Lee County Board Of County Commissioners
Agenda Item Summary

Blue Sheet No. 20060746 – UTL

1. ACTION REQUESTED/PURPOSE: Approve award of Formal Quotation No.'s Q-060116 Belt Press Rebuilt Two (2 each) Aquabelt Sz 4 (3.0 Meter) Type 85 and Q-060117 Belt Press Rebuilt Klampress Sz 3 (2.0 Meter) Type 85 for Public Works/Utilities, to the low quoter meeting specifications, Andritz Ruthner, Inc., at the prices listed on the attached Lee County Tabulation Sheets. Total cost to rebuild all presses will come to $226,214.00. Funding will come from the individual department/ division's budget whom will be responsible for monitoring their individual expenditures.

2. WHAT ACTION ACCOMPLISHES: Allows Public Works/Utilities to obtain necessary belt press rebuilding services.

3. MANAGEMENT RECOMMENDATION: Approve as stated.

4. Departmental Category: C10B			**5. Meeting Date:** 6-27-06
6. Agenda:	**7. Requirement/Purpose:** *(specify)*		**8. Request Initiated:**
X **Consent**	___ **Statute**		**Commissioner**
___ **Administrative**	___ **Ordinance**		**Department** Public Works
___ **Appeals**	X **Admin. Code**	AC-4-1	**Division** Utilities
___ **Public**	___ **Other**		**By:** Ivan Velez 6/12/06
___ **Walk-On**			

9. Background: On May 16, 2006, the Purchasing Division received sealed quotations for the rebuilding of Aquabelts and Klampress for the Public Works/Utilities Division. On that date, two responses were received. The quotations have been thoroughly reviewed, and a recommendation was made to award to Andritz Ruthner, Inc. as the low quoter meeting all specification requirements.

On May 22, 2006 the intent to award was sent to all quoters.

5/25/06 Initial Notice of Intent to File a Bid Protest was received from Ashbrook Simon-Hartley.
6/6/06 The Purchasing Division received a late Formal Bid Protest from Ashbrook Simon-Hartley. This information was received in purchasing beyond the 10 calendar days outlined in the bid protest procedure and the information was returned with explaination via certified mail.

Funding is available: 20727248720.506310

Please See Attachments:
(1) Tabulation Sheets
(2) Specifications
(3) Andritz Ruthner, Inc.Quotations
(4) Division's Recommendation

10. Review for Scheduling:

Department Director	Purchasing or Contracts	Human Resources	Other	County Attorney	Budget Services (after 6/15)				County Manager/P.W. Director
					Analyst	Risk	Grants	Mgr.	
6-12-06	6-12-06			6/13/06	6/14/06	6/14/06	6/14/06	6/19/06	6-12-06

11. Commission Action:
___ **Approved**
___ **Deferred**
___ **Denied**
___ **Other**

RECEIVED BY COUNTY ADMIN: 6/14/06 8:20 AM
COUNTY ADMIN FORWARDED TO: 6/15/06 2PM

Rec. By CoAtty
Date: 6/13/06
Time: 3:45 pm
Forwarded To: Admin 6/16

06 JUN -6 AM 7:2

June 5, 2006

Ms. Janet Sheehan
Lee County Purchasing Director
1825 Hendry Street
3rd Floor
Ft. Myers, FL 33901

missed Deadline for protest may be at Bid meeting

Ref: Formal Written Protest on Quotes Q-060116 and Q

Dear Ms. Sheehan,

In accordance with our Intention to file a protest, Ashbrook Simon-Hartley is submitting our formal written protest on Quotes Q-060116 and Q-060117.

This protest is being filed in accordance with the procedures and timeframes established within the general conditions of these quotes as established by the Lee County Board of County Commissioners.

As stated in our intention letter, the apparent low bidder is not capable of providing numerous items within the specifications and should have qualified their proposal as stated after Division 4: Warranties (page 16 of the Request for Quotation)

> "Note: at the end of each of the following divisions you will be asked if your firm can meet the requirements in each division. If you answer the question regarding meeting the requirements with a NO response your firm will be considered non-responsive. In other words to be considered for this project, you must answer unequivocally YES."

Paragraph 1.03, states that the basis of the award for these quotations will be the overall low quoter (lowest grand total cost) **MEETING SPECIFICATIONS.**

Specifically, Section 1.01c requires that all parts shall **be new, of the current original equipment manufacturer only** (OEM). Ashbrook Simon-Hartley is the original equipment manufacturer and no other bidder asked us for a quote for all of the parts required for the rebuild prior to the bid. As such, no other bidder could have certified that they meet this requirement with their bid.

Ashbrook Simon-Hartley

11600 East Hardy, Houston, TX 77093-1098 Phone 281-449-0322 / 800-362-9041 Fax 281-449-1324 Visit Our Website: www.ashbrookcorp.com

10/11 Brindley Court Lymedale Business Park Newcastle-under-Lyme Staffordshire ENG ST5 9QH Phone 011 44 178 257 8650 Fax 011 44 178 226 0534

Ashbrook Chile, S.A. Avenida Presidente Kennedy 5757 Torre Oriente, Oficina 501 Comuna de Las Condes Santiago Chile Phone 011 562 224 7858 Fax 011 562 224 9525

Additionally, the bidders were to stipulate that they were **regularly engaged in the design, fabrication, assembly, testing, start-up and servicing of the Aquabelt and Klampress** respectively. No other bidder is regularly engaged in the design, fabrication, assembly, testing, start-up and servicing of the Aquabelt and Klampress.

Paragraph 1.01d stipulated that **all labor to perform factory modifications and repairs shall be by the current original equipment manufacturer qualified factory trained personnel** experienced in the disassemble/reassemble of the Aquabelt/Klampress. No other bidder has any personnel that have qualified as Ashbrook Simon-Hartley factory trained personnel.

Division 2: Mechanical Requirements details the level of all replacement parts on the belt press. Within this division, section 2.02 Bearings, require replacement of all internal components (i.e. triple labyrinth seals, spacers, taper lock nut assembly, splash guards, etc.). All new internal bearing components must meet the original design specifications.

Additionally, the latest O.E.M. design requirement is called for in paragraphs 2.05 Hydraulic System, 2.07 Belt Drive System, and 2.13 Hydraulic Power Unit.

Although no bidder contacted us prior to the bid to obtain the specifications for any of these components, many of these may be copied from our design such that the external dimensions are maintained. However, some internal components such as internal hydraulic units, seals, and other repair kits, etc. will not match the Ashbrook O.E.M. parts and will become non standard components with limited parts documentation. This is especially critical for bearings where the only seal that will fit within our bearing housing is the Ashbrook seal which is not available to the other bidder.

As such, the apparent low bidder should have stipulated that they cannot abide by the Division 2 requirements.

Division 3: Contractors Qualifications (Submittals) requires the following:

A. Experience record showing the bidder's experience in similar work.
B. List and brief description of similar work satisfactorily completed with location, dates, contact names, addresses of owners and phone numbers.
C. List of equipment and facilities available to do the work.
D. List of personnel, by name and title, contemplated to perform the repairs and modifications to the equipment.
E. Provide proof of ability to obtain a Performance/maintenance bond, if you do not have a formal quality system in place.

The bidder was further required to "list all equipment that does not meet O.E.M Specification. Supporting documentation must be provided to verify that material does not meet O.E.M. specification is of equal quality."

Again at the end of that section, the bidder was required to stipulate that they can meet and abide by the Division 3 Contractor's Qualification Requirements. Since no other bidder contacted Ashbrook prior to the bid, they can not know the requirements for the OEM parts, and cannot stipulate that they have qualified personnel that have been factory trained by the OEM. The answer from the apparent low bidder should again have been an unqualified NO.

The requirements for a Local Contractor/Vendor also appear to be impossible for the apparent low bidder to follow given that

" 'Local Contractor/Vendor' shall mean: ...b) any person, firm, partnership, company or corporation that has provided goods or services to Lee County on a regular basis for the preceding five (5) years, and that has the personnel, equipment, and materials located within the boundaries of Lee County sufficient to constitute a present ability to perform the service or provide the goods."

Since the apparent low bidder cannot supply O.E.M. parts that can only come from Ashbrook Simon-Hartley's factory in Houston and cannot have trained personnel; they cannot have personnel and materials located within the boundaries of Lee County and should not be granted status as a Local Contractor/Vendor.

We recognize that Lee County has the right to purchase Substitutes as outlined in paragraph 3 (page 3) of the request for quotations. However, it is a requirement of the specification that the vendor names such products and proves to the county that the products are equal to the products specified. The apparent low bidder did not list any substitutions and we believe that the facts stipulated above are clear. The apparent low bidder cannot meet the specifications without taking exception.

If any bidder had any issues with the specifications, they should have been raised prior to the bid including the pre-bid meeting. Any resulting discussions that were deemed worthy, should have resulted in a written change to the specifications. Since none of these issues were raised or changed, we do not believe any verbal discussions to be binding or in any regard supersede the written specifications. Ashbrook Simon-Hartley prepared our bid in full compliance with the written specifications and expected all bidders to do likewise.

It is our contention that only Ashbrook Simon-Hartley could fully comply with the specifications unless an exception was requested with the bid. As such, we are the only bidder meeting the specifications and request that the projects be awarded to Ashbrook Simon-Hartley Operations L.P.

We have included our bond No. KO 72 87 49 5 in the amount of $10,000.00 as required.

Should you have any questions, please contact me at 281-985-4430.

Respectfully,

William Decker
Biosolids Business Unit Manager

Cc: Irving Stern, Esq.

Bond No. KO 72 87 49 5

Proposal Protest Indemnity Bond

KNOW ALL MEN BY THESE PRESENTS:

That we, Ashbrook Simon-Hartley Operations, L.P., as Principal, and Westchester Fire Insurance Company, a company organized under the laws of the State Of New York, with its principal office in the City of Philadelphia, as Surety, are held bound unto Lee County Florida, as Obligee, in the full penal sum of Ten Thousand and 00/100 Dollars ($10,000.00), lawful money of the United States, for the payment of which, well and truly to be made, we bind ourselves, our heirs, executors, administrators, successors and assigns, jointly and severally, firmly by these presents.

WHEREAS, the above bounden Principal has filed a Notice of Intent to File a Protest and/or a Formal Written Protest, and under procedures of the Obligee must file this bond for payment of any cost, that may be levied against the Principal as the result of a frivolous Protest.

NOW, THEREFORE, THE CONDITION OF THIS BOND IS SUCH, that if the above bounden Principal shall in all things stand and abide by, and well and truly indemnify the Obligee against any cost, that may be levied due to a frivolous Protest, then this obligation shall be void, otherwise to remain in full force and effect.

PROVIDED FURTHER, that if the Surety shall so elect, this bond may be cancelled by the Surety as to subsequent liability by giving sixty (60) days notice in writing to said Obligee.

Signed, seal and dated this 1st day of June, 2006.

Principal:

Ashbrook Simon-Hartley Operations, L.P.

By: _____
Name & Title

Surety:

Westchester Fire Insurance Company

By: _____
Eric S. Feighl, Attorney-in-Fact

Power of Attorney

WESTCHESTER FIRE INSURANCE COMPANY

1102736

Know all men by these presents: That WESTCHESTER FIRE INSURANCE COMPANY, a corporation of the State of New York, having its principal office in the City of Atlanta, Georgia, pursuant to the following Resolution, adopted by the Board of Directors of the said Company on November 8, 1999, to wit:

RESOLVED, that the following rules shall govern the execution by the Company of bonds, undertakings, recognizances, contracts and other writings in the nature thereof:

[illegible]

Any bond, undertaking, recognizance, contract or other writing executed in accordance with these rules shall be as binding upon the Company as if signed by the President and sealed and delivered by the Corporate Secretary.

The signature of the President, any Senior Vice-President, or Vice-President, or the Attorney-in-Fact, and the seal of the Company may be affixed by facsimile on any power of attorney granted pursuant to the foregoing, and the signature of a Corporate Officer and the seal of the Company may be affixed by facsimile to any certificate of any such power, and any such power or certificate bearing such facsimile signature and seal shall be valid and binding on the Company.

Such officers of the Company, and such other persons, shall have authority to certify or verify copies of the foregoing, the By-Laws of the Company, and any actions or records of the Company necessary to the [illegible]

[illegible]

Pursuant to said Resolution, does hereby appoint PHILIP S. BAIR, JANE DERMINO, AVICE OLIVIER, PHYLLIS RAMIREZ, JIMMYE LANGFORD, ERIC S. FEIGH, and JOYCE A. JOHNSON all of the City of Houston, State of Texas, each individually if there be more than one named, its true and lawful attorney-in-fact, to make, execute, seal and deliver on its behalf, and as its act and deed any and all bonds, undertakings, recognizances, contracts and other writings in the nature thereof to penalties not exceeding Twenty Million Dollars ($20,000,000) and the execution of such writings in pursuance of these presents shall be as binding upon said Company, as fully and amply as if they had been duly executed and acknowledged by the regularly elected officers of the Company at its principal office.

IN WITNESS WHEREOF, the said Stephen M. Haney, Vice President, has hereunto subscribed his name and affixed the corporate seal of the said WESTCHESTER FIRE INSURANCE COMPANY, this 27th day of April 2005.

WESTCHESTER FIRE INSURANCE COMPANY

Stephen M. Haney, Vice President

COMMONWEALTH OF PENNSYLVANIA :
COUNTY OF PHILADELPHIA : ss.:

On this 27th day of April, A.D. 2005, before me, a Notary Public of the Commonwealth of Pennsylvania in and for the County of Philadelphia came Stephen M. Haney, Vice-President of the WESTCHESTER FIRE INSURANCE COMPANY to me personally known to be the individual and officer who executed the preceding instrument, and he acknowledged that he executed the same, and that the seal affixed to the preceding instrument is the corporate seal of said Company; that the said corporate seal and his signature were duly affixed by the authority and direction of the said corporation, and that Resolution, adopted by the Board of Directors of said Company, referred to in the preceding instrument, is now in force.

IN TESTIMONY WHEREOF, I have hereunto set my hand and affixed my official seal at the City of Philadelphia the day and year first above written.

NOTARIAL SEAL
Kathleen Tirri, Notary Public
Philadelphia, Philadelphia County
My commission expires September 22, 2007

Notary Public

I, the undersigned Secretary of WESTCHESTER FIRE INSURANCE COMPANY, do hereby certify that the original POWER OF ATTORNEY, of which the foregoing is a substantially true and correct copy, is in full force and effect.

In witness whereof, I have hereunto subscribed my name as Secretary, and affixed the corporate seal of the Corporation, this 1st day of June 2006.

George D. Mulligan, Secretary

THIS POWER OF ATTORNEY MAY NOT BE USED TO EXECUTE ANY BOND WITH AN INCEPTION DATE AFTER April 27, 2007.

BS-38449-T

FORMAL QUOTATION #Q-060116 OPENING DATE: May 16, 2006 BUYER: Chris Jeffcoat	LEE COUNTY, FLORIDA TABULATION SHEET FOR BELT PRESS REBUILT TWO (2EACH) AQUABELT SZ 4 (3.0 METER) TYPE 85 FOR LEE COUNTY UTIL.	
VENDORS	ANDRITZ RUTHNER, INC.	ASHBROOK SIMON-HARTLEY OPERATIONS, LP
COPIES PROVIDED	YES	YES
ADDENDUM ACKNOWLEDGED	YES	YES
GRAND TOTAL COST TO REBUILD 2 AQUABELTS	$113,544.00	$166,640.00
SUBMITTALS FURNISHED	YES	YES
TO BE COMPLETED WITHIN	70	90 per machine
LOCAL VENDOR PREFERENCE	YES	NO
MODIFICATIONS	NO	NO
QUOTE SIGNED	YES	YES
Meets Specifications	YES	YES
Occupational License Number	N.A.	N.A.
NO BIDS		
GODWIN PUMPS OF AMERICA, INC.		
HOWCO ENVIRONMENTAL SERVICES		
ENVIRONMENTAL MACHINES & SERVICES		
HARN R/0 SYSTEMS, INC.		
POSTING TIME/DATE		
FROM: _____ / _____		
UNTIL: _____ / _____		
BY:		

ATTACHMENT 1

FORMAL QUOTATION #Q-060117	LEE COUNTY, FLORIDA TABULATION SHEET					
OPENING DATE: May 16, 2006	FOR					
BUYER: Chris Jeffcoat	BELT PRESS REBUILT KLAMPRESS SZ 3 (2.0 METER) TYPE 85 FOR LEE COUNTY UTIL.					
	ANDRITZ	ASHBROOK				
VENDORS	RUTHNER, INC.	SIMON-HARTLEY OPERATIONS, LP				
COPIES PROVIDED	YES	YES				
ADDENDUM ACKNOWLEDGED	YES	YES				
GRAND TOTAL COST TO REBUILT KLAMPRESS	$112,670.00	$129,180.00				
SUBMITTALS FURNISHED	YES	YES				
TO BE COMPLETED WITHIN	70	90				
LOCAL VENDOR PREFERENCE	YES	NO				
MODIFICATIONS	NO	NO				
QUOTE SIGNED	YES	YES				
Meets Specifications	YES	YES				
Occupational License Number	N.A.	N.A.				
NO BIDS						
GODWIN PUMPS OF AMERICA, INC.						
HOWCO ENVIROMENMENTAL SERVICES						
ENVIRONMENTAL MACHINES & SERVICES						
HARN R/0 SYSTEMS, INC.						
POSTING TIME/DATE						
FROM: /						
UNTIL: /						
BY:						

ATTACHMENT 2

LEE COUNTY
SOUTHWEST FLORIDA

PROJECT NO.: Q-060117

OPEN DATE: May 16, 2006

AND TIME: 2:30 P.M.

