Eskom Rotek Industries	**Provision of Splicing and Lagging Service at Duvha** **SCOPE OF WORK**	**Bulk Material Services**

Title: **SOW – Provision of Splicing and Lagging Service at Duvha**

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1. Purpose

The purpose of this document is to outline the scope requirements for the provision of splicing and lagging services at Duvha on an “as and when required basis”.

2. Context of Environment

Eskom Rotek Industries (ERI) Bulk Material Services (BMS) maintains the Overland (OVL) and On Terrace System (OTS) conveyors at Duvha Power Station.

3. Scope of Work

The objective is to:

- Ensure the provision of a 24 hour splicing and lagging service to Duvha BMS.

The scope is to:

- Have a dedicated team available on site that will be responsible for splicing, belt repairs and pulley lagging on an “as and when required” basis.
- The Duvha Coal conveyor system consist of transfer houses, 23 conveyor belts of varying lengths, approximately 18 km long in total, viz:

Overland:

- Sample Conveyor
- Reject Conveyor
- Conveyors 2A & 2B
- Conveyors 3A & 3B
- Conveyors 4A & 4B
- Conveyors 5A & 5B

Inside station:

- Conveyors 6A & 6B
- Conveyors 7A & 7B
- Conveyors 8A & 8B
- Reclaim conveyor
- Cross Conveyor
- Link Conveyor
- Ramp Conveyor
- Shuttle Conveyor
- Boom Conveyor
- Magnet Conveyor

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Splicing and Belt Repairs

- Providing Splicing, Belt repair and Pulley lagging services to ensure the efficient running of the Duvha Power Station Conveying Operations on an as and when required basis
- Ensure that the Staff and Equipment meet the safety, health and environmental regulations and requirements at all times.
- The *Contractor* provides Equipment, tools and consumables for the all splicing, securing, pulling of the conveyors to ensure effective operation of the *Works,* inclusive of mobile generators, hot splice press, rigging/lifting equipment, approved belt clamps, humidity meters and shore hardness testers.
- Provision of 300mm (width) x 12mm (thickness) x 10m (length) rubber skirting as and when required.
- The Contractor must compile their own Safe Work Procedures and QCP for each activity on splicing, repairs and lagging.
- On call out, the Splicing Contractor Supervisor shall be on site within **60 minutes**, after being called out for assessment of work and planning.
- All splices on Steel Cord and Plied Textile belts shall be done using a hot vulcanizing press, unless otherwise agreed with ERI technical person on site.
- The Splicing Contractor can use 380 V and 220 V power supplies where these services are currently available on site. Power is not available along all conveyors.
- Assist with pulling of belt for new rolls of conveyor, inserts and splices.
- ERI will supply a mobile crane where required.
- Steel cord belt splicing should comply with SANS 485 ‘Conveyor belting - Splicing of steel cord reinforced conveyor belting’, 2009 edition.
- Hot splicing of textile reinforced conveyor belt splicing should comply with SANS 484 part 1:’ Conveyor belting - Step splicing for multi-ply textile-reinforced rubber covered conveyor belting Part 1: Hot-splicing method’, 2009 edition
- Splicing of textile conveyor belt using the cold splicing method should comply with SANS 484 part 2: ‘Conveyor belting - Step splicing for multi-ply textile-reinforced rubber covered conveyor belting Part 2: Cold-splicing method‘, 2009 edition.
- All splices, hot and cold repairs shall be marked with a unique identity number indicating the date and company name and recorded in a register. The register shall be maintained by the *contractor* and submitted to the maintenance manager on monthly basis with assessment.
- Splicing equipment should be verified, calibrated and tested at intervals indicated in Table 1 below. A copy of the calibration report from the press manufacturer or company approved by the manufacturer should be submitted to the ERI representative on request otherwise every 6 months.
- Proof of thermocouple and pressure gauge verification done monthly should be submitted to the ERI’s representative on a monthly basis.
- The Splicing Contractor to have at least one person authorized to operate overhead hoists and cranes for the lifting splicing equipment when and where required within three months of the contract been awarded. Proof of competency and appointment letter to be placed on contractor safety file on site.

