GREAT LAKES CHEMICAL PROCESSING

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Issue Date: October 15, 2024
Response Due: October 22, 2024 - 4:00 PM EST
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REQUEST FOR QUOTATION
Ultrasonic Thickness Survey Services
Amine Treating Unit (ATU-100)

1. INTRODUCTION

Great Lakes Chemical Processing (GLCP) is soliciting quotations from qualified Non-Destructive Examination (NDE) contractors to perform ultrasonic thickness (UT) survey services on piping systems within our Amine Treating Unit (ATU-100) at the Hamilton Plant facility. This survey is part of our ongoing mechanical integrity program in compliance with API 570 requirements.

2. SCOPE OF WORK

2.1 General Requirements

The Contractor shall provide all personnel, equipment, and materials necessary to perform ultrasonic thickness measurements at designated Condition Monitoring Locations (CMLs) on the piping systems listed in Attachment A. The work shall be performed in accordance with the requirements specified herein and the applicable codes and standards.

2.2 Specific Tasks

• Perform ultrasonic thickness measurements at all designated CML locations

• Record thickness readings using digital data logging equipment

• Photograph each CML location and gauge display for critical readings

• Compare current readings to historical data (2019 survey) provided by GLCP

• Calculate corrosion rates based on historical trending

• Identify any readings below minimum required thickness (t-min)

• Prepare comprehensive inspection report with findings and recommendations

• Provide all raw data in electronic format (CSV/Excel)

3. SCOPE SUMMARY

Item	Quantity
Total Piping Lines	18
Total CML Locations	150
Estimated Field Days	4
Previous Survey Date	October 2019

4. TECHNICAL REQUIREMENTS

4.1 Applicable Codes and Standards

• API 570 - Piping Inspection Code

• API 574 - Inspection Practices for Piping System Components

• ASME B31.3 - Process Piping (for t-min calculations)

• ASME Section V, Article 5 - Ultrasonic Examination Methods

• GLCP-NDT-001 - Site-Specific NDE Requirements (Attachment B)

4.2 Equipment Requirements

All ultrasonic thickness gauges shall be digital instruments capable of 0.001" resolution with data logging capability. Calibration shall be verified daily using NIST-traceable step blocks. Current calibration certificates shall be provided prior to mobilization.

4.3 Personnel Qualifications

All inspection personnel shall be qualified to ASNT SNT-TC-1A or equivalent. Minimum qualification: UT Level II. Lead inspector shall have minimum 5 years experience in refinery/petrochemical piping inspection. All personnel shall complete GLCP site-specific safety orientation prior to work commencement.

5. SCHEDULE

Milestone	Date
RFQ Issue Date	October 15, 2024
Questions Due	October 18, 2024
Proposal Due Date	October 22, 2024
Anticipated Award	October 25, 2024
Kick-off Meeting	October 29, 2024
Field Work Window	November 4-7, 2024
Draft Report Due	November 14, 2024
Final Report Due	November 21, 2024

6. DELIVERABLES

The Contractor shall provide the following deliverables:

Deliverable	Due Date
Draft Inspection Report	Within 5 business days of field work completion
Final Inspection Report (PDF)	Within 2 business days of GLCP comments
Raw Data Files (CSV/Excel)	With draft report
Photographs (organized by CML)	With draft report
Calibration Certificates	Prior to mobilization
Personnel Certifications	Prior to mobilization
Daily Field Reports	End of each work day

7. SAFETY REQUIREMENTS

All Contractor personnel shall comply with GLCP safety requirements including but not limited to: completion of site-specific safety orientation, daily Job Safety Analysis (JSA) review, valid work permits for all activities, and adherence to all posted safety signage and procedures. Personal protective equipment requirements include: hard hat, safety glasses, steel-toed boots, FR clothing, and H2S monitor (provided by GLCP).

8. PROPOSAL REQUIREMENTS

Proposals shall include the following:

• Company qualifications and relevant experience

• Proposed inspection team with certifications

• Equipment list with calibration status

• Detailed work plan and schedule

• Lump sum pricing with breakdown by task

• Rate schedule for potential additional work

• Sample inspection report from similar project

• Three (3) references from similar projects

• Proof of insurance ($2M general liability minimum)

9. ATTACHMENTS

• Attachment A - Piping Line List and CML Summary

• Attachment B - GLCP-NDT-001 Site-Specific Requirements

• Attachment C - Previous Survey Data (2019)

• Attachment D - Piping Isometrics with CML Locations

• Attachment E - Unit Plot Plan

— End of RFQ Body —

ATTACHMENT A

Piping Line List and CML Summary

Line Number	Service	Size	Material	CMLs
2-RF-102	Reflux	2"	316SS	7
2-RV-102	Regen Overhead	2"	A106 Gr.B	6
2-ST-101	Reboiler Steam	2"	A106 Gr.B	6
3-CW-101	Amine Cooler CW	3"	A106 Gr.B	6
3-CW-102	Amine Cooler CW	3"	A106 Gr.B	5
3-RF-101	Reflux	3"	316SS	9
3-RV-101	Regen Overhead	3"	A106 Gr.B	8
4-LA-101	Lean Amine Supply	4"	A106 Gr.B	9
4-LA-102	Lean Amine Supply	4"	A106 Gr.B	8
4-LA-104	L/R Exchanger	4"	A106 Gr.B	10
4-RA-101	Rich Amine	4"	A106 Gr.B	12
4-RA-102	Rich Amine	4"	A106 Gr.B	11
4-RA-104	L/R Exchanger	4"	A106 Gr.B	8
6-LA-103	Lean Amine Header	6"	A106 Gr.B	10
6-RA-103	Rich Amine Header	6"	A106 Gr.B	14
6-SG-101	Sour Gas Inlet	6"	A106 Gr.B	8
6-SG-102	Sour Gas Inlet	6"	A106 Gr.B	6
8-TG-101	Treated Gas	8"	A106 Gr.B	7
TOTAL				**150**

Notes:

- All piping is carbon steel (A106 Gr.B) except 3-RF-101 and 2-RF-102 which are 316SS
- Rich Amine lines (RA) are Schedule 80 due to corrosive service
- CML locations shown on isometric drawings in Attachment D