PRE-BID DATE: May 10, 2006

AND TIME: 8:30 A.M.

LOCATION: Lee County Purchasing
1825 Hendry St. 3rd Floor
Ft. Myers, Fl. 33901

REQUEST FOR QUOTATIONS

TITLE:
BELT PRESS REBUILT KLAMPRESS SIZE 3 (2.0 METER) TYPE 85 FOR LEE COUNTY UTILITIES

REQUESTER: LEE COUNTY BOARD OF COUNTY COMMISSIONERS
DIVISION OF PURCHASING

MAILING ADDRESS
P.O. BOX 398
FORT MYERS, FL 33902-0398

PHYSICAL ADDRESS
1825 Hendry St 3rd Floor
FORT MYERS, FL 33901

BUYER: CHRIS JEFFCOAT
PURCHASING AGENT
PHONE NO.: (239) 344-5458

GENERAL CONDITIONS

Sealed Quotations will be received by the DIVISION OF PURCHASING, until 2:30pm on the date specified on the cover sheet of this "Request for Quotations", and opened immediately thereafter by the Purchasing Director or designee.

Any question regarding this solicitation should be directed to the Buyer listed on the cover page of this solicitation, or by calling the Division of Purchasing at (239) 344-5450.

1. SUBMISSION OF QUOTE:

a. Quotations shall be sealed in an envelope, and the outside of the envelope should be marked with the following information:

1. Marked with the words "Sealed Quote"
2. Name of the firm submitting the quotation
3. Title of the quotation
4. Quotation number

b. The Quotation shall be submitted in triplicate as follows:

1. The original consisting of the Lee County quotes forms completed and signed.
2. A copy of the original quote forms for the Purchasing Director.
3. A second copy of the original quote forms for use by the requesting department.

c. The following should be submitted along with the quotation in a separate envelope. This envelope should be marked as described above, but instead of marking the envelope as "Sealed Quote", please indicate the contents; i.e., literature, drawings, submittals, etc. This information should be submitted in duplicate.

1. Any information (either required or in addition to that asked for by the specifications) necessary to analyze your quotation; i.e., required submittals, literature, technical data, financial statements.

2. Warranties and guarantees against defective materials and workmanship.

d. **ALTERNATE QUOTE:** If the vendor elects to submit more than one quote, then the quotes should be submitted in separate envelopes and marked as indicated above. The second, or alternate quote should be marked as "Alternate".

e. **QUOTES RECEIVED LATE:** It is the quoter's responsibility to ensure that his quote is received by the Division of Purchasing prior to the opening date and time specified. Any quote received after the opening date and time will be promptly returned to the quoter unopened. Lee County will not be responsible for quotes received late because of delays by a third party delivery service; i.e., U.S. Mail, UPS, Federal Express, etc.

f. **QUOTE CALCULATION ERRORS:** In the event there is a discrepancy between the total quoted amount or the extended amounts and the unit prices quoted, the unit prices will prevail and the corrected sum will be considered the quoted price.

g. **PAST PERFORMANCE:** All vendors will be evaluated on their past performance and prior dealings with Lee County (i.e., failure to meet specifications, poor workmanship, late delivery, etc.).

h. **WITHDRAWAL OF QUOTE:** No quote may be withdrawn for a period of 90 days after the scheduled time for receiving quotes. A quote may be withdrawn prior to the quote-opening date and time. Such a request to withdraw should be made in writing to the Purchasing Director, who will approve or disapprove of the request.

i. **COUNTY RESERVES THE RIGHT:** The County reserves the right to waive minor informalities in any quote; to reject any or all quotes with or without cause; and/or to accept the quote that in its judgment will be in the best interest of the County of Lee.

j. **EXECUTION OF QUOTE:** All quotes shall contain the signature of an authorized representative of the quoter in the space provided on the quote proposal form. All quotes shall be typed or printed in ink. The bidder may not use erasable ink. All corrections made to the quote shall be initialed.

2. **ACCEPTANCE**

The materials and/or services delivered under the quote **shall** remain the property of the seller until a physical inspection and actual usage of these materials and/or services is accepted by the County and is to be in compliance with the terms herein, fully in accord with the specifications and of the highest quality. In the event the materials and/or

services supplied to the County are found to be defective or do not conform to specifications, the County reserves the right to cancel the order upon written notice to the seller and return such product to the seller at the seller's expense.

3. **SUBSTITUTIONS**

Whenever in these specifications a brand name or make is mentioned, it is the intention of the County only to establish a grade or quality of materials and not to rule out other brands or makes of equality. However, if a product other than that specified is quote, it is the vendor's responsibility to name such product with his quote and to prove to the County that said product is equal to the product specified. Lee County **shall** be the sole judge as to whether a product being offered by the quoter is actually equivalent to the one being specified by the detailed specifications. (Note: This paragraph does not apply when it is determined that the technical requirements of this solicitation require only a specific product as stated in the detailed specifications.)

4. **RULES, REGULATIONS, LAWS, ORDINANCES & LICENSES**

The awarded vendor shall observe and obey all laws, ordinances, rules, and regulations, of the federal, state, and local government, which may be applicable to the supply of this product or service.

a. Occupational License – Vendor shall submit within 10 calendar days after request.
b. Specialty License(s) – Vendor shall possess at the time of the opening of the quote all necessary permits and/or license required for the sale of this product and/or service and upon the request of the County provide copies of licenses and/or permits within 10 calendar days after request.

5. **RECYCLED PRODUCTS**

It is the Lee County Board of County Commissioners' stated policy objective to "Ensure all departments are aware of the availability of recycled products..." (Administrative Code #AC-10-4). In an effort to provide the utmost opportunity for the use of recycled products by Lee County, vendors should list on their letterhead, all necessary information regarding any applicable recycled products they have available. Recycled products should meet all other specifications listed and have a minimum of 50%-recycled content. Whenever fiscally feasible, available recycled products will be purchased.

6. **WARRANTY/GUARANTY** (unless otherwise specified)

All materials and/or services furnished under this quote shall be warranted by the vendor to be free from defects and fit for the intended use.

7. **PRE-BID CONFERENCE**

A pre-bid conference will be held at the location, date, and time specified on the cover of this solicitation. Pre-bid conferences are generally non-mandatory, but it is highly recommended that everyone planning to submit a quote attend.

In the event a pre-bid conference is classified as mandatory, it will be so specified on the cover of this solicitation and it will be the responsibility of the quoter to ensure that they are represented at the pre-bid. Only those quoters who attend the pre-bid conference will be allowed to quote on this project.

8. **BIDDERS LIST MAINTENANCE**

A bidder should respond to "Request for Quotations" in order to be kept on the Bidder's List. Failure to respond to three different "request for quotations" may result in the vendor being removed from the Bidder's List. A bidder may do one of the following, in order to respond properly to the request:

a. Submission of a quotation prior to the quote receipt deadline.
b. Submission of a "no bid" notice prior to the quote receipt deadline.

9. **LEE COUNTY PAYMENT PROCEDURES**

All vendors are requested to mail one original invoice and one invoice copy to:

Lee County Finance Department
Post Office Box 2238
Fort Myers, FL 33902-2238

All invoices will be paid as directed by the Lee County payment procedure unless otherwise differently stated in the detailed specification portion of this quote.

Lee county will not be liable for request of payment deriving from aid, assistance, or help by any individual, vendor, quoter, or bidder for the preparation of these specifications.

Lee County is generally a tax-exempt entity subject to the provisions of the 1987 legislation regarding sales tax on services. Lee County will pay those taxes for which it is

obligated, or it will provide a Certificate of Exemption furnished by the Department of Revenue. All contractors or quoters should include in their quote all sales or use taxes, which they will pay when making purchases of material or subcontractor's services.

10. **LEE COUNTY BID PROTEST PROCEDURE**

Any contractor/vendor/firm that has submitted a formal bid/quote/proposal to Lee County, and who is adversely affected by an intended decision with respect to the award of the formal bid/quote/proposal, shall file with the County's Purchasing Director or Public Works Director a written "Notice of Intent to File a Protest" not later than seventy-two (72) hours (excluding Saturdays, Sundays and Legal Holidays) after receipt of a "Notice of Intended Decision" from the County with respect to the proposed award of the formal bid/quote/proposal.

The "Notice of Intent to File a Protest" is one of two documents necessary to perfect Protest. The second document is the "Formal Written Protest", both documents are described below.

The "Notice of Intent to File a Protest" document shall state all grounds claimed for the Protest, and clearly indicate it as the "Notice of Intent to File a Protest". Failure to clearly indicate the Intent to file the Protest shall constitute a waiver of all rights to seek any further remedies provided for under this Protest Procedure.

The "Notice of Intent to File a Protest" shall be received ("stamped in") by the Purchasing Director or Public Works Director not later than Four o'clock (4:00) PM on the third working day following the day of receipt of the County's Notice of Intended Decision.

The affected party shall then file its Formal Written Protest within ten (10) calendar days after the time for the filing of the Notice of Intent to File a Protest has expired. Except as provided for in the paragraph below, upon filing of the Formal Written Protest, the contractor/vendor/firm shall post a bond, payable to the Lee County Board of County Commissioners in an amount equal to five percent (5%) of the total bid/quote/proposal, or Ten Thousand Dollars ($10,000.00), whichever is less. Said bond shall be designated and held for payment of any costs that may be levied against the protesting contractor/vendor/firm by the Board of County Commissioners, as the result of a frivolous Protest.

A clean, Irrevocable Letter of Credit or other form of approved security, payable to the County, may be accepted. Failure to submit a bond, letter of credit, or other approved security simultaneously with the Formal Written Protest shall invalidate the protest, at which time the County may continue its procurement process as if the original "Notice of Intent to File a Protest" had never been filed.

Any contractor/vendor/firm submitting the County's standard bond form (CSD: 514), along with the bid/quote/proposal, shall not be required to submit an additional bond with the filing of the Formal Written Protest.

The Formal Written Protest shall contain the following:

- County bid/quote/proposal identification number and title.
- Name and address of the affected party, and the title or position of the person submitting the Protest.
- A statement of disputed issues of material fact. If there are no disputed material facts, the Formal Protest must so indicate.
- A concise statement of the facts alleged, and of the rules, regulations, statues, or constitutional provisions, which entitle the affected party to relief.
- All information, documents, other materials, calculations, and any statutory or case law authority in support of the grounds for the Protest.
- A statement indicating the relief sought by the affected (protesting) party.
- Any other relevant information that the affected party deems to be material to Protest.

Upon receipt of a timely filed "Notice of Intent to File a Protest", the Purchasing Director or Public Works Director (as appropriate) may abate the award of the formal bid/quote/proposal as appropriate, until the Protest is heard pursuant to the informal hearing process as further outlined below, except and unless the County Manager shall find and set forth in writing, particular facts and circumstances that would require an immediate award of the formal bid/quote/proposal for the purpose of avoiding a danger to the public health, safety, or welfare. Upon such written finding by the County Manager, the County Manager may authorize an expedited Protest hearing procedure. The expedited Protest hearing shall be held within ninety-six (96) hours of the action giving rise to the contractor/vendor/firm's Protest, or as soon as may be practicable for all parties. The "Notice of Intent to File a Protest" shall serve as the grounds for the affected party's presentation and the requirements for the submittal of a formal, written Protest under these procedures, to include the requirement for a bond, shall not apply.

The Dispute Committee shall conduct an informal hearing with the protesting contractor/vendor/firm to attempt to resolve the Protest, within seven working days

(excluding Saturdays, Sundays and legal holidays) from receipt of the Formal Written Protest. The Chairman of the Dispute Committee shall ensure that all affected parties may make presentations and rebuttals, subject to reasonable time limitations, as appropriate. The purpose of the informal hearing by the Dispute Committee, the protestor and other affected parties is to provide and opportunity: (1) to review the basis of the Protest; (2) to evaluate the facts and merits of the Protest: and (3) to make a determination whether to accept or reject the Protest.

Once a determination is made by the Dispute Committee with respect to the merits of the Protest, the Dispute Committee shall forward to the Board of County Commissioners its recommendations, which shall include relevant background information related to the procurement.

Upon receiving the recommendation from the Dispute Committee, the Board of County Commissioners shall conduct a hearing on the matter at a regularly scheduled meeting. Following presentations by the affected parties, the Board shall render its decision on the merits of the Protest.

If the Board's decision upholds the recommendation by the Dispute Committee regarding the award, and further finds that the Protest was either frivolous and/or lacked merit, the Board, at its discretion, may assess costs, charges, or damages associated with any delay of the award, or any costs incurred with regard to the protest. These costs, charges or damages may be deducted from the security (bond or letter of credit) provided by the contractor/vendor/firm. Any costs, charges or damages assessed by the Board in excess of the security shall be paid by the protesting contractor/vendor/firm within thirty (30) calendar days of the Board's final determination concerning the award.

All formal bid/quote/proposal solicitations shall set forth the following statement:

"FAILURE TO FOLLOW THE BID PROTEST PROCEDURE REQUIREMENTS WITHIN THE TIMEFRAMES AS PRESCRIBED HEREIN AND ESTABLISHED BY LEE COUNTY BOARD OF COUNTY COMMISSIONERS, FLORIDA, SHALL CONSTITUTE A WAIVER OF YOUR PROTEST AND ANY RESULTING CLAIMS."

11. **PUBLIC ENTITY CRIME**

Any person or affiliate as defined by statute who has been placed on the convicted vendor list following a conviction for a public entity crime may not submit a bid or a contract to provide any goods or services to the County; may not submit a bid on a contract with the County for the construction or repair of a public building or a public work; may not submit bids or leases of real property to the County; may not be awarded or perform

works as a contractor, supplier, subcontractor, or consultant under a contract with the County, and may not transact business with the County in excess of $25,000.00 for a period of 36 months from the date of being placed on the convicted vendor list.

12. **QUALIFICATION OF QUOTERS** (unless otherwise noted)

Quotes will be considered only from firms normally engaged in the sale and distribution or provision of the services as specified herein. Quoters shall have adequate organization, facilities, equipment, and personnel to ensure prompt and efficient service to Lee County. The County reserves the right before recommending any award to inspect the facilities and organization; or to take any other action necessary to determine ability to perform is satisfactory, and reserves the right to reject quotes where evidence submitted or investigation and evaluation indicates an inability of the quoter to perform.

13. **MATERIAL SAFETY DATA SHEETS**

In accordance with Chapter 443 of the Florida Statues, it is the vendor's responsibility to provide Lee County with Materials Safety Data Sheets on quoted materials, as may apply to this procurement.

14. **MISCELLANEOUS**

If a conflict exists between the General Conditions and the detailed specifications, then the detailed specifications shall prevail.

15. **WAIVER OF CLAIMS**

Once this contract expires, or final payment has been requested and made, the awarded contractor shall have no more than 30 days to present or file any claims against the County concerning this contract. After that period, the County will consider the Contractor to have waived any right to claims against the County concerning this agreement.

16. **AUTHORITY TO PIGGYBACK**

It is hereby made a precondition of any quote and a part of these specifications that the submission of any quote in response to this request constitutes a quote made under the same conditions, for the same price, and for the same effective period as this quote, to any other governmental entity.

17. **COUNTY RESERVES THE RIGHT**

a) State Contract

If applicable, the County reserves the right to purchase any of the items in this quote from State Contract Vendors if the prices are deemed lower on State Contract than the prices we receive in this quotation.

b) Any Single Large Project

The County, in its sole discretion, reserves the right to separately quote any project that is outside the scope of this quote, whether through size, complexity, or dollar value.

c) Disadvantaged Business Enterprises

The County, in its sole discretion, reserves the right to purchase any of the items in this quote from Disadvantage Business Enterprise vendor if the prices are determined to be in the best interest of the County, to assist the County in the fulfillment of any of the County's grant commitments to federal or state agencies.

The County further reserves the right to purchase any of the items in this quote from DBE's to fulfill the County's state policy toward DBE's as outlined in County Ordinance 88-45 and 90-04, as amended.

d) Anti-Discrimination

The vendor for itself, its successors in interest, and assignees, as part of the consideration there of covenant and agree that:

In the furnishing of services to the County hereunder, no person on the grounds of race, religion, color, age, sex, national origin, handicap or marital status shall be excluded from participation in, denied the benefits of, or otherwise be subjected to discrimination.

The vendor will not discriminate against any employee or applicant for employment because of race, religion, color, age, sex, national origin, handicap or marital status. The vendor will make affirmative efforts to insure that applicants are employed and that employees are treated during employment without regard to their race, religion, color, age, sex, national origin, handicap or marital status. Such action shall include, but not be limited to, acts of employment, upgrading, demotion or transfer; recruitment advertising; layoff or termination, rates of pay or

other forms of compensation and selection for training, including apprenticeship.

Vendor agrees to post in a conspicuous place, available to employees and applicants for employment, notices setting forth the provisions of this anti-discrimination clause.