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- During adverse weather conditions such as rain and wind the Splicing Contractor is to erect a shelter over the splice or repair area to keep out the elements.
- The Splicing Contractor is required to prepare H-Block samples during every steel cord splice as per par 8.3 of SANS 485 2009, to enable ERI to conduct cord pull out tests.
- The Splicing Contractor will not be paid for rework or any splice that fails within the guarantee period, subject to the findings of an investigation by ERI maintenance manager and contractor representative.
- As per the SANS requirement the Splicing Contractor will have to provide proof from the belt manufacturer that the compound that the Splicing Contractor is using for conveyor belt splicing is compatible with the brand of belt that is being spliced.
- The site working area must be kept clean at all times. This will also be the last point on the QCP.

Refer to table below for number of conveyors and their lengths

NAME OF CONVEYOR	TOTAL LENGTH IN METRES
Sample Belt	35
Reject Belt	45
2A	3307
2B	3315
3A	2820
3B	2835
4A	149
4B	160
5A	661
5B	653
6A	662
6B	671
7A	90
7B	104
8A	1038
8B	1040
RECLAIM	2508
CROSS	482
LINK	86

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RAMP	119
SHUTTLE	31
BOOM	65

Verification and testing requirements for splicing equipment

ITEM	ACTIVITY	INTERVAL
Thermocouple gauges	Verification with calibrated thermocouple	Monthly
Pressure gauges	Verification with calibrated gauge	Monthly
Control box wiring inspection	Inspection by splicing contractor	Weekly
Platen element test	Test by press manufacturer	6 Monthly
Thermocouple gauges	Verification by press manufacturer	6 Monthly
Cylinders/pressure bags	Pressure test, check for leak and condition by press manufacturer	6 Monthly
Control box wiring tests	Correct functioning and safety by press manufacturer	6 Monthly
Hardness meter (durometer)	Verification/Calibration	6 Monthly
Humidity meter	Verification/Calibration	6 Monthly

Pulley Lagging

- The *Contractor* will be responsible to supply their own material, equipment required to do lagging of pulleys
- All equipment to do pulley lagging should be supplied by the *contractor*, including at least four 1.5 ton Lever Hoists, and four 3.2 ton lever hoists, approved belt clamps and spreader bars.
- *Contractor* will be responsible to pull the belt away from the pulleys using their own equipment during the lagging process.
- The Employer will only be responsible for lifting of the counterweight, lowering of the counterweight/de-tensioning of the belt.
- The Rubber lagging should consist of one continuous sheet and only the joint where the two ends of the lagging sheet meet around the circumference will be allowed. **No joining of 'pieces' will be allowed on the pulley.**
- The *Contractor* should provide Quality Control (QC) documentation for each pulley that is lagged, and records there-of kept in a file in maintenance manager office.

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❖ Duvha has ceramic lagging imbedded in rubber on most of the drive pulleys and lagging of these pulleys will be required from time to time. This lagging should consist of continuous strips of lagging across the full width of the pulley

4. Standards and Specifications

All the splicing, repair and work carried out on the belts and the pulleys must comply to the following standards and specifications.

a. 240-55864585 Textile Ply Belt Splicing Quality Control Standard
b. 240-55864495 On-Site Splicing of Plied Textile Conveyor Belting Procedure
c. SANS 484-1/2 Conveyor Belt Splicing
d. SANS 1669 Pulley Lagging Procedure
e. SABS 970:1980, Conveyor Belting Cover Compounds
f. SABS 1173, Troughed conveyor belts
g. SABS ISO 9001: Quality management systems and requirements.
h. 240-55864546 Ceramic Lagging of Pulleys Guideline
i. SANS 484-1 Hot Splicing Standards as a guideline
j. DIN 7 716: Rubber products, requirements for storage, cleaning, and maintenance
k. DIN 22 104: Antistatic conveyor belts; requirements, testing

