



Works Information

Generation
Duvha Power Station

Title: **REFURBISHMENT WORKS
INFORMATION FOR BOILER
AND TURBINE SAFETY VALVES**

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1. INTRODUCTION

Duvha Power Station units 1, 2, 4, 5 and 6 comprise of identical Turbine and Boiler House that consist of the HP Heaters, LP Heaters, DA/DST Vessels, Feed Water, Auxiliary Steam Range, Soot Blower, FRF, BFPT and MOT Safety Valves that need to be refurbished during planned outages. The refurbishment of the Safety Valves during planned outages will increase plant availability and reliability as well as production performance.

2. SUPPORTING CLAUSES

2.1 SCOPE

The *Works* consists of the Provision of Manpower and Consumables to perform Safety and Pressure Relief Valves full refurbishment during outages. Therefore, the SOW will cover outages on Turbine and Boiler Auxiliary areas and the scope of work must be performed by the *Contractor* according to the information stipulated in this contract document. A Working Instruction will be issued in writing by the *Employer's* engineers before any work commences.

2.1.1 Purpose

The purpose of this document is to provide the *Contractor* with all the details required to perform the work as defined in the scope of work and to meet the expectations of the *Employer*.

2.1.2 Applicability

This document applies to the valves in the Boiler and Turbine Plants at Duvha Power Station.

2.2 NORMATIVE/INFORMATIVE REFERENCES

Parties using this document shall apply the most recent edition of the documents listed in the following paragraphs.

2.2.1 Normative References

- | | | |
|-----|---------------|---|
| [1] | 240-69258336 | Pressure Relieving Safety Devices Standard |
| [2] | 240-106628253 | Standard for Welding Requirements on Eskom Plant |
| [3] | 240-84979413 | Maintenance and Repair of High Temperature and High-Pressure Valves and Fittings Standard |
| [4] | OHS Act: | Occupational Health and Safety Act 85 of 1993 (Pressure Equipment Regulation 2009). |
| [5] | ISO 9001 | Quality Management Systems |

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- [6] SANS 347 Standard specification for the categorization and conformity assessment criteria for all pressure equipment.
- [7] 240-168966153 Tender Technical Evaluation Procedure
- [8] 240-83539994 Standards for Non-Destructive Testing on Eskom Plant.
- [9] 240-105658000 Supplier Management Quality Specification

2.2.2 Informative References

- [10] 03A-ENG0001 Outage Scope Management Guideline

2.3 DEFINITIONS

For the purposes of this *Works* information, the following definitions shall apply:

Definition	Description
Safety Valve	A spring-operated valve that operates by means of static upstream pressure against a spring. The opening is characterised by rapid action or “popping” and mostly used for compressive fluids. The valves are designed to provide immediate relief of over-pressure for any fluid (compressible fluids like air, gasses, steam) which could cause an explosion if over-pressurised.
Relief Valve	A spring-operated valve that operates by means of static upstream pressure against a spring. The opening travel is in proportion to the pressure increase to operating pressure. The Relief Valves are designed to relieve excessive pressure in systems containing incompressible fluids.
Safety Relief Valve	A spring-operated pressure relief valve that can be used either as relief valve or safety valve depending on application.
<i>Employer</i>	Eskom Duvha Power Station
Construction	Materials, fabrication, design, modification, repair, installation, examination, inspection, testing and certification
Eskom Welding Co-ordinator	A Welding Engineer/Technologist appointed by the employer to oversee all welding activities within Eskom SOC Holdings Ltd.
Low Pressure equipment	Equipment regulated by the PER (>50 kPa) and equipment that falls under Sound Engineering Practice

High pressure equipment	Equipment for the conveyance of steam, water, gases or other fluids whose design pressure equals or exceeds 2.0 MPa and/or whose design temperature equals or exceeds 200 °C.
Pressure Equipment	A steam generator, pressure vessel, piping, pressure accessory and safety accessory (device designed to protect pressure equipment), transportable gas container, and fire extinguisher and includes, but is not limited to an accumulator, a hot-water geyser and hyperbaric chambers.
Procedure Qualification Record (PQR)	A record comprising all relevant data from the welding of a test piece needed for the approval of a welding procedure specification as described in the ASME Boiler and Pressure Vessel Code Section IX
Welding Procedure Qualification Record (WPQR)	A record comprising all relevant data from the welding of a test piece needed for the approval of a welding procedure specification as described in the welding specification BS EN ISO 15614
Welding Procedure Specification (WPS)	A document meeting the requirements of BS EN 15609 or ASME Boiler and Pressure Vessel Code Section IX and derived from the WPQR/PQR that sets out in detail the required variables for a specific application to assure repeatability
Welder Qualification Record (WQR)	A document meeting the requirements of SANS 9606 or ASME Boiler and Pressure Vessel Code Section IX, that presents the results of the approval testing of a welder to perform a fusion welding process.

