 4 hours Hard dry not more than 18 hours Film thickness per coat 75 micron.
2)	Consistency	Thixotropic liquid.
3)	Covering Capacity	5 sq.m./litre
4)	Color	Black/Brown/Black in alternate layer.

**IX) Characteristics :**

The paint shall be non phenolic non-toxic and shall not impart any test or odour or to the water to flow through the pipe. It shall afford a highly durable protective air tight coating to prevent corrosion or rusting of iron and steel against air moisture/water and shall be of sufficient elasticity to prevent racking, blistering or peeling. It shall retain its consistency at the ordinary atmospheric temperatures when packed in suitable containers. After application or drying, the paint shall not



show any surface cracks due to drying, weathering action or expansion and contraction. Its resistance to water must be perfect. It shall also be resistant to weak acid and alkalis, natural salts and to dry heat up to 150 centigrade. It should have good brushability.

The primer as well as paint shall have to be applied as per the manufacturer's specification. The paints shall be tested in the laboratory by the Owner at the cost of the contractor if found necessary. Each lot of primer and paint supplied shall be accompanied by the certified copies of the result of tests carried out by the manufacturer. The entire procedure of applying the paint as specified shall be rigidly inspected right from cleaning stage to application of final coat. If at any time it is found that the procedure of applying the paint is not as per standard laid down, all such painting work done shall be rejected.

The consumption of paint and primer shall be as manufacturer's specification. No deviation in consumption shall be allowed.

#### **C) TECHNICAL SPECIFICATION FOR COATING :**

**Reinforced Cement Mortar Coating :** The Reinforced cement mortar coating of 25 mm thick outside of M.S. pipe for all dia pipes shall be carried out as per IS:1916-1989. The minimum reinforcement in the coating shall be three percent of the quantity of steel cylinder of minimum plate thickness as per IS:3589-1991. The reinforcement for coating in the form of welded wire mesh of 3.15 mm dia and suitable pitch confirming to IS:4948 be wrapped on the outside by tack welding. On outside 50 mm length from end of pipe shall be uncoated to facilitate welding. Gunniting shall be 25 mm thick of strength not less than 25N/mm<sup>2</sup> at 28 days. Contractor shall have to prepare suitable moulds at his cost for taking cubes of concrete/mortar in required numbers for testing. Rebound materials shall not be used.

#### **LOWERING, LAYING & JOINTING OF M.S. PIPE :**

M.S. pipe shall be lowered, laid and jointed by welding including preparation of ends wherever required grinding as per relevant IS code of welding, testing etc. complete as per IS:5822-1994.

#### **SPECIFICATIONS FOR WELDING :**

The specifications cover shop welding as well as site welding for required of M.S. pipe in particular length and M.S. pipe in particular length and M.S. Specials. Following types of joints are considered for connecting the two pipes or pipe and specials.

- 1) Fillet weld with swaging of one end of pipe
- OR
- 2) Butt weld without swaging on one end of pipe.

## **WELDING UNDER RAIN AND STRONG WIND:**

If welding is to be done during rain or strong wind, suitable protection shall be provided for the parts to be welded and the welder. Pre-heating of electrodes shall be done so as to remove any moisture. Where this is not practicable, no welding shall be done on piping under such conditions.

All the types of bends, scour Tees, Air valve Tees, Tail pieces of valves and water meters etc. shall be fabricated as per standard practice from M.S. pipe to be supplied by Contractor. The contractor shall have to provide M.S. pipe pieces and 18 to 20 mm thick flanges of required diameter for branch of tees, reducers, enlargers, etc., and paid on mt. Basis in the Item of Supply of M.S. Pipe. Fillet of butt weld as may be required shall do joint. Holes of appropriate diameter shall be drilled in flanges of specials at appropriate spacing to facilitate jointing of sluice valves, water meter, air valves and other types of valves.

The following codes are applicable for welding:

- |         |   |   |
|---------|---|---|
| IS:814  | - | Code for covered electrode for metal Arc welding for mild steel.  |
| IS:815  | - | Classification and coding of covered electrodes for metal Arc welding of Mild Steel and Low alloy High Tensile Steel. |
| IS:1663 | - | Part-I / Part II regarding method of tensile testing of steel sheets and stripes.                                     |
| IS:3600 | - | Codes of procedure for testing of fusion welding joints and weld metal in steel.                                      |

## **ELECTRODES:**

The contractor shall use preferably adani Orelikon overcord S.S. Green (Blue) or other electrodes as approved by Engineer-in-charge depending upon the thickness of the plate and type of joint. They shall use standard current and Arc Voltage required for the machine in use as per manufacturer's directions. Welding electrode shall confirm to test procedure of IS:814 and IS:815. The contractor shall submit manufacturer's test certificate for each batch of electrode used by him. Electrodes shall be stored unopened in original containers. Electrodes when used shall be free of rust, oil, grease and all other matter which could be harmful for the good quality of welding.

## **QUALIFICATION OF WELDERS:**

Only such welders who are experienced and whose workmanship is satisfactory shall be employed for the work. Welders will be individually tested for the welding skill before they are allowed to work.

## **WELDING PROCESS:**

All welds shall be made down-hand by manual or automatic shielded arc welding process. Welding shall be done so that there shall be through fusion and complete penetration. Sealing runs in the inside shall be done manually. The joints for seams and circular welding shall be square but as per standard practice as per IS:816 shall be accepted.

## **END PENETRATION:**

Ends to the welded will be preferably made by machining. However, preparation of ends may be made by flame cutting, provided all grooves and irregularities are ground off and all the oxidation is removed.

## **CLEANING:**

The ends to be welded shall properly cleaned. All paint, oil, grease, rust and oxide as well as all earth, sand or any other material sticking which could be harmful to the welding should be removed. Ends shall be totally dry while welding. No dirt or debris will be permitted in the pipe line. Prior to alignment, the inside of each joint shall be adequately scrapped by approved means to the satisfaction of the Engineer-in-charge.

## **ALIGNMENT AND SPACING:**

Pipes to be welded shall be aligned and fitted with external line up clamp and spaced in a suitable manner so as to hold ends during welding at a distance to ensure full penetration. Root opening shall not be more than as specified. Internal offset shall not be exceed 1.5 mm. The pipe piece to be butt welded shall be bridge "C" clamps. Owner's inspector may check and approve the joint fit-up and alignment prior to the commencement of welding.

## **WELDING TECHNIQUE:**

### **ROOT PASS:**

### **FOR BUTT JOINTS:**

The maximum electrode size shall be 3.15 mm (10 SWG) and the electrode holder shall be connected, having due regard for the polarity requirement of the electrode approved for the use for pipe in horizontal position. Upward technique shall be used with the recommended values of current.

The root pass of butt joints, regardless of the technique used, shall be such as to achieve full penetration. However, projection of weld metal into the pipe bore shall not exceed more than 5 mm. Root grooves and defective restart of the welding shall be carefully avoided. For pipes having diameter greater than 500 mm, all circumferential joints shall be welded on both sides i.e. outside and inside.

At each interruption of welding and on completion of each run, craters, weld irregularities and slag shall be removed by grinding or chiseling. After the welding is started and until the joint has been completed displacements, chocks, vibration or stresses shall be avoided in order to prevent cracks or breaks in the weld.

#### **FOR FILLT WELDS:**

The maximum electrode size shall be 4 mm (8 SWG). On completion of the root pass, any visual defect or irregularity shall be ground off to avoid defects or irregularities in the next pass.

#### **JOINT COMPLETION:**

Electrode size of more than 8 SWG (4mm) shall not be allowed for filling of the weld upward technique shall generally be used for pipe in horizontal and vertical position welding. At each interruption of welding and after each run of welding is completed, chipping and slag removal shall be done. When the welding is completed, butt joints shall have a cover pass. It shall be slightly convex and fuse into the surface of the base metal in such a manner as to have a gradual notch edges. Welds shall have a regular appearance and shall be free from defects. Welder number shall be stamped alongside each weld whenever required by the Engineer-in-charge or Consulting Engineer.

#### **WELDING EQUIPMENT, TOOLS AND SUPPLIES:**

All welding machines, line up clamps, beveling machines, cutting torches and other equipment, tools and supplies used in connection with the welding work shall be kept in good working condition so as to produce sound welds. The welding machines shall have adequate controls for obtaining current adjustment for all pipeline welding requirements. Ground clamps shall be of such design as to be dependable and should not deflect the pipe and with as large contact area as is practicable.

#### **PREPARATION OF PIPE FACE FOR WELDING:**

Before aligning, assembling and welding, pipe faces shall be cleaned by scrapping by wire brushes or by any other method approved by Engineer-in-charge. The correctness of shape and bevel edge will be checked with templates and required corrections carried out before welding.

#### **WELDED JOINTS:**

As required in the welding work following points shall be observed. The contractor shall use the standard electrode depending on thickness of the plate and type of joints. They shall also use standard current and arc voltage required for the machine in use as per the direction of the Engineer-in-charge. Welding electrodes shall conform to IS 814 of Indian or equivalent foreign make of required quality approved by Engineer-in-charge shall be used where ever possible.

**GAS CUTTING:**

Gas cutting if required for preparing on sit distance pieces, straps etc. and cutting out holes in the pipe line shall have to be carried out by the Contractor at his own cost. After cutting the edges shall be made smooth and even by using electrical or pneumatic grinder so as to remove all inequalities. Care shall be taken to see that the shape of the material cut does not defect in any way at the time of cutting.

**BLANK FLANGES:**

Blank flanges shall be provided at all ends left unattached for temporary closure of work and also for commissioning a section of work and also for commissioning a section of pipeline for testing the line laid. For temporary closure non pressure blank flanges consisting of M.S. plate tack welded at the pipe ends may be used. The blank flanges or domes designed as per requirement shall be provided. Separate payment will not be made for the flanges or domes.

**STRAPS:**

Whenever pipe line is to be done from two faces and or required to be done in broken stretches due to any difficulty met at site of final connection has to be done by introducing straps to cover the gap up to 30 cms length. Such straps shall be fabricated in field by cutting pipes splitting them longitudinally and tapping them over the ends connected in the form of collar. The collar shall be in two valves and shall have the inside diameter equal to the outside diameter of pipe to be connected. A minimum lap of 8 cm on either end of the pipe shall be kept and fillet welds shall be run for circumferential joint. The longitudinal joint of the collar shall be butt welded. The material for straps and labour for doing above work included in the rat and nothing extra shall be paid for material as well as labour. The joints shall be provided with Reinforced cement mortar coating outside and cement mortar lining inside.

**HYDRAULIC TEST:**

The final high pressure test on the completed sections over ground or in the trench shall be performed before back filling. The testing shall be carried out in strict compliance with the testing procedure that shall be specified by the Engineer-in-charge or consultant. The final hydrostatic pressure test on the pipe line shall be performed with water. All arrangement required for testing shall be made by the contractor and after testing they shall be removed to the entire satisfaction of the Engineer-in-charge. Water to be used for testing should be clean, arranged and supplied by the contractor. While the line is full, hydrostatic pressure shall be applied at 1.5 times the internal design pressure i.e. 200 mtrs. And maintained on the line without significant loss. The testing shall be at last for 24 hours. Failure of the line disclosed by loss of pressure shall be located and reported by the contractor. Cost of required repairs shall be borne by the contractor. Before taking delivery and commencement he should inspect the pipes and if any defect is noticed at the time of taking over he should bring it to the notice of the Engineer-in-charge.