Vendor will provide all information and reports required by relevant regulations and/or applicable directives. In addition, the vendor shall permit access to its books, records, accounts, other sources of information, and its facilities as may be determined by the County to be pertinent to ascertain compliance. The vendor shall maintain and make available relevant data showing the extent to which members of minority groups are beneficiaries under these contracts.

Where any information required of the vendor is in the exclusive possession of another who fails ore refuses to furnish this information, the vendor shall so certify to the County its effort made toward obtaining said information. The vendor shall remain obligated under this paragraph until the expiration of three (3) years after the termination of this contract.

In the event of breach of any of the above anti-discrimination covenants, the County shall have the right to impose sanctions as it may determine to be appropriate, including withholding payment to the vendor or canceling, terminating, or suspending this contract, in whole or in part.

Additionally, the vendor may be declared ineligible for further County contracts by rule, regulation or order of the Board of County Commissioners of Lee County, or as otherwise provided by law.

The vendor will send to each union, or representative of workers with which the vendor has a collective bargaining agreement or other contract of understanding, a notice informing the labor union of worker's representative of the vendor's commitments under this assurance, and shall post copies of the notice in conspicuous places available to the employees and the applicants for employment.

The vendor will include the provisions of this section in every subcontract under this contract to insure its provisions will be binding upon each subcontractor. The vendor will take such actions with respect to any subcontractor, as the contracting agency may direct, as a means of enforcing such provisions, including sanctions for non-compliance.

18. **AUDITABLE RECORDS**

The awarded vendor shall maintain auditable records concerning the procurement adequate to account for all receipts and expenditures, and to document compliance with the specifications. These records shall be kept in accordance with generally accepted accounting methods, and Lee County reserves the right to determine the record-keeping method required in the event of non-conformity. These records shall be maintained for two years after completion of the project and shall be readily available to County personnel with reasonable notice, and to other persons in accordance with the Florida Public Disclosure Statues.

19. **DRUG FREE WORKPLACE**

Whenever two or more quotes/proposals, which are equal with respect to price, quality and service, are received for the procurement of commodities or contractual services, a quote/proposal received from a business that certifies that it has implemented a drug-free workplace program shall be given preference in the award process. In order to have a drug-free workplace program, a business shall comply with the requirements of Florida Statutes 287.087.

20. **REQUIRED SUBMITTALS**

Any submittals requested should be returned with the quote response. This information may be accepted after opening, but no later than 10 calendar days after request.

21. **TERMINATION**

Any agreement as a result of this quote may be terminated by either party giving thirty (30) calendar days advance written notice. The County reserves the right to accept or not accept a termination notice submitted by the vendor, and no such termination notice submitted by the vendor shall become effective unless and until the vendor is notified in writing by the County of its acceptance.

The Purchasing Director may immediately terminate any agreement as a result of this quote for emergency purposes, as defined by the Lee County Purchasing and Payment Procedure Manual.

Any vendor who has voluntarily withdrawn from a formal quote/proposal without the County's mutual consent during the contract period shall be barred from further County procurement for a period of 180 days. The vendor may apply to the Board of Lee County Commissioners for waiver of this debarment. Such application for waiver of debarment must be coordinated with and processed by Purchasing.

22. **CONFIDENTIALITY**

Vendors should be aware that all submittals (including financial statements) provided with a quote/proposal are subject to public disclosure and will **not** be afforded confidentiality.

23. **ANTI-LOBBYING CLAUSE**

All firms are hereby placed on formal notice that neither the County Commissioners nor candidates for County Commission, nor any employees from the Lee County Government, Lee County staff members, nor any members of the Qualification/Evaluation Review Committee are to be lobbied, either individually or collectively, concerning this project. Firms and their agents who intend to submit qualifications, or have submitted qualifications, for this project are hereby placed on *formal notice* that they are ***not*** to contact County personnel for such purposes as holding meetings of introduction, meals, or meetings relating to the selection process outside of those specifically scheduled by the County for negotiations. Any such lobbying activities may cause immediate disqualification for this project.

24. **INSURANCE (AS APPLICABLE)**

Insurance shall be provided, per the attached insurance guide. Upon request, an insurance certificate complying with the attached guide may be required prior to award.

FORMAL QUOTATION NO.:Q-060117

LEE COUNTY, FLORIDA
PROPOSAL QUOTE FORM
FOR BELT PRESS REBUILT FOR KLAMPRESS SIZE 3
(2.0 METER) TYPE 85 FOR LEE COUNTY UTILITIES

DATE SUBMITTED: _____

VENDOR NAME: _____

TO: The Board of County Commissioners
Lee County
Fort Myers, Florida

Having carefully examined the "General Conditions", and the "Detailed Specifications", all of which are contained herein, the Undersigned proposes to furnish the following which meet these specifications:

The undersigned acknowledges
receipt of Addenda numbers: _____

GRAND TOTAL COST $_____

NOTE: SUBMITTALS ARE REQUIRED WITH THIS QUOTE. SEE PAGE 25 DIVISION 3 CONTRACTORS QUALIFICATIONS. ALL REQUESTED SUBMITTALS SHALL BE SUBMITTEDWITH YOUR FIRMS QUOTATION.

TO BE COMPLETED WITHIN _____CALENDAR DAYS AFTER RECEIPT OF AWARD AND PURCHASE ORDER.

Is your firm interested in being considered for the Local Vendor Preference?
Yes _____ No _____

If yes, then read the paragraph entitled "Local Vendor Preference" included in these specifications. Also complete the Local Vendor Preference Questionnaire and return with your quotation.

Quoters should carefully read all the terms and conditions of the specifications. Any representation of deviation or modification to the quote may be grounds to reject the quote.

Are there any modifications to the quote or specifications:

Yes _____ No _____

Failure to clearly identify any modifications in the space below or on a separate page may be grounds for the quoter being declared nonresponsive or to have the award of the quote rescinded by the County.

MODIFICATIONS:

Quoter shall submit his/her quote on the County's Proposal Quote Form, including the firm name and authorized signature. Any blank spaces on the Proposal Quote Form, qualifying notes or exceptions, counter offers, lack of required submittals, or signatures, on County's Form may result in the Quoter/Quote being declared non-responsive by the County.

ANTI-COLLUSION STATEMENT

THE BELOW SIGNED QUOTER HAS NOT DIVULGED TO, DISCUSSED OR COMPARED HIS QUOTE WITH OTHER QUOTERS AND HAS NOT COLLUDED WITH ANY OTHER QUOTER OR PARTIES TO A QUOTE WHATSOEVER. NOTE: NO PREMIUMS, REBATES OR GRATUITIES TO ANY EMPLOYEE OR AGENT ARE PERMITTED EITHER WITH, PRIOR TO, OR AFTER ANY DELIVERY OF MATERIALS. ANY SUCH VIOLATION WILL RESULT IN THE CANCELLATION AND/OR RETURN OF MATERIAL (AS APPLICABLE) AND THE REMOVAL FROM THE MASTER BIDDERS LIST.

FIRM NAME _____

BY (Printed): _____

BY (Signature): _____

TITLE: _____

FEDERAL ID # OR S.S.#_____

ADDRESS: _____

_____

PHONE NO.:_____

FAX NO.: _____

CELLULAR PHONE/PAGER NO.: _____

LEE COUNTY OCCUPATIONAL LICENSE NUMBER: _____

E-MAIL ADDRESS_____

REVISED: 7/28/00

LEE COUNTY, FLORIDA
DETAILED SPECIFICATIONS FOR MODIFICATIONS AND REPAIRS
ASHBROOK CORPORATION KLAMPRESS SIZE 3 (2.0 METER) Type 85
FOR LEE COUNTY UTITLITIES

DIVISION 1: GENERAL REQUIREMENTS

1.01 Scope of Work
1.02 Delivery requirements
1.03 Basis of Award
1.04 Workmanship and Design
1.05 Quality Assurance
1.06 Patents

DIVISION 2: MECHANICAL REQUIREMENTS

2.01 Recondition Rollers
2.02 Bearings
2.03 Structural Main Frame
2.04 Spray Brushes & Spray Nozzles
2.05 Hydraulic Cylinders
2.06 Electrical System
2.07 Belt Drive System
2.08 Bull & Pinion Gears
2.09 Drain Pans
2.10 Discharge Blades/Chicane Blades
2.11 Poly Wear Bars/Rubber Seal
2.12 Dewater Belts
2.13 Hydraulic Unit

DIVISION 3: CONTRACTOR'S QUALIFICATIONS

DIVISION 4: WARRANTIES

Note: At the end of each of the following divisions you will asked if your firm can meet the requirements in each division. If you answer the question regarding meeting the requirements with a NO response your firm will be considered non-responsive. In other words to be considered for this project you must answer unequivocally YES.

DIVISION 1: GENERAL REQUIREMENTS

1.01 Scope of Work

The successful bidder understands that this is a turnkey project that will include the following:

a. All parts, handling, arranging, scheduling,crane service and shipping services to the awarded vendors facility and the shipping services to return to the counties facility will be paid by the contractor.
b. All work shall be coordinated with the Plant Superintendent prior to commencing.
c. All parts shall be new, of current original equipment manufacturer only. **(OEM)**
d. All labor to perform factory modifications and repairs shall be by current original equipment manufacturer qualified factory trained personnel experienced in the disassemble/reassemble of the Klampress.

1.02 Delivery Requirements

The grand total cost quoted shall include delivery, F.O.B. Destination.

1.03 Basis of Award

The basis of award for this quotation will be the overall low quoter (lowest grand total cost) meeting specifications.

1.04 Workmanship and Design

All new original equipment manufacturer parts and reconditioned components shall be engineered for long, continuous and uninterrupted service. Provisions shall be made for easy lubrication, adjustment, or replacement of all parts. Corresponding parts of multiple units shall be interchangeable.

1.05 Quality Assurance

Consideration will be given only to bidders who can demonstrate that they comply with all requirements of the specifications.
Bidder submitting bid for said work shall be by a firm who is regularly engaged in the design, fabrication, assembly, testing, start-up and servicing of the Klampress.

If a bidder does not have a formal quality system in place, or documentation to prove so, a performance/maintenance bond in the amount of 100% of the installed price (including equipment, labor, piping, and wiring associated with the system covered under this specification) will be required. The bond should be made out to the owner for 100% of the amount bid, and shall be in force for a minimum of five (5) years from the date of first beneficial use of the equipment. The five (5) year minimum is to cover all warranties listed under this specification. The performance bond shall be issued by the successful quoter within twenty-one calendar days from date of Written Intent to Award. A surety company considered satisfactory by Lee County and otherwise authorized to transact business in the State of Florida shall be required from the successful quoter. This shall insure the faithful performance of the obligations imposed by the resulting contract and protect the County from lawsuits for non-payment of debts incurred during the successful quoter's performance under such contract.

QUALIFICATIONS OF SURETY COMPANIES

In order to be acceptable to the County, a surety company issuing quotation guaranty bonds or performance bonds in the amount listed, called for herein, shall meet and comply with the following minimum standards:

All Sureties for Lee County projects, must be admitted to do business in the State of Florida and shall comply with the provisions of Florida Statute 255.05.

Attorneys-in-fact who sign bid bonds or performance bonds for Lee County projects must file with such bond a certified copy of their Power of Attorney to sign such bond.

Agents of surety companies must list their name, address and telephone number on all bonds.

The life of the bond provided to Lee County shall extend for the term of the warranty (5years).

To be acceptable to the Owner as Surety on projects not in excess of $500,000.00, Surety shall comply with these minimum provisions of State Statute 287.0935 as follows:

Surety must have twice the minimum surplus and capital required by Florida Insurance Code at the time of bid solicitation.

Surety must be in compliance with all provisions of the Florida Insurance Code and hold a currently valid certificate of authority issued by the United States Department of the Treasury under SS.31 U.S.C. 9304-9308.

Sureties on projects in excess of $500,000.00 shall comply with the above minimum provisions as well as being rated through A.M. Best shall comply with the following provisions:

The Surety shall be rated as "A-" or better as to General Policyholders Rating and Class VII or better as to financial category by the most current Best's Key Rating Guide, published by A.M. Best Company.

Surety must have fulfilled all of its obligations on all other bonds previously given to the County. Surety must have a minimum underwriting limitation of $5,000,000 published in the latest

edition of the Federal Register for Federal Bonds (U.S. Dept. of Treasury).

1.06 Patents

The bidder warrants that the machine components for rebuilding the existing equipment will not infringe any U.S. or foreign patents or patents pending. In the event of any claim of infringement the bidder shall defend and indemnify the owner free from any liabilities associated with the use of the patented equipment or process.

The bidder hereby grants to the owner, in perpetuity, a paid-up license to use any inventions covered by patent or patents pending, owned, or controlled by the bidder in the operation of the facility being constructed in conjunction with the equipment supplied under this contract, but without the right to grant sublicenses.

Can your firm meet and abide by the Division 1 General Requirements? _____YES or _____No

DIVISION 2: MECHANICAL REQUIREMENTS

2.01 Recondition Rollers

Roller reconditioning, Reconditioning of solid rollers shall consist of removing the existing coating then recoating. The existing coating will be machined off to the true roller diameter prior to applying new coating. No other method of removing existing coating will be acceptable. Drive rollers shall be recoated with ¼ inch Buna N rubber. All other solid rollers shall be recoated with 30 mils. of nylon (Rilsan). Roller shall be coated up to the point of insertion into the bearing block. Perforated dandy roller shall be sandblasted, cleaned and inspected. If the skin of this roller is cracked beyond repair replacement of the roller will be needed. The new roller shall have improved thicker design outer skin.

Preparation of rollers prior to applying new coatings shall be as specified above.

The heat setting thermoplastic nylon (Rilsan) coating shall have the following properties. Nylon coating shall be applied by means of fluidized bed process. Spray-on method will also be acceptable. Any rollers beyond repair will be replaced. Any wedge plates beyond repair will be replaced.

Coefficient of friction: 0.10-0.30

Elongation (ASTM D638): 15%

Hardness, Shore D, (ASTM D2240): 77 minimum

Impact, RT. & 45 F, direct pass, (ASTM D2794): 160in.lbs. min

Melting point, (ASTM D789): 370 degrees F min

Rockwell Hardness, R Scale, 20 Degrees C: 06

Scratch Resistance, Clemen Apparatus: 59 N min.
(0.44mm thickness)

Tensile strength, psi, (ASTM D638): 6,000 min

Buna-N rubber coating shall have the following properties:

Tensile strength, ASTM D-412: 2,500 psi min

Tear strength, die C, ASTM D-624: 360 psi min

Elongation at break, ASTM D-412: 90%

Hardness, Shore A, ASTM D-676 90

2.02 Bearings

Reconditioning of the existing bearing assemblies shall consist of: a) clean and recoat bearing housings; b) install new bearings (with machined brass retainer) and c) replace all bearing internal components (ie. triple labyrinth seals, spacers, taper lock nut assembly, splash guards, etc.). All new internal bearing components must meet the original design specifications.

Bearing housings shall be coated with 8-12 mils of thermoplastic nylon (Rilsan), as specified per Section 2.01.

Bearings supporting the steering rollers shall be non-self aligning cylindrical roller bearings in pivot mounted pillow block housings.

All other rollers shall be supported by self aligning spherical roller bearings mounted in fixed pillow block housings. Any bearing houses beyond repair need to be replaced.

All bearings shall have a minimum L10 bearing life of 500,000 hours, calculated by using the ANSI/AFBMA, Std 11-1978, standard with 1.15 capacity modification factor per ISO recommendation. The L10 life shall be based on the summation of forces applied to the bearings from roller mass forces and belt tension on the rollers. The belt tension forces exerted on the pressure zone rollers shall include a minimum load of 200 pounds per lineal inch of belt width, which equates to a belt tension of 50 pli. Certified calculations, based on the AFBMA/ISO capacity formula, showing that all bearings comply with the specified requirements for minimum L10 bearing life, at maximum loadings, shall be submitted to the engineer as set forth in the contract documents upon request.

Recoated bearing housings shall be class 30 cast iron with four mounting bolts and four cap bolts. The outer side of the housing shall be solid, without end caps or filler plugs. The housings shall be designed with an integrally cast water trough which, when shrouded by a shaft mounted water flinger, shall divert water from the bearing seal area. The housings shall be cleaned, iron phosphated, and coated as specified per Section 2.01.

The bearing seal in the pillow block housing shall be of nonmetallic construction with a carrier/flinger which rotates with the roller shaft. A static sealing arrangement between the carrier/flinger and the shaft shall be a triple rubber seal, constructed in a manner that prevents relative rotation between the seal and the shaft. A dynamic sealing arrangement between the carrier/flinger and the bearing housing shall consist of a primary dynamic contact seal of ozone resistant rubber which shall seal by rotational contact with a machined housing surface. A secondary dynamic seal shall be a labyrinth seal between the carrier/flinger and the bearing housing which utilizes a nonmetallic retaining ring to hold the seal assembly in position within the housing.

Bearing lubrication shall be performed through a monel or type 316 stainless steel button head grease fitting mounted on the bearing housing. All bearings shall be outboard (externally mounted) and shall be greaseable while the unit is in operation. Lubrication shall not be required more often than once every six months.

