Annex No 4

THE TENDER FORM

**TENDER FOR PROCUREMENT OF THE CUSTOMIZED SEAMER FOR WELDING OF CONES**

**2022 [\_\_\_] (month). [\_\_\_] (day)**

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| --- | --- |
| Name of the Supplier and its business registration number or VAT number (fill in for each member when the tender is submitted by a group of entities): |  |
| Address of the Supplier: |  |
| Contact person in charge of the tender: |  |
| Telephone number: |  |
| Email: |  |

Herewith we confirm that we unconditionally accept all terms of the tender listed in the bellow presented places and documents:

1. The tender announcement on the website www.esinvesticijos.lt;
2. The tender terms and conditions publication;
3. Annexes No 1-5 of the tender terms and conditions publication.

We quote the procurement object for the price of USD, EUR (please, underline the actual currency) (without VAT \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ( DAP ALYTUS, Incoterms 2020). This price comprises all supply expenses, among other (but not restricted to) transportation, insurance, loading, mounting, commissioning, testing and training of personnel.

We present and confirm the next parameters, supplementary installations and services to the customized seamer for welding of cones:

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| --- | --- | --- |
| **No** | **Parameter** | **Value** |
| **1** | **General layout of the equipment.** |  |
| 1.1 | The seamer is intended mainly for welding of a closing seam of cones which are parts of stainless steel tanks. The seamer should be capable of welding of the two marginal types of cones- the Cone-15 and the Cone-55 - while being able to perform the designated task, it is believed, all other requested shapes of cones would fall into the range of weldable jobs. The drawings of the Cone-15 and Cone- 55 are presented in Annex 2 to the Tender Terms and Condition. | ☐Yes ☐No |
| 1.2 | The Cone-15 shall be welded from outside and the Cone-55 shall be welded from inside. | ☐Yes ☐No |
| 1.3 | The seamer stands on one-level-flooring and has an elevation gear for purpose of keeping of the Cone-15 seam in the horizontal position during welding. | ☐Yes ☐No |
| 1.4 | The very end of the supporting framework of the seamer (the lower part- the mandrel, the upper parts- the tabletop and the boom with weld carriage slides) is customised for a weld reach of closing seams of the cones. However, it is admitted that due to geometry constraints the very end section of the seam (it's length should be minimised) would remain inaccessible and should get finished manually after removal of the cones from the seamer. | ☐Yes ☐No |
| 1.5 | The mandrel of the seamer has T-slots on both sides for mounting of support fixtures provided by Astra. The T-slots can also be implemented in the way of an external attachment to the body of the mandrel. | ☐Yes ☐No |
| 1.6 | The mandrel and the tabletop have two easily interchangeable latches- one is customised for the small diameter openings like in the Cone-15 and the more rigid another one is intended for openings without space constraint. | ☐Yes ☐No |
| 1.7 | The table-top has pneumatic clamps for sheet fixing in a desired position with force of at least 60 kg/cm. | ☐Yes ☐No |
| 1.8 | The seamer has a possibility of motorized manually jogged vertical elevation. The height of a working surface of the mandrel above ground shall be at the ergonomically based benchmark of approximately 900 mm. The highest point of the working surface achieved by the elevation motion should be suitable to weld the Cone 15's closing seam in the horizontal position while the cone's opposite edge is above or on the ground level. | ☐Yes ☐No |
| 1.9 | The seamer has a motorized programmable horizontal weld gear stroke x equalling | Value: |
| 1.10 | The seamer has a motorized manually jogged cross-seam adjustment slide. | ☐Yes ☐No |
| 1.11 | The seamer is intended for welding of the stainless steel AISI304, AISI316 sheets which thicknesses for cones ranges from 2 to 10 mm and for pieceparts of plain sheets - from 2 to 15 mm. | ☐Yes ☐No |
| 1.12 | The seamer has PAW & GTAW weld gear packages with separate welding power sources or one common source for both processes. | ☐Yes ☐No |
| 1.13 | The first torch situated next to the latching mechanism is retractable aside by means of some kind of a hinge so as to minimize unreachable to weld distance for the second torch in a row. As an alternative, allowed is design of such the weld carriage when changeover of torches into the same position is implemented. In the latter case, it is mandatory to implement the next design features: 1) easy, "tool-less" changing of torches between the idle-operation positions, 2) no position adjustment efforts of an operator are required when putting a torch into the operation position. Whether the hinge or the changeover design is implemented, disconnection of power supply cables or water hoses from torches is not allowed -there must be switching devices installed for that purposes. | ☐Yes ☐No |