5. Supporting Documents

NB: Adherence to the following documentation must be proven accordingly during the evaluation process:

- Quality control plan – Conveyor Belt splicing
- SANS 485 ‘Conveyor belting - Splicing of steel cord reinforced conveyor belting’
- SANS 484 part 1: ‘Conveyor belting - Step splicing for multi-ply textile-reinforced rubber covered conveyor belting Part 12: Hot splicing method ‘
- ISO 9001 Quality Management Systems
- OSHAS 1800 Safety Management Systems
- ISO 14001 Environmental Management Systems
- Occupational Health and Safety Act and Regulations (85 of 1993)

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- 240-62196227_Eskom Life Saving Rules - compliance
- Criminal Procedures Act 51 of 1977
- National Road Traffic Act 93 of 1996
- Labour Relations Act 66 of 1995
- Basic Conditions of Employment Act 75 of 1997

5.1 Working times

- 24 hours a day based on scheduled work and call – outs in event of breakdowns
- After hours and weekends applicable

5.2 PPE

Required PPE on Sites (Specification to be supplied under SHEQ) supplied by contractor:

- Overalls-specific to activity, with own company branding
- Safety boots (that provides protection to the ankles)
- Hard helmets
- Gumboots (as required)
- Pigskin Gloves
- Safety goggles
- Ear plugs/muffs
- Dust masks
- Reflector vests
- Winter Jackets

5.3 Required Tools/Resources:

❖ The *Contractor* provides Equipment, tools and consumables for the all splicing, securing, pulling of the conveyors to ensure effective operation of the *Works,*

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inclusive of mobile generators, hot splice press, rigging/lifting equipment, approved belt clamps, humidity meters and shore hardness testers.

5.4 Management strategy and start up

The *Contractor*'s plan for the *service*

- Services are "as and when required"

5.5 Documentation control

5.6 Invoicing and payment

Invoicing and payment turnaround time is 30 days. Assessments are to be conducted from the 26th of each month.

❖ Contract change management

Not applicable

❖ Records of defined cost to be kept by the *Contractor*

All jobcards to be signed off by ERI representative upon completion of work, and prior to leaving site. A monthly assessment to be submitted to Employer on or before the 25th of each month.

6. Health, Safety, Environment and Quality assurance

Health and safety risk management

The *Contractor* shall at all times comply with the health and safety requirements prescribed by law as they may apply to the *service*s.

The *Contractor* shall, when coming on site always abide by the Eskom Lifesaving Rules safety requirements.

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The *Contractor* shall also abide by Safety, Health and Environmental Specifications for Contractors Procedure, which will also be provided by the *Employer*.

The *Employer* follows an accident/ incident prevention policy that includes the investigation of all accidents/ incidents involving personnel and property. This is done with the intention of introducing control measures to prevent recurrence of the same incidents. The *Contractor* is expected to fully co-operate to achieve this objective. Refer to 32-95_Environmental, Occupational Health and safety Incident Management Procedure

The *Contractor* implements a safety plan and maintains the safety system until completion of the whole of the works. The plan, will as a minimum, contain PPE information, written safe work procedures, job specific risk assessments, safety meetings, etc. The plan will be to the *Employer*'s satisfaction and will be accepted prior to the commencement of any work.

The *Contractor* will be subject to periodic audits by the *Employer* in order to ensure compliance with the plan. Any deviations will be corrected to the *Employer*'s satisfaction.

The *Project Manager* has the right to stop the *Contractor*'s work activities which, in the opinion of the *Project Manager*, is un-safe. The *Contractor* may only continue with work activities when all safety deficiencies have been corrected to the *Service Manager's* satisfaction. The *Contractor* shall have no claim against the *Employer* in respect of delay due to the above.