The manufacturer of the belt filter press shall warrant the complete bearing assembly, as specified herein, for a period of five years from the date of start-up, or acceptance of the equipment, whichever occurs first. The warranty shall include all parts for repairing or replacing any bearing assembly part that fails during the warranty period.

All mounting hardware (type 316 stainless steel) shall be provided to secure the bearing housings to the main frame of the machine.

2.03 Structural Main Frame

The structural main frame and all other galvanized structural components and all carbon steel painted components shall be cleaned and hot dipped galvanized to a 4-7 mills minimum thickness. No welding shall be allowed after frame and components have been galvanized.

The galvanized coating shall be warranted for a period of three
years from the date of start-up, not to exceed three and a half years from date of delivery. The frame shall not require preventive maintenance during the warranty period. Any defects or corrosion occurring within the warranty period shall be repaired or replaced at no additional cost to the owner.

2.04 Spray Brushes & Spray Nozzles

New upper and lower washbox inner spray bar brush. Total of (44) forty four 2.5mm spray nozzles, nozzle gaskets and retaining rings for upper and lower spray bars.

2.05 Hydraulic System

The worn hydraulic system shall be replaced. New hydraulic system to consist of original equipment manufacturer's 316 stainless steel steering valves, tensioning valve, fittings, tensioning and steering cylinders.

New upper and lower steering valves shall be provided with a 316 stainless steel paddle weldment and ceramic wear pad which rides on the edge of the belts to detect their position.

Replace existing hydraulic cylinders with the latest O.E.M. fiberglass steering and tensioning cylinders. New hydraulic cylinders shall have fiberglass outer casing, laminated phenolic heads, stainless steel tie rods and 316 stainless steel piston rods. Operating pressure of fiberglass cylinders shall be rated at 750psi.
New drive side and non-drive side steering pivot plates.

The new steering valves and tensioning valve shall be warranted for a period of 5 years against defects of workmanship and operations. Valves will not be warranted due to damage resulting from neglect or misuse. Replace hydraulic lines as needed.

2.06 Electrical System

The worn electrical system shall be replaced with new electrical system. New electrical system to consist of belt limit switches, belt breakage proximity switches, no-cake proximity switch and press mount 316 stainless steel NEMA 4x junction box and wiring/fittings.

2.07 Belt Drive System

New platform mounted gear reducer (Eurodrive K87). New DC motor meeting the latest design standards shall be installed. Gear reducer shall meet the latest original equipment manufacture **(O.E.M.)** design standards. All parts will be made to the O.E.M's standard level of quality under ISO9001:2000 certified procedures. New Eurodrive platform mounted gear reducer is warranted for two years against defects in materials and workmanship.

2.08 Bull & Pinion Gears

New set of drive gears including (2) two main bull gears, (1) one pinion gear and (2) two drive bushings.

2.09 Drainage Pans

New stainless steel drainage pans shall be provided as necessary to contain filtrate from all dewatering areas within the belt filter press without splashing and to prevent rewetting of downstream cake. All drainage piping shall be furnished, adequately sized for the intended service, and rigidly attached to the press frame.

Drainage piping shall terminate inside the structural frame at the bottom of the press. Drain connection shall be self-venting to prevent overflow. Drainage pans shall be located such that the moving belts do not come into contact with the pans under any conditions.

All new drain pans, piping and splash guards shall be identical to new collection system on the new belt filter presses

2.10 Discharge Blades/Chicane Blades

New discharge blades shall be provided to scrap dewatered sludge from the belt at the final discharge rollers. New chicane blades and 316 stainless steel locking collars shall be installed in the gravity section. All hardware shall be 316 stainless steel.

The blades shall be of ultra high molecular weight polyethylene construction, shall be readily removable and shall be identical to the discharges blades on the new belt filter presses.

2.11 Poly Wear Bars/Rubber Seal

New poly wear bars (ultra-high molecular weight polyethylene) shall be installed on the upper and lower gravity grid weldments.

New rubber seal material shall be installed on the washboxes and on the sludge restrainers in the gravity and wedge sections.

2.12 Dewatering Belts

Each belt filter press shall be supplied with a new set of dewatering belts(6647 Durotex Belts). Belts shall be fabricated of monofilament polyester and shall have 316 Stainless Steel seams. The mesh design shall be selected for optimum dewatering of the sludge to be processed.

Belt selection shall be based on the manufacturers experience obtained from testing the sludge during start-up of the belt filter press(es) and at other installations dewatering similar sludges with similar polyelectrolyte conditioning chemicals.

Each belt and connecting seam shall be designed for a minimum tensile strength equal to five times the normal maximum dynamic
tension to which the belt shall be subjected. The seam shall be designed to fail before the belt.

Belts shall have a width as hereinbefore specified and shall have a minimum life warranty of 2,000 hours operation at the rated design conditions. The manufacturer shall prorate the charge for replacement belts, based on the total number of hours of operation since the belt filter press was placed into useful service.

Belts shall be designed for ease of replacement with a minimum of belt filter down time. Belt replacement shall be such that disassembly of the equipment is not required.

2.13 Hydraulic Power Unit

The existing free-standing 20 gallon hydraulic power unit shall be upgraded with the latest original equipment manufacturer (O.E.M.) stand mounted hydraulic unit.

The belt filter press shall be provided with a dedicated hydraulic power system to provide pressurized oil for the steering and tensioning. The unit shall consist of a two-gallon 316 stainless steel reservoir; variable-displacement pressure compensated hydraulic oil pump and drive motor, hydraulic oil filter (reusable), pressure gauges, piping and valves to make a complete operational system.

The pump, motor, reservoir, oil filter and valves shall be mounted to a free standing hydraulic stand. All hydraulic lines shall be properly sized for the pressure and flow of the unit.

The pump motor shall be a 1hp and shall not exceed a noise level of 70 DBA. The motor shall be a cast iron TEFC 1,200 rpm, NEMA B design with a "C" face mounting for the hydraulic pump adapter.

Maximum system pressure shall be set equal to the highest pressure required to obtain the desired operating belt tension. The maximum system operating pressure is 1,000 PSI.

Hydraulic system controls shall be grouped for easy access and ease of operation. There shall be means provided to retract the belt tension cylinders for service. The valves, fittings, manifold and associated parts shall be of non-corroding materials such as FRP, glass filled Nylon and stainless steel.

The oil pressure gauges, one for each belt tension cylinders (upper & lower belt) shall indicate oil pressure in PSI and the belt tension in PLI. Normal operating limits shall be indicated on the face of each gauge. Low-pressure switches shall be provided to sense the absence of belt tension pressure.

Customer's electrician shall be responsible for electrical wiring/conduit between new press mounted motor/pressure switches and Belt Press Control Panel.
Hydraulic unit shall meet the latest original equipment manufacture **(O.E.M.)** design standards. All parts will be made to the O.E.M's standard level of quality.

Can your firm meet and abide by the Division 2 General Mechanical Requirements? _____YES or _____No

DIVISION 3: CONTRACTOR'S QUALIFICATIONS (SUBMITTALS)

The bid shall be awarded to a responsible bidder, qualified by experience to provide the work specified. The bidder shall submit the following information with his bid.

A. Experience record showing the bidder's experience in similar work.
B. List and brief description of similar work satisfactorily completed with location, dates, contact names, addresses of owners and phone numbers.
C. List of equipment and facilities available to do the work.
D. List of personnel, by name and title, contemplated to perform the repairs and modifications to the equipment.
E. Provide proof of ability to obtain a Performance/maintenance bond, if you do not have a formal quality system inplace.

The bidder is required list all equipment that does not meet O.E.M Specification. Supporting documentation must also be provided to verify that material that does not meet O.E.M. specification is of equal quality. (Insert additional pages as required).

Can your firm meet and abide by the Division 3 Contractor's Qualification Requirements? _____YES or _____No

DIVISION 4: WARRANTY

The contractor shall warrant that the Klampress shall be free from defects in material and workmanship for a period of five years from date of recommissioning equipment, unless noted otherwise within the specifications.

Can your firm meet and abide by the Division 4 Warranty Requirements? _____YES or _____No

LOCAL BIDDER'S PREFERENCE

Note: In order for your firm to be considered for the local vendor preference, you must complete and return the attached "Local Vendor Preference Questionnaire" with your quotation.

The Lee County Local Bidder's Preference Ordinance No. 00-10 is being included as part of the award process for this project. As such, Lee County at its sole discretion, may choose to award a preference to any qualified "Local Contractor/Vendor" in an amount not to exceed 3 % of the total amount quoted by that firm.

"Local Contractor / Vendor" shall mean: a) any person, firm, partnership, company or corporation whose principal place of business in the sole opinion of the County, is located within the boundaries of Lee County, Florida; or b) any person, firm, partnership, company or corporation that has provided goods or services to Lee County on a regular basis for the preceding consecutive five (5) years, and that has the personnel, equipment and materials located within the boundaries of Lee County sufficient to constitute a present ability to perform the service or provide the goods.

The County reserves the exclusive right to compare, contrast and otherwise evaluate the qualifications, character, responsibility and fitness of all persons, firms, partnerships, companies or corporations submitting formal bids or formal quotes in any procurement for goods or services when making an award in the best interests of the County.

ATTACHMENT A

LOCAL VENDOR PREFERENCE QUESTIONNAIRE
(LEE COUNTY ORDINANCE NO. 00-10)

Instructions: Please complete either Part A or B whichever is applicable to your firm

PART A: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS LOCATED WITHIN LEE COUNTY (Only complete Part A if your principal place of business is located within the boundaries of Lee County)

1. What is the physical location of your principal place of business that is located within the boundaries of Lee County, Florida?

_____

_____

2. What is the size of this facility (i.e. sales area size, warehouse, storage yard, etc.)

_____

_____

_____

PART B: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS NOT LOCATED WITHIN LEE COUNTY OR DOES NOT HAVE A PHYSICAL LOCATION WITHIN LEE COUNTY (Please complete this section.)

1. How many employees are available to service this contract? _____

2. Describe the types and amount of equipment you have available to service this contract.

_____

_____

_____

LOCAL VENDOR PREFERENCE QUESTIONNAIRE CONTINUED

3. Describe the types and amount of material stock that you have available to service this contract.

_____

_____

_____

4. Have you provided goods or services to Lee County on a regular basis for the preceding, consecutive five years?

Yes _____ No _____

If yes, please provide your contractual history with Lee County for the past five, consecutive years. Attach additional pages if necessary.

_____

_____

_____

_____

_____

_____

INSURANCE REQUIREMENTS

NOTE: Your certificate of insurance must meet the following requirements:

Requirement #1:

The Lee County Board of County Commissioners shall be added as an additional insured on the comprehensive general liability policy.

Requirement #2:

Certificate holder shall be listed as follows:

Lee County Board of County Commissioners
C/O Lee County Purchasing
P.O. Box 398
Fort Myers, FL 33902-0398

Requirement #3:

Each policy shall provide a 30-day notification clause in the event of cancellation, non-renewal or adverse change.

STANDARD CONTRACT - Contracts that will not exceed three hundred and sixty five (365) calendar days; or where costs will not exceed $500,000; and/or there are no unusual hazards present.

1. Minimum Insurance Requirements: ***Risk Management in no way represents that the insurance required is sufficient or adequate to protect the vendor's interest or liabilities, but are merely minimums.***

   a. Workers' Compensation - Statutory benefits as defined by FS 440 encompassing all operations contemplated by this contract or agreement to apply to all owners, officers, and employees regardless of the number of employees. Individual employees may be exempted per State Law. Employers' liability will have minimum limits of:

   $500,000 per accident
   $500,000 disease limit
   $500,000 disease limit per employee

b. Commercial General Liability - Coverage shall apply to premises and/or operations, products and/or completed operations, independent contractors, contractual liability, and broad form property damage exposures with minimum limits of:

$500,000 bodily injury per person (BI)
$1,000,000 bodily injury per occurrence (BI)
$500,000 property damage (PD) or
$1,000,000 combined single limit (CSL) of BI and PD

c. Business Auto Liability - The following Automobile Liability will be required and coverage shall apply to all owned, hired and non-owned vehicles use with minimum limits of:

$500,000 bodily injury per person (BI)
$1,000,000 bodily injury per occurrence (BI)
$100,000 property damage (PD) or
$1,000,000 combined single limit (CSL) of BI and PD

The required limit of liability shown in Standard Contract: 1.a; 1.b; 1.c; may be provided in the form of "Excess Insurance" or "Commercial Umbrella Policies." In which case, a "Following Form Endorsement" will be required on the "Excess Insurance Policy" or "Commercial Umbrella Policy."

2. Verification of Coverage:

a. Ten (10) days prior to the commencement of any work under this contract a certificate of insurance will be provided to the Risk Manager for review and approval. The certificate shall provide for the following:

1. ***"Lee County, a political subdivision and Charter County of the State of Florida, its agents, employees, and public officials@*** **will be named as an "Additional Insured" on the General Liability policy.**

2. Lee County will be given thirty (30) days notice prior to cancellation or modification of any stipulated insurance. Such

notification will be in writing by registered mail, return receipt requested and addressed to the Risk Manager (P.O. BOX 398 Ft. Myers, FL 33902).

3. Special Requirements:

   a. An appropriate "Indemnification" clause shall be made a provision of the contract.

   b. It is the responsibility of the general contractor to insure that all subcontractors comply with all insurance requirements.

To the fullest extent permitted by applicable law, Contractor shall protect, defend, indemnify, save and hold the County, the Board of County Commissioners, its agents, officials, and employees harmless from and against any and all claims, demands, fines, loss or destruction of property, liabilities, damages, for claims based on the negligence, misconduct, or omissions of the Contractor resulting from the Contractor's work as further described in this contract, which may arise in favor of any person or persons resulting from the Contractor's performance or non-performance of its obligations under this contract except any damages arising out of personal injury or property claims from third parties caused solely by the negligence, omission(s) or willful misconduct of the County, its officials, commissions, employees or agents, subject to the limitations as set out in Florida general law, Section 768.28, Florida Statutes, as amended. Further, Contractor hereby agrees to indemnify the County for all reasonable expenses and attorney's fees incurred by or imposed upon the County in connection therewith for any loss, damage, injury or other casualty. Contractor additionally agrees that the County may employ an attorney of the County's own selection to appear and defend any such action, on behalf of the County, at the expense of the Contractor. The Contractor further agrees to pay all reasonable expenses and attorney's fees incurred by the County in establishing the right to indemnity.

FORMAL QUOTATION NO.:Q-060117

LEE COUNTY PURCHASING - BIDDERS CHECK LIST

IMPORTANT: Please read carefully and return with your bid proposal.
Please check off each of the following items as the necessary action is completed:

____ 1. The Quote has been signed.

____ 2. The Quote prices offered have been reviewed.

____ 3. The price extensions and totals have been checked.

____ 4. The original (must be manually signed) and 2 copies of the quote have been submitted.

____ 5. Three (3) identical sets of descriptive literature, brochures and/or data (if required) have been submitted under separate cover.

____ 6. All modifications have been acknowledged in the space provided.

____ 7. All addendums issued, if any, have been acknowledged in the space provided.

____ 8. Erasures or other changes made to the quote document have been initialed by the person signing the quote.

____ 9. Bid Bond and/or certified Check, (if required) have been submitted with the quote in amounts indicated.

____ 10. Any Delivery information required is included.

____ 11. The mailing envelope has been addressed to:

MAILING ADDRESS		**PHYSICAL ADDRESS**
Lee County Purchasing		Lee County Purchasing
P.O. Box 398	or	1825 Hendry St 3rd Floor
Ft. Myers, FL 33902-0398		Ft. Myers, FL 33901

____ 12. The mailing envelope **MUST** be sealed and marked with:
Quote Number
Opening Date and/or Receiving Date

____ 13. Tbe quote will be mailed or delivered in time to be received no later than the specified opening date and time. (Otherwise quote cannot be considered or accepted.)

____ 14. If submitting a "NO BID" please write quote number here _____
and check one of the following:
_____ Do not offer this product _____ Insufficient time to respond.
_____ Unable to meet specifications (why)
_____ Unable to meet bond or insurance requirement.
Other: _____

Company Name and Address:

_____

_____

LEE COUNTY
SOUTHWEST FLORIDA

PROJECT NO.: Q-060116

OPEN DATE: May 16, 2006

AND TIME: 2:30 P.M.

PRE-BID DATE: May 10, 2006

AND TIME: 8:30 A.M.

LOCATION: Lee County Purchasing
1825 Hendry St. 3rd floor
Ft. Myers, Fl. 33901

REQUEST FOR QUOTATIONS

TITLE:
BELT PRESS REBUILT TWO (2 EACH) AQUABELT SZ 4 (3.0 METER) TYPE 85 FOR LEE COUNTY UTILITIES

REQUESTER:LEE COUNTY BOARD OF COUNTY COMMISSIONERS
DIVISION OF PURCHASING

MAILING ADDRESS
P.O. BOX 398
FORT MYERS, FL 33902-0398

PHYSICAL ADDRESS
1825 Hendry St 3rd Floor
FORT MYERS, FL 33901

BUYER: CHRIS JEFFCOAT
PURCHASING AGENT
PHONE NO.: (239) 344-5458

GENERAL CONDITIONS

Sealed Quotations will be received by the DIVISION OF PURCHASING, until 2:30pm on the date specified on the cover sheet of this "Request for Quotations", and opened immediately thereafter by the Purchasing Director or designee.

