	Scope of Work	Engineering
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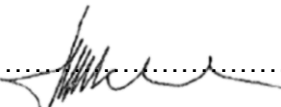


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1. Introduction

Kriel Stores department is going out on open tender for a supply contract for the mill labyrinth seals. The contract will be for 5 years.

The scope of work is defined in this document.

2. Supporting Clauses

2.1 Scope

The scope of this document defines the scope of work the supply contractor will have to execute at his works.

2.1.1 Purpose

The purpose of the document is to define the scope of work in line with the service information on the NEC3 Supply contract.

2.1.2 Applicability

This document is applicable to Kriel Power Station.

2.1.3 Effective date

The document will be effective from the date of authorisation.

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

[1] ISO 9001 Quality Management Systems

2.2.2 Informative

[2] 32-1033: Eskom Procurement and Supply Chain Management Policy

[3] 32-1034: Eskom Procurement and Supply Management Procedure during the tender process

2.3 Definitions

None

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2.4 Abbreviations

Abbreviation	Explanation
AIA	Approved Inspection Authority
GO	General Overhaul
IWE	International Welding Engineer
MGO	Mini General Overhaul
N/A	Not Applicable
OBL	Outside battery limits
WPS	Welding procedure specification

2.5 Roles and Responsibilities

2.6 Process for Monitoring

N/A

2.7 Related/Supporting Documents

N/A

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3. Supply and delivery of mill labyrinth seal scope of work

3.1 Executive Overview

The contract covers the manufacture and supply of mill labyrinth seals and labyrinth seals casing for 10.8E and 12E used at Kriel Power Station.

3.2 Employer's requirements for the service

3.2.1 General

The supplier is responsible for the supply and delivery of mill labyrinth seals as stock items on an "as and when required" basis. The labyrinth seals must be made to the specified Eskom drawings and applicable international standards.

The labyrinth seals must be assembled upon delivery, with all components in position. The data pack must be submitted electronically to the end-user and in hard copy when the delivery is made.

The contractor must only work to original manufacturing specifications and to approved quality control plans which must be made available for inspection by the employer.

The contractor must commit to a reasonable lead-time at the start of the contract. The delivery date of each order must be communicated with the contract manager and end-user.

The delivery of a unit will only be considered as complete if and when all the associated documentation is available at Kriel Power Station. All deliveries must be made to Kriel Power Station Main Stores. The end-user must be notified two days before any delivery to arrange the offloading of the material.

Deliveries must be made during the week within the following hours:

Monday, Tuesday, Wednesday, Thursday: 07h00 until 14h30

Friday: 07h00 until 10h00

3.2.2 Scope of work

The **10.8E mill labyrinth seal** must be made to Eskom drawing 0.45-304 rev 4 and 13.45-305 rev 2. The phosphor bronze components must be made to BS EN1400:1973. Aluminium components must be made to LM4 (EN 1706 AC-45200).

The **10.8E mill labyrinth seal casing** must be made to Eskom drawing 28.45/60992 rev 1. The material must be to BS EN 10293:2005 or equivalent.

The **12E mill labyrinth seal** must be made to Eskom drawing 13.45-348 (13.45-348 sheet 1 rev 2; 13.45-348 sheet 2 rev 1; 13.45-348 sheet 3 rev 3). The phosphor bronze components must be made to BS EN1400:1973. Aluminium components must be made to LM4 (EN 1706 AC-45200).

The used labyrinth seals must be assessed at the contractor's works to determine which components can be re-used. The assessment report must be submitted to Eskom to confirm the scope of work on the labyrinth seal assembly.

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Short description	Stock number
Labyrinth seal 10.8E	104474
Labyrinth seal 10.8E - Casing	666020
Labyrinth seal 12E	113840

3.2.3 Standards and Specifications

3.2.3.1 Quality Control Plan

A Quality control plan must be developed and submitted to Eskom for approval. The plan has to include quality control on material for new components, quality control of components not manufactured by the contractor where applicable.

Intervention points on critical manufacturing and assembling steps must be approved before the work starts. Involvement of a third party inspector has to be indicated where applicable.

3.2.3.1.1 Intervention points

Intervention points will be approved for each individual unit and is to be detailed in the applicable Task Order.

The employer's representative may from time to time visit the contractor's works to inspect and monitor progress without prior notice.

3.2.3.1.2 Material certificates

The quality control plan must state the controls to confirm the quality of all materials used, NDT test required during fabrication and assembly and heat treatment requirements. The physical property test certificate, chemical composition certificates, NDT certificates and heat treatment certificates must be in the data pack (where applicable).

3.2.4 The Programme

The starting date and completion date as per the relevant Task Order will be applicable for each unit.

A program must be submitted for each task order with the activities broken down to show how the end date will be achieved.

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4. Acceptance

This document has been seen and accepted by:

Name	Designation
Zama Mkondweni	Technical advisor – MMD Boiler

5. Revisions

Date	Rev.	Compiler	Remarks
July 2024	3	MJ Mkhonto	Remove the wear rings as they are part of the labyrinth seals.
April 2021	2	FW le Roux	10.8E labyrinth seal casing added to the scope of work Labyrinth seal assessment section added to accommodate it as RF items.
January 2021	1	FW le Roux	Document finalised and comments incorporated.
January 2021	0.1	FW le Roux	Document created to formalise the scope of work required for the NEC used in the procurement of the spares.

6. Development Team

The following people were involved in the development of this document:

- MJ Mkhonto
- Z Mkondweni

7. Acknowledgements

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