

City Creek Water Treatment Plant - BRIC

2200 City Creek Canyon Road
Salt Lake City, UT 84116

Haskell Project No. 6704187
90% GMP Bid Package

Addendum #3

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RFI 229 Response:

Purpose of the shrink wrap requirement defined in Section 40 05 59.23 Paragraph 1.06.B.1 is primarily to prevent exposure to salts and other contaminants during shipping between the point of fabrication and the job site. The risk typically exists during the winter months due to salt spray. Manufacturer may choose means of protecting equipment. In lieu of Paragraph 1.06 as it is currently written, the Paragraph shall read as follows:

1.06 Stainless Steel Cleaning

- A. All Stainless Steel components shall be protected, cleaned and tested as follows:
1. Stainless steel components shall be protected from carbon steel contamination during fabrication and assembly as defined in Paragraph 8 of ASTM A380. Surfaces surrounding joints shall be cleaned as discussed in Paragraph 6.3 prior to welding. Careful adherence to good stainless steel practices may minimize descaling and cleaning requirements.
 2. Welding temperatures shall be carefully monitored as to not sensitize the material and thereby increase the risk of intergranular corrosion.
 3. After completion of welding, all surfaces shall be descaled as necessary using methods described in Paragraph 5 of ASTM A380. Weld surfaces (including surfaces within the heat affected zone of the weld) shall be descaled using a pickling solution as discussed in Paragraph 5.2. Surfaces shall be thoroughly rinsed in accordance with

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Paragraph 5.2.5.

4. Following descaling, all surfaces shall be cleaned as necessary using methods described in Paragraph 6 of ASTM A380. Final cleaning of all surfaces shall be in accordance with Paragraph 6.4.

5. Upon completion of cleaning, all surfaces shall be visually inspected in accordance with Paragraph 7.2.1 of ASTM A380 prior to testing. Any gross indications of iron as defined in Paragraph 7.2.1.1 shall be cleaned as necessary.

6. Testing to ensure proper passivation and cleaning has occurred shall be as defined in Paragraph 7.2.5 of ASTM A380. First, perform a water-wetting and drying test on all stainless-steel surfaces in accordance with Paragraph 7.2.5.1 of ASTM A380 or a Practice A - Water immersion Test as defined in Paragraph 14.1 of ASTM A967. Failed areas shall be re-cleaned and retested using a Copper Sulfate Test in accordance with Paragraph 7.2.5.3 or Practice D - Copper Sulfate Test found in Paragraph 14.4 of ASTM A967. Any remaining failed areas shall be cleaned using a nitric acid solution in accordance with Table A2.1 Part II of ASTM A380 followed by retesting of all affected areas using a Copper Sulfate Test.

7. Manufacturer shall notify Engineer of any failed tests. No equipment shall be shipped without certification that all surfaces have passed inspection and testing. Manufacturer shall remove test chemical in accordance with the testing manufacturers recommendations. no visible indications of iron may exist prior to shipment. Any evidence of rust or blooming upon arrival on site shall be the responsibility of the manufacturer to address. Manufacturer responsible to select proper shipping protection to prevent exposure to contaminants as needed.

Note: The intent of these requirements are not to impose heavy cleaning or passivation requirements on the Manufacturer beyond their standard practice, but rather for the manufacturer to follow standard industry practice in protecting stainless steel during the manufacturing process. Requiring expensive cleaning process that may not be required if the manufacturer follows industry standard practice, Engineer requires minimal testing at end of manufacturing process to verify the absence of free iron on stainless surfaces, only imposing more significant cleaning and testing requirements should the components fail initial testing. Should requirements still impose significant c-osts to the equipment, Manufacturer shall provide additional information for the Engineer to consider in a separate RFI.

RFI 221 Response:

[1] ASTM A480 does not define a surface roughness associated with a 2B finish. Standard provides an explanation for a 2B finish as "a smooth, moderately reflective cold-rolled annealed and pickled or descaled finish typically produced by imparting a final light cold-rolled pass using polished rolls." It does not define a surface roughness for a 2B finish. Typically, this requirement applies to the material supplied by the mill rather than the finished product.