2.3.1 Disclosure Classification

Controlled Disclosure: Controlled Disclosure to external parties (either enforced by law, or discretionary).

2.4 ABBREVIATIONS

Abbreviation	Meaning Given to the abbreviation
AIA	Approved Inspection Authority
AP	Appointed Person
AS	Authorized Supervisor
BFPT	Boiler Feedpump Turbine
DA	Dearator
DST	Dearator Storage Tank
EA	Each

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EFP	Electrical Feedpump
HP	High Pressure
HT	Hardness Testing
LAR	Limited Access Register
LH	Left Hand
LP	Low Pressure
M/Level	Meter/Level
NB	Nominal Bore
NCR	Non-Conformance Report
NDE	Non-Destructive Evaluation
NDT	Non-Destructive Testing
N/A	Not Applicable
PMI	Positive Material Identification
PQR	Procedure Quality Record
PT	Dye-Penetrant Testing
PTW	Permit to Work
PWHT	Post Weld Heat Treatment
QA	Quality Assurance
QC	Quality Control
QCP	Quality Control Plan
Qty	Quantity
RH	Right Hand
RP	Responsible Person
SOW	Scope of Work
WPQR	Welding Procedure Quality Record
WPS	Welding Procedure Specification

2.5 ROLES AND RESPONSIBILITIES

The roles and responsibilities are as defined in 03A-ENG0001 Outage Scope Management Guideline.

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3. WORKS INFORMATION

3.1 General Works Description

1. The *Works* is for full refurbishment on existing safety valves and pressure relief valves.
2. The *Works* include provision of manpower, consumables, and anything else needed to perform full refurbishment of the valves, including welding and machining during planned Outage(s).
3. A QCP must be generated and approved by the *Employer's* engineer, QC inspector and AIA, before work commences.
4. All valves to be removed from site, refurbished and installed back on exact positions where they were removed. No swapping of valves positions will be tolerated, and non-compliance will result in NCR(s) being issued.
5. The *Contractor* to provides all equipment and associated engineering services including design requirements and design calculations as required by the applicable plant area design code to fulfil and execute the requirements of the *Works* Information (SOW) and to provide a fully operational system.

3.2 Standard Works to be carried out on every valve:

1. Strip and visually inspect the valves. This includes visual inspections of valve bodies, seats, spindles and internals for wear, damage or cracks and note all findings (photos must be attached in the inspection reports as well).
2. Clean all spare parts (this includes studs/bolts, nuts & holes threads etc).
3. Inspect spindles for runout and straightness, score marks and any damage to seating areas.
4. Inspect and surface crack test body seats.
5. Conduct NDT (Dye Pen) on the seat nozzle of the safety valves.
6. Inspect springs for physical damage.
7. Verify spring tensions and if damages it must be replaced.
8. Formal written repair recommendations to be done for Eskom Engineering acceptance.
9. Compile refurbishment QCP. Eskom Engineering to accept.
10. Replace all damaged components with new ones where necessary (Eskom Engineering to be consulted for approval before any replacement of components).
11. Lap and blue check body seats and spindle seats.
12. Pressure test valves to correct set-pressure values as provided by the *Employer*.
13. Cut gaskets of flanges to correct sizes. The *Contractor* to use correct gasket and take note that the valves operate on either HP or LP areas (Systems Pressure Ratings and Pressure Test Ratings will be provided by the *Employer*).

14. Sandblasting of the bodies external and painting to be done on all safety valves after all repairs are completed.
15. Replace all soft goods (O-rings, gaskets etc.)
16. The *Contractor* supplies all the required spares to complete the *Works*.
17. Do valve pressure setting and lifting test. Install lead seal.
18. Eskom`s Engineer, QC Inspector and Third-Party Inspector (AIA) to witness all inspections & pressure testing and put additional recommendations where necessary.
19. Re-install valve back in the plant at Duvha Power Station.
20. Compile and submit data back. Data pack to be approved by Eskom Engineering or QC and submitted to client within 14 days of work completion. Data pack shall include the following as a minimum:
 - Strip down inspection report and sizes
 - Repair recommendations report
 - QCP
 - All NDE and welding reports
 - Pressure test and setting certificates
 - Final certificate of acceptance and compliance
 - All NCR's

3.3 Seat re-stelliting

In instance where seats re-stelliting is required, the following must be adhered to:

1. Take measurements on all components, record tolerances on both seats and record before machining or hard-facing/stellite removal.
2. Valves re-stelliting will range between 3mm and 6mm depending on the valve's size and operating conditions or application.
3. The exact re-stelliting thickness must be discussed and approved by *Employer's* engineer in line with the relevant qualified procedure.
4. The re-stelliting will therefore be done on a case-to-case basis depending on the extent of damage on a particular valve. The thickness of stellite overlay must be within the ranges qualified on the welding procedure.
5. Upon completion of re-stelliting, *Contractor* must carry out Dye Pen testing on the seats as well as the valve body through an independent company.
6. All welding procedure qualifications that will be used (overlay for base material repair and stellite 6 overlay as well as seal welding) must be submitted with the QCP for approval.

7. Any heat treatment (as per the qualified WPS) will be done using calibrated recorders to generate the heat treatment chart. The HT chart and calibration certificate must be included in the final data pack.
8. After NDE is completed valves to be blue checked.

3.4 Rigging and Transport Requirements

1. All rigging to be done in accordance with the OHSA.
2. All lifting equipment to do the *Works* to be supplied and must have the necessary load and test certificates.
3. All valves to be identified and marked before removing (AKZ Numbers and full descriptions to be used).
4. *Contractor* shall do all required rigging to remove valves that needs to be removed for offsite repairs.
5. If valves require blocking before being removed as deemed necessary by *Employer*, a method statement for blocking shall be provided by the *Contractor* for approval by the *Employer*.
6. Valves will be collected from Duvha Power Station to the *Contractor's* workshop by the *Contractor*. Project Manager will do all necessary paperwork (Picking/Exit Ticket).

3.5 NDT Requirements

1. All NDTs must be conducted by an Eskom approved NDT company in position of an approval letter.
2. All welding NDT is performed according to the requirements of the *Employer* as detailed in the Standard 240-8353994.

4. WELDING REQUIREMENTS

4.1 Welding Statutory Requirements

There are several statutory requirements, governing rules, standards and specifications related to welding that are always applicable when the *Contractor* conducts welding activities on the *Employer's* equipment or machinery. These include:

- OHS-Act.
- SANS 347.
- Relevant area design and /or construction codes.
- Latest Eskom Welding Standard 240-106628253 and *Employer's* Standards.

4.2 WPS and PQR Requirements

1. Before commencing with the work, the *Contractor* must submit WPS and WPQR to the *Employer's* responsible Welding Agent/Engineer/Technologist for approval.
2. Verified copies of all WPS's used during the contract is included in the maintenance records.
3. Due to the criticality of the *Works*, it is very important that every WPS is supported by a valid WPQR/PQR for all Level I and II area work and is also recommended in the case of Level III area work.
4. The PQR/WPQR shall be approved by a registered IWE or IWT with minimum qualifications as defined in 240-106628253.

The following information must appear on the WPQR/PQR:

- a) Heat input (defined in BS EN 1011-1): the speed of weld progression must be recorded in mm/s; the weld current range must be measured with a clip-on gauge/ tong tester; the open circuit voltage of the welding machine and the weld voltage range shall be measured with a volt-meter (multi meter). (Provide practical range and elaborate around arc energy, HI equipment characteristic etc.). When welding machines with pulsed mode is used; in which case the heat input as calculated by the equipment needs to be recorded.
 - b) Commercial trade name of the welding consumable.
 - c) The tensile strength of the coupons as recorded during the tensile tests. It is recommended that a copy of the actual graph generated during execution of the tensile tests shall be part of the permanent record package for the reviewer to check on the results.
 - d) The heat treatment chart (where applicable) shall form part of the permanent record of the WPQR/ PQR.
 - e) Material certificates for both filler and parent material(s) shall be part of the permanent record of the WPQR/PQR.
 - f) The impact test results (where applicable)
5. The *Employer* reserves the right to review a WPS already verified by the AIA, prior to commencement of fabrication.
 6. The information on the WPS accurately reflects the parameter ranges as reported on the WPQR/PQR, to be approved for use on *Employer's* areas. A suitably qualified TPI AIA Company must verify that the data listed in the WPQR/PQR is correctly transferred to the WPS.
 7. Approval of the WPS document by an IWE/IWT is mandatory, with emphasis on the critical evaluation of the technical content suiting the circumstances and requirements of the intended applications.