**LOWERING:**

- 1) After the application and inspection of coating, the entire welded pipes shall be normally lowered into the finished trench next day after the completion of the coating wherever required.
- 2) The trenches shall be of sufficient width, to enable lowering of pipe without difficulty. The trench bottom shall not be uneven.
- 3) If required, 20 cm. thick bedding be provided using the selected excavated soil or murrum without any extra cost. The bedding shall be watered, rammed, and well consolidated before laying or pipes.
- 4) Water present in the trench at the time of lowering shall be bailed out by the contractor without any extra cost.

**CONTRACTOR'S SCOPE:**

Cutting of pipes required for fabricated specials or for completing the gaps should be cut in such a way that the wastage shall be minimum.

**THE SCOPE FOR THE ITEM COVERS:**

Cost of right of use and crop compensation required to be paid for getting access to pipe line alignment, arranging pipes along alignment, dumping excavated stuff etc. (exceeding 10 mtr. Width) shall be paid by contractor at his cost. Cost of additional excavation required for jointing, clearing the site of all shrubs, bushes and trees and dewatering wherever necessary.

Cost of all materials like steel, cement, aggregate bolts, nuts, washers, white lead, grease, rubber packing etc. necessary for pipe lowering, laying and jointing. Labour for laying pipes in trenches to correct alignment at required depth with tools including cutting of pipes and specials if required for laying the pipes, including connecting pipes to specials and appurtenances.

Cost of scaffolding, tools, and plants, ropes etc.

Protection of existing works from damage and cost of repairs to the damages carried out to the existing structures, poles, sewer, pipeline, telephone/electricity cables, electric lines, gas pipeline, irrigation pipeline etc.

Labour for making joints including welding with all materials for joints, tools as well as test for welded including testing of welded joint as per IS 5822:1994 Para 6.2 etc.

Testing of pipes for leakages under water pressure and flushing the pipes after testing. Water required for this hydraulic testing and construction work shall have to be arranged by the contractor at his own cost.

## **REWELDING DEFECTIVE JOINTS:**

Providing temporary arrangements to keep the pipe clean and in position.

Labour for cutting pipes by gas cutting any other method and laying and fixing the same. Labour for fabricating necessary specials such as bends, Tees, Reducers, Enlargers, Branch, Flange, etc. using M.S. plates including drilling holes in flanges as may be required.

Carting surplus pipes, pieces, scrap etc. to stores at plant site, head work or sub head work sites.

## **METHOD OF MEASUREMENT AND PAYMENT:**

The measurement shall be recorded in running meter of pip length laid along center line or the axis of pipe line including tees, enlargers, reducers, and bends, correct up to 0.01 mt. Length. No payment shall be made for overlaps etc. The payment shall be made as mentioned in price bid.

## **PVC PIPES**

Providing and supplying in standard length, ISI marked rigid unplasticised PVC pipes suitable for potable water, elastometric ring fit type only, with extra couplers and solvent cement as per requirement, as per IS specification No. 4985/2000, ISO 9002 including all local and central taxes, insurance, freight charges, Octroi, inspection charges, loading, unloading, conveyance to the site of works and including cost of jointing material etc., murrum bedding, lowering, laying and jointing with PVC specials including cost of specials, pipes of following diameters in proper position, grade and alignment, refilling of trench, giving satisfactory hydraulic testing as per ISI code etc. complete. **6.00 kg/cm<sup>2</sup>.**

### **This item includes:**

1. Lowering, laying and jointing PVC pipes and specials including cost of labour, materials, with extra couplers and cement solvent as required, giving satisfactory hydraulic testing as per ISI code etc. complete.
2. Job connection with existing line.

### **UNPLASTICIZED PVC PIPES**

For Indian manufacturers a valid license issued by the Bureau of Indian Standards for marking the PVC pipes with ISI mark is a mandatory requirement both for PVC pipes & rings

### **STANDARDS:**

- The UPVC Pipes to be manufactured, supplied and delivered under the scope of this contract shall be manufactured in accordance and confirming to IS:4985-2000 or its latest revision or amendments or other authoritative standard that ensure at least a substantially equal quality to the IS:4985-2000 or its latest revision or amendments
- Elastometric sealing ring shall be as per specification of IS – 5382- 1985, and ISO: 4633-1996 or it shall be EPDM rubber ring.
- The dimensions, material compositions, tests etc. shall be as per IS:4985-2000 or with its latest revision or amendments.
- The minimum wall thickness weight shall be as per Appendix I of the tender.
- The colour of pipes shall be as per IS 4985-2000



- Bureau of Indian Specifications (BIS)/Indian Standard (IS) shall mean the latest version issued by BIS.
- The material from which the pipes are made shall consist substantially of unplasticized polyvinyl chloride conforming to IS: 10151, to which may be added only those additives that are absolutely needed to facilitate the manufacture of the polymer, and the production of sound, durable pipes of good surface, finish, mechanical strength and opacity.
- The bulk density of the UPVC compound shall be 0.50 to 0.53 and the density of UPVC pipe shall be 1.40 to 1.46 g / cm<sup>3</sup>.
- The additional of the manufactures own rework material shall comply to clause 4.2 of IS: 4985.
- PVC resin of suspension grade K-66/K-67 shall be used for extrusion of UPVC pipe.
- In line with BIS 4985-2000 the tolerance on outside diameter of the pipe shall be as under:

Nominal Outside Diameter in mm	Outside Diameter in mm		Outside Diameter At Any Point in mm	
	Minimum	Maximum	Minimum	Maximum
90	90	90.30	88.90	91.10
110	110	110.40	108.60	111.40
140	140	140.50	138.30	141.70
160	160	160.50	158.00	162.00
180	180	180.60	177.80	182.20
200	200	200.60	197.60	222.40
225	225	225.70	222.30	227.70
250	250	250.80	247.00	253.00
280	280	280.90	276.60	283.40
315	315	316	311.20	318.80

- “The pipes shall be transported to the store by flat floored trucks in pre packed wooden crate. The height of crate should not be exceeding more than 2 meters. The both ends of packaging unit (crate) shall be covered with plastic sheet to ensure adequate protection during transport. At the time

of packing and stacking of pipes, the sockets shall be alternated within the pipe of pipes and shall project sufficiently for the pipes to be correctly supported along their whole length. The pipes shall rest uniformly on the vehicle bed over their whole length during transport to avoid sagging or deformation.

- The packing material like wooden crate, plastic sheet etc. shall be the property of tenderer and he is permitted to reuse the packing material for transporting next batch of pipes”.
- The pressure rating of pipes shall be in accordance with IS 4985 with a maximum continuous working pressure at 27<sup>0</sup> C. of 6 & 10 kg/cm<sup>2</sup>. This working pressure shall be down graded for ambient underground soil temperature of 45<sup>0</sup> C. as per the figure given in IS 4985 for design purposes.
- The pipes when subjected to internal hydrostatic pressure in accordance with IS: 12235-1986 (part – 8) shall not burst during the prescribed test duration. The temperature, duration and test and induced internal stress shall conform to the parameters given below:

Sr. No.	Test	Temp. (°C)	Min. duration (h)	Induced Stress (Mpa)	Requirements
1	Type test	60	1000	10	No failure
2	Acceptance Test	27	1	36	No failure

- The integral socket of the pipe shall be tested for internal hydrostatic pressure in accordance with ISO: 3603 and ISO 1167.
- The UPVC pipe shall not contain vinyl chloride monomer (VCM) exceeding 1 ppm when determined by means of gas phase chromatography using the “headspace” method according to IS: 10151.
- The wall of the socket and the wall of the plain pipe shall not transmit more than 0.2% of visible light falling on them when tested in accordance with IS:12235 (part -3).

- The pipes shall be supplied in straight length of 6 mtrs with tolerance of +20mm and -0mm. The effective length of socket pipe shall be considered as shown in figure 2 of IS 4985.
- All plastic and non plastic material for components of the UPVC piping system e.g. Elestomeric sealing ring, lubricants, when in permanent or in temporary contact with water which is intended for human consumption, shall not adversely affect the quality of the drinking water.
- Concentrations of chemicals, biological agents or other substance leached from pipe materials in contact with drinking water and the values of the relevant physical parameters, shall not exceed the maximum values recommended by IS: 10500.
- The pipe material shall be in accordance with IS 4985, clause 6.3.
- The quality control system and sampling model shall be as under:

Quality Control System and Sampling Model				
Order of Tests to be conducted	By Manufacturer	By Third Party Inspection/ PMC representative	Codes/ Standards to be followed	Remark
Raw Material 1) Resin K-valve Particle size dis. Bulk density 2) PVC compound density	Laboratory test certificates from the original manufacturer of resin and confirmation of the same by the pipe manufacturer in their laboratory. Both test certificates have to be presented during inspection	Verification of test certificates and witness of sample test at pipe manufacture 's laboratory at discretion	IS: 4669	For every batch of PVC resin used prior to formulation of compound
Process Check Degree of fusion of extruded UPVC pipe by Acetone immersion test.	Minimum one specimen per extrusion condition or moulding condition per day	May witness test during inspection	ASTM D 2152	Test shall be conducted on samples form each machine

Quality Control System and Sampling Model				
Order of Tests to be conducted	By Manufacturer	By Third Party Inspection/ PMC representative	Codes/ Standards to be followed	Remark
On line Check Quality Outside diameter Wall thickness Length of pipe surface finish Socket dimensions	Each & every pipe shall be checked by the manufacturer during extrusion of pipe	Sample testing shall be done for acceptance of the lot as per sampling procedure given Appendix – A, Table -5 of IS 4985	IS: 4985 ISO: 2045 Specification	Wall thickness shall also be checked by cutting the pipe at any place by the inspector
Finished product check. Reversion test Stress relief test	Min. 2 samples per machine per shift shall be tested	Sample testing shall be done as per IS 4985, Table 6&7	IS: 4985 IS: 12235 Part 5&6	Test records shall be submitted to PMC on request
Drop impact test Internal Hydrostatic pressure test. Pressure test for integral joint	Min. 1 samples per machine per shift	Sample testing shall be done as per IS 4985, Table-8	IS: 4985 IS: 12235 Part 8&9 ISO 3603 ISO 1167	Whenever the pipe is cut for hydrostatic test, the inspector will also verify the pipe thickness
Capacity Effect on water	Min. one sample for every change in compound formulation	One sample per 100 km of length of supply at the discretion of inspector	IS: 4985 IS: 12235 Part 3,4&10	Test records shall be submitted to PMC on request
Long term hydrostatic test	Min. 3 samples of different diameter from the regular production lot.	May witness test during inspection	Is: 4985 IS: 12235	Test records shall be submitted to PMC on request

Quality Control System and Sampling Model				
Order of Tests to be conducted	By Manufacturer	By Third Party Inspection/ PMC representative	Codes/ Standards to be followed	Remark
Density	Min. one sample per machine per shift	Min 5 samples per lot	IS: 8543 part 1/ sec 2	Reconfirmation may be done at store by checking the samples at the approved laboratory
Ash content	Min. one sample per machine per shift	Min 5 samples per lot	MTNL Standard/ ISO: 3451-5	Reconfirmation may be done at store by checking the samples at the approved laboratory
Vicat softening temp.	Min. one sample per machine per shift	Min. one sample per lot.	ISO : 2507	

#### TEMPERATURE VARIATIONS:

All the pipes to be manufactured, supplied and delivered shall be subjected to weather conditions like sun, dust, rain, wind as available in State of Gujarat. They shall be also subjected to carry and convey drinking water under variable temperature conditions ranging from 4 C<sup>0</sup> to 45 C<sup>0</sup>.