Any question regarding this solicitation should be directed to the Buyer listed on the cover page of this solicitation, or by calling the Division of Purchasing at (239) 344-5450.

1. **SUBMISSION OF QUOTE:**

   a. Quotations shall be sealed in an envelope, and the outside of the envelope should be marked with the following information:

      1. Marked with the words "Sealed Quote"
      2. Name of the firm submitting the quotation
      3. Title of the quotation
      4. Quotation number

   b. The Quotation shall be submitted in triplicate as follows:

      1. The original consisting of the Lee County quotes forms completed and signed.
      2. A copy of the original quote forms for the Purchasing Director.
      3. A second copy of the original quote forms for use by the requesting department.

   c. The following should be submitted along with the quotation in a separate envelope. This envelope should be marked as described above, but instead of marking the envelope as "Sealed Quote", please indicate the contents; i.e., literature, drawings, submittals, etc. This information should be submitted in duplicate.

      1. Any information (either required or in addition to that asked for by the specifications) necessary to analyze your quotation; i.e., required submittals, literature, technical data, financial statements.

      2. Warranties and guarantees against defective materials and workmanship.

   d. **ALTERNATE QUOTE:** If the vendor elects to submit more than one quote, then the quotes should be submitted in separate envelopes and marked as indicated above. The second, or alternate quote should be marked as "Alternate".

e. **QUOTES RECEIVED LATE:** It is the quoter's responsibility to ensure that his quote is received by the Division of Purchasing prior to the opening date and time specified. Any quote received after the opening date and time will be promptly returned to the quoter unopened. Lee County will not be responsible for quotes received late because of delays by a third party delivery service; i.e., U.S. Mail, UPS, Federal Express, etc.

f. **QUOTE CALCULATION ERRORS:** In the event there is a discrepancy between the total quoted amount or the extended amounts and the unit prices quoted, the unit prices will prevail and the corrected sum will be considered the quoted price.

g. **PAST PERFORMANCE:** All vendors will be evaluated on their past performance and prior dealings with Lee County (i.e., failure to meet specifications, poor workmanship, late delivery, etc.).

h. **WITHDRAWAL OF QUOTE:** No quote may be withdrawn for a period of 90 days after the scheduled time for receiving quotes. A quote may be withdrawn prior to the quote-opening date and time. Such a request to withdraw should be made in writing to the Purchasing Director, who will approve or disapprove of the request.

i. **COUNTY RESERVES THE RIGHT:** The County reserves the right to waive minor informalities in any quote; to reject any or all quotes with or without cause; and/or to accept the quote that in its judgment will be in the best interest of the County of Lee.

j. **EXECUTION OF QUOTE:** All quotes shall contain the signature of an authorized representative of the quoter in the space provided on the quote proposal form. All quotes shall be typed or printed in ink. The bidder may not use erasable ink. All corrections made to the quote shall be initialed.

2. **ACCEPTANCE**

The materials and/or services delivered under the quote **shall** remain the property of the seller until a physical inspection and actual usage of these materials and/or services is accepted by the County and is to be in compliance with the terms herein, fully in accord with the specifications and of the highest quality. In the event the materials and/or services supplied to the County are found to be defective or do not conform to specifications, the County reserves the right to cancel the order upon written notice to the seller and return such product to the seller at the seller's expense.

3. **SUBSTITUTIONS**

Whenever in these specifications a brand name or make is mentioned, it is the intention of the County only to establish a grade or quality of materials and not to rule out other brands or makes of equality. However, if a product other than that specified is quote, it is the vendor's responsibility to name such product with his quote and to prove to the County that said product is equal to the product specified. Lee County **shall** be the sole judge as to whether a product being offered by the quoter is actually equivalent to the one being specified by the detailed specifications. (Note: This paragraph does not apply when it is determined that the technical requirements of this solicitation require only a specific product as stated in the detailed specifications.)

4. **RULES, REGULATIONS, LAWS, ORDINANCES & LICENSES**

The awarded vendor shall observe and obey all laws, ordinances, rules, and regulations, of the federal, state, and local government, which may be applicable to the supply of this product or service.

a. Occupational License – Vendor shall submit within 10 calendar days after request.
b. Specialty License(s) – Vendor shall possess at the time of the opening of the quote all necessary permits and/or license required for the sale of this product and/or service and upon the request of the County provide copies of licenses and/or permits within 10 calendar days after request.

5. **RECYCLED PRODUCTS**

It is the Lee County Board of County Commissioners' stated policy objective to "Ensure all departments are aware of the availability of recycled products..." (Administrative Code #AC-10-4). In an effort to provide the utmost opportunity for the use of recycled products by Lee County, vendors should list on their letterhead, all necessary information regarding any applicable recycled products they have available. Recycled products should meet all other specifications listed and have a minimum of 50%-recycled content. Whenever fiscally feasible, available recycled products will be purchased.

6. **WARRANTY/GUARANTY** (unless otherwise specified)

All materials and/or services furnished under this quote shall be warranted by the vendor to be free from defects and fit for the intended use.

7. PRE-BID CONFERENCE

A pre-bid conference will be held at the location, date, and time specified on the cover of this solicitation. Pre-bid conferences are generally non-mandatory, but it is highly recommended that everyone planning to submit a quote attend.

In the event a pre-bid conference is classified as mandatory, it will be so specified on the cover of this solicitation and it will be the responsibility of the quoter to ensure that they are represented at the pre-bid. Only those quoters who attend the pre-bid conference will be allowed to quote on this project.

8. BIDDERS LIST MAINTENANCE

A bidder should respond to "Request for Quotations" in order to be kept on the Bidder's List. Failure to respond to three different "request for quotations" may result in the vendor being removed from the Bidder's List. A bidder may do one of the following, in order to respond properly to the request:

a. Submission of a quotation prior to the quote receipt deadline.
b. Submission of a "no bid" notice prior to the quote receipt deadline.

9. LEE COUNTY PAYMENT PROCEDURES

All vendors are requested to mail one original invoice and one invoice copy to:

Lee County Finance Department
Post Office Box 2238
Fort Myers, FL 33902-2238

All invoices will be paid as directed by the Lee County payment procedure unless otherwise differently stated in the detailed specification portion of this quote.

Lee county will not be liable for request of payment deriving from aid, assistance, or help by any individual, vendor, quoter, or bidder for the preparation of these specifications.

Lee County is generally a tax-exempt entity subject to the provisions of the 1987 legislation regarding sales tax on services. Lee County will pay those taxes for which it is obligated, or it will provide a Certificate of Exemption furnished by the Department of Revenue. All contractors or quoters should include in their quote all sales or use taxes, which they will pay when making purchases of material or subcontractor's services.

10. **LEE COUNTY BID PROTEST PROCEDURE**

Any contractor/vendor/firm that has submitted a formal bid/quote/proposal to Lee County, and who is adversely affected by an intended decision with respect to the award of the formal bid/quote/proposal, shall file with the County's Purchasing Director or Public Works Director a written "Notice of Intent to File a Protest" not later than seventy-two (72) hours (excluding Saturdays, Sundays and Legal Holidays) after receipt of a "Notice of Intended Decision" from the County with respect to the proposed award of the formal bid/quote/proposal.

The "Notice of Intent to File a Protest" is one of two documents necessary to perfect Protest. The second document is the "Formal Written Protest", both documents are described below.

The "Notice of Intent to File a Protest" document shall state all grounds claimed for the Protest, and clearly indicate it as the "Notice of Intent to File a Protest". Failure to clearly indicate the Intent to file the Protest shall constitute a waiver of all rights to seek any further remedies provided for under this Protest Procedure.

The "Notice of Intent to File a Protest" shall be received ("stamped in") by the Purchasing Director or Public Works Director not later than Four o'clock (4:00) PM on the third working day following the day of receipt of the County's Notice of Intended Decision.

The affected party shall then file its Formal Written Protest within ten (10) calendar days after the time for the filing of the Notice of Intent to File a Protest has expired. Except as provided for in the paragraph below, upon filing of the Formal Written Protest, the contractor/vendor/firm shall post a bond, payable to the Lee County Board of County Commissioners in an amount equal to five percent (5%) of the total bid/quote/proposal, or Ten Thousand Dollars ($10,000.00), whichever is less. Said bond shall be designated and held for payment of any costs that may be levied against the protesting contractor/vendor/firm by the Board of County Commissioners, as the result of a frivolous Protest.

A clean, Irrevocable Letter of Credit or other form of approved security, payable to the County, may be accepted. Failure to submit a bond, letter of credit, or other approved security simultaneously with the Formal Written Protest shall invalidate the protest, at which time the County may continue its procurement process as if the original "Notice of Intent to File a Protest" had never been filed.
Any contractor/vendor/firm submitting the County's standard bond form (CSD: 514), along with the bid/quote/proposal, shall not be required to submit an additional bond with

the filing of the Formal Written Protest.

The Formal Written Protest shall contain the following:

- County bid/quote/proposal identification number and title.
- Name and address of the affected party, and the title or position of the person submitting the Protest.
- A statement of disputed issues of material fact. If there are no disputed material facts, the Formal Protest must so indicate.
- A concise statement of the facts alleged, and of the rules, regulations, statues, or constitutional provisions, which entitle the affected party to relief.
- All information, documents, other materials, calculations, and any statutory or case law authority in support of the grounds for the Protest.
- A statement indicating the relief sought by the affected (protesting) party.
- Any other relevant information that the affected party deems to be material to Protest.

Upon receipt of a timely filed "Notice of Intent to File a Protest", the Purchasing Director or Public Works Director (as appropriate) may abate the award of the formal bid/quote/proposal as appropriate, until the Protest is heard pursuant to the informal hearing process as further outlined below, except and unless the County Manager shall find and set forth in writing, particular facts and circumstances that would require an immediate award of the formal bid/quote/proposal for the purpose of avoiding a danger to the public health, safety, or welfare. Upon such written finding by the County Manager, the County Manager may authorize an expedited Protest hearing procedure. The expedited Protest hearing shall be held within ninety-six (96) hours of the action giving rise to the contractor/vendor/firm's Protest, or as soon as may be practicable for all parties. The "Notice of Intent to File a Protest" shall serve as the grounds for the affected party's presentation and the requirements for the submittal of a formal, written Protest under these procedures, to include the requirement for a bond, shall not apply.

The Dispute Committee shall conduct an informal hearing with the protesting contractor/vendor/firm to attempt to resolve the Protest, within seven working days (excluding Saturdays, Sundays and legal holidays) from receipt of the Formal Written Protest. The Chairman of the Dispute Committee shall ensure that all affected parties

may make presentations and rebuttals, subject to reasonable time limitations, as appropriate. The purpose of the informal hearing by the Dispute Committee, the protestor and other affected parties is to provide and opportunity: (1) to review the basis of the Protest; (2) to evaluate the facts and merits of the Protest: and (3) to make a determination whether to accept or reject the Protest.

Once a determination is made by the Dispute Committee with respect to the merits of the Protest, the Dispute Committee shall forward to the Board of County Commissioners its recommendations, which shall include relevant background information related to the procurement.

Upon receiving the recommendation from the Dispute Committee, the Board of County Commissioners shall conduct a hearing on the matter at a regularly scheduled meeting. Following presentations by the affected parties, the Board shall render its decision on the merits of the Protest.

If the Board's decision upholds the recommendation by the Dispute Committee regarding the award, and further finds that the Protest was either frivolous and/or lacked merit, the Board, at its discretion, may assess costs, charges, or damages associated with any delay of the award, or any costs incurred with regard to the protest. These costs, charges or damages may be deducted from the security (bond or letter of credit) provided by the contractor/vendor/firm. Any costs, charges or damages assessed by the Board in excess of the security shall be paid by the protesting contractor/vendor/firm within thirty (30) calendar days of the Board's final determination concerning the award.

All formal bid/quote/proposal solicitations shall set forth the following statement:

"FAILURE TO FOLLOW THE BID PROTEST PROCEDURE REQUIREMENTS WITHIN THE TIMEFRAMES AS PRESCRIBED HEREIN AND ESTABLISHED BY LEE COUNTY BOARD OF COUNTY COMMISSIONERS, FLORIDA, SHALL CONSTITUTE A WAIVER OF YOUR PROTEST AND ANY RESULTING CLAIMS."

11. **PUBLIC ENTITY CRIME**

Any person or affiliate as defined by statute who has been placed on the convicted vendor list following a conviction for a public entity crime may not submit a bid or a contract to provide any goods or services to the County; may not submit a bid on a contract with the County for the construction or repair of a public building or a public work; may not submit bids or leases of real property to the County; may not be awarded or perform works as a contractor, supplier, subcontractor, or consultant under a contract with the

County, and may not transact business with the County in excess of $25,000.00 for a period of 36 months from the date of being placed on the convicted vendor list.

12. **QUALIFICATION OF QUOTERS** (unless otherwise noted)

Quotes will be considered only from firms normally engaged in the sale and distribution or provision of the services as specified herein. Quoters shall have adequate organization, facilities, equipment, and personnel to ensure prompt and efficient service to Lee County. The County reserves the right before recommending any award to inspect the facilities and organization; or to take any other action necessary to determine ability to perform is satisfactory, and reserves the right to reject quotes where evidence submitted or investigation and evaluation indicates an inability of the quoter to perform.

13. **MATERIAL SAFETY DATA SHEETS**

In accordance with Chapter 443 of the Florida Statues, it is the vendor's responsibility to provide Lee County with Materials Safety Data Sheets on quoted materials, as may apply to this procurement.

14. **MISCELLANEOUS**

If a conflict exists between the General Conditions and the detailed specifications, then the detailed specifications shall prevail.

15. **WAIVER OF CLAIMS**

Once this contract expires, or final payment has been requested and made, the awarded contractor shall have no more than 30 days to present or file any claims against the County concerning this contract. After that period, the County will consider the Contractor to have waived any right to claims against the County concerning this agreement.

16. **AUTHORITY TO PIGGYBACK**

It is hereby made a precondition of any quote and a part of these specifications that the submission of any quote in response to this request constitutes a quote made under the same conditions, for the same price, and for the same effective period as this quote, to any other governmental entity.

17. **COUNTY RESERVES THE RIGHT**

a) State Contract

If applicable, the County reserves the right to purchase any of the items in this quote from State Contract Vendors if the prices are deemed lower on State Contract than the prices we receive in this quotation.

b) Any Single Large Project

The County, in its sole discretion, reserves the right to separately quote any project that is outside the scope of this quote, whether through size, complexity, or dollar value.

c) Disadvantaged Business Enterprises

The County, in its sole discretion, reserves the right to purchase any of the items in this quote from Disadvantage Business Enterprise vendor if the prices are determined to be in the best interest of the County, to assist the County in the fulfillment of any of the County's grant commitments to federal or state agencies.

The County further reserves the right to purchase any of the items in this quote from DBE's to fulfill the County's state policy toward DBE's as outlined in County Ordinance 88-45 and 90-04, as amended.

d) Anti-Discrimination

The vendor for itself, its successors in interest, and assignees, as part of the consideration there of covenant and agree that:

In the furnishing of services to the County hereunder, no person on the grounds of race, religion, color, age, sex, national origin, handicap or marital status shall be excluded from participation in, denied the benefits of, or otherwise be subjected to discrimination.

The vendor will not discriminate against any employee or applicant for employment because of race, religion, color, age, sex, national origin, handicap or marital status. The vendor will make affirmative efforts to insure that applicants are employed and that employees are treated during employment without regard to their race, religion, color, age, sex, national origin, handicap or marital status. Such action shall include, but not be limited to, acts of employment, upgrading, demotion or transfer; recruitment advertising; layoff or termination, rates of pay or

other forms of compensation and selection for training, including apprenticeship.

Vendor agrees to post in a conspicuous place, available to employees and applicants for employment, notices setting forth the provisions of this anti-discrimination clause.

Vendor will provide all information and reports required by relevant regulations and/or applicable directives. In addition, the vendor shall permit access to its books, records, accounts, other sources of information, and its facilities as may be determined by the County to be pertinent to ascertain compliance. The vendor shall maintain and make available relevant data showing the extent to which members of minority groups are beneficiaries under these contracts.

Where any information required of the vendor is in the exclusive possession of another who fails ore refuses to furnish this information, the vendor shall so certify to the County its effort made toward obtaining said information. The vendor shall remain obligated under this paragraph until the expiration of three (3) years after the termination of this contract.

In the event of breach of any of the above anti-discrimination covenants, the County shall have the right to impose sanctions as it may determine to be appropriate, including withholding payment to the vendor or canceling, terminating, or suspending this contract, in whole or in part.

Additionally, the vendor may be declared ineligible for further County contracts by rule, regulation or order of the Board of County Commissioners of Lee County, or as otherwise provided by law.

The vendor will send to each union, or representative of workers with which the vendor has a collective bargaining agreement or other contract of understanding, a notice informing the labor union of worker's representative of the vendor's commitments under this assurance, and shall post copies of the notice in conspicuous places available to the employees and the applicants for employment.

The vendor will include the provisions of this section in every subcontract under this contract to insure its provisions will be binding upon each subcontractor. The vendor will take such actions with respect to any subcontractor, as the contracting agency may direct, as a means of enforcing such provisions, including sanctions for non-compliance.