4.3 Welding Requirements

In addition to fulfilling the regulatory and area safety requirements, the following is required by the *Contractor*:

1. The *Contractor* compiles and submits QCP's / ITP's, Weld maps, PMI reports, PQR's & WPS's for approval by the *Employer's Agent* prior to the commencement of any *Works*.
2. All welding must be done using a BS EN ISO 15614 or ASME IX qualified welding procedure.
3. Welding procedures must be qualified to BS EN ISO 15614 or ASME IX. All WPS's and PQR's must be approved by the company IWE/IWT before submission to Eskom.
4. Welding procedure mechanical test results must be accompanied with the PQR for review by Eskom.
5. All tests as required by the qualification code must clearly demonstrate an increase in the hardness as per stellite consumable data sheet. It must also proof that there will be no dis-bonding between the seat base material and the stellite overlay.
6. The acceptance criteria for all welds will be ISO 5817 quality level B. All the *Works* for send away valves shall be carried out at the *Contractor's/Partner's* premises.
7. Sufficient and appropriate welding documentation approval, verification and control as required by applicable BS EN 3834 Quality level.
8. The requirement of ISO 3834 Part 2 certification of Contractors that work on Safety Critical Area / Level 1&2 area is mandatory. No welding work will be awarded if certification is not available. ISO 3834-2 certificate must include as a minimum material Groups 1, 5, 6 & 8.
9. Material and welding consumable control must be adhered to.
10. Completed data packages and record keeping are required for all work. Any work will only be released once the data pack are fully signed off.

4.4 Welding Personal

1. The *Contractor* must have responsible welding coordinators according to ISO 14731.
2. These are individuals who can competently coordinate and apply good practice in the welding activities carried out by the Contractor.
3. The *Contractor* may be required to supply the *Employer* with a labour force as per activities allocated by the *Employer*. These may include but not limited to quality controller with a Level 2 SAIW Inspector Qualification, qualified welders (ISO 9606 or ASME IX) and welding operators working in accordance with the latest applicable health and safety standard (OHS Act).
4. All qualifications to be in line with the Eskom Welding Standard 240-16628253.

5. NON-CONFORMANCES

1. The *Employer* issues Non-conformance Reports (NCR's) for defects, non-conforming materials, parts, workmanship, or documentation which form part of the permanent quality records.
2. NCRs are submitted to the *Contractor's* Project Manager for the attention of the QA representative or inspection authority. The *Contractor* is obliged to respond by stating the Cause, Corrective Action, Action taken to prevent Recurrence and Effective date.
3. The *Contractor* consequently applies for a concession or production permit when non-conforming materials, components or workmanship are suitable for repair, rework or use as is.
4. The *Employer's* project manager/QA Representative or its authority then issues a concession or production certificate if the materials, components, or workmanship are suitable for repair, rework or use as is.

6. GENERAL REQUIREMENTS FOR THE CONTRACT

1. It is the *Contractor's* own responsibility to get authorized in terms of the Eskom Plant Safety Regulations. The *Contractor* must be fully authorized within 2 months after the contract placement.
2. Constraints on the sequence and timing of work exist due to other contractors also performing work on the same plant. The *Contractor* will liaise and plan with these contractors for access.
3. It is the *Contractor* responsibility to manage the Manpower/Resources as per the activities allocated by the *Employer*. Daily Milestone to be clearly indicated on the Program/ (Indicate the important milestone dates e.g start date and end date of the activity as well as material/spares, NDT date, pressure test date etc).
4. The *Contractor* supplies all equipment required to prepare, cut, machine, transport, and lift, as well as the safety equipment and protective clothing to conduct the *Works* onsite and offsite Duvha Power Station premises.
5. The *Employer* reserves the right to conduct periodic audits of the *Contractor* to ensure compliance with all requirements.
6. The *Employer* reserves the rights to request the *Contractor* to submit proof of qualifications for all the personnel involved in the *Works* at any given time.
7. Only welding, machining and NDE activities can be outsourced to sub-contractors.

7. TENDER RETURNABLES

The following returnable to be supplied for tender evaluation. Take note that subcontractor documentation can also be supplied, it must just clearly be indicated on the tender which sub/contractor will be used.

7.1 Mandatory Returnable

If these are not met the tender will not be evaluated further.

M1). Submit a company profile of the tenderer that intends on executing the physical scope containing:

- **Company main business**
- **Proof of address of main workshop** where safety valves will be refurbished is occupied by the tenderer.
- **Complete Company organogram including**
 - Executive level structure
 - Workshop level structure (indicating years of experience on safety valves)

The tenderer shall be the entity that executes the physical scope, **not a subcontractor with the exception of the acceptable risks** 3.6 Foreseen Acceptable / Unacceptable Qualifications. The tenderer's facilities will be visited for confirmation of their capacity to execute the required scope in M3.