#### MARKING :

The methods of marking all the pipes to be delivered under scope of contract shall ensure that all the information will remain legible even after transportation, storage in open space etc. In general the legible and indelible marking upon the goods shall indicate the followings;

- i) Certification mark on each pipe.
- ii) Manufacturers brand name and/or trademark.
- iii) Purchasers mark as "GWSSB" be inscribed.
- iv) The outside diameter and pressure rating.
- v) Batch number or lot number.
- vi) Inspector's mark on each pipe
- vii) Any other important matter that the manufacturer or purchaser deems fit to be inscribed.

### Electrometric sealing ring

These sealing ring shall be Sturine Butadin in red color as specified in IS. The lubricant applied for jointing of elastomeric rubber ring shall be of good quality and comply the following specifications:

- a) Must have paste like consistency and be ready for use, preferably soap jelly.
- b) Has to adhere wet and dry surfaces of UPVC pipes and rubber ring.
- c) Must be non-toxic.
- d) Must be water-soluble.
- e) Must not-affecting physico-chemical and organoleptic properties of drinking water carried on the pipe.
- f) Must not have an objectionable odour.
- g) Must not harmful to the skin.

Elastomeric sealing ring shall be in accordance with one of the types (Type - 1 to Type – 6) as per ISS 5382. These sealing rings shall be EPDM rubber ring. The sealing ring shall be with ISI mark.

In case of imported EPDM Ring, such rings shall conform to relevant International Standards or the Standards of country of origin, which are equivalent or higher than the Bureau of Indian Standard Specifications. In case of manufacturers who have applied for getting a BIS certification mark, it would be mandatory for such bidders to produce the BIS certification license on or before the date of opening of the price bids. An undertaking in this regard shall have to be provided along with the technical bid.

The rubber sealing rings shall be vulcanized from Ethylene Propylene (EPDM) with strengths as per table 2 of IS 5382-1985.

### **TYPE TEST:**

- a) Type test capacity, test for effect on water, test for resistance to Sulfuric Acid, internal Hydrostatic pressure test for 1000 Hrs. shall be carried out at least once at any time during the contract. Or shall be taken at least once during every six months irrespective of the ordered quantity.
- b) The said type test shall be taken by the GWSSB representative or third party inspection agency at the in-house laboratory of the manufacturer

**COLOR OF PIPES:**

- The color of the pipes shall be as per IS 4985-2000.
- The pipes shall bear ISI mark confirming to IS:4985-2000 or its latest amendment/revision if any.

**TEST FOR PVC RESIN & PIPE:****Test For PVC Resin**

It shall be sufficient to show the certificate of chemical test (in accordance with IS 4669) to the inspecting authority to confirm the 'K' value to be 64 to 67 as per clause No. 6.1.2. of IS 4985-2000

**Specific Gravity and Ash Content Tests:****a) Density:**

These tests shall be carried out by the inspection agency as per the IS:4985-2000 OR its latest revision OR amendments. The value shall be between 1.40 and 1.46 as per the ISS clause No. 10.6

**b) Sulphate Ash content:**

When tested as per Annex B, of IS 4985-2000, the sulphated ash content in the pipe shall not exceed 10 percent.

- c) Other test shall be carried out as per ISS 4985-2000 or its latest revision or amendment

**TOLERANCE IN WEIGHT OF PIPES:**

(-) 1% tolerance in actual weight of pipes shall be allowed but in overall weight there should not be any minus tolerance i.e. minus tolerance may be compensated in overall weight. If the tolerance is in minus, the consignment shall be outright rejected. The weight of pipes as given in Appendix-I shall be considered. If required the consignee can weight the whole lot of supply for verification.

**Quality Assurance**

The manufacturer shall have a laid down Quality Assurance Plan for the manufacture of the products offered which shall be submitted along with the tenders.

**APPENDIX - I**

Unit weight and minimum wall thickness of unplasticized ring fit type PVC pipes are as per IS 4985-2000

**Lowering, laying and jointing of PVC Pipe**

**Lowering, laying and jointing PVC pipes and specials of following class and diameter including cost of conveyance from stores to site of works including cost of labour, material, except cement solvent, giving satisfactory hydraulic testing as per ISI code, etc. complete.**

- 1) The excavation for trenches shall be done before laying of the pipes as per required depth and width so that adequate space can be made available for joint.

- 2) The pipes & joints shall be procured, supplied by the Contractor at work site at his own cost. Every care shall be taken in carting them to site. During transportation any damage shall be occurring to pipes for fittings the replacement of pipes given by the contractor at his own cost.
- 3) Before laying the pipes it shall be brushed through out length so that the dust and soil can be removed.
- 4) Reducer bends tees, and adopter etc. to be supplied by the contractor as per requirement.
- 5) All the specials such as bends, tees, reducer, etc. shall be fixed as per instruction of engineer-in-charge in the pipeline.
- 6) The pipe shall be hydraulically tested during the testing no leakage shall be observed. If, leakage observed, it shall be set rightly by the contractor at his own cost as per the instruction of engineer-in-charge. The payment shall be as per payment schedule.

#### **THE SCOPE FOR THE ITEM COVER**

Cost of additional excavation required for jointing clearing the site of all scrubs, bushes, and trees and dewatering where necessary.

Labour for laying pipes in trenches to correct alignment at required depth with tools, including cutting of pipes and specials if required for laying of pipes including connecting pipes to specials and appurtenances. Cost of the scaffolding, tools and plants, ropes etc.

Protection of existing works from damage and cost of repair to the damages carried out to the existing structure, sewer line telephone/electricity cables, electric cables, electric lines, gas pipe line, irrigation pipe line etc.

The pipe laying across the state highways, national highways etc. will have to be done either through open cut method or through push through method depending upon the requirement to be prescribed by the sanctioning authority. However, mostly it would be push through method.

GWSSB will not be able to provide water for testing of the pipelines & water containers of the project. This shall have to be managed by the contractor at his costs and risk.



Labor for making joints including jointing material for joints, tools as well as tests. Testing of pipes for leakage under water pressure and flushing the pipes after testing and construction work shall have to be arranged by the contractor at his own cost.

#### **METHOD OF MEASUREMENT AND PAYMENT**

The measurement shall be recorded in running meter of pipe length laid along the centerline of axis of pipeline including tees, enlarges, reducers and bends, correct up to 0.01 m length. No payment shall be made for overlaps etc. The payment shall be made as mentioned in price bid.

# **VALVE**

Providing and supplying ISI mark CI D/F Sluice valves, butterfly valves, Reflux valves of following class and diameter including all taxes, insurance, transportation, freight charges, octroi, inspection charges, loading, unloading, conveyance to departmental stores, stacking etc. complete.

## **SLUICE VALVE**

Sluice valve as per I.S: 780 & 2906 / 1984

PN-1.6 with wheel operated (Alt 1 type long body)

## **GENERAL**

The contractor shall be covering manufacturing, supplying and delivery of Sluice valve conforming to IS: 2906-1-A & IS: 780 or its latest revision (Specification for sluice valves (50 to 900 mm size) with ISI certification.

## **STANDARDS**

The C.I. sluice valves to be manufactured, supplied and delivered under the scope of this contract shall be manufactured in accordance with and conforming to Indian standard specifications as given below with ISI certification mark on each sluice valves.

## **TEMPERATURE VARIATION**

All sluice valves manufactured, supplied and delivered shall be subjected to drinking water under variable temperature condition ranging from 4° to 45° C.

## **MARKING**

The legible and in deniable marking upon each valve shall indicate the following:

- (1).ISI certification mark on each sluice valve only.
- (2).Manufacture's brand name and/or trade mark.
- (3).Size of valve and nominal pressure of valve.
- (4).Serial number of cast.
- (5).Serial number in punch

(6).Where a valve has been tested for only open and test, it should be marked 'O' distinctly and permanently.

(7). Any other important matter that the manufacturer deems fit to be Inscribed embossed.

### TEST CERTIFICATE

The contractor shall always provide manufacture's test certificate in accordance with every batch/ lot as valves so manufactured and supplied.

The contractor shall also produce, in addition to manufacture's test certificate the inspection certificate issued by the authorized person /agency appointed by Engineer/board for the same purpose. The inspection charges of the authorized person/agency as fixed by GWSSB shall have to be borne by the contractor and the contractor as per the terms and condition of GWSSB shall pay the necessary payment to the inspecting agency.

### NORMAL PRESSURE

Sluice valves shall be designed by nominal pressure (PN) defined as the maximum permissible gauge working pressure in Mpa as "PN-11" (Mpa = 10 kgf/m<sup>2</sup> approx)

The nominal size shall refer to the nominal bore at any point, shall not be less than the nominal size required.

### MATERIAL:

The materials for the different component parts of the sluice valve shall confirm to requirements given in Table

Materials for components parts of sluice valve

Sr. No.	Component	Material	Ref.to.	Grade of designation
1	Body, bonnet wedge stuffing box, gland thrust plate, cap.	Grey cast iron	210-FG 1978 (1)	
2	Steam	High tensile brass	320 – 1961 (2)	Ally 1 of 2
3	Wedge nut	Leaded in bronze	318- 1962 (3)	2
4	Body seat ring. wedge facing ring	Leaded tin bronze	318-1962 (3)	2
5	Bolts	Carbon Steel	1367 – 1967 (4)	Class 4.6
6	Nuts	Carbon Steel	1367 – 1967 (4)	Class 4
7	Bonnet gasket	Compressed fiber Board	2112 – 1971 (5)	C
8	Gland packing	Jute & hemp	5414-1969 (6)	-

- (1) Specification for gray iron castings (third revision).
- (2) Specification for high tensile brass rods and sections (revised).
- (3) Specification for leaded tin bronze ingots and casting (revised).
- (4) Specification for technical supply condition threaded fasteners  
(first revision)
- (5) Specification for compressed asbestos fiber jointing (first revision)
- (6) Specification for gasket packing, jute and hemp.

### **MANUFACTURE**

Sluice valve bodies for 80 mm to 900 mm size valves shall be provided with double-flanged ends connection.

### **FLANGES**

The flanges and their dimensions of drilling shall be in accordance with part IV and VI of I.S. 1538 (Part I to XXII) 1976 (Specification for cast Iron fittings for pressure pipes for water gas and sewage) or its latest revision.

### **MODE OF MEASUREMENT AND PAYMENT**

Measurement shall be paid on number basis as per relevant dia of the item in schedule 'B' of the tender & as per price schedule.

## **BUTTERFLY VALVES**

Butterfly valves as per **IS - 13095 / 1991**

### **1.0 SCOPE** – Fabricated valve will not be considered.

- 1.1 This standard cover double flanged and wafer type of metal seated, resilient seated cast iron, ductile iron, and carbon steel and lined butterfly valves for general purpose. Valves covered under this standard are manually, pneumatically, hydraulically or electrically operated.
- 1.2 It covers valves of nominal pressure designations up to and including 4 Mpa. and class 300 with ends flanged in accordance with appropriate table of I.S 6418 : 1971 'Cast iron and malleable cast iron flanges for general engineering purpose' or wafer type valves with bodies designed to be accommodate between pipe work flanges in accordance with appropriate table of IS 6418 : 1971 or IS 6392 : 1971 'steel pipe flanges' in nominal size DN 40 to DN 2000. It also covers valves up to class 300 and flanges as per the pressure/temperature ratings given in IS 13159 ( Part 1 ) : 1991 'steel pipe flanges and flanged fittings : part I dimensions' and IS 6418 : 1971 'cast iron and malleable cast iron flanges for general engineering purposes'.

### **2.0 REFERENCE**

The Indian standards listed in Annex A are necessary adjuncts to this standard.

### **3.0 TERMINOLOGY AND DEFINITIONS**

Terminology and definition covered in IS 4854 (Part3) : 1974 are generally applicable.