6.1 Environmental constraints and management

The *Contractor* shall comply with ERI management system. This includes the identification, collection, storage, transportation and disposal of waste. Hazardous waste shall be disposed of in line with the applicable environmental legislation. It is important to note that all spillages must be cleaned immediately and reported to the project manager as soon as possible. It is the responsibility of the polluter to clean all spillages and for the rehabilitation of the polluted land and the cost associated with that.

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6.2 Quality assurance requirements

The *Contractor* implements a quality system and maintains the quality system until the completion of the whole of the *works*. The system, will as a minimum, comply with the provisions of the ISO9001 series. The system will be to the *Employer's* satisfaction and will be accepted prior to the commencement of any work on site. The *Contractor* will be subject to self-assessments by the *Employer* in order to ensure compliance with the system. Any deviations will be corrected to the *Employer*'s satisfaction.

The *Project Manager* has the right to stop the *Contractor's* work activities, which, in the opinion of *Project Manager*, does not meet the requirements of the system and will have a detrimental effect on plant performance. The *Contractor* may only continue with work activities when all deficiencies have been corrected to the *Project Manager's* satisfaction. The *Contractor* shall have no claim against the *Employer* in respect of delay due to the above.

The *Contractor* ensures that all plant and materials for the *works* are to the standard and quality accepted by the *Employer* and ensures that they are suitable for the purpose intended by the manufacturer.

The *Contractor* will work according to the *Employer's* standards, specifications, guidelines and procedures. Where no standards, specifications, guidelines and procedures are available, the *Contractor* will work according to the Generation Quality manual and professional guidelines. Where possible, standards will be reflected in the Task Order.

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The employer shall evaluate, control and monitor the performance and effectiveness of the Contractor

7. Procurement

People

Eskom Holdings Limited's requirements regarding employment of unskilled or semi-skilled workers are as follows:

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- ERI requires that during recruitment of unskilled or semi-skilled labour, a contractor should make every effort to employ minimum target of 100 % suitable candidates from all disciplines from the local community and will only resort to other avenues if the local community cannot provide the required resources.

7.1 Plant and Materials

7.1.1 Correction of defects

If there is part of work that the *Employer* is not happy with, this will be indicated to the *Contractor* and will have to be rectified by the *Contractor* immediately where reasonably possible or within 5 working days after the defect was reported.

7.1.2 Plant & Materials provided by the *Employer*

a. Water and Electricity
b. Lighting and Ventilation
c. Ablution facilities
d. Sitting facilities

NB: The *Contractor* will be responsible for their meals, own accommodation and transport to and from the place of work.

8. Working on the Affected Property

Under no circumstances will the *Contractor* do the work without proper PPE. The Supervisor on the *Contractor's* side will make it his duty to make sure that this is properly addressed.

8.1 Employer's site entry and security control, permits, and site regulations

The *Contractor's* access to site shall be in line with the Site access procedure. The *Contractor* shall be required to make an application for his employees to enter site for the duration of the contract, including defects period. The permits shall only be issued once the *Contractor's* employees have

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attended the safety induction training, submitted police clearance certificates and have undergone medical checks. The safety induction will be for the *Employer's* account. The medical and Police clearance checks will be for the *Contractor's* account

8.2 People restrictions, hours of work, conduct and records

The Contractor shall provide a 24 hour service. After hours and weekends are applicable.

- **Records of *Contractor*'s Equipment**

The *Contractor's* Supervisor should keep record of all the equipment used by the *Contractor*. The *Contractor* is responsible for the safekeeping of all their equipment.

- **Control of noise, dust, water and waste**

The contractor must supply their own dust masks and cloth masks as part of PPE. Drinking water is available on site as well as waste bins for disposing waste

9. Acceptance

This document has been seen and accepted by:

Name	Designation
Nokuthula Ngwenya	Project Manger

10. Revisions

Date	Rev.	Compiler	Remarks

11. Development Team

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

- Nokuthula Ngwenya-Project Manager

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- W Brown-Site Manager
- M Mabaso- Senior Supervisor Mechanical

11 Acknowledgements

None

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