18. **AUDITABLE RECORDS**

The awarded vendor shall maintain auditable records concerning the procurement adequate to account for all receipts and expenditures, and to document compliance with the specifications. These records shall be kept in accordance with generally accepted accounting methods, and Lee County reserves the right to determine the record-keeping method required in the event of non-conformity. These records shall be maintained for two years after completion of the project and shall be readily available to County personnel with reasonable notice, and to other persons in accordance with the Florida Public Disclosure Statues.

19. **DRUG FREE WORKPLACE**

Whenever two or more quotes/proposals, which are equal with respect to price, quality and service, are received for the procurement of commodities or contractual services, a quote/proposal received from a business that certifies that it has implemented a drug-free workplace program shall be given preference in the award process. In order to have a drug-free workplace program, a business shall comply with the requirements of Florida Statutes 287.087.

20. **REQUIRED SUBMITTALS**

Any submittals requested should be returned with the quote response. This information may be accepted after opening, but no later than 10 calendar days after request.

21. **TERMINATION**

Any agreement as a result of this quote may be terminated by either party giving thirty (30) calendar days advance written notice. The County reserves the right to accept or not accept a termination notice submitted by the vendor, and no such termination notice submitted by the vendor shall become effective unless and until the vendor is notified in writing by the County of its acceptance.

The Purchasing Director may immediately terminate any agreement as a result of this quote for emergency purposes, as defined by the Lee County Purchasing and Payment Procedure Manual.

Any vendor who has voluntarily withdrawn from a formal quote/proposal without the County's mutual consent during the contract period shall be barred from further County procurement for a period of 180 days. The vendor may apply to the Board of Lee County Commissioners for waiver of this debarment. Such application for waiver of debarment must be coordinated with and processed by Purchasing.

22. **CONFIDENTIALITY**

Vendors should be aware that all submittals (including financial statements) provided with a quote/proposal are subject to public disclosure and will **not** be afforded confidentiality.

23. **ANTI-LOBBYING CLAUSE**

All firms are hereby placed on formal notice that neither the County Commissioners nor candidates for County Commission, nor any employees from the Lee County Government, Lee County staff members, nor any members of the Qualification/Evaluation Review Committee are to be lobbied, either individually or collectively, concerning this project. Firms and their agents who intend to submit qualifications, or have submitted qualifications, for this project are hereby placed on *formal notice* that they are ***not*** to contact County personnel for such purposes as holding meetings of introduction, meals, or meetings relating to the selection process outside of those specifically scheduled by the County for negotiations. Any such lobbying activities may cause immediate disqualification for this project.

24. **INSURANCE (AS APPLICABLE)**

Insurance shall be provided, per the attached insurance guide. Upon request, an insurance certificate complying with the attached guide may be required prior to award.

FORMAL QUOTATION NO.: Q-060116

LEE COUNTY, FLORIDA
PROPOSAL QUOTE FORM
FOR BELT PRESS REBUILT TWO AQUABELTS SIZE 4
(3.0 METER) TYPE 85 FOR LEE COUNTY UTILITIES

DATE SUBMITTED: _____

VENDOR NAME: _____

TO: The Board of County Commissioners
Lee County
Fort Myers, Florida

Having carefully examined the "General Conditions", and the "Detailed Specifications", all of which are contained herein, the Undersigned proposes to furnish the following which meet these specifications:

The undersigned acknowledges
receipt of Addenda numbers: _____

GRAND TOTAL COST TO REBUILD 2 AQUABELTS $_____

NOTE: SUBMITTALS ARE REQUIRED WITH THIS QUOTE. SEE PAGE 25 DIVISION 3 CONTRACTORS QUALIFICATIONS. ALL REQUESTED SUBMITTALS SHALL BE SUBMITTED WITH YOUR FIRMS QUOTATION.

TO BE COMPLETED WITHIN _____CALENDAR DAYS AFTER RECEIPT OF AWARD AND PURCHASE ORDER.

Is your firm interested in being considered for the Local Vendor Preference?
Yes _____ No _____

If yes, then read the paragraph entitled "Local Vendor Preference" included in these specifications. Also complete the Local Vendor Preference Questionnaire and return with your quotation.

Quoters should carefully read all the terms and conditions of the specifications. Any representation of deviation or modification to the quote may be grounds to reject the quote.

Are there any modifications to the quote or specifications:

Yes _____ No _____

Failure to clearly identify any modifications in the space below or on a separate page may be grounds for the quoter being declared nonresponsive or to have the award of the quote rescinded by the County.

MODIFICATIONS:

Quoter shall submit his/her quote on the County's Proposal Quote Form, including the firm name and authorized signature. Any blank spaces on the Proposal Quote Form, qualifying notes or exceptions, counter offers, lack of required submittals, or signatures, on County's Form may result in the Quoter/Quote being declared non-responsive by the County.

FORMAL QUOTATION NO.: Q-060116

ANTI-COLLUSION STATEMENT

THE BELOW SIGNED QUOTER HAS NOT DIVULGED TO, DISCUSSED OR COMPARED HIS QUOTE WITH OTHER QUOTERS AND HAS NOT COLLUDED WITH ANY OTHER QUOTER OR PARTIES TO A QUOTE WHATSOEVER. NOTE: NO PREMIUMS, REBATES OR GRATUITIES TO ANY EMPLOYEE OR AGENT ARE PERMITTED EITHER WITH, PRIOR TO, OR AFTER ANY DELIVERY OF MATERIALS. ANY SUCH VIOLATION WILL RESULT IN THE CANCELLATION AND/OR RETURN OF MATERIAL (AS APPLICABLE) AND THE REMOVAL FROM THE MASTER BIDDERS LIST.

FIRM NAME _____

BY (Printed): _____

BY (Signature): _____

TITLE: _____

FEDERAL ID # OR S.S.# _____

ADDRESS: _____

_____

PHONE NO.: _____

FAX NO.: _____

CELLULAR PHONE/PAGER NO.: _____

LEE COUNTY OCCUPATIONAL LICENSE NUMBER: _____

E-MAIL ADDRESS: _____

REVISED: 7/28/00

FORMAL QUOTATION NO.: Q-060116

LEE COUNTY,FLORIDA
DETAILED SPECIFICATIONS FOR MODIFICATIONS AND REPAIRS OF TWO ASHBROOK CORPORATION AQUABELT SIZE 4 (3.0 METER) TYPE 85 FOR LEE COUNTY UTILITIES

DIVISION 1: GENERAL REQUIREMENTS

1.01 Scope of Work
1.02 Delivery requirements
1.03 Basis of Award
1.04 Workmanship and Design
1.05 Quality Assurance
1.06 Patents

DIVISION 2: MECHANICAL REQUIREMENTS

2.01 Recondition Rollers
2.02 Bearings
2.03 Structural Main Frame
2.04 Spray Brushes & Spray Nozzles
2.05 Hydraulic Cylinders
2.06 Electrical System
2.07 Belt Drive System
2.08 Bull & Pinion Gears
2.09 Drain Pans
2.10 Discharge Blades/Chicane Blades
2.11 Poly Wear Bars/Rubber Seal
2.12 Dewater Belts
2.13 Hydraulic Unit

DIVISION 3: CONTRACTOR'S QUALIFICATIONS

DIVISION 4: WARRANTIES

Note: At the end of each of the following divisions you will asked if your firm can meet the requirements in each division. If you answer the question regarding meeting the requirements with a NO response your firm will be considered non-responsive. In other words to be considered for this project you must answer unequivocally YES.

DIVISION 1: GENERAL REQUIREMENTS

1.01 Scope of Work

The successful bidder understands that this is a turnkey project that will include the following:

a. All parts, handling, arranging, scheduling and shipping services to the awarded vendors facility and the shipping services to return to the counties facility will be paid by the contractor.
b. All work shall be coordinated with the Plant Superintendent prior to commencing.
c. All parts shall be new, of current original equipment manufacturer only. **(OEM)**
d. All labor to perform factory modifications and repairs shall be by current original equipment manufacturer qualified factory trained personnel experienced in the disassemble/reassemble of the Aquabelt.

1.02 Delivery Requirements

The grand total cost quoted shall include delivery, F.O.B. Destination.

1.03 Basis of Award

The basis of award for this quotation will be the overall low quoter (lowest grand total cost) meeting specifications.

1.04 Workmanship and Design

All new original equipment manufacturer parts and reconditioned components shall be engineered for long, continuous and uninterrupted service. Provisions shall be made for easy lubrication, adjustment, or replacement of all parts. Corresponding parts of multiple units shall be interchangeable.

1.05 Quality Assurance

Consideration will be given only to bidders who can demonstrate that they comply with all requirements of the specifications.
Bidder submitting bid for said work shall be by a firm who is regularly engaged in the design, fabrication, assembly, testing, start-up and servicing of the Aquabelt.

If a bidder does not have a formal quality system in place, or documentation to prove so, a performance/maintenance bond in the amount of 100% of the installed price (including equipment, labor, piping, and wiring associated with the system covered under this specification) will be required. The bond should be made out to the owner for 100% of the amount bid, and shall be in force for a minimum of five (5) years from the date of first beneficial use of the equipment. The five (5) year minimum is to cover all warranties listed under this specification. The performance bond shall be issued by the successful quoter within twenty-one calendar days from date of Written Intent to Award. A surety company considered satisfactory by Lee County and otherwise authorized to transact business in the State of Florida shall be required from the successful quoter. This shall insure the faithful performance of the obligations imposed by the resulting contract and protect the County from lawsuits for non-payment of debts incurred during the successful quoter's performance under such contract.

QUALIFICATIONS OF SURETY COMPANIES

In order to be acceptable to the County, a surety company issuing quotation guaranty bonds or performance bonds in the amount listed, called for herein, shall meet and comply with the following minimum standards:

All Sureties for Lee County projects, must be admitted to do business in the State of Florida and shall comply with the provisions of Florida Statute 255.05.

Attorneys-in-fact who sign bid bonds or performance bonds for Lee County projects must file with such bond a certified copy of their Power of Attorney to sign such bond.

Agents of surety companies must list their name, address and telephone number on all bonds.

The life of the bond provided to Lee County shall extend for the term of the warranty (5 years).

To be acceptable to the Owner as Surety on projects not in excess of $500,000.00, Surety shall comply with these minimum provisions of State Statute 287.0935 as follows:

Surety must have twice the minimum surplus and capital required by Florida Insurance Code at the time of bid solicitation.

Surety must be in compliance with all provisions of the Florida Insurance Code and hold a currently valid certificate of authority issued by the United States Department of the Treasury under SS.31 U.S.C. 9304-9308.

Sureties on projects in excess of $500,000.00 shall comply with the above minimum provisions as well as being rated through A.M. Best shall comply with the following provisions:

The Surety shall be rated as "A-" or better as to General Policyholders Rating and Class VII or better as to financial category by the most current Best's Key Rating Guide, published by A.M. Best Company.

Surety must have fulfilled all of its obligations on all other bonds previously given to the County.

Surety must have a minimum underwriting limitation of $5,000,000 published in the latest

edition of the Federal Register for Federal Bonds (U.S. Dept. of Treasury).

1.06 Patents

The bidder warrants that the machine components for rebuilding the existing equipment will not infringe any U.S. or foreign patents or patents pending. In the event of any claim of infringement the bidder shall defend and indemnify the owner free from any liabilities associated with the use of the patented equipment or process.

The bidder hereby grants to the owner, in perpetuity, a paid-up license to use any inventions covered by patent or patents pending, owned, or controlled by the bidder in the operation of the facility being constructed in conjunction with the equipment supplied under this contract, but without the right to grant sublicenses.

Can your firm meet and abide by the Division 1 General Requirements? _____YES or _____No

DIVISION 2: MECHANICAL REQUIREMENTS

2.01 Recondition Rollers

Roller reconditioning, Reconditioning of solid rollers shall consist of removing the existing coating then recoating. The existing coating will be machined off to the true roller diameter prior to applying new coating. No other method of removing existing coating will be acceptable. Drive rollers shall be recoated with 1/4" inch Buna N rubber. All other solid rollers shall be recoated with 30 mils. of nylon (Rilsan). Roller shall be coated up to the point of insertion into the bearing block.

Preparation of rollers prior to applying new coatings shall be as specified above.

The heat setting thermoplastic nylon (Rilsan) coating shall have the following properties. Nylon coating shall be applied by means of fluidized bed process to ensure uniform coating thickness. Spray-on method will also be acceptable.

Any rollers beyond repair will be replaced. Any wedge plates beyond repair will be replaced.

Coefficient of friction: 0.10-0.30

Elongation (ASTM D638): 15%

Hardness, Shore D, (ASTM D2240): 77 minimum

Impact, RT. & 45 F, direct pass, (ASTM D2794): 160in.lbs. min

Melting point, (ASTM D789): 370 degrees F min

Rockwell Hardness, R Scale, 20 Degrees C: 06

Scratch Resistance, Clemen Apparatus: 59 N min.
(0.44mm thickness)

Tensile strength, psi, (ASTM D638): 6,000 min

Buna-N rubber coating shall have the following properties:

Tensile strength, ASTM D-412: 2,500 psi min

Tear strength, die C, ASTM D-624: 360 psi min

Elongation at break, ASTM D-412: 90%

Hardness, Shore A, ASTM D-676 90

2.02 Bearings

Reconditioning of the existing bearing assemblies shall consist of: a) clean and recoat bearing housings; b) install new bearings (with machined brass retainer) and c) replace all bearing internal components (ie. triple labyrinth seals, spacers, taper lock nut assembly, splash guards, etc.). All new internal bearing components must meet the original design specifications.

Bearing housings shall be coated with 8-12 mils of thermoplastic nylon (Rilsan), as specified per Section 2.01.

Bearings supporting the steering rollers shall be non-self aligning cylindrical roller bearings in pivot mounted pillow block housings. Any bearing houses beyond repair need to be replaced.

All other rollers shall be supported by self aligning spherical roller bearings mounted in fixed pillow block housings.

All bearings shall have a minimum L10 bearing life of 500,000 hours, calculated by using the ANSI/AFBMA, Std 11-1978, standard with 1.15 capacity modification factor per ISO recommendation. The L10 life shall be based on the summation of forces applied to the bearings from roller mass forces and belt tension on the rollers. The belt tension forces exerted on the pressure zone rollers shall include a minimum load of 200 pounds per lineal inch of belt width, which equates to a belt tension of 50 pli. Certified calculations, based on the AFBMA/ISO capacity formula, showing that all bearings comply with the specified requirements for minimum L10 bearing life, at maximum loadings, shall be submitted to the engineer as set forth in the contract documents upon request.

Recoated bearing housings shall be class 30 cast iron with four mounting bolts and four cap bolts. The outer side of the housing shall be solid, without end caps or filler plugs. The housings shall be designed with an integrally cast water trough which, when shrouded by a shaft mounted water flinger, shall divert water from the bearing seal area. The housings shall be cleaned, iron phosphated, and coated as specified per Section 2.01.

The bearing seal in the pillow block housing shall be of nonmetallic construction with a carrier/flinger which rotates with the roller shaft. A static sealing arrangement between the carrier/flinger and the shaft shall be a triple rubber seal, constructed in a manner that prevents relative rotation between the seal and the shaft. A dynamic sealing arrangement between the carrier/flinger and the bearing housing shall consist of a primary dynamic contact seal of ozone resistant rubber which shall seal by rotational contact with a machined housing surface. A secondary dynamic seal shall be a labyrinth seal between the carrier/flinger and the bearing housing which utilizes a nonmetallic retaining ring to hold the seal assembly in position within the housing.

Bearing lubrication shall be performed through a monel or type 316 stainless steel button head grease fitting mounted on the bearing housing. All bearings shall be outboard (externally mounted) and shall be greaseable while the unit is in operation. Lubrication shall not be required more often than once every six months.

The manufacturer of the gravity belt thickner shall warrant the complete bearing assembly, as specified herein, for a period of five years from the date of start-up, or acceptance of the equipment, whichever occurs first. The warranty shall include all parts for repairing or replacing any bearing assembly part that fails during the warranty period.

All mounting hardware (type 316 stainless steel) shall be provided to secure the bearing housings to the main frame of the machine.

2.03 Structural Main Frame

The structural main frame and all other galvanized structural components and all carbon steel painted components shall be cleaned and hot dipped galvanized to a 4-7 mills minimum thickness. No welding shall be allowed after frame and components have been galvanized.
The galvanized coating shall be warranted for a period of three
years from the date of start-up, not to exceed three and a half years from date of delivery. The frame shall not require preventive maintenance during the warranty period. Any defects or corrosion occurring within the warranty period shall be repaired or replaced at no additional cost to the owner.

2.04 Spray Brushes & Spray Nozzles

New upper and lower washbox inner spray bar brush. Total of (32) thirty two 2.5mm spray nozzles, nozzle gaskets and retaining rings for upper and lower spray bars.

2.05 Hydraulic System

The worn hydraulic system shall be replaced. New hydraulic system to consist of original equipment manufacturer's 316 stainless steel steering valves, tensioning valve, fittings, tensioning and steering cylinders.

New upper and lower steering valves shall be provided with a 316 stainless steel paddle weldment and ceramic wear pad which rides on the edge of the belts to detect their position.