| 1.14 | The seamer has an operator's console which allows to view weld, to monitor weld parameters and to program the weld parameters from one location. | ☐Yes ☐No |
| 1.15 | Shield gas supply flow indicators are observable from the operator's console. Applicable to both PAW and GTAW processes. | ☐Yes ☐No |
| 1.16 | The seamer has a central electric cabinet which distributes power to absolutely all hardware on the seamer. All circuits must be circuit-breaker protected. | ☐Yes ☐No |
| 1.17 | The seamer has a mandrel opening mechanism for easy insert and removal of a piecepart. When opened, the distance between clamping fingers and the mandrel surface near entry is at least 100 mm. | ☐Yes ☐No |
| 1.18 | The seamer has a pedal switch intended for clamping of a inserted piecepart. | ☐Yes ☐No |
| 1.19 | The seamer has a remote control for the elevation motion and opening of the mandrel. | ☐Yes ☐No |
| 1.20 | The seamer has a separate high resolution colour camera mounted on a weld carriage intended for observation of a weld seam after a shield gas trailer. | ☐Yes ☐No |
| **2** | **Key components/parameters supplied with the Plasma arc welding (PAW) process:** |  |
| 2.1 | Entire length of the Cone-55 closing seam is reachable to weld with the PAW process using small run-off tabs. | ☐Yes ☐No |
| 2.2 | Length b of the closing seam of the Cone-15 unreachable to weld with the PAW process with a magnetic oscillator probe mounted. | Value: |
| 2.3 | Length c of the closing seam of the Cone-15 unreachable to weld with the PAW process with the magnetic oscillator probe dismounted. | Value: |
| 2.4 | PAW process conducted either in keyhole plasma mode or with-wire mode. | ☐Yes ☐No |
| 2.5 | Programmable slide provided for vertical torch positioning and arc voltage control for the PAW process. | ☐Yes ☐No |
| 2.6 | Wire feeder allowing the programming and control of feed rate, retract, delay, and pulsation (synchronized to current pulsation). Precise wire positioning device allowing operator to fine-tune the wire position in 2 axis directions in relation to weld torch and weld puddle, controlled from the operator's console is included. Wire feed rolls for 1.0, 1.2 mm wire are included. Wire straightening, rolling gear is included. | ☐Yes ☐No |
| 2.7 | High resolution colour weld camera for the PAW torch with mounting brackets, a water-cooled body is included. Auxiliary lighting to aid in viewing the weld joint prior to welding is included. If the changeover design of weld torches is implemented (1.13), allowed is installation of one common weld camera used for both PAW and GTAW processes. | ☐Yes ☐No |
| 2.8 | Magnetic oscillation module with a water-cooled probe are included. The module allows to program the next oscillation parameters: frequency, left and right deviation, oscillation centreline, dwell and an amplitude of the magnetic field not less than 9,5 mm. For purposes of the better weld reach, the probe must be disconnectable by unplugging its cable and water lines with fast connection joints or distractible without unplugging it's cable and water supply hoses. The magnetic oscillation parameters are integrated into a weld program. If the changeover design of weld torches is implemented (1.13), allowed is installation of one common magnetic oscillation module used for both PAW and GTAW processes. | ☐Yes ☐No |
| 2.9 | Welding power source rated output at 38 VDC, 100% duty cycle | Value: |
| 2.10 | Easily dismountable, water-cooled or gas-cooled shield gas trailer with a separate gas supply nozzle intended for protection of a cooling weld beneath the torch. | ☐Yes ☐No |
| 2.11 | Water-cooled one-fits-all bed insert on the mandrel allowing to protect with shield gas seams of steel sheets of all thicknesses during the PAW root pass welding. 2 pcs of the inserts are included. | ☐Yes ☐No |
| **3** | **Key components/parameters supplied with the Gas tungsten arc welding (GTAW) process:** |  |
| 3.1 | Length d of the closing seam of the Cone-15 unreachable to weld with the GTAW process with the magnetic oscillator probe mounted. | Value: |
| 3.2 | Length e of the closing seam of the Cone-15 unreachable to weld with the GTAW process with the magnetic oscillator probe dismounted. | Value: |
| 3.3 | Length y of the unreachable to weld section of the seam near opening of the Cone-55 using GTAW process. | Value: |
