

instructions. Alignment shall be checked after (a) levelling, (b) after joining with other parts of the Plant and (c) after initial operation of each individual piece of Plant. Any misalignment detected at any stage must be corrected immediately and before proceeding with the next steps of installation.

1.1.32 Welding

- A. Welding alloys shall be nobler (i.e. Cathodic) than at least one of the joined metals. Also, these alloys shall be compatible to both the other metals, and to the conductive medium for immersed installation.
- B. The Electrical Conductivity of the Storm water/ Groundwater are a guide to its total dissolved solids (TDS) Content. The Contractor is required to consider the value of the expected EC in the locality to ensure provision of effective Anodic/ Coating Protection systems for the fabricated equipment and plants to be supplied and installed.
- C. Together with the description of working methods for welding the Contractor shall submit full details of the professional qualifications and experience of the personnel employed. The Contractor shall engage on Site only such certified welders that have passed the tests specified by International and National Standards for welding. All works shall be executed under the supervision of an experienced welding engineer. The working methods shall include a detailed description of the system proposed for the storage of material, control and treatment of consumables, heat treatment, non-destructive testing, spectrographic material checks on weld and parent material, repair and general quality control.
- D. Before welding works commence the Contractor shall submit to the Engineer a list of all electrodes and consumables to be used in the Works. Electrodes and consumables shall be in conformity with the approved Standards and shall be suitable for their intended use.
- E. In case of weld cracking, and prior to any repair, the Engineer may require that a full investigation shall be made in order to locate the cause/source of such cracking.

1.1.33 Temporary Supports

- A. The Contractor shall be responsible for temporary supports, props and packing required to facilitate erection and alignment. He shall also ensure that all supporting parts of the civil work structure are able to support any temporary or permanent