Replace existing hydraulic cylinders with the latest O.E.M. fiberglass steering and tensioning cylinders. New hydraulic cylinders shall have fiberglass outer casing, laminated phenolic heads, stainless steel tie rods and 316 stainless steel piston rods. Operating pressure of fiberglass cylinders shall be rated at 750psi.

New drive side and non-drive side steering pivot plates.

The new steering valves and tensioning valve shall be warranted for a period of 5 years against defects of workmanship and operations. Valves will not be warranted due to damage resulting from neglect or misuse. Replace hydraulic lines as needed.

2.06 Electrical System

The worn electrical system shall be replaced with new electrical system. New electrical system to consist of belt limit switches, belt breakage proximity switches, no-cake proximity switch and press mount 316 stainless steel NEMA 4x junction box and wiring/fittings.

2.07 Belt Drive System

New platform mounted gear reducer (Eurodrive K87). New DC motor meeting the latest design standards shall be installed. Gear reducer shall meet the latest original equipment manufacture **(O.E.M.)** design standards. All parts will be made to the O.E.M's standard level of quality under ISO9001:2000 certified procedures. New Eurodrive platform mounted gear reducer is warranted for two years against defects in materials and workmanship.

2.08 Bull & Pinion Gears

New set of drive gears including (1) two main bull gears, (1) one pinion gear and (1) two drive bushings.

2.09 Drainage Pans

New stainless steel drainage pans shall be provided as necessary to contain filtrate from all dewatering areas within the belt filter press without splashing and to prevent rewetting of downstream cake. All drainage piping shall be furnished, adequately sized for the intended service, and rigidly attached to the press frame.

Drainage piping shall terminate inside the structural frame at the bottom of the press. Drain connection shall be self-venting to prevent overflow. Drainage pans shall be located such that the moving belts do not come into contact with the pans under any conditions.

All new drain pans, piping and splash guards shall be identical to new collection system on the new belt filter presses

2.10 Discharge Blades/Chicane Blades

New discharge blades shall be provided to scrap dewatered sludge from the belt at the final discharge rollers. New chicane blades and 316 stainless steel locking collars shall be installed in the gravity section. All hardware shall be 316 stainless steel.

The blades shall be of ultra high molecular weight polyethylene construction, shall be readily removable and shall be identical to the discharges blades on the new belt filter presses.

2.11 Poly Wear Bars/Rubber Seal

New poly wear bars (ultra-high molecular weight polyethylene) shall be installed on the upper gravity grid weldments. New rubber seal material shall be installed on the washboxes and on the sludge restrainers in the gravity and wedge sections.

2.12 Dewatering Belt

Aquabelt shall be supplied with a new dewatering belt(6647 Durotex Belts). Belt shall be fabricated of monofilament polyester and shall have 316 Stainless Steel seams. The mesh design shall be selected for optimum dewatering of the sludge to be processed.

Belt selection shall be based on the manufacturers experience obtained from testing the sludge during start-up of the belt filter press(es) and at other installations dewatering similar sludges with similar polyelectrolyte conditioning chemicals.

Belt and connecting seam shall be designed for a minimum tensile strength equal to five times the normal maximum dynamic tension to which the belt shall be subjected. The seam shall be designed to fail before the belt.

Belt shall have a width as hereinbefore specified and shall have a minimum life warranty of 2,000 hours operation at the rated design conditions. The manufacturer shall prorate the charge for replacement belts, based on the total number of hours of operation since the belt filter press was placed into useful service.

Belt shall be designed for ease of replacement with a minimum of belt filter down time. Belt replacement shall be such that disassembly of the equipment is not required.

2.13 Hydraulic Power Unit

The existing free-standing 20 gallon hydraulic power unit shall be upgraded with the latest original equipment manufacturer (O.E.M.) stand mounted hydraulic unit.

The Aquabelt shall be provided with a dedicated hydraulic power system to provide pressurized oil for the steering and tensioning. The unit shall consist of a two-gallon 316 stainless steel reservoir; variable-displacement pressure compensated hydraulic oil pump and drive motor, hydraulic oil filter (reusable), pressure gauges, piping and valves to make a complete operational system.

The pump, motor, reservoir, oil filter and valves shall be mounted to a free standing hydraulic stand. All hydraulic lines shall be properly sized for the pressure and flow of the unit.

The pump motor shall be a 1hp and shall not exceed a noise level of 70 DBA. The motor shall be a cast iron TEFC 1,200 rpm, NEMA B design with a "C" face mounting for the hydraulic

pump adapter.

Maximum system pressure shall be set equal to the highest pressure required to obtain the desired operating belt tension. The maximum system operating pressure is 1,000 PSI.

Hydraulic system controls shall be grouped for easy access and ease of operation. There shall be means provided to retract the belt tension cylinders for service. The valves, fittings, manifold and associated parts shall be of non-corroding materials such as FRP, glass filled Nylon and stainless steel.

The oil pressure gauges, one for each belt tension cylinders (upper & lower belt) shall indicate oil pressure in PSI and the belt tension in PLI. Normal operating limits shall be indicated on the face of each gauge. Low-pressure switches shall be provided to sense the absence of belt tension pressure.
Customer's electrician shall be responsible for electrical wiring/conduit between new press mounted motor/pressure switches and gravity belt thickner Control Panel.

Hydraulic unit shall meet the latest original equipment manufacture (**O.E.M.**) design standards. All parts will be made to the O.E.M's standard level of quality.

Can your firm meet and abide by the Division 2 Mechanical Requirements? _____YES or _____No

DIVISION 3: CONTRACTOR'S QUALIFICATIONS (SUBMITTALS)

The bid shall be awarded to a responsible bidder, qualified by experience to provide the work specified. The bidder shall submit the following information with his bid.

A. Experience record showing the bidder's experience in similar work.
B. List and brief description of similar work satisfactorily completed with location, dates, contact names, addresses of owners and phone numbers.
C. List of equipment and facilities available to do the work.
D. List of personnel, by name and title, contemplated to perform the repairs and modifications to the equipment.
E. Provide proof of ability to obtain a Performance/maintenance bond, if you do not have a formal quality system in place.

The bidder is required list all equipment that does not meet O.E.M Specification. Supporting documentation must also be provided to verify that material that does not meet O.E.M. specification is of equal quality. (Insert additional pages as required).

Can your firm meet and abide by the Division 3 Contractor's Qualification Requirements? _____YES or _____No

DIVISION 4: WARRANTY

The contractor shall warrant that the Aquabelt shall be free from defects in material and workmanship for a period of five years from date of recommissioning equipment, unless noted otherwise within the specifications.

Can your firm meet and abide by the Division 4 Warranty Requirements? _____YES or _____No

LOCAL BIDDER'S PREFERENCE

Note: In order for your firm to be considered for the local vendor preference, you must complete and return the attached "Local Vendor Preference Questionnaire" with your quotation.

The Lee County Local Bidder's Preference Ordinance No. 00-10 is being included as part of the award process for this project. As such, Lee County at its sole discretion, may choose to award a preference to any qualified "Local Contractor/Vendor" in an amount not to exceed 3 % of the total amount quoted by that firm.

"Local Contractor / Vendor" shall mean: a) any person, firm, partnership, company or corporation whose principal place of business in the sole opinion of the County, is located within the boundaries of Lee County, Florida; or b) any person, firm, partnership, company or corporation that has provided goods or services to Lee County on a regular basis for the preceding consecutive five (5) years, and that has the personnel, equipment and materials located within the boundaries of Lee County sufficient to constitute a present ability to perform the service or provide the goods.

The County reserves the exclusive right to compare, contrast and otherwise evaluate the qualifications, character, responsibility and fitness of all persons, firms, partnerships, companies or corporations submitting formal bids or formal quotes in any procurement for goods or services when making an award in the best interests of the County.

ATTACHMENT A
LOCAL VENDOR PREFERENCE QUESTIONNAIRE
(LEE COUNTY ORDINANCE NO. 00-10)

Instructions: Please complete either Part A or B whichever is applicable to your firm

PART A: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS LOCATED WITHIN LEE COUNTY (Only complete Part A if your principal place of business is located within the boundaries of Lee County)

1. **What is the physical location of your principal place of business that is located within the boundaries of Lee County, Florida?**

_____

_____

2. What is the size of this facility (i.e. sales area size, warehouse, storage yard, etc.)

_____

_____

_____

PART B: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS NOT LOCATED WITHIN LEE COUNTY OR DOES NOT HAVE A PHYSICAL LOCATION WITHIN LEE COUNTY (Please complete this section.)

1. How many employees are available to service this contract? _____

2. Describe the types and amount of equipment you have available to service this contract.

_____

_____

_____

LOCAL VENDOR PREFERENCE QUESTIONNAIRE CONTINUED

3. Describe the types and amount of material stock that you have available to service this contract.

_____

_____

_____

4. Have you provided goods or services to Lee County on a regular basis for the preceding, consecutive five years?

Yes _____ No _____

If yes, please provide your contractual history with Lee County for the past five, consecutive years. Attach additional pages if necessary.

_____

_____

_____

_____

_____

_____

INSURANCE REQUIREMENTS

NOTE: Your certificate of insurance must meet the following requirements:

Requirement #1:

The Lee County Board of County Commissioners shall be added as an additional insured on the comprehensive general liability policy.

Requirement #2:

Certificate holder shall be listed as follows:

Lee County Board of County Commissioners
C/O Lee County Purchasing
P.O. Box 398
Fort Myers, FL 33902-0398

Requirement #3:

Each policy shall provide a 30-day notification clause in the event of cancellation, non-renewal or adverse change.

STANDARD CONTRACT - Contracts that will not exceed three hundred and sixty five (365) calendar days; or where costs will not exceed $500,000; and/or there are no unusual hazards present.

1. Minimum Insurance Requirements: ***Risk Management in no way represents that the insurance required is sufficient or adequate to protect the vendor's interest or liabilities, but are merely minimums.***

   a. Workers' Compensation - Statutory benefits as defined by FS 440 encompassing all operations contemplated by this contract or agreement to apply to all owners, officers, and employees regardless of the number of employees. Individual employees may be exempted per State Law. Employers' liability will have minimum limits of:

   $500,000 per accident
   $500,000 disease limit
   $500,000 disease limit per employee

b. Commercial General Liability - Coverage shall apply to premises and/or operations, products and/or completed operations, independent contractors, contractual liability, and broad form property damage exposures with minimum limits of:

$500,000 bodily injury per person (BI)
$1,000,000 bodily injury per occurrence (BI)
$500,000 property damage (PD) or
$1,000,000 combined single limit (CSL) of BI and PD

c. Business Auto Liability - The following Automobile Liability will be required and coverage shall apply to all owned, hired and non-owned vehicles use with minimum limits of:

$500,000 bodily injury per person (BI)
$1,000,000 bodily injury per occurrence (BI)
$100,000 property damage (PD) or
$1,000,000 combined single limit (CSL) of BI and PD

The required limit of liability shown in Standard Contract: 1.a; 1.b; 1.c; may be provided in the form of "Excess Insurance" or "Commercial Umbrella Policies." In which case, a "Following Form Endorsement" will be required on the "Excess Insurance Policy" or "Commercial Umbrella Policy."

2. Verification of Coverage:

a. Ten (10) days prior to the commencement of any work under this contract a certificate of insurance will be provided to the Risk Manager for review and approval. The certificate shall provide for the following:

1. ***"Lee County, a political subdivision and Charter County of the State of Florida, its agents, employees, and public officials@*** **will be named as an "Additional Insured" on the General Liability policy.**

2. Lee County will be given thirty (30) days notice prior to cancellation or modification of any stipulated insurance. Such notification will be in writing by registered mail, return receipt requested and addressed to the Risk Manager (P.O. BOX 398 Ft. Myers, FL 33902).

3. Special Requirements:

   a. An appropriate "Indemnification" clause shall be made a provision of the contract.

   b. It is the responsibility of the general contractor to insure that all subcontractors comply with all insurance requirements.

To the fullest extent permitted by applicable law, Contractor shall protect, defend, indemnify, save and hold the County, the Board of County Commissioners, its agents, officials, and employees harmless from and against any and all claims, demands, fines, loss or destruction of property, liabilities, damages, for claims based on the negligence, misconduct, or omissions of the Contractor resulting from the Contractor's work as further described in this contract, which may arise in favor of any person or persons resulting from the Contractor's performance or non-performance of its obligations under this contract except any damages arising out of personal injury or property claims from third parties caused solely by the negligence, omission(s) or willful misconduct of the County, its officials, commissions, employees or agents, subject to the limitations as set out in Florida general law, Section 768.28, Florida Statutes, as amended. Further, Contractor hereby agrees to indemnify the County for all reasonable expenses and attorney's fees incurred by or imposed upon the County in connection therewith for any loss, damage, injury or other casualty. Contractor additionally agrees that the County may employ an attorney of the County's own selection to appear and defend any such action, on behalf of the County, at the expense of the Contractor. The Contractor further agrees to pay all reasonable expenses and attorney's fees incurred by the County in establishing the right to indemnity.

FORMAL QUOTATION NO.: Q-060116

LEE COUNTY PURCHASING - BIDDERS CHECK LIST

IMPORTANT: Please read carefully and return with your bid proposal.
Please check off each of the following items as the necessary action is completed:

____ 1. The Quote has been signed.

____ 2. The Quote prices offered have been reviewed.

____ 3. The price extensions and totals have been checked.

____ 4. The original (must be manually signed) and 2 copies of the quote have been submitted.

____ 5. Three (3) identical sets of descriptive literature, brochures and/or data (if required) have been submitted under separate cover.

____ 6. All modifications have been acknowledged in the space provided.

____ 7. All addendums issued, if any, have been aeknowledged in the space provided.

____ 8. Erasures or other changes made to the quote document have been initialed by the person signing the quote.

____ 9. Bid Bond and/or certified Check, (if required) have been submitted with the quote in amounts indicated.

____ 10. Any Delivery information required is included.

____ 11. The mailing envelope has been addressed to:

MAILING ADDRESS		**PHYSICAL ADDRESS**
Lee County Purchasing		Lee County Purchasing
P.O. Box 398	or	1825 Hendry St 3rd Floor
Ft. Myers, FL 33902-0398		Ft. Myers, FL 33901

____ 12. The mailing envelope **MUST** be sealed and marked with:
Quote Number
Opening Date and/or Receiving Date

____ 13. The quote will be mailed or delivered in time to be received no later than the specified opening date and time. (Otherwise quote cannot be considered or accepted.)

____ 14. If submitting a "NO BID" please write quote number here _____
and check one of the following:
_____ Do not offer this product _____Insufficient time to respond.
_____ Unable to meet specifications (why)
_____ Unable to meet bond or insuranee requirement.
Other: _____

Company Name and Address:

_____

_____

ATTACHMENT 3

FORMAL QUOTATION NO.: Q-060116

LEE COUNTY, FLORIDA
PROPOSAL QUOTE FORM
FOR BELT PRESS REBUILT TWO AQUABELTS SIZE 4
(3.0 METER) TYPE 85 FOR LEE COUNTY UTILITIES

DATE SUBMITTED: May 15, 2006

VENDOR NAME: Andritz Ruthner, Inc.

TO: The Board of County Commissioners
Lee County
Fort Myers, Florida

Having carefully examined the "General Conditions", and the "Detailed Specifications", all of which are contained herein, the Undersigned proposes to furnish the following which meet these specifications:

The undersigned acknowledges
receipt of Addenda numbers: One (1) Pages 19, 20, and 22

GRAND TOTAL COST TO REBUILD 2 AQUABELTS $ 113,544.00

NOTE: SUBMITTALS ARE REQUIRED WITH THIS QUOTE. SEE PAGE 25 DIVISION 3 CONTRACTORS QUALIFICATIONS. ALL REQUESTED SUBMITTALS SHALL BE SUBMITTED WITH YOUR FIRMS QUOTATION.

TO BE COMPLETED WITHIN 70 CALENDAR DAYS AFTER RECEIPT OF AWARD AND PURCHASE ORDER.

Is your firm interested in being considered for the Local Vendor Preference?
Yes X No _____

If yes, then read the paragraph entitled "Local Vendor Preference" included in these specifications. Also complete the Local Vendor Preference Questionnaire and return with your quotation.

Quoters should carefully read all the terms and conditions of the specifications. Any representation of deviation or modification to the quote may be grounds to reject the quote.

Are there any modifications to the quote or specifications:

Yes _____ No ___X___

Failure to clearly identify any modifications in the space below or on a separate page may be grounds for the quoter being declared nonresponsive or to have the award of the quote rescinded by the County.

MODIFICATIONS:

Quoter shall submit his/her quote on the County's Proposal Quote Form, including the firm name and authorized signature. Any blank spaces on the Proposal Quote Form, qualifying notes or exceptions, counter offers, lack of required submittals, or signatures, on County's Form may result in the Quoter/Quote being declared non-responsive by the County.