| 3.4 | Programmable slide provided for vertical torch positioning and arc voltage control for the GTAW process. | ☐Yes ☐No |
| 3.5 | Wire feeder allowing the programming and control of feed rate, retract, delay, and pulsation (synchronized to current pulsation). Precise wire positioning device allowing operator to fine-tune the wire position in relation to weld torch and weld puddle, controlled from the operator's console is included. Wire feed rolls for 1.0, 1.2 mm wire are included. Wire straightening, rolling gear is included. | ☐Yes ☐No |
| 3.6 | High resolution colour weld camera for the GTAW torch with mounting brackets, a water-cooled body is included. Auxiliary lighting to aid in viewing the weld joint prior to welding is included. If the changeover design of weld torches is implemented (1.13), allowed is installation of one common weld camera used for both PAW and GTAW processes. | ☐Yes ☐No |
| 3.7 | Magnetic oscillation module with a water-cooled probe are included. The module allows to program the next oscillation parameters: frequency, left and right deviation, oscillation centreline, dwell and an amplitude of the magnetic field not less than 9,5 mm. For purposes of the better weld reach, the probe must be disconnectable by unplugging its cable and water lines with fast connection joints or distractible without unplugging it's cable and water supply hoses. The magnetic oscillation parameters are integrated into a weld program. If the changeover design of weld torches is implemented (1.13), allowed is installation of one common magnetic oscillation module used for both PAW and GTAW processes. | ☐Yes ☐No |
| 3.8 | High frequency arc starter for establishing GTAW arc at an outset. | ☐Yes ☐No |
| 3.9 | Welding power source rated output at 38 VDC, 100% duty cycle. | Value: |
| 3.10 | Welding power source can operate in programmable pulse mode. | ☐Yes ☐No |
| 3.11 | Easily dismountable, water-cooled or gas-cooled shield gas trailer with a separate gas supply nozzle intended for protection of a cooling weld beneath the torch. | ☐Yes ☐No |
| **4** | **Miscellaneous other requirements:** |  |
| 4.1 | Price of the equipment includes crating, delivery to Ulonų g. 33, 62161 Alytus, Lithuania, assembly and commissioning. Unloading and storage of the equipment at the place of delivery are undertaken by Astra LT. | ☐Yes ☐No |
| 4.2 | Price of the equipment includes site performance acceptance testing program which aim is to check if target weld process objectives set by the Buyer are achieved. The testing program layout is presented in the Annex 3 to the Tender terms and Conditions. The successful execution of the testing program triggers the last 10% payment foreseen in the supply contract. | ☐Yes ☐No |
| 4.3 | Price of the equipment includes costs of at least 24 hours long training program for operators and technicians. Part of this program could be conducted during tests and commissioning of the equipment. | ☐Yes ☐No |
| 4.4 | CE declaration of conformity in English | ☐Yes ☐No |
| 4.5 | Safety requirements of usage of the equipment in English and Lithuanian. | ☐Yes ☐No |
| 4.6 | Operating manual in English both paper and electronic copy. | ☐Yes ☐No |
| 4.7 | Service manual with electrical and mechanical drawings, spare parts lists both in paper and electronic copy. | ☐Yes ☐No |
| 4.8 | Warranty period. | Value: |
| 4.9 | The equipment must be new (unused) and manufactured no earlier than 3 years before the date of purchase. | ☐Yes ☐No |

The next documents are supplemented with the tender:\*

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| **No** | **Title of the document:** |
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\*1. If some data provided in the attached commercial description, brochures of the equipment contradicts to statements filled in the tender form, then only the latter are valid and considered.

2. If some documents supplemented to the tender contain clauses or links to other documents containing clauses, them being in conflict with the Tender Terms and Conditions, such conflicting clauses are regarded void and invalid in advance.

The tender is valid until \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_(minimum 3 months).

We, signed bellow, confirm that all information submitted in this tender is correct and valid; we have not concealed any important information needed to fulfil the above listed requirements.

We understand and agree that in the case of mismatch of the declared in the tender parameters with the actual ones, we will be expelled from the tender at any time. Such the elimination from the tender does not deprive the Buyer the right to require losses compensation as well.

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Name and surname of the authorized person Signature