

AMENDMENT OF SOLICITATION/MODIFICATION OF CONTRACT			1. CONTRACT ID CODE	PAGE OF PAGES
			J	1 6
2. AMENDMENT/MODIFICATION NO. 0004	3. EFFECTIVE DATE 04-Jun-2004	4. REQUISITION/PURCHASE REQ. NO. W25PHS-4030-6670	5. PROJECT NO.(If applicable)	
6. ISSUED BY US ARMY ENGINEER DISTRICT, PHILADELPHIA CONTRACTING DIVISION WANAMAKER BUILDING 100 PENN SQUARE EAS PHILADELPHIA PA 19107-3390	CODE W912BU	7. ADMINISTERED BY (If other than item 6) US ARMY ENGINEER DISTRICT, PHILADELPHIA POC: KARYN JOHNSON WANAMAKER BUILDING 100 PENN SQUARE EAST PHILADELPHIA PA 19107		CODE E5CTSKDJ
8. NAME AND ADDRESS OF CONTRACTOR (No., Street, County, State and Zip Code)			X	9A. AMENDMENT OF SOLICITATION NO. W912BU-04-B-0013
			X	9B. DATED (SEE ITEM 11) 28-Apr-2004
				10A. MOD. OF CONTRACT/ORDER NO,p
				10B. DATED (SEE ITEM 13)
CODE	FACILITY CODE			
11. THIS ITEM ONLY APPLIES TO AMENDMENTS OF SOLICITATIONS				
<input checked="" type="checkbox"/> The above numbered solicitation is amended as set forth in Item 14. The hour and date specified for receipt of Offer <input checked="" type="checkbox"/> is extended, <input type="checkbox"/> is not extended.				
Offer must acknowledge receipt of this amendment prior to the hour and date specified in the solicitation or as amended by one of the following methods: (a) By completing Items 8 and 15, and returning <u>1</u> copies of the amendment; (b) By acknowledging receipt of this amendment on each copy of the offer submitted; or (c) By separate letter or telegram which includes a reference to the solicitation and amendment numbers. FAILURE OF YOUR ACKNOWLEDGMENT TO BE RECEIVED AT THE PLACE DESIGNATED FOR THE RECEIPT OF OFFERS PRIOR TO THE HOUR AND DATE SPECIFIED MAY RESULT IN REJECTION OF YOUR OFFER. If by virtue of this amendment you desire to change an offer already submitted, such change may be made by telegram or letter, provided each telegram or letter makes reference to the solicitation and this amendment, and is received prior to the opening hour and date specified.				
12. ACCOUNTING AND APPROPRIATION DATA (If required)				
13. THIS ITEM APPLIES ONLY TO MODIFICATIONS OF CONTRACTS/ORDERS. IT MODIFIES THE CONTRACT/ORDER NO. AS DESCRIBED IN ITEM 14.				
A. THIS CHANGE ORDER IS ISSUED PURSUANT TO: (Specify authority) THE CHANGES SET FORTH IN ITEM 14 ARE MADE IN THE CONTRACT ORDER NO. IN ITEM 10A.				
B. THE ABOVE NUMBERED CONTRACT/ORDER IS MODIFIED TO REFLECT THE ADMINISTRATIVE CHANGES (such as changes in paying office, appropriation date, etc.) SET FORTH IN ITEM 14, PURSUANT TO THE AUTHORITY OF FAR 43.103(B).				
C. THIS SUPPLEMENTAL AGREEMENT IS ENTERED INTO PURSUANT TO AUTHORITY OF:				
D. OTHER (Specify type of modification and authority)				
E. IMPORTANT: Contractor <input type="checkbox"/> is not, <input type="checkbox"/> is required to sign this document and return _____ copies to the issuing office.				
14. DESCRIPTION OF AMENDMENT/MODIFICATION (Organized by UCF section headings, including solicitation/contract subject matter where feasible.) This is Amendment 0004 for Solicitation W912BU-04-T-0013: 1. The date and time set for receipts of bids is extended to 2:15 p.m., Tuesday, June 15, 2004. 2. Section C, pages C-28 through C32 are deleted in their entirety. Substitute therefore with the attached pages number C-28 thru C-32 annotated Amendment 0004.				
Except as provided herein, all terms and conditions of the document referenced in Item 9A or 10A, as heretofore changed, remains unchanged and in full force and effect.				
15A. NAME AND TITLE OF SIGNER (Type or print)			16A. NAME AND TITLE OF CONTRACTING OFFICER (Type or print)	
			TEL: _____ EMAIL: _____	
15B. CONTRACTOR/OFFEROR	15C. DATE SIGNED	16B. UNITED STATES OF AMERICA		16C. DATE SIGNED
_____ (Signature of person authorized to sign)		BY _____ (Signature of Contracting Officer)		