### **4.0 VALVE END CONNECTIONS**

- 4.1 Double flanged valves  
A valve having flanged ends for connection to pipe flanges by individual bolting as shown in Fig. 1
- 4.2 WATER VALVE  
A valve for clamping between two pipe flanges using through bolting this may be single flange, lug type, U- section or flangeless type as shown in Fig 2,3,4,5 and 6.

### **5.0 SERVICE APPLICATIONS**

- 5.1 Valves shall be suitable for one or more of the following applications.
  - (a) Tight shut off - A valve having no visible leakage past the disc in closed position under test conditions.
  - (b) Regulating - A valve intended for regulating purpose and which may have a clearance between the disc and the body in close position.
  - (c) Low leakage - A valve which has specified maximum leakage rate past the disc in the closed position.
- 5.2 VACUUM CONDITION  
Where valve are to be used under vacuum conditions, purchaser shall mention specifically and the detailed design provision shall be mutually agreed between the purchaser and the manufacturer.

### **6.0 NOMINAL SIZES**

The range of nominal valve size (DN) in mm shall be as follows:

40,50,65,80,100,150,200,250,300,350,400,450,500,600,700,800,900,1000,1200,1400,1600,1800 and 2000

## **7.0 NOMINAL PRESSURES**

- 7.1 Valve shall be designated by nominal pressure (PN) defined as the maximum permissible working pressure (Mpa) at 20 ° C temperature as follows:  
PN 0.25, PN0.6, PN1.0, PN1.25 and PN4.0
- 7.2 The class designation for valves specified by nominal pipe size shall be class 125, class 150 and class 300.

## **8.0 PRESSURE/TEMPERATURE RATINGS**

Maximum permissible gauge working pressure and operating temperatures shall be in accordance with IS 6418 : 1971 and IS 13159 ( Part I ) : 1991 except that restriction on temperature may be placed by the manufacturer on valves in accordance with this standard by reason of valve type, trim materials or other factors. However, all valves shall be suitable for continuous use at their PN designation within the temperature range of -10 ° c to 65 ° c.

## **9.0 BODY ENDS**

### **9.1 DOUBLE FLANGED BODY ENDS**

The dimensions of flanged body ends and drillings shall be in accordance with the requirement given in Annex B. Flanges as per any other specific requirements of the purchaser may also be given as agreed to between the manufacturer and the purchaser or as per I.S. 13159 ( part I ) : 1991.

- 9.1.1 Flanges shall be at right angles to the axis of the bore and concentric with the bore. Flanges shall be drilled unless otherwise specified and bolt holes shall be off centers. Tapped by the design of the valve

### **9.2 WAFER BODY ENDS**

- 9.2.1 Body ends shall be capable of being fitted between the pipe flanges complying with the requirements of annex B flange drilling.
- 9.2.2 The joint faces shall be at right angles to the axis of the bore and concentric with the bore.
- 9.2.3 Holes may be provided, where required by the design, for the passage of the bolts securing the flanges and the valve. Where through bolting is not practicable due to the presence of valve shaft, bearing housing, tapped holes may be provided for individual bolting of each flange.

## **10.0 FACE TO FACE DIMENSIONS**

- 10.1 Face to face dimensions of double flanged and wafer types of valve shall be as per Table 1.
- 10.2 Face to face dimensions given in Table 1 are exclusive of the sealing gaskets at both ends.
- 10.3 The manufacturer shall ensure that adequate space will be available between valve flanges for bolting when flanged valve with short body face to face to face or wafer long face to face are manufactured.
- 10.4 Tolerance on face to face dimension in Table 1 shall be as follow

Face to face dimension of Unlined valve		Tolerance
MM		MM
Over	Up to and Including	
0	250	±2
250	500	±3
500	800	±4
800	1000	±5
1000	2400	±6

## **11.0 BODIES**

Bodies end ports shall be circular and the numerical valves of the diameter shall be as close as possible to the valve of DN.

## **12.0 DISC AND SHAFT**

The disc and shaft shall be designed to withstand the maximum pressure differential across the valve in either direction of flow. The shaft may be of one piece design or in two pieces separately attached to the disc. Any means of attachment between the shaft and the disc shall be such as to preclude components becoming loose in service.

## **13.0 SEATING AND LININGS**

Non-integral seating, and lining where used, and their means of attachment shall be such as to preclude their becoming loose in service.

## **14.0 BEARINGS**

- 14.1 The bearings shall be suitable for the maximum loads imposed by the shaft during testing and in service.
- 14.2 For valves DN 350 and above, a bearing shall be provided to take the axial thrust, spring retaining clips (circlips) shall not be used as thrust bearing.
- 14.3 Suitable sealing shall be provided for the shaft where it passes outside the pressure containing en closer.

## **15.0 MATERIALS**

This standard is based on materials specified in Table 2. Unless otherwise agreed, the materials shall be of a grade equivalent to those given in Table 2 or superior. Other material may be used as per agreement between the manufacturer and the purchaser.

## **16.0 OPERATION**

### **16.1 MANUAL OPERATION**

All valves shall be capable of operated at a differential pressure across the disc as marked on the valve. Lever, worms gear/traveling nut type or any other suitable type of operator can be used.

#### **16.1.1 DIRECTION**

Unless otherwise, specified manually operated valves shall be closed by turning hand wheel or lever in a clockwise direction when facing the hand wheel or lever. The design of lever when fitted shall be such that the lever may only be assembled to the valve so that it is parallel to the direction of flow when the valve is open.

16.1.2 All gear traveling nut operators shall be provided with suitable stops to prevent movement of the shaft beyond the limit corresponding to the fully closed position of the disc.

16.1.3 All gear traveling nut operators shall be packed with grease for life time operation. Gear/traveling nut operators shall be totally enclosed and weather proof for general application. For special applications such as marine, submerged service etc. the purchaser may specify special en-closer.

16.1.4 All gear/traveling nut operators shall be self locking type. All leaver operated valve shall be capable of being locked at least three intermediate position.

16.2 The operating hand-wheels shall be marked 'CLOSE' or 'SHUT' to indicate the direction of closer.

16.3 The operator shall be provided with arrangement to indicate the disc position.

## 17.0 TESTING

All valves shall hydrostatically tested by the manufacturer before dispatch. The pressure shall be obtained without any significant hydraulic shock. Testing shall be carried on before application of paint or other similar treatment unless otherwise agreed between the purchaser and the manufacturer. There shall be no air entrapped within the part of the valves subjected to test pressure.

### 17.1 PERFORMANCE TESTING

Each valve shall be shop operated from fully closed to fully open position and reverse, under no pressure and no flow condition to demonstrate that the complete assembly is workable.

### 17.2 BODY TEST

Completely assembled valve shall be tested as follows:

‘The body ends shall be blanked so that the valve is subjected to the full pressure in all directions include by the test pressure wafer valves may be tested in any suitable manner agreed between the purchaser and the manufacturer. The valve disc shall be in slightly open position and pressure equivalent to 1.5 times the maximum permissible working pressure shall be applied with water. The duration of this test shall be as in Table 3.’

### 17.3 SEAT TEST

The seating surface of the valve shall be cleaned unless a surface treatment forms an integral part of the design or the use of a temporary surface treatment has been agreed between the manufacturer and the purchaser to avoid the possibility of damage under the condition of the test.

TABLE-3

NOMINAL DIA MM	MINIMUM TEST DURATION IN MINUTES	
	BODY TEST	SEAT TEST WHEN APPLICABLE
Up to and including 50	0.25	0.25
65 to 150	1.00	1.00
200 to 300	2.00	2.00
350 to 1000	5.00	2.00
1200 to 2000	5.00	3.00

17.3.1 Each valve shall be shop tested for leaks in close position. The test shall be conducted with the body flanges in a horizontal position. Pressure shall be applied to the upstream end of the valve, the downstream being open to atmosphere. The duration of test shall be as per Table 3. There shall be no indication of leakage past the valve disc during test and valves shall be drop tight. Seat test shall be carried out in both the direction of valve if agreed between the manufacturer and the purchaser. The seat pressure applied on upstream side shall be equivalent to 1.1 times the maximum permissible working pressure at 20 ° c and shall be applied with water.

17.3.2 For regulating type valves seat test shall not be applicable.

### 17.4 DISC STRENGTH TEST

The test shall be conducted with the body flanges in horizontal position. The test pressure shall be 1.5 times the maximum permissible pressure at 20 ° C With disc in closed position, hydro test pressure shall be applied to the lower face of the disc for



duration as per table-3. There shall be no damage to the valve disc nor shall any part of valve or disc be permanently deformed by the test. The purpose of this test is to provide evidence of the adequacy and structural integrity of disc and body. Any leakage past the seat shall not be the criteria for rejection of the valve (Sampling test sample as per IS 2500). For regulating type valves, disc strength shall not be applicable.

17.5 Maximum permissible leakage shall be as given in Table-4

## 18.0 TEST CERTIFICATES

When specified by the purchaser, the manufacturer shall issue a test certificate confirming that the valves have been tested in accordance with this standard and stating the actual pressures and medium used in the test.

VALVE TYPE	LEAKAGE RATE
Tight shut-off	No visible leakage for duration of test
Low leakage	$0.1 \text{ mm}^2 / \text{s} \times \text{DN (sec 5)}$
Regulating	Not specified. Outside the scope of this standard.

## 19.0 INSPECTION

If inspection is required, this shall be stated in the enquiry/order. The purchaser or his authorized representative shall have access to the manufacturer's works at all reasonable times to inspect assembled valve to his order.

## 20.0 WITNESSING OF TESTS

When the purchaser desires to witness the tests, this shall be specifically agreed in advance.

## 21.0 MARKING

Marking shall be cast integral on the body or on a plate securely attached to the body. The markings shall be in accordance with I.S. 9866: 1981.

## 22.0 PREPARATION FOR DESPATCH

- Valve shall be complete in all respect when shipped. Each valve shall be drained, cleaned, prepared and suitably protected with 2 coats of red oxide on un machined surfaces and rust preventive coats on machined and flanged surfaces for dispatch in such a way as to minimize the possibility of damage and deterioration during transit and storage. Painting other than specified on the finished valve shall be as per the agreement between the manufacturer and the purchaser.
- Disc shall be unseated when dispatched, but care shall be taken to ensure that there is no risk of damage to the disc.
- When specified, the body ends shall be suitably sealed to exclude foreign matter during transit and storage.
- Components shipped unattached shall be adequately protected and identified to permit correct field assembly.

## MODE OF MEASUREMENT AND PAYMENT

Measurement shall be paid on number basis as per relevant dia of the item in schedule 'B' of the tender & as per price schedule.

## **AIR VALVE [Double Ball Flange Kinetick (DK)]**

Providing and supplying CI Air valves of approved make & quality of following class and diameter including all taxes, insurance, transportation, freight charges, octroi, inspection charges, loading, unloading, conveyance to departmental stores, stacking etc. complete.

### **Air valve double ball flange kinetick (DK)**

#### **GENERAL**

The air valve shall conform to the I.S.S. as and when published and shall be have approved make and quality. The standard applies to air valves used for water mains.

The details given below briefly cover the requirement for materials, dimensions and test for air valves.

Double air valve (DK) shall have two ball chambers, on outlet of large capacity shall be provided for admission and release of bulk volume of air during emptying and filling of the main, another of small outlet type for the escape of smaller quantities of air accumulating under pressure. They shall be of flanged type.

#### **MATERIALS**

##### **CAST IRON**

Cast Iron for bodies' pressure covers, splash covers, glands, caps, joints support rings shall be best gray iron of selected grade, 20 of I-S-210-1978 specification for gray iron castings.

