

Dąbrowa Górnicza, 24.06.2021

Answers to questions received during the tender process no. 3/0784/2021

Regarding the request for quotation no. 3/0784/2021 concerning **purchase, deliveries, installation and start-up of the elements of Control block in Heavy Section Mill in Dąbrowa Górnicza.**

QUESTION	ANSWER
1. Does the track system know where on the rail the sticker is located? a. Without this information, retraction of brush for sticker is not possible.	AMP system send the number and position of stickers. The marking machine has the length measuring device just before brushing and the AMP system read this information from PLC.
2. A PM (profile measurement unit) cannot perform a twist measurement. a. Additional unit, app. 150 k€, is required.	Twist measurement is required. Module, if necessary, must be added to the offer.
3. Please explain Insulation standard (AMP)	Investor's standards are available at www.arcelormittal.com/poland , tab "FOR CONTRACTORS"
4. Please explain waviness module	It is flatness module (wrong translation). Point 3.2 A in the RFQ.
5. Technical Specification point 3.1, E Can we use existing cable trays?	Yes.
6. Technical Specification point 3.1, H Utilization and disposal of generated waste by Bidder, during installation not including waste generated by AM during disassembly. Is that correct?	Correct. Wastes generated by AMP are up to AMP.
7. Technical Specification point 3.1, K It's impossible to provide a list of spare parts necessary "for 1 year of operation of new modules, worth exactly 5% of the value of the commercial offer". Is it OK if we will provide a list of recommended spare parts with their value?	Please provide a list of spare parts which we will choose and the Bidder will deliver. The value of spare parts = 5% of the total contract value.
Technical Specification point 22 IT Requirements:	
8. How many viewing Stations are needed?	In total 4 stations. One for control the new modules. Additional 3 for viewing.
9. for viewing FMG results the connection to database is necessary, OSIRIS data can be viewed offline rail by rail in separated files - OSIRIS offline viewer works with database connection or as filebased viewer OSIRIS database can be kept in small size (10 days of data) - results are	Acceptable solution.

<p>automatically file based exported and stored for longterm availability - no need for database splitting. OSIRIS data can be viewed rail by rail in separated files. Is that acceptable?</p>	
<p>10. The FMG has a reporting tool with various exporting functions: time based reports, detailed shift reports – if that does not fulfill requirements, please specify the requirements.</p>	<p>Alle data must be exported to the excel file *.xls.</p>
<p>11. " The network hardware should use...." Please specify which ArcelorMittal Standards should be used – please provide specification document</p>	<p>Please check: "AIM Addendum to tender - automation system requirements EN V13"</p>
<p>12. Can we use windows defender? Is it possible to use it? We cannot guarantee the workflow with McAfee.</p>	<p>During the cold tests, AMP will install McAfee and after introducing the exclusions provided by the bidder, we will check if the system is working properly. If we don't uninstall McAfee and we'll stick to windows defender.</p>
<p>13. Is the HSM tracking system the same which was installed in 2008 together with cold testing line?</p>	<p>We have a new production tracking system, it is based on the reading of 2D codes stuck on the rail in the production zones.</p> <p>The identification of the rail before NDT is based on OCR (stamped number), the rail data (length, profile, grade) is entered by the operator (prompted from the system). And the rail is marked with a 2D code, before entering the NDT and is tracked in the production process using 2D code scanners.</p> <p>Data on the number and position of stickers with 2D code are sent to the marking system.</p> <p>The profile, length and rail number data are sent to the WinCC system.</p> <p>After the test is over, the system imports measurement data from the NDT database, but at this point we need to establish a communication protocol - we can read messages via TCP / IT, read data from the database, or similar – we need to have possibility to import all data from NDT to our system.</p>
<p>Technical Specification C Cleaning Machine</p>	
<p>14. point 5 - "The new module must provide geometry measurement of railway rails according to ArcelorMittal catalogue." Should Cleaning Machine measure the geometry?</p>	<p>No. Adaptation of the cleaning machine to all rails in the ArcelorMittal catalogue. There is no need to measure the geometry of the rails. The cleaner is to work in automatic mode and automatically adapt to the cleaned profile through information obtained from WinCC.</p>
<p>15. Point 16 How do we get the serial numbers of the rails – which kind of interface can we use? Via WinCC, or</p>	<p>From OCR system through WinCC.</p>

<p>other? Please provide specification/description?</p>	
<p>16. Where sticker is located: position on rail, on which part of the rail (web, head,...)</p>	<p>Chamber of the rail from the concave marking side.</p>
<p>17. The signal to stop/restart brushing in case of sticker is provided by AMP, or do we get only length position information of stickers?</p>	<p>No, AMP system only send the number and position of stickers, brushing is started by the marking machine PLC.</p>
<p>18. If we get length position information, the brushing machine needs a length information of passing rail – is this information provided by AMP or do we need a separate length measuring device in front of the brushing machine?</p>	<p>The marking machine has the length measuring device just before brushing and the AMP system read this information from PLC.</p>
<p>19. Please provide image of sticker</p>	
<p>20. point 17 - What does this mean: "profile meter measurement control system"</p>	<p>Wrong translation. Control system based on Siemens controllers, preferably: S7-300, S7-1200 or S7-1500 (or equivalent solution).</p>
<p>21. Technical Specification Point 4 Work completion time - is it possible to extend the deadline beyond 10 days?</p>	<p>Dismantling the existing equipment at a standstill. Cannot be disassembled before the shutdown. Installation works should be performed within 10 days of the stoppage. After 10 days, AMP must be able to drive the rail through the new modules. Please provide such resources to complete the work in the proposed time period.</p>
<p>22. Technical Specification Point 5 Guarantee and warranty of delivery and quality of workmanship - Will AMP accept the exclusion of wearing parts, e.g. lasers, filters, from the 24-month warranty of such elements?</p>	<p>The 24-month warranty covers all elements supplied as part of the project; if something needs to be replaced during this period, please include it in the technical / commercial offer. There can be no exclusions here like lasers, filters.</p>
<p>23. Response time for reporting the failure Monday to Friday during working hours. Is it acceptable?</p>	<p>No. During the warranty period: The required response time for reporting a failure (technical contact or VPN connection) up to max. 24h; in the scope of 24/7</p>



24. Technical Specification Table 2. Environment-related data - what is the room temperature where the measurement systems are located?	5 – 35 deg C
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