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[2] In this case, the intent is to have the manufacturer provide components that are clean and overall uniform in appearance (i.e. surfaces don't contain deep scrapes or gouges). Thus, the shaft finish defined in the question is acceptable for the shafts. All other stainless-steel components shall be reasonably uniform and smooth in appearance (free of burrs, sharp edges, dents, etc. with uniform thickness and smooth surface).

The following shall be added for cleaning and passivation requirements for all stainless-steel components as Paragraph 2.08 in Section 46 41 42.

2.08 Stainless Steel Cleaning

A. All Stainless Steel components shall be protected, cleaned and tested as follows:

1. Stainless steel components shall be protected from carbon steel contamination during fabrication and assembly as defined in Paragraph 8 of ASTM A380. Surfaces surrounding joints shall be cleaned as discussed in Paragraph 6.3 prior to welding. Careful adherence to good stainless steel practices may minimize descaling and cleaning requirements.
2. Welding temperatures shall be carefully monitored as to not sensitize the material and thereby increase the risk of intergranular corrosion.
3. After completion of welding, all surfaces shall be descaled as necessary using methods described in Paragraph 5 of ASTM A380. Weld surfaces (including surfaces within the heat affected zone of the weld) shall be descaled using a pickling solution as discussed in Paragraph 5.2. Surfaces shall be thoroughly rinsed in accordance with Paragraph 5.2.5.
4. Following descaling, all surfaces shall be cleaned as necessary using methods described in Paragraph 6 of ASTM A380. Final cleaning of all surfaces shall be in accordance with Paragraph 6.4.
5. Upon completion of cleaning, all surfaces shall be visually inspected in accordance with Paragraph 7.2.1 of ASTM A380 prior to testing. Any gross indications of iron as defined in Paragraph 7.2.1.1 shall be cleaned as necessary.
6. Testing to ensure proper passivation and cleaning has occurred shall be as defined in Paragraph 7.2.5 of ASTM A380. First, perform a water-wetting and drying test on all stainless-steel surfaces in accordance with Paragraph 7.2.5.1 of ASTM A380 or a Practice A - Water immersion Test as defined in Paragraph 14.1 of ASTM A967. Failed areas shall be re-cleaned and retested using a Copper Sulfate Test in accordance with Paragraph 7.2.5.3 or Practice D - Copper Sulfate Test found in Paragraph 14.4 of ASTM A967. Any remaining failed areas shall be cleaned using a nitric acid solution in accordance with Table A2.1 Part II of ASTM A380 followed by retesting of all affected areas using a Copper Sulfate Test.

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7. Manufacturer shall notify Engineer of any failed tests. No equipment shall be shipped without certification that all surfaces have passed inspection and testing. Manufacturer shall remove test chemical in accordance with the testing manufacturers recommendations. no visible indications of iron may exist prior to shipment. Any evidence of rust or blooming upon arrival on site shall be the responsibility of the manufacturer to address.

Note: The intent of these requirements are not to impose heavy cleaning or passivation requirements on the Manufacturer beyond their standard practice, but rather for the manufacturer to follow standard industry practice in protecting stainless steel during the manufacturing process. Requiring expensive cleaning process that may not be required if the manufacturer follows industry standard practice, Engineer requires minimal testing at end of manufacturing process to verify the absence of free iron on stainless surfaces, only imposing more significant cleaning and testing requirements should the components fail initial testing. Should requirements still impose significant costs to the equipment, Manufacturer shall provide additional information for the Engineer to consider in a separate RFI.

B. Clarifications

- a. Hard Rock is being defined a rock that cannot be excavated by a 330-sized excavator equipped with "Tiger Teeth".
- b. Haskell will no longer be submitting any additional RFIs. The latest RFI Log included in this addendum has all the RFIs submitted, including RFIs are still awaiting responses.

*Please acknowledge you've received this addendum in your proposal.