##### **GUN METAL**

Gunmetal shall be of mixture of 88% copper, 10% tin 2% Zinc having excellent hard wearing qualities, Ball guides of small orifice units and outlet bushes of large orifice valves shall be of gunmetal.

##### **FOREGED BROZNE**

Nipples, spindles shall be machined from rolled, extruded or forged high tensile brass or aluminum bronze. The produce shall possess much greater strength than ordinary cast product.

##### **MILD STEEL**

Bolts, nuts, flanges etc. shall be of mild steel unless otherwise specified and shall confirm to I.S. 226-1975 specification for structural steel.

## **MATERIALS FOR BALLS**

The balls shall be of rubber covered and vulcanite covered. The rubber shall have a smooth and hard surface. It shall be as per I.S. 638-1965 specification for rubber and insertion jointing.

## **FLANGE JOINTING MATERIALS**

The jointing material used between the flanges of components part of the valve shall be compressed fiberboard or rubber of thickness between 1.5 mm to 3 mm. The rubber shall be as per I.S. 683:1965 specifications for rubber and Insertion jointing. The fiberboard shall be impregnated with chemically natural mineral oil and shall have a smooth and hard surface.

## **SIZE**

Size of the Air valves shall be as per relative item mentioned in schedule B of the tender.

## **CHARACTERISTICS**

Small orifice valves shall have rubber-covered balls and nipples of forged bronze or special alloy in to brass plug.

Large orifice valve shall have vulcanite-covered ball closing on rubber sealing backed with leather and gunmetal outlet bushes. They shall be screwed or flanged. The flanged shall be faces and drilled to I.S.S. seals.

Air Valves shall be sound in all respect and uniformly forged so as to have uniform bore. They shall be free from any defects such as unwanted projection, holes or roughness and shall have inner and outer surface perfectly smooth.

## **COATING**

Immediately after casting and before machining, all cast iron parts shall be thoroughly cleaned and before rusting commences shall be coated by dipping in a bath containing a composition having a tar base.

The coating shall be such that it shall not impose any test of small to water. The coating shall be smooth glossy and sufficiently hard. It shall not chip when scratched lightly with the point of penknife.

## **INSPECTION AND TESTING**

The engineer in charge or his authorized representative shall have free access to the works for inspection at any stage of manufacture and to reject any materials, which does not confirm to the specified requirements.

The manufacturer shall arrange to supply all labor and appliance for the tests if the testing is to be done at his works. Each valve shall be subjected to the hydraulic test

and shall show to sign of leakage under these tests i.e. the balls shall function properly. The valve shall be tested to double the maximum working pressure.

#### **MANUFACTURERS GUARANTEE**

The manufacturers shall guarantee that if any defects chargeable to faulty workmanship, design or materials are found in the valves within a period of one year of dispatch be shall replace any part that prove defective, free of charge at the place of dispatch.

The following information shall be cast on each valve body:

- (a) Manufacturer's name or trademark.
- (b) Size of -valve
- (c) ISI mark

#### **TENDER PRICE:**

The tender price shall include all labor, material and machinery cost for:

- a) Proper manufacturing of the valves.
- b) All tests required to be undertaken at manufacturer's premises.
- c) Transportation of the valves either by Rail and/or Road services with all the covers duly and appropriately insured.
- d) Delivery of specials with proper loading, unloading, stacking at Municipality store as indicated by Engineer-in-charge.
- e) Further towards proper discharge of all contractual obligations. The storage of all specials to be manufactured, supplied and delivered under the scope of, contracts shall be in general be made as described in Technical specification document.

#### **DELIVERY SCHEDULE:**

The delivery schedule shall be governed by the Engineer of Municipality.

#### **MARKING :**

The methods of marking all the valves to be delivered under scope of contract shall ensure that all the information will remain legible even after transportation, storage in open space etc. In general the legible and indelible marking upon the valves shall indicate the followings:

- i) Manufactures brand name and/or trademark.
- ii) Purchasers mark as "Municipality" be inscribed.
- iii) Diameter and class of valves.
- iv) Any other important matter that the manufacturer or purchase or deems fit to be inscribed.

#### **PACKING AND HANDLING:**

The materials shall always be packed separately dispatched from manufacturer's works with adequate protective measures to prevent damages deterioration while in transport or stored at any place. The packing shall always be so neat and tidy that may withstand any robust and rough handling.

When the materials are transported at railway risk, special packing as per IRCA rules are absolutely necessary for which the extra cost, if any, shall be borne in total by supplier only.

The supplier shall use proper handling instruments/equipment's and shall follow to a suitable method of handling pipes as may be approved by Engineer, while unloading and stacking material in the stores.

#### **MATERIALS AND WORKMANSHIP:**

General requirements of materials and workmanship shall mean any material or article either raw or finished one is required to be used in any manufacturing process of tanks.

All the material shall be new and of high quality.

In case, if materials is not specified by relevant ISS for manufacturing part or the whole as item, the supplier shall prepare specification in concurrence with manufacturer and shall seek an approval of engineer prior to its use in the manufacturer.

#### **TEST CERTIFICATE:**

The contractor shall always provide manufacturer's test certificate in accordance with every batch/lot of goods so manufactured and supplied.

The shall also produce in addition to manufacturer's test certificate contractor The inspection certificate issued by the authorized person/agency appointed by Engineer or Board for the same purpose.

**INSPECTION:**

This clause is applicable in general to all materials such as all types of valves, Pre-cast chambers, other specials and materials etc. under this contract.

Inspection of materials will be carried out at factory site by Inspecting agency to be fixed and authorized by GWSSB. The supplier on receipt of supply order from Municipality shall intimate inspecting agency to carry out inspection as soon as material is ready.

The inspection call for Air valve should be given. Inspection will be carried out normally within one weeks time and on receipt of such intimation the inspecting agency will inspect the materials as per the specification and on satisfying itself, will mark the inspection marks on all valves and issued inspection note to the supplier and concerned consignee.

For inspection purpose the manufacture has to go in for stenciling for identifying size and class for proper segregation. The stock of offered material shall be in a manageable batch with adequate space like spreading the pieces etc. to permit proper inspection and inspection authority to be present during stamping so as to ensure that only actually cleared material is stenciled. Manufacturer does not load material after sunset to avoid inadvertent dispatch of wrong material.

Inspection note issued by the inspection agency to supplier as well as consignee (Concerned Executive Engineer) materials with inspection mark will be dispatched to stores stipulated in supply order and on receipt at stores the verification will be carried out by concerned Municipality Engineer as regards quantity and quality. Here quality means physical soundness of materials as precaution against breakage during transit. The supplier has to submit the test certificate as well as detailed test results carried out by inspection authority to the consignee along with the dispatch documents of materials. The material shall be considered as received only on receipt given by the concerned Municipality Engineer after verifying and satisfying the above requirements.

**MODE OF MEASUREMENT AND PAYMENT**

Measurement shall be paid on number basis as per relevant dia of the item in schedule 'B' of the tender & as per price schedule.

## **Lowering, Laying and Jointing, Valves**

### **Reflux Valves, Butterfly Valves, Sluice Valves And Air Valves**

Lowering, laying and jointing in position following C.I. / D.F. Reflux valves, Butterfly valves, sluice valves and Air valves including cost of all labour, jointing material, including nut bolts and giving satisfactory hydraulic testing, etc. complete (Rate for all class of valves)

[A] SLUICE VALVES, BUTTERFLY VALVES, REFLUX VALVE, SCOUR VALVE

#### **SUPPLY OF MATERIAL**

Cast iron double-flanged sluice valve/butterfly valves with two tailpieces suitable to pipe shall be supplied and carted by the contractor as per latest IS. The rate shall include loading, unloading and stacking at site.

The sluice valve/butterfly valves and tailpieces shall be examined before laying for cracks and other flaws. They shall be undamaged in all respect.

The sluice valves/butterfly valves shall be operated before laying.

All grits and foreign materials shall be removed from the inside of the valves before placing.

All the four faces shall be thoroughly cleaned and coated with a thin layer of mineral grease.

The tightening of gland shall be checked with a pair of inside-calipers. Clearance between the top of stuffing box and the underside of the gland shall be uniform all the sides.

#### **JOINTING MATERIAL**

The contractor shall provide all necessary jointing materials such as nuts bolts, rubber packing white zinc jute lead wool etc.

All tool's and plant required for the contractor shall provide installation of sluice valve.

All jointing materials shall be not approved from the Engineer-in-charge before use.

The nut and bolts shall conform to Item No MSP-19 of specification of materials.

The rubber packing shall confirm all specifications as narrated in item No MSP-20 of specifications of materials.



## **INSTALLATION**

The sluice valve/butterfly valve shall be lowered in to the trench carefully.

If necessary tailpieces shall be fitted with sluice valve first outside the trench and then lowered in to the trench.

The rubber packing shall be three ply and have approved thickness. The packing shall be of full diameter of the flange with necessary holes and the sluice/butterfly valve bore. It shall be even at both the inner and outer edges.

The flange faces thoroughly greased.

If flange faces are not free, the contractor shall use thin fibers of lead wool.

After placing the packing, nuts and bolts shall be inserted and tightened to make the joint.

The valve shall be tightly closed when being installed to prevent any foreign materials from getting in between the working parts of the valve.

Each flange bolt shall be tightened a little at a time taking care to tighten diametrically opposite bolts alternatively.

The sluice valve/butterfly valve shall be installed in such a way that its

Spindle shall remain in truly vertical position.

The other end of tailpiece shall be fitted with pipes so that continuous lines can work.

Extra excavation required for facility of lowering and fixing sluice valve shall not be paid for.

## **TESTING**

After installation of sluice valve/butterfly valve the same is tested to 1 1/2 times of its test pressure.

The joints sluice valve/butterfly valve shall withstand the test pressure of pipelines.

Defects noticed during test and the contractor at his own cost shall rectify operation of sluice valve without any extra claim to the entire satisfaction of the Engineer-in-charge.

### **[B] AIR VALVES SINGLE BALL FLANGED / SCREWED TYPE**

The single acting air valve shall be supplied and carted by the contractor as per latest IS. The rate shall include loading, unloading and stacking at site.

The materials shall be carted to store or site of work including all freight, loading, unloading including all taxes, insurance, including necessary jointing materials such as G.1 Nipple saddle pieces shall be brought by the contractor for fixing of air valve.

A suitable hole shall be drilled on the pipeline. The pipeline shall be of any type such as AC, PVC or CI pipes. A clamp shall be got prepared with a nipple welded on it. The clamp shall be fixed on pipe with bolts and nuts in such a way that the part of nipple fixed in the clamp shall remain in the hole drilled in pipe. The rubber packing shall be provided between the clamp and the pipe. White zinc spun yarn shall be used for fixing the nipple of a valve.

Bolt holes shall be drilled according to center lines. Bolt heads and nut shall be hexagonal and shall conform to IS: 1363 (specification for black hexagonal bolts, nuts and lock nuts and black hexagonal screws).

The neoprene seat ring shall be held securely in place under the low-pressure cover by jointing support ring to prevent it from sagging when the ball is not soaking the orifice.

## **JOINTING MATERIAL**

Jointing material shall be brought by contractor with all necessary joint rings nuts, bolts and washers for completing the joints on all the flanges of valve supplied under this contract including these flanges which will be jointed to pipe system. The lengths of bolts shall be assumed to be suitable for jointing material supported under the contract shall be inclusive of rates.

Joint rings shall be of flat section at least 3 mm thick. They shall be of rubber in accordance with IS: 638-1965 or its latest edition (specifications for rubber and insertion jointing) of hardness proven in practice so as to form a water tight joint and use of jointing paste shall not be allowed.