C590 PIPELINE SUPPORT ITEMS

A. CONTRACT DRAWINGS

Drawing 633-A215-01, Rev -
Drawing 633-A590-01, Rev -

B. SCOPE

The work covered under this clause consists of providing all materials, labor, plant, and equipment and delivering pipe pedestals, bearing collars, pivot bearings with pipe saddle, and pipe bands for dredge pontoon pipe as specified herein and/or as shown on the Contract Drawing 633-A590-01, Rev.-. One of each item shall be installed on the twenty pontoons as shown on the Contract Drawing 633-A215-01, Rev. -. Five of each item shall be delivered as spares with the delivery of the finished pontoons.

1. Items to be Furnished

<u>Item</u>	<u>Description</u>	<u>Qty.</u>	<u>Material</u>
001	Pipe Pedestal	25	ASTM A27/A27M Grade N-2
002	Bearing Collar	25	ASTM A27/A27M Grade N-2
003	Pivot Bearing/Pipe Saddle	25	ASTM A27/A27M Grade N-2
004	Pipe Band	25	ASTM A36/A36M

2. Casting Quality Control

The clause applies to all castings and should be coordinated with Clause C025 and E03.

The Contractor shall establish and maintain quality control for the work specified in this clause to assure compliance with requirements and maintain records of his quality control for all construction operations including, but not limited to the following:

- a. Inspection on delivery of all supplies and materials.
- b. Inspection at the work site to assure use of specified materials and equipment.
- c. Casting, fabrication, welding, installation, and testing.

3. Applicable Publications

The publications listed below form a part of this clause to the extent referenced. The publications are referred to in the text by basic designation only.

American Society for Testing and Materials (ASTM)

ASTM A27/A27M-03	Standard Specification for Steel Castings, Carbon, for General Application
ASTM A36/A36M-04	Standard Specification for Carbon Structural Steel
ASTM E94-04	Standard Guide for Radiographic Examination
ASTM E186-98	Standard Reference Radiographs for Heavy-Walled (2 to 4 1/2-in. (51 to 114-mm)) Steel Castings
ASTM E280-98	Standard Reference Radiographs for Heavy-Walled (4 1/2 to 12-in. (114 to 305-mm)) Steel Castings
ASTM E446-98	Standard Reference Radiographs for Steel Castings Up to 2 in. (51 mm) in Thickness
ASTM E1444-01	Standard Practice for Magnetic Particle Examination

4. General Requirements

See Clause C025, Contractor Quality Standards and Clause E03 Quality Control and Inspection.

C. PIPE BAND

The pipe band is to be rolled from A36 steel plate.

D. CASTINGS

Steel used in construction of the pipe pedestal, pivot bearing with pipe saddle, and the bearing collar shall comply with the requirements of ASTM Specifications ASTM A27/A27M, Grade N-2,.

The structure of the metal in the castings shall be homogeneous and free from excessive nonmetallic inclusions. Excessive segregation of impurities or alloys at critical points in castings will be cause for rejection.

E. PATTERNS

The Contract Drawing 633-A590-01, Rev.-, details the final product. The patterns for the castings shall be developed to produce steel castings that are true to the dimensions shown on the Contract Drawing, within a tolerance of plus or minus 1/816-inch.

Care shall be taken to avoid sharp corners or abrupt changes in cross section and ample fillets shall be used in the construction of patterns. Draft and increases in pattern thicknesses shall be added as required to conform to the standard foundry practice applied and as necessary to ensure that all metal thicknesses of the finished castings conform to the dimensions shown on the Contract Drawing and are within the tolerances indicated. All patterns shall become the property of the Government and not be used for work under any other contract unless specifically authorized by the Contracting Officer. The patterns shall be delivered with the completed pontoons to the U.S. Army Corps of Engineers, ST. Louis District identified in Section F, Clause F02.