FORMAL QUOTATION NO.: Q-060116

ANTI-COLLUSION STATEMENT

THE BELOW SIGNED QUOTER HAS NOT DIVULGED TO, DISCUSSED OR COMPARED HIS QUOTE WITH OTHER QUOTERS AND HAS NOT COLLUDED WITH ANY OTHER QUOTER OR PARTIES TO A QUOTE WHATSOEVER. NOTE: NO PREMIUMS, REBATES OR GRATUITIES TO ANY EMPLOYEE OR AGENT ARE PERMITTED EITHER WITH, PRIOR TO, OR AFTER ANY DELIVERY OF MATERIALS. ANY SUCH VIOLATION WILL RESULT IN THE CANCELLATION AND/OR RETURN OF MATERIAL (AS APPLICABLE) AND THE REMOVAL FROM THE MASTER BIDDERS LIST.

FIRM NAME ANDRITZ RUTHNER, INC.

BY (Printed): JOHN MADDEN

BY (Signature):

TITLE: PRESIDENT

FEDERAL ID # OR S.S.# TX-25-1342907

ADDRESS: 1010 COMMERCIAL BLVD. SOUTH
ARLINGTON, TX 76001

PHONE NO.: 817-419-1728

FAX NO.: 817-419-1928

CELLULAR PHONE/PAGER NO.: 817-266-9512

LEE COUNTY OCCUPATIONAL LICENSE NUMBER:

E-MAIL ADDRESS: ARMONDO.ALVARADO@ANDRITZ.COM

REVISED: 7/28/00

The Surety shall be rated as "A-" or better as to General Policyholders Rating and Class VII or better as to financial category by the most current Best's Key Rating Guide, published by A.M. Best Company.

Surety must have fulfilled all of its obligations on all other bonds previously given to the County.

Surety must have a minimum underwriting limitation of $5,000,000 published in the latest

edition of the Federal Register for Federal Bonds (U.S. Dept. of Treasury).

1.06 Patents

The bidder warrants that the machine components for rebuilding the existing equipment will not infringe any U.S. or foreign patents or patents pending. In the event of any claim of infringement the bidder shall defend and indemnify the owner free from any liabilities associated with the use of the patented equipment or process.

The bidder hereby grants to the owner, in perpetuity, a paid-up license to use any inventions covered by patent or patents pending, owned, or controlled by the bidder in the operation of the facility being constructed in conjunction with the equipment supplied under this contract, but without the right to grant sublicenses.

Can your firm meet and abide by the Division 1 General Requirements? __x__YES or _____No

DIVISION 2: MECHANICAL REQUIREMENTS

2.01 Recondition Rollers

Roller reconditioning, Reconditioning of solid rollers shall consist of removing the existing coating then recoating. The existing coating will be machined off to the true roller diameter prior to applying new coating. No other method of removing existing coating will be acceptable. Drive rollers shall be recoated with 1/4" inch Buna N rubber. All other solid rollers shall be recoated with 30 mils. of nylon (Rilsan). Roller shall be coated up to the point of insertion into the bearing block.

Preparation of rollers prior to applying new coatings shall be as specified above.

The heat setting thermoplastic nylon (Rilsan) coating shall have the following properties. Nylon coating shall be applied by means of fluidized bed process to ensure uniform coating thickness. Spray-on method will not be acceptable.

Hydraulic system controls shall be grouped for easy access and ease of operation. There shall be means provided to retract the belt tension cylinders for service. The valves, fittings, manifold and associated parts shall be of non-corroding materials such as FRP, glass filled Nylon and stainless steel.

The oil pressure gauges, one for each belt tension cylinders (upper & lower belt) shall indicate oil pressure in PSI and the belt tension in PLI. Normal operating limits shall be indicated on the face of each gauge. Low-pressure switches shall be provided to sense the absence of belt tension pressure.
Customer's electrician shall be responsible for electrical wiring/conduit between new press mounted motor/pressure switches and gravity belt thickner Control Panel.

Hydraulic unit shall meet the latest original equipment manufacture (**O.E.M.**) design standards. All parts will be made to the O.E.M's standard level of quality.

Can your firm meet and abide by the Division 2 Mechanical Requirements? ____**x**YES or _____No

DIVISION 3: CONTRACTOR'S QUALIFICATIONS (SUBMITTALS)

The bid shall be awarded to a responsible bidder, qualified by experience to provide the work specified. The bidder shall submit the following information with his bid.

A. Experience record showing the bidder's experience in similar work.
B. List and brief description of similar work satisfactorily completed with location, dates, contact names, addresses of owners and phone numbers.
C. List of equipment and facilities available to do the work.
D. List of personnel, by name and title, contemplated to perform the repairs and modifications to the equipment.
E. Provide proof of ability to obtain a Performance/maintenance bond, if you do not have a formal quality system in place.

The bidder is required list all equipment that does not meet O.E.M Specification. Supporting documentation must also be provided to verify that material that does not meet O.E.M. specification is of equal quality. (Insert additional pages as required).

Can your firm meet and abide by the Division 3 Contractor's Qualification Requirements? ___**x**__YES or _____No

DIVISION 4: WARRANTY

The contractor shall warrant that the Aquabelt shall be free from defects in material and workmanship for a period of five years from date of recommissioning equipment, unless noted otherwise within the specifications.

Can your firm meet and abide by the Division 4 Warranty Requirements? ___x___YES or _____No

LOCAL BIDDER'S PREFERENCE

Note: In order for your firm to be considered for the local vendor preference, you must complete and return the attached "Local Vendor Preference Questionnaire" with your quotation.

The Lee County Local Bidder's Preference Ordinance No. 00-10 is being included as part of the award process for this project. As such, Lee County at its sole discretion, may choose to award a preference to any qualified "Local Contractor/Vendor" in an amount not to exceed 3 % of the total amount quoted by that firm.

"Local Contractor / Vendor" shall mean: a) any person, firm, partnership, company or corporation whose principal place of business in the sole opinion of the County, is located within the boundaries of Lee County, Florida; or b) any person, firm, partnership, company or corporation that has provided goods or services to Lee County on a regular basis for the preceding consecutive five (5) years, and that has the personnel, equipment and materials located within the boundaries of Lee County sufficient to constitute a present ability to perform the service or provide the goods.

The County reserves the exclusive right to compare, contrast and otherwise evaluate the qualifications, character, responsibility and fitness of all persons, firms, partnerships, companies or corporations submitting formal bids or formal quotes in any procurement for goods or services when making an award in the best interests of the County.

FORMAL QUOTATION NO.: Q-060116

ATTACHMENT A
LOCAL VENDOR PREFERENCE QUESTIONNAIRE
(LEE COUNTY ORDINANCE NO. 00-10)

Instructions: Please complete either Part A or B whichever is applicable to your firm

PART A: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS LOCATED WITHIN LEE COUNTY (Only complete Part A if your principal place of business is located within the boundaries of Lee County)

1. **What is the physical location of your principal place of business that is located within the boundaries of Lee County, Florida?**

_____

_____

2. What is the size of this facility (i.e. sales area size, warehouse, storage yard, etc.)

_____

_____

_____

PART B: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS NOT LOCATED WITHIN LEE COUNTY OR DOES NOT HAVE A PHYSICAL LOCATION WITHIN LEE COUNTY (Please complete this section.)

1. How many employees are available to service this contract? 10

2. Describe the types and amount of equipment you have available to service this contract.

CRANES, FABRICATION & PRODUCTION FACILITIES, FORKLIFTS

_____

_____

LOCAL VENDOR PREFERENCE QUESTIONNAIRE CONTINUED

3. Describe the types and amount of material stock that you have available to service this contract.

BELTS, PLOWS, SEALS, SHOWER BRUSHES, BEARINGS

4. Have you provided goods or services to Lee County on a regular basis for the preceding, consecutive five years?

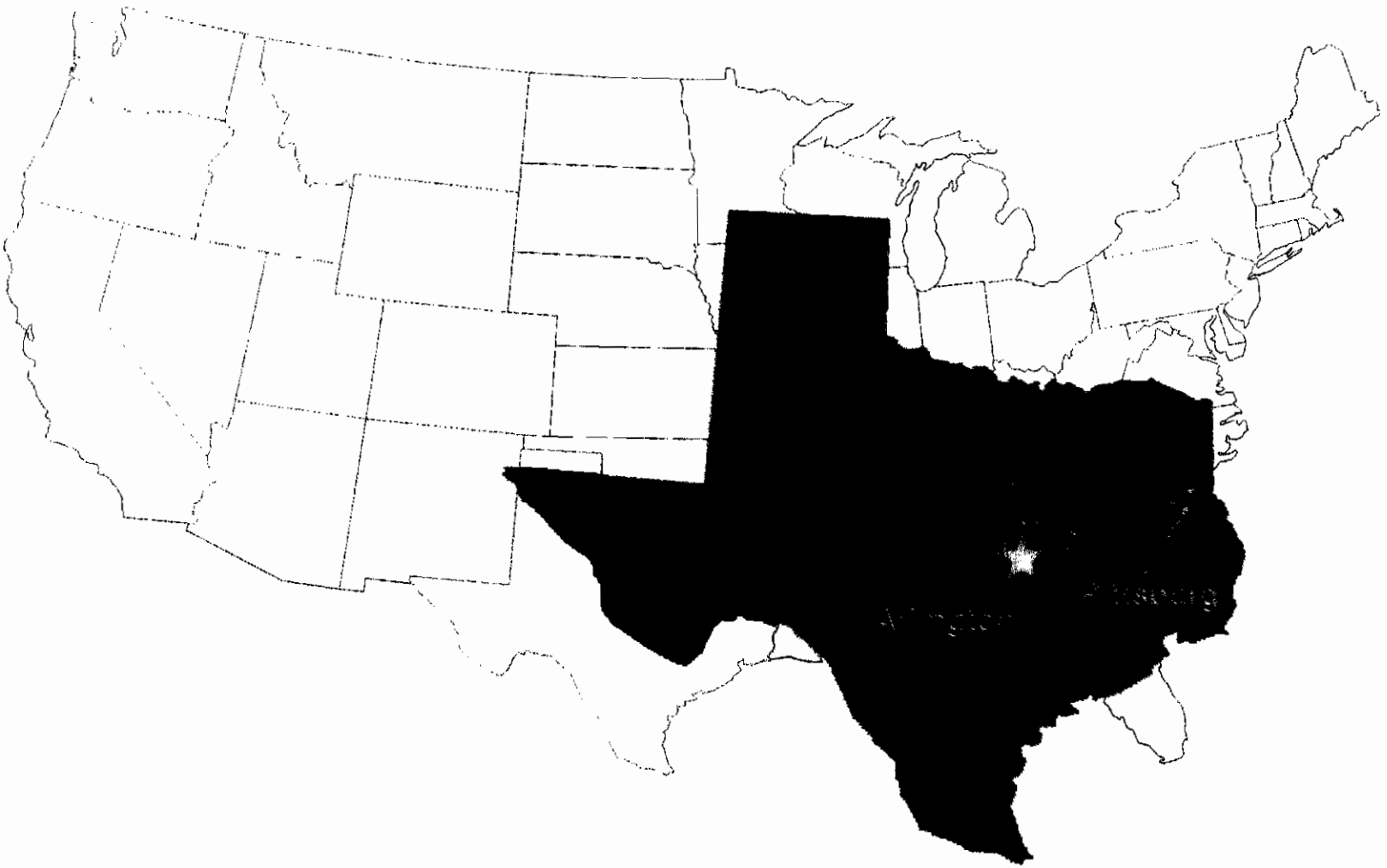
Yes _____ No ___X___

If yes, please provide your contractual history with Lee County for the past five, consecutive years. Attach additional pages if necessary.

REFURBISHMENT REFERENCE LIST

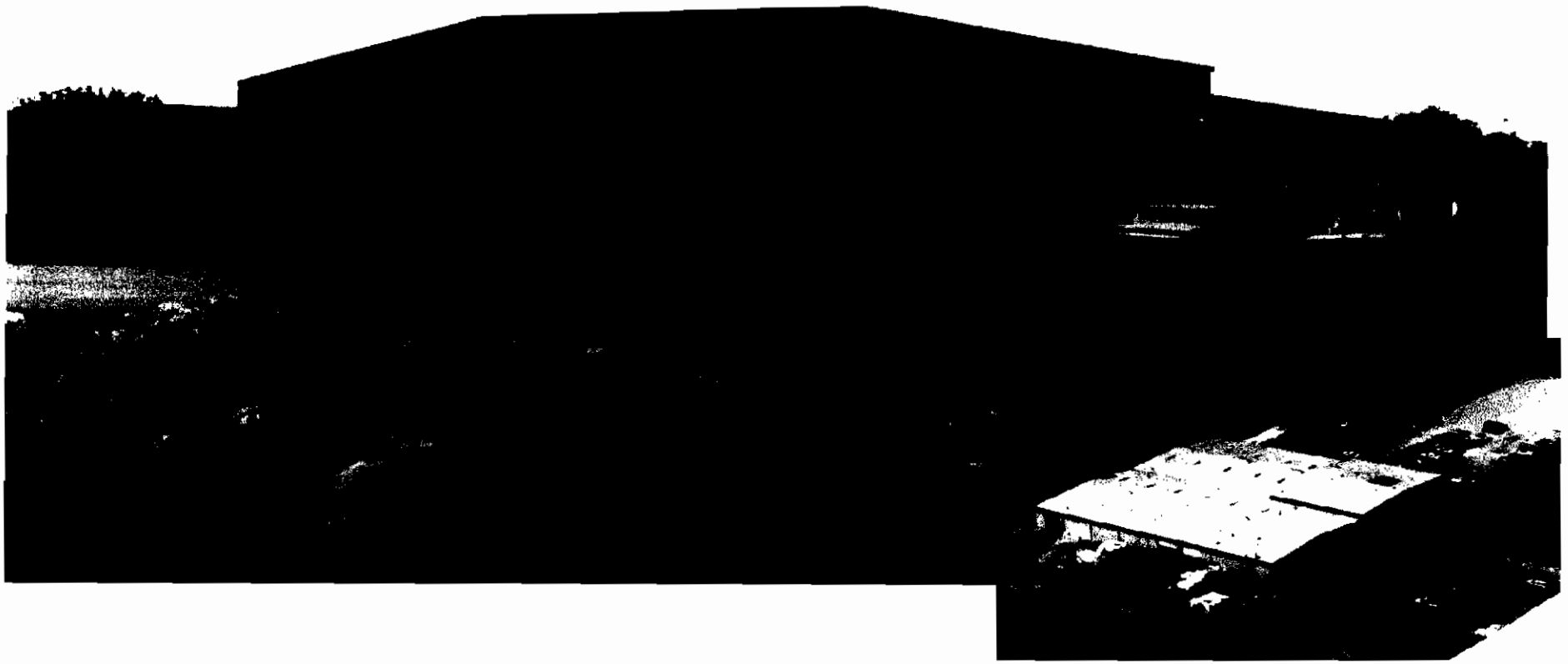
CUSTOMER	LOCATION	EQUIPMENT	CONTACT	COMMENTS
City of Erie WTP	Erie, PA	2ea BFP 2.2 SMX S-7	Mark Ventresca 814/870-1360	Completed turnkey refurbishment of belt presses on-site.
City of Riverside	Riverside, CA	2ea BFP 2.2 SMX S-7	Ben Urquiza 951-351-6259	Turnkey refurbishment of 2 belt presses 1st BFP complete, 2nd BFP shipping 7-22
City of Vacaville	Vacaville, CA	1ea BFP 2.0 SMX S-8	Grover Wright 707-330-7243	Turnkey refurbishment, in our facility been refurbished.
Dow Chemicals	Plaquemine, LA	1ea CPF SDM 80-S5	Joe Benson 225-353-6055	Turnkey refubishment with SS Frame
Metro Sewer District Bissell Point	St. Louis, MO	15ea BFP 2.0 SMX S-8	Ed Cope 314/436-8749	Converting 2.0 SMX S-8 to 2.0 SMX S-14 to improve cake dryness between 3 to 5 %.
Trinity River Authority	Dallas, TX	3ea Winkle Press 3ea Aquabelts	Greg Mikus 972-263-2251	Replacement of rolls and service on both Ashbrook's BFP & GBT.
St. Johns County	St. Agustine FL	1ea Ashbrook Klampress Klampress	Greg James 904/824-2942	Completed on-site turnkey refurbishment BFP

Andritz-Ruthner, Inc.



Andritz-Ruthner, Inc.
Arlington, TX

Employees:	100 (6 in NJ)
Office Area:	15,000 ft^2 (1,394 m^2)
Shop Area:	30,000 ft^2 (1,787 m^2)



ANDRITZ

Andritz-Ruthner, Inc.
Pittsburg, TX

Employees:	40
Office Area:	5,000 ft^2 (465 m^2)
Shop Area:	34,000 ft^2 (3,158 m^2)

List of Personnel

Name	Title
Armondo Alvarado	Project Manager
Gary Dobbs	Productions Manager
Roger Pierce	Shop Foreman
Steve Knight	Assembly Supervisor

ENVIRONMENT AND PROCESS TECHNOLOGIES

Andritz-Ruthner, Inc.

Quality Policy Overview

SECTION I: SCOPE

This document is meant to serve as an overview of the Andritz-Ruthner Quality Program. A Program Designed To Meet The Requirements Of Commercial Standards Currently Dominant In Our Industry. The Quality System is implemented within the scope of customer and/or contractual requirements.

SECTION II: RESPONSIBILITY

- The basic responsibility of Andritz is to manufacturer and/or deliver a quality product to it's customers on a timely basis, at a competitive price, in