## **(C) AIR VALVES DOUBLE BALL FLANGED KINETIC (DK)**

### **GENERAL**

The double air valves shall have two ball chambers having one outlet of large capacity for admission and release of bulk volume of air during emptying and filling of the main and another having small outlet for escape of smallest quantities of entrapped air. This type of air valves shall be of flanged type with full conformation with IS: 1538 same valve shall be supplied and carted by the contractor as per latest IS. The rate shall include loading, unloading and stacking at site.

The ball-seated orifice always remains open while air is exhausting and is immediately closed when water rises in the chamber, lifts the ball and seals the orifice. It shall also ensure that there are no recesses or pockets, sheltering, escaping air for the large orifice (low pressure) ball to drop into when the valve is open. Turbulent air at the time of filling of pipe shall not circulate in such cavities and cause the ball to be blown in to.

Double acting Air valve shall be bolt up evenly on all sides after providing necessary rubber packing etc. on the flange of the Tees. Where facing of the flange is not true a line, fiber or lead wood or rubber packing shall be used. It shall be rubber insertion cloth of two plies and of approved quality. Any defects in jointing observed during the test shall be made good by the contractor till there is no further leakages are there.

#### **MODE OF MEASUREMENT AND PAYMENT**

Measurement shall be paid on number basis as per relevant dia of the item in schedule 'B' of the tender & as per price schedule.

### **PROVIDING & SUPPLYING DI, MS AND HDPE SPECIALS:**

- A) **Manufacture, supply and delivery of Ductile Iron Flange Socket spigot bends, tees, reducers or any other specials as per BS-EN-545 / 1995 class-A series K-12 suitable for use with DI pipes manufactured as per IS 8329/1994 delivery of specials is to be made to site of works including all taxes, loading, unloading, carting, stacking, insurance, inspection charges, Octroi etc. complete with internal cement mortar lining with EPDM rubber gaskets.**
- B) **Manufacture, supply and delivery of MS flanges, Tee, bends, tail piece, reducers, air valve raiser pipes or any other specials suitable for use with DI & HDPE pipes and delivery of specials is to be made to site of works any where in Gujarat including all taxes, loading, unloading, carting, stacking, insurance, inspection charges, Octroi etc. complete.**
- C) **Manufacture, Supply & Delivery of HDPE Flanges, tee, bend, tail pies, reducers or any other specials suitable for use with HDPE Pipes and delivery of specials is to be made to site of works in the proposed area of the project including all taxes, loading, unloading, carting, stacking, insurance, inspection charges, octroi etc. complete.**
- D) **Manufacture, supply and delivery of CID joints with Rubber Rings of Standard quality or any other specials suitable for use with D.I. and HDPE pipes and delivery of specials is to be made to site of works any where in Gujarat including all taxes, loading, unloading, carting, stacking, insurance, inspection charges, Octroi etc. complete**

**The DI Specials** with all types of diameters suitable of K9-K7 grade pipes with inner cement mortal lining.

The necessary DI Specials required during the lowering & lying of Ductile Iron Pipe shall be supplied by the agency and shall be as per standard specification. And per IS specification.

It shall be of best quality as per requirement Rate shall be including loading, unloading, carting, insurance and labour charge etc. complete.

The payment shall be made on kg. basis & as per schedule of payment of this tender.

**The MS Specials** required during the lowering & laying of DI & HDPE Pipe shall be supplied by the agency and shall be as per standard specification. MS specials included Air valves risers, Flanges, Tailpiece etc. It shall be of best quality as per requirement Rate shall be including loading, unloading, carting, insurance etc. complete.

The payment shall be made on kg basis & as per schedule of payment of this tender.

**The HDPE specials** shall be of the same material used for HDPE pipes and should be best quality as approved by the Engineer In Charge.

The payment shall be made on kg basis & as per schedule of payment of this tender.

### **(D) TECHNICAL SPECIFICIATIONN FOR CAST IRON DETACHABLE JOINTS**

80 MM DIA TO 700 MM DIA (SHORT AND LONG)

- I) **GENRAL TECHNICAL SPECIFLCATIONS**

### **SCOPE OF CONTRACT**

The contract shall be covering manufacturing, supplying and delivering of :

## **"CAST IRON DETACHABLE JOINTS WITH SYNTHETIC RUBBER RINGS CONFIRMING TO RELEVANT INDIAN STANDARDS."**

### **STANDARDS :**

CID joints confirming to IS:8794-1988 or its latest revision.

Rubber sealing rings confirming to IS:5382-1969 and IS:10292(Part - II) 1982.

### **TENDER PRICE :**

The prices are inclusive of all labor, material and machinery cost necessitated to be utilized for :

- Proper manufacturing of the cast iron detachable joints.
- All tests required to be undertaken at manufacturer's premises.
- Transportation of the joints wither by Rail and/or Road services with all the covers duly and appropriately insured;
- Delivery of joints with proper loading, unloading stacking at GWSSB store as indicated by Engineer-in-charge.
- Further towards proper discharge of all contractual obligations. The storage of all joints to be manufactured, supplied and delivered under the scope of contracts shall be in general be made as described in technical specification attached in this tender document.

### **MARKING :**

The methods of marking all the joints to be delivered under scope of contract shall ensure that all the information will remain legible even after transportation storage in open space, etc. In general the legible and indelible marking upon the goods shall indicate the followings :

- Manufacturer's brand name and/or trade mark.
- purchaser's mark as " GWSSB " be inscribed.
- Diameter and class of joints.
- Any other important matter that the manufacturer deems fit to be inscribed.
- ISI certification mark on each joints in case of joints with ISI mark.

### **PACKING AND HANDLING :**

The materials shall always be packed separately and desparchea from manufacturer's works with adequate protective measures to prevent damages and deterioration while in transport or stored at any place.

When the materials are transported at Railway Risk. Special packing as per IRCA Rules are absolutely necessary for which the extra cost, if any, shall be borne in total by supplier only.

The supplier shall use proper handling instrument /equipment and shall follow to a suitable method of handling of joints as may be approved by Engineer, while unloading and stacking material in the stores.

### **MATERIAL AND WORKMANSHIP :**

General requirements of materials and workmanship shall mean any material or article either raw or finished one required to be used in the manufacturing process of joints.

All the material shall be new and of high quality.

In case, if materials is not specified by relevant ISS for manufacturing part or the whole as item, the supplier shall also produce in addition to manufacturer and shall seek an approval of Engineer prior to its use in the manufacture.

## TEST CERTIFICATE :

The supplier shall always provide manufacturer's test certificate in accordance with every batch/lot of goods so manufactured and supplied.

The supplier shall also produce in addition to manufacturer's test certificate as mentioned in para 8.1 above, the inspection certificate issued by the authorized agency/person appointed by Board for the same purpose.

## II. TECHNICAL SPECIFICATIONS FOR C.I.D. JOINTS :

All CID joints shall be well machined and suitable for the A.C. PRESSURE pipes manufactured as per the ISS No. 1592/1989 with its latest revision if any. The CID joints upto 700 mm dia (Short Collar) shall be as per ISS No. 8794/1988 with its latest revision if any. The materials composition and test criteria shall be as per ISS 8794/1988 OR with its latest revision if any. For long collar joints the material composition and test criteria shall be as per ISS-8794/1988 or with its latest revision if any.

All CID joints shall withstand the pressure to the particular class of A.C. pressure pipes for which they are use. The materials specification for all joints shall be as per ISS 8794/1988 with its latest revision if any. Bolts of CID joints shall be of adequate lengths and well threaded so that while fitting the joints by hand the bolt end shall project for screwing on the nuts and at the end of the fitted nuts there should be some extra threaded length left bolt. The nuts and bolts shall be approved by the inspecting authority.

Each set CID joints shall consist of the following accessories :

- Joint flanges...2 Nos.
- Synthetic Rubber Rings...2 Nos
- Joint Collar 1 No.
- M.S. bolts and nuts as per the ISS per CID joint one set of M.S. Bolts (Well threaded) and nuts sufficient in number for one joint.
- The minimum weight of long collar CID joints, nuts and bolts, size and number of bolts and nuts, etc. are as under :

SR No.	Size in mm and Class	Weight of CID joints without nut and bolts & rubber rings Kg/Nos.	Size & No of Bolts(in inch.)	Remarks
1	2	3	4	5
1.	80/5,10,15	4.5	6x1/2x3	
2.	100/5,10,15	5.5	6x1/2x3	
3.	125/5,10,15	8.9	6x1/2x4	
4.	150/5,10,15	10.7	7x1/2x4	
5.	200/5,10,15	18	9x5/8x4	
6.	250/5,10	24	10x5/8x4	
7.	250/15	27.3	10x5/8x4	
8.	300/5,10	35.0	11x5/8x4	
9.	300/15	38.0	11x5/8x5	
10.	350/5,10,15	44.0	11x5/8x6	
11.	400/5,10	60.0	11x5/8x6	
12.	400/15	63.0	11x5/8x6	
13.	450/5,10,15	65.0	11.5x5/8x7	
14.	500/5,10	82.0	11.5x3/4x8	

15.	500/15	86.0	11.5x3/4x8	
16.	600/5,10	120.0	11.5x3/4x9	
17.	600/15	125.0	11.5x3/4x9	
18.	700-5/10	239.0	11.5x3/4x9	
19.	700-15	246.0	11.5x3/4x9	

**NB :** 1) Tolerance in weight of long collar shall be  $\pm 12\%$  as per IS:1538-1976 clause 10.1.1 the permissible tolerances on non standard fittings. This will be applicable in case of individual joint, however the tolerance in case of the whole lot should not exceed  $\pm 10\%$ .

The length of bolts shall be as suitable to the width of long collars.

#### **LONG COLLAR DIMENSION:**

Thickness at end:

Thickness of long collars at ends shall be kept similar to the thickness of short collars at ends as per the IS:8794-1988.

#### **Width of long collars:**

Width of long collars shall be as under ;

Sr. / Class	Width (mm)
80/5,10,15	83 to 85
100/5,10,15	98 to 100
125/5,10,15	114 to 128
150/5,10,15	136 to 140
200/5,10,15	142 to 150
250/5,10,15	162 to 135
300/5,10,15	166 to 180
350/5,10,15	190 to 196
400/5,10,15	190 to 196
450/5,10,15	196 to 205
500/5,10,15	205 to 210
600/5,10,15	205 to 210
700-5,10,15	205 to 215

#### **Over sized long collars :**

They are required for maintenance purpose. The internal diameter of the oversized long collars may vary from 5 mm to 8 mm compared to standard I.D. as per the requirement for field officers.

#### **MODE OF PAYMENT**

The payment shall be made on kg basis & as per schedule of payment of this tender.

### **Anchor/Thrust blocks/Columns/Footings:**

**Providing and laying Cement Concrete M-150 , 1:2:4 R.C.C. with 12 to 20 mm size black stone crushed metal including centering, curing, finishing, etc. complete including necessary reinforcement as per contractor's design but minimum of 80 Kg/C.M. of Cement Concrete. (This Item includes the cost of reinforcement, bending and binding also).**

Specifications for Anchor Thrust/Thrust Block/ Column/ Footings for Pipeline are as under:

"Anchor Thrust/Thrust Block/ Column/ Footings for Pipeline shall be carried out in cement concrete M-150 using trap metal as per instructions and workmanship of the engineering in charge. Materials and workmanship shall be given in concrete section." The reinforcement as per IS Standard and specifications.

This Item also includes the designing of Thrust Block where necessary and got approval before Execution from the Employer's Representative.