F. EXECUTION

1. Machining

The castings to be furnished under this clause shall be finished, except as indicated herein, by the Contractor by machining and/or grinding, drillings, and tapping to dimensions shown on the Contract Drawing. The dimensions of the finished surfaces of the steel castings shall be true to the dimensions shown within a tolerance of plus or minus 1/~~8~~¹⁶-inch.

2. Repair of Defects

~~Repairs to castings shall not be made prior to approval by the COR.~~ The Contractor shall notify the COR with any defects to the castings, digital photographs of the affected areas, and recommendations for repairing the defect. The repair of defects in castings shall not be accomplished by peening, plugging, or impregnating. Minor surface imperfections not affecting the strength of castings may be welded in the “green” if approved by the inspector. Any defect in the castings that are deemed repairable by the Contractor may be removed and repaired by welding. The defects shall be removed entirely so as not to affect the strength, use, or machinability of the castings when properly welded and stress relieved. The welding procedure shall be in accordance with Clauses C025 and E03. The deposited weld metal shall have a degree of hardness and other mechanical properties comparable to the same quality standards required of the casting, and the areas shall be suitably marked to facilitate inspection.

3. Identification Marking

Castings shall bear the producer’s name or symbol and pattern mark, except castings of such small size as to mark such marking impracticable. Castings weighing over 50 pounds shall have the heat or foundry lot number cast or stamped on the casting.

4. Tests

a. Testing of Material: The Contractor shall make, or have made at his expense, inspections and tests to determine that the materials furnished meet the requirements of these specifications. A testing agency capable of performing the required tests shall be selected by the Contractor and approved in writing by the COR. Certified test reports, along with all radiographic films and interpretations shall be furnished to the COR prior to the installation of castings on the pontoons. The Contractor shall notify the COR with any defects to the castings, digital photographs or radiographic films and interpretations of the affected areas, and recommendations for repairing the defect. Any defective casting shall be replaced or repaired by welding upon COR approval as necessary and retested, all at the Contractor’s expense.

b. Radiographic Testing: The COR may select four samples from each cast item for radiographic testing. The selection of sample by the COR shall be made at random after the castings have been poured. The Contractor shall determine the areas on each casting item to be inspected by radiographic examination and indicate them on the required drawings during the Engineering Phase (Phase II). The radiographic examination shall be performed by the testing agency approved by the Contracting Officer.

If this examination indicates any defective areas of tested samples, the Contractor shall have a testing agency radiograph those areas on additional castings at the Contractor's expense. The radiograph test procedure shall conform to the requirements of ASTM E94. Standards of acceptance shall be in accordance with the provisions of ASTM E446 for castings up to 2-inches thick, ASTM E186 for castings between 2 and 4 ½-inches thick, and ASTM E280 for casting between 4 ½ and 12-inches thick. Sufficient radiographs shall be taken of sample castings, as describe above, to demonstrate to the Contracting Officer that the castings are sound, homogeneous and comply with this specification. Categories D and E with severity level of 1 will be acceptable only if the angle between defect and direction of the principle stress is not greater than 20 degrees. Each casting shall be adequately marked, if not already marked by the foundry, to permit correction of radiographic films to their castings. The Contractor shall notify the COR with any defects to the castings and recommendations for repairing the defect. Any defective casting shall be replaced or repaired by welding as upon COR approval necessary and retested, all at the Contractor's expense

c. Magnetic Particle Testing: Four samples from each cast item, not chosen for Radiographic Testing, shall undergo magnetic particle examination. The magnetic particle test methods and acceptance standards shall be in accordance with ASTM E1444. The Contractor shall notify the COR with any defects to the castings and recommendations for repairing the defect. Any defective casting shall be replaced or repaired by welding as necessary and retested, all at the Contractor's expense

~~d. Acceptance: The Contractor shall supply one of each casting and one pipe band to the Government for installation and testing on an existing pontoon prior to full production of the castings. The initial castings and pipe band shall be transported to the final destination identified in Clause F02 at the Contractor's expense. The Government shall install the test castings and pipe band to ensure a proper fit. The Contractor may only begin production of the remaining castings and pipe bands following written authorization from the COR.~~

~~The castings shall be satisfactorily cleaned for their intended use when offered for inspection. When each shipment of casting has been delivered to the Contractor's facility, the Government will make the final inspection and acceptance. All material and workmanship shall be subject to inspection, examination and test by the COR. When the COR determines that the casting has been satisfactorily completed, it will be accepted for installation.~~