M2). Provide proof of valid, up to date ISO 3834-2 certificate:

- **All pages of the ISO 3834-2 certificate to be submitted. Material Groups 1, 5, 6, 8 must be listed on the certificate.**
- **Submitted certificates with missing pages/material groups will result in tenderers being disqualified.**

NB: Eskom reserves the rights to verify validity of submitted certificates with necessary authorities.

M3). Provide proof of workshop/pressure testing facilities capable of doing both water and air pressure tests

(Photos of facilities, instrumented pressure test and safety valve calibration rig and address must be submitted).

In order to verify certain technically critical information required for the contract, the tenderer's workshop will be visited by the TET team and contract manager. Appropriate notice will be provided.

M4). Submit a **5-Year** track record of maintenance safety valves in the form of

1. A table format consisting of a project list containing:
 - a) The **dates** when the work was done
 - b) **Client** or **company name** work was done for
 - c) The **scope of work** executed by the tenderer
 - d) Client contact details: e-mail, contact number and contact person.
2. Evidence of the work done in the form of a **formal, approved contract for all listed work in 1 above**.
(If no evidence is submitted, that record will not be considered)

The track record must cover five (5) separate calendar years (a min of one (1) project must be listed per calendar year for the calendar year to be counted), it is not required for the calendar years to be consecutive. However, no contracts before 2018 will be considered.

The submitted track record will be verified by the tender evaluation team, during the evaluation of tenders. The listed client contact persons on the track records will be contacted to verify if the work was done, and if the client was satisfied with the work.

Clients that state that they were not satisfied with the work done by the tenderer or clients that dispute that work was done by the tenderer, will be disregarded from the tenderer's track record. If there is no confirmation of satisfactory execution of the work by a previous client, then the entry on the track record will be disregarded

There are two conditions that must be met by the submitted track record for mandatory requirement M-4 to be satisfied:

1. 60% of all the tenderer's previous clients listed on the submitted track record that are valid as per the conditions above, must confirm that the tenderer executed the stated work, and to their (clients) satisfaction.
2. The total track record of verified satisfactory work (disregarded clients or projects will not be considered), must covers a 5-year period, no further back than 2018. The calendar years need not be consecutive.

7.2 Qualitative Returnable

The following will be evaluated using a scoring system, at least 70% score is required.

Q1). *Contractor* to provide two (3) separate method statements:

- (a) for calibration verification test and,
- (b) for confirming coil spring stiffness.

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(c) for the safe transportation of Safety Valves

Q2). *Contractor* to provide at least one example of a WPS. Provide the following Welding procedures qualified to ISO 15614-7 as a minimum:

- Carbon steel base material PQR & WPS with stainless steel butter layer overlaid with Stellite 6. Mechanical test results must be submitted.
- Overlay PQR & WPS for Group 5.2 base material overlaid with Stellite 6 with PWHT. Mechanical test results must be included.

Q3). Contractor to provide the following:

a) **Workshop Supervisor** To be in possession of:

- Minimum National Diploma or N5 (Engineering) OR SAQA accredited equivalent WITH proof of exact equivalency from SAQA.
- 5 years managing workshop for valve repairs including Safety Valve.

b) **Machinist** To be in possession of:

- Mechanical Fitter Trade Tested with a min N2 qualification OR SAQA accredited equivalent WITH proof of exact equivalency from SAQA
- 3 years' practical machinist experience after acquiring trade test.

c) **Quality inspectors** (QC) To be in possession of:

- QC Certification (Min SAIW Level 2 Inspector or equivalent)
- 3 years QC for Safety Valves repairs.

d) **Semi-Skilled Artisans/ Operators**

Min 3 years' experience working with Safety Valves hands on.

Q4). Technical exclusions. If there are no technical exclusions, this must be clearly stated in a signed letter format.

8. AUTHORISATION

This document has been seen and accepted by:

Name	Designation
Michael Amir	Senior Consultant – Generation Engineering
Nicolaas Hallatt	Chief Engineer – Turbine Engineering
Sylvester Mashaba	Senior Engineer – Turbine Engineering
Zamo Kumalo	System Engineer – Turbine Engineering
Ben Hlatshwayo	Senior Engineer – Boiler Engineering
Lucas Mabuza	System Engineer – Turbine Engineering

9. REVISIONS

Date	Rev.	Compiler	Remarks
January 2024	0	M Mashaba	Draft Document for Comments Review Process.
February 2024	1	M. Mashaba	Reviews comments incorporated
May 2026	2	M Mashaba	Updated evaluation criteria, TET member and Foreseen qualifications

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