The payment shall be made as per the Cubic meter of Cement Concrete Executed & as per schedule of payment of this tender.

### **Concrete Encasing:**

**Providing C.C. M-100 for encasing using trap metal size 12 mm to 40 mm including Form work, curing, consolidation, etc. complete.**

Specification for Encasing of Pipe is as under:

"Encasing of pipe shall be carried out in cement concrete M-100 using trap metal as per instructions and workmanship of the engineering in charge. Materials and workmanship shall be given in concrete section."

The payment shall be made as per the Cubic meter of Cement Concrete Executed & as per schedule of payment of this tender.

### **Providing sand or murrum bedding incl. ramming, watering, consolidating, etc. complete from selected excavated earth (minimum thickness : 10 cm)**

#### **a) From selected excavated earth**

1. Bedding on trench or foundation bed using selected excavated stuff The selected excavated stuff of Murrum shall be got approved from the Engineer In charge before using the same for providing bedding on trench bed. The filling of selected excavated stuff or Murrum for bedding shall be done in required thick layers and it should be well watered and consolidated. Big clods shall be broken into small places and trees roots, meets and bit stones and other objectionable materials liable to decay shall not be used in the work.

The payment shall be made after completion of work as mentioned in price bid & as per schedule of payment of this tender.



## **REFILLING THE PIPE LINE TRENCHES**

**Refilling the pipeline trenches incl. ramming, watering, consolidating disposal of surplus stuff as directed within a radius of 3 km.**

### **1.0 General :**

The refilling will generally refer to refilling of trenches up to GL with excavated stuff or selected soil brought from outside if required.

### **2.0 Filling materials :**

Filling materials may be either excavated stuff on the selected soil, if required. If excavated stuff in any section of pipeline is not suitable for refilling in the trenches as per the opinion of Engineer-in-charge, the contractor shall have to bring the material from outside without any extra cost.

### **3.0 Refilling :**

- 3.1 The contractor shall do refilling in a systematic manner. Each layer of 15 cms thickness shall be well watered and compacted before the upper layer is laid, till the final level is reached to form a thoroughly compacted base. 3.2 Trenches for line shall be back filled after the pipeline is laid and engineer-in-charge has permitted for filling. The refilling shall be done upto 30 cm above the pipe except the joint portion. The remaining portion of trench to be refilled after completion the hydraulic testing of pipe line.
- 3.3 Refilling on top of pipe shall be carried out carefully with the excavated soft stuff. The filling shall be raised 250 mm above G.L. for settlement.
- 3.4 The contractor shall be fully responsible for any settlement after passing of time or during monsoon and the same shall be refilled with soil brought from outside if necessary without any extra cost.
- 3.5 The process of refilling in 15cm. layers including watering, ramming etc. shall be carried out in such a way as not to damage the pipe line or foundation, footing, masonry already laid or built up.

### **4.0 Mode of measurement and payment :**

The payment shall be paid after completion of item as mentioned in price bid & as per schedule of price of this tender.

## **Connection work of New Pipe Line with Existing Old Pipe Line**

- 1.0 The work inclusive of excavation, cutting of pipe, dewatering, refilling, jointing of pipe with all jointing materials such as nuts, bolts, rubber packing, washers, led, jute etc. wherever is required for completion connection job work of new pipe line with existing pipe line.
- 2.0 The work inclusive protection of existing service connection, telephone connection, electric cable, drainage line etc. during the connection work. If any service connection shall be damaged during the work, the contractor fully responsible for this damages.
- 3.0 The payment shall be paid after completion of item as mentioned in price bid and as per schedule of price of this tender.

## **PROVIDING & FIXING MS LADDER**

Providing and fixing 50 cm wide M.S. ladder fabricated from M.S. flats 10 mm x 60 mm with 20 mm dia steel bar steps, @ 30 cm C/C. The item includes stays of 10 mm x 50 mm flats as 3 meter including fixing it in 1 : 2 : 4 cement concrete block of 60 cm x 30cm x 30 cm and painting the ladder etc. complete as directed by Engineer-In-Charge.

### **General :-**

The item pertains to the provision and fixing of a 45 cm. wide steel ladder including fixing in cement concrete block and painting.

### **Material :**

Mild steel flat, mild steel bar.

Cement concrete 1: 2: 4 oil paints shall conform to the respective specifications laid in basic material section.

### **Fabrication and fixing:**

The shape of the ladder shall conform to the drawing or as ordered by the Engineer. The upper end shall be bent so as to provide easy climbing. The cued top of the stringers shall be at least 75 cm. above the top of the tank. The last step shall be 30 cm. below the top of the tank. The stringer after the curve shall extend up to the top of the tank. The spacing of steps shall be 30 cm.

Fabrication shall conform to the specification of structural steel work.

The lower end of the ladder shall be embedded into a block of 1:2:4 cement concrete.

The ladder shall be painted with a base coat of red lead paint and two coats of good anticorrosive oil paint approved shade.

Item to Include:

- (1) Mild steel flats, bars, concrete and paints.
- (2) Fabricating, fixing in concrete block and painting.
- (3) All necessary labor, materials and use of tools and equipment for the satisfactory completion of the item.

### **MODE OF PAYMENT**

Payment shall be made on running meter basis & as per schedule of payment of this tender.

## **PAINTING LETTERS**

Painting letters with enamel paint for capacity of tank. The size of letters shall be 45 cm. Height & 5cm width.

The letters shall be painted in block letters on backgrounds, as directed on the exterior face of the vertical wall. The size of the latter shall not be less than 45cms height & 5cms in which of approved quality enamel paints.

The Executive Engineer prior to starting of painting works shall approve the paint. The works includes labor work, scaffolding, platform etc. complete with materials required for the works.

The latter shall be painted in Gujarati, English as directed.

### **MODE OF PAYMENT**

Payment shall be made on number basis & as per schedule of payment of this tender.

## **PROVIDING & FIXING EXPANSION JOINT**

Providing and fixing water tight contraction expansion joints made of G.I. Plain of 16 or 18 gauge and 30cm. Wide.

The G.I. plain sheet of 16 to 18 gauge should be provided by the contractor & it should be 30cm. Wide & should be approved by Engineer-in-charge.

The work of construction and expansion joints should be carried out as per instruction of Engineer-in-charge & as shown in drawing or as per actual requirement at site of work.

The expansion joints should be of watertight & there should be no any leakage found in the water container from construction joints.

Bitumen shall be filled in it & brought by the contractor at his own cost.

The work should be carried out when and where it is required during the progress of the work.

The work shall be carried out in good workman like manner and should be of satisfaction of Engineer-in-charge.

### **MODE OF PAYMENT**

Payment shall be made on running meter basis & as per schedule of payment of this tender.

## **PROVIDING & FIXING CI/DF PIPE**

Providing and fixing C.I. double-flanged Class-A pipes vertically for RCC reservoir including providing clamps at every 3.00 m, all necessary specials e.g. duck foot bends, tees, bell mouth pieces, jointing materials such as nuts, bolts, rubber packing & hydraulic testing and necessary scaffolding etc. complete.

The double-flanged C.I. Pipes of the designed sizes shall be supplied by the contractor for making used in inlet, overflow and washout pipeline in work.

The double-flanged pipes shall be of cost iron B class. The pipes shall be as per the latest edition of I.S. 1536 shall be in standard lengths. In case of short length required as per actual site condition, same shall be provided by agency with flanged on each or short legged pipe pieces. The diameter of pipes shall be truly to the design size. The pipe shall be without any short of air or sand holes, cold shuts, or warping. If required pipes shall be hydraulically testes before its use.

The materials to be used in work shall be got approved from the Engineer-in-charges before its use. Entire work shall be carried out as for the direction of Engineer-in-charge. The necessary scaffolding and staging etc. for rising and lowering pipes shall be prepared by the contractor at his own costs. Contractor at his own cost shall repair any short of damage to the structure during course of fixing vertical pipeline. The rates are inclusive of supplying and labor charges for fixing the pipes in position.

Any short of accident or damage to human being or property is the entire responsibility of the contractor. The necessary fittings such as circling flanges, duck foot bends tees, reducers, flanges etc. shall be brought by the contractor and fixed in to position at his own cost, the rate are inclusive of all shorts of special such as duck foot bends tees bell mouth pieces etc.

No extra payment shall be made for special such as duck foot bends bell mouthpieces bends tees etc. The contractor shall have to provide all short of jointing materials such as Nuts, Bolts, Rubbers packing etc. and required tools at his own cost for fitting works. Wherever required, necessary by excavation lowering the line in trench and refilling shall be done by contractor at his own cost. Necessary testing shall give the contractor completion of work.

The item includes all short of taxes loading, unloading, refilling, lowering, stacking, freight charges insurance etc. complete.

The double-flanged C.I. pipes of the designed sizes shall be supplied by the contractor for making used in inlet, overflow and washout pipeline in work.

The double-flanged pipes shall be of cost iron a class. The pipes shall be as per the latest edition of I.S.: 1536 shall be in standard lengths. In case of short length required as per actual site conditions, same shall be provided by agency with flanged on each or short legged pipe pieces. The diameter of pipes shall be truly to the designed size. The pipe shall be without any short of air or sand holes, cold shuts, or warping. If required pipes shall be hydraulically tested before its use.

#### **MODE OF PAYMENT**

Payment shall be made on length meter basis & as per schedule of payment of this tender.

### **COWL TYPE VENTILATOR**

Providing & fixing C.I. cowl type ventilator with air filter and jali in C.C. 1:2:4 with boles & nuts etc. complete including costs of jointing materials carting etc. complete 150 mm dia.

The 150mm dia cowl type ventilator shall be supplied by the contractor at his own cost and shall be fixed in position as per instruction of Engineer-in-charge.

Necessary crippling flanges pieces shall be fixed during construction of roof done slab. The cowl type ventilator shall be fixed with the crippling flanges by nuts & bolts etc.

All necessary materials required for jointing such as nuts bolts rubber-packing wire etc. shall be supplied by the contractor at his own cost at site.

#### **MODE OF PAYMENT**

Payment shall be made on number basis & as per schedule of payment of this tender.

### **C.I. M.H. FRAME AND COVER**

Providing and fixing all type of C.I.M.H. frame & cover in C.C. work including carting etc. complete.

The contractor shall have to provide and cart C.I. M.H. frame & cover to site of work with all safety at his own cost. Materials used shall be of best quality approved by Executive Engineer or by Deputy Ex. Engineer.

The C.I.M.H. frame & cover shall be fixed in c.c. 1:2:4 by contractor. The locking arrangement shall consist of flat 50 x 20mm size and required length. Necessary locking clamps at fixed in C.C.

#### **MODE OF PAYMENT**

Payment shall be made on Kg. basis & as per schedule of payment of this tender.

## **RCC PRECAST CHAMBER**

**Manufacture, supply and delivery of RCC Precast chambers fixing at site of work with top cover as per specification and drawing attached with the tender documents for sizes as mentioned below and depth as per requirement. The rates includes all taxes, loading, carting, unloading, stacking, including Octroi and labour charges for erection.**

**Size of R.C.C. chamber shall be as specified in schedule - B.**

### **1.1 Pre-cast RCC chambers:**

Specification for RCC Pre-cast chambers of size;

Pre-cast chamber shall be folded one, made up of four sidewalls and top cover. The chamber shall be of outside dimension not less than 70cm X 70cm X 90cm deep for (i) & 100cm X 100cm X 145cm for (ii) suitable to accommodate sluice valve 80 mm to 600 mm as show in drawing. Casting shall be done on vibrating table in steel moulds.

Vertical wall shall not be less than 5cm thick and two walls shall have opening to accommodate pipes up to 300mm dia. The walls shall be fixed by 37mm X 3mm flat iron right angle clamps outside with nut bolts of size 12mm X 75mm including necessary washer.

Top cover shall be not less than 6.5cm thick, 150mm dia hole at the center for operating the valve, with M.S. handles for lifting and locking arrangement as shown in drawing.

The top cover is to be tied on all four vertical wall with the rode of 6mm dia M.S. bar for lifting of the top cover. 10mm dia for steel hocks shall be provided.

Tolerance shall be allowable as + or - 5mm in thickness and 10mm in length, breadth and depth.

Reinforcement steel of 6mm dia bar shall be provided 12.5 cm. center to centre both way for cites, vertical wall and at 10 cm centre to centre both the way for top cover.

A tie road shall be provided in the centre and any two of opposite vertical walls to be tied with the reinforcement in the top cover with the suitable opening kept in the top cover at the centre of all the four sites of the top cover. Extra reinforcement shall be provided over the opening for the pipes in the two vertical walls.

Concrete shall be of C.C. 1 : 1 1/2 : 3 M-200 mix consistence of portland cement sand and black trap metal of graded sizes from 6 mm to 12 mm concrete shall be mixed in concrete mixture. Necessary compression test and slump test shall be carried out at the tie of manufacturing. Compression test means cube test as per relevant IS. The C. C. blocks of 15 cm x 15 cm x 15 cm size be casted for the mix of the concrete prepared for manufacturing of the chambers and that to be tested to confirm the compressive strength of the concrete mix M-200.

Proper curing of chamber shall be made by manufacturer by any proper method of curing.

### **Specification for Footrests of Chambers:**

Foot rest dimensions shall be as per drawing No.-3 attached for (i) 60 X 60 X 100 cm. (ii) 90 x 90 x 145, (iii) 130 x 130 x 145 size of chambers respectively.

Concrete shall be C.C. 1:1.5:3 of Portland cement, sand and black trap metal of graded size from 6 mm to 12 mm concrete shall be mixed in concrete mixture. Necessary compression test and slump test shall be carried out at the time of manufacturing. Compression test means cube test as per relevant IS. The C.C. blocks of 15 cm x 15 cm x 15 cm size are caste for the mix of the concrete prepared for manufacturing of the chambers and that to be tested to confirm the compressive strength of the concrete mix

M-200. Manufacturing shall make proper curing of chambers by any proper method of curing. The rate shall be quoted per chamber comprising of four walls and top cover including cost of fixing and fastening and locking arrangement.

Fixing R.C.C. Chamber in c.c. 1:3:6 including, excavation, carting, loading, unloading etc. completed.

1. The Precast chamber of required size as per item shall be supplied by the contractor
2. Necessary excavation fitting of Precast chamber shall be fixed with angle nuts & bolts as per instruction of Engineer in charge.
3. C.C. 1:3:6 shall be done at bottom of chamber on own expenditure of contractor as per the specification.
4. The payment of providing and fixing Precast chambers will be made on number basis & as per payment schedule.

## **Construction of Valve Chambers**

**Construction of masonry valve chambers of required size for Sluice valves, Butter fly valves etc. as per detailed drawing and specification and as per instruction of Engineer - in - charge.**

**The size of chamber should be as specified in schedule - B**

Additional excavation required to be done shall be carried out as per instruction of engineer - in - charge. For foundation chamber 15 cm. thick 1:3:6 PCC shall be provided and 23 cm. up to 1.5m. depth and beyond 1.5 m. depth 35 cm thick BB masonry walls in CM 1:6 shall be constructed.

Second class brick of standard size shall be brought by the Contractor & shall got approval before use in the work from the Engineer - in - charge.

12mm thick cement plaster in CM 1:3 shall be provided on inside and outside of walls up to 20 cm below from G.L. cement pointing in CM 1:3 shall be provided for outside below G.L. from 20 cm.

20mm dia MS bar steps shall be provided and fixed in wall at 30 cm c/c for facilitating access into the chamber. First step should be at a depth of 0.5 m from top and last step should be 0.5 m above bottom.

Chamber shall be covered with 150mm thick RCC 1:2:4 precast or cast in situ slab in four parts with key hole to insert key for operation.

Reinforcement for the cover slab shall be provided considering heavy traffic load.

Curing of concrete, BB masonry, RCC etc. shall be done using chemical or water for 14 days.

12mm dia MS bar handles minimum two nos. shall be provided to each piece of slab during the time of casting of slab.

Sides of chamber shall be refilled properly with selected excavated earth.

All the above items shall be carried out in workman like manner as per prevalent sound engineering practice and instruction of Engineer - in - charge.

### **PAYMENT**

Payment shall be made per No. of chamber constructed & as per payment schedule of this tender.

## **Railway Crossing Works**

Drilling of required dia size Horizontal bore hole for water main pipe line under the railway tracks in all strata with required length incl. providing & fixing of required dia M.S. casing pipe with welding pushing etc. complete incl. providing and fixing water main of required size of G.I. / M.S. pipe for railway premises as per instruction of railway authority & under supervision of railway authority incl. providing and supplying fixing of ISI make sluice valve of required size at bore & railway boundary with construction of brick edge pavement incl. providing & fixing of M.S. / Iron manhole frame with cover for valve chamber with locking arrangement etc. complete with all materials labour fabrication, hydraulic testing of pipe & valve etc. complete (45mt. length) for required size of water main.

Drilling of required dia horizontal bore hole for water main pipe line under Road in all strata with required length. The work is to be carried out under the supervision of railway authority after taking necessary permission from railway department. As per drawing given by the railway department.

Necessary permission from railway authority shall have to arranged by agency. Necessary help will be given by GWSSB.

The Drilling of horizontal bore work is to be carried out by necessary augur and by mechanized method.

M. S. casing pipe of required dia (both side epoxy painting) shall have to be brought by the agency incl. necessary pushing, welding etc. complete. The specification of M.S. pipe are same as per schedule. cost of M.S. pipe & specials are included in this work.

2 Nos. of required dia sluice valve shall have to be supplied and fixed at the both ends of railway crossing. The specification of sluice valve of are same as per detailed specification of sluice valve of this tender.

Construction of B.B. Masonry chamber sizes 1.30 x 1.30 x 3.0 Mt. should be constructed at the both end of the railway crossing for sluice valve. The work is to be carried out as per specification of item for tender including providing & fixing M.S. manhole frame & cover with lacking arrangement etc. complete.

Necessary excavation and C. C. M - 100 block at the ends of railway crossing work shall have to be carried out by agency without any extra cost. As per approved drawing & requirement from railway department.

Necessary brick edge pavement in C.M. 1:6 and cement pointing work shall have to carried out for damaged pavement on both side of railway track.

Necessary refilling work shall have to carried out after completion of railway crossing work. The rates are inclusive of considering required size & length of M.S. casing pipe, required size & length of D.I. pipe for water main, required size of sluice valve & valve chamber for both side of railway track & necessary charges of railway department to be paid to the railway authority for permission.

### **CROSSING**

#### **GENERAL SPECIFICATIONS**

At railways crossing the construction drawings issued by the department pipe line shall be installed in M.S. casing pipes conforming to the specifications given herein.

The casing pipes shall be installed in accordance with the details given in drawing and the casing, bushing and insulators, etc., shall be installed on the carrier pipe as detailed in drawings. Casing pipe size shall be about 100mm (Hundred millimeters) larger than the carrier pipe to facilitate the insertion of the later without disturbing the casing pipe and to provide adequate drainage, casing shall be installed with even bearing throughout its length and shall slope towards one end, as specified or desired by the engineer - in charge. The ends of the

casing shall be sealed to outside of carrier pipe in accordance with the details given in drawing.

Before installation, holes for installing vent pipes shall be cut and burrs if any shall be removed. The welding of both carrier pipe and casing pipe shall be done in accordance with the welding specifications, given herein. Before installing the casing pipe, it should be cleaned of all internal obstructions and during installation care should be taken to keep the inside clean.

The section of carrier pipe to be placed in any casing shall be closed at each end, hydrostatically tested preferably with dead weight tester for at least two hours. Only on successful completion of this test, shall the carried pipe section be inserted in the casing pipe. The installation of casing may open cut as circumstances may permit or require as directed by the engineer - in - charge.

The installation of casing in bended section of the carrier pipe shall be performed by meter bends of the casing pipe provided that the length of each meter cut out of casing pipe shall be such as to provide a clearance of at least 1-1 / 2" between the inside of the casing pipe and the outside of the coated carrier pipe.

Excavation for casing installation shall be immediately backfilled at the completion of the work with suitable solid matter and packed thoroughly to prevent seepage of water into the excavation.

The rate shall have to pay as per Job basis & as per payment schedule of this tender.



## **Road and Irrigation Canal Crossings**

At road & canal crossing the work shall be performed to the specifications of local authorities or such public bodies as may be in charge (S) of roads, and canals to be crossed.

In case, however the minimum requirements of the governing agencies are less than those set out in the drawing or the specifications given herein, then the requirements given in the drawing and the specifications given for encased line shall be followed.

Where as the casing pipe in the case of encased line to be laid normal by boring, tunneling, engineer - in - charge may at his discretion permit open-cuts to be made for the installation of casing provided, however, that the TENDERER shall procure the necessary permit / license for the same from competent authority. At locations wherein the open cut methods are permitted, the TENDERER shall pass the carrier pipe through the casing located in the trench after the approval of the engineer - in - charge in writing and care shall be exercised to avoid damage to pipe coating and wrapping during this operation. The TENDERER shall produce a certificate in writing from concerned authorities for its satisfactory restoration and payment therefore.

At all crossings the carrier pipe shall be laid straight without bends so that if necessary the pipe at a later date may be replaced without cutting the casing. The carried pipe shall extend at least 2 meters beyond the end of casing pipe at either end.

At railway crossings the TENDERER shall eliminate unnecessary bending of pipe to conform to the contour of ground by gradually deepening the ditch at such approaches as directed by the engineer - in - charge. Where the installation of the casing has been made by open cut TENDERER shall install suitable temporary bridge work ensuring the safety of the traffic aids and safeguards for protection of the public safety, or he shall provide suitable diversions as desired by the engineer - in - charge.

The method of carrying out a cased crossing by boring for various crossings on this pipe line route shall be jointly inspected by the representative of the GWSSB and TENDERER for each category of work prior to commencement of actual work.

Pipe line under high way & road and irrigation canal an applicable portion of the right-of-way shall be encased in accordance with the specification. This item of work shall include, necessary clearing and grading required therefore, trenching to the depths and widths required or drilling of bore hole for providing, fixing, casing and carrier pipes, testing, lowering in, installation of vent assemblies, end seals, insulator and all other fittings that may be required, backfilling, clean up, complete restoration to the original condition and further strengthening and protective works as may be required & charges of road & irrigation authority for permission should be paid by contractor. The work shall be carried out in accordance with the drawings and as directed by the engineer - in - charge. For various operations mentioned above, the specifications pertaining to these operations shall apply in addition to the specifications given herein.

The TENDERER shall be permitted to use Willing Sons type Neoprene seals in place of concrete end seals for the crossings. The item shall be procured by the TENDERER himself as per the provisions under the appropriate head of work in case TENDERER so desires. The representative of the MUNICIPALITY may also be associated to determine the quality of the material and its delivery schedule from the open market. However, the particular work defined under the proper head shall not be delayed on account of non - availability of Neoprene end seals. In such case, concrete seals may be provided.

On both ends of pushing concrete supports are to be provided as per direction of engineer - in - charge.

### **MODE OF PAYMENT**

The payment shall be made on No. of job basis as shown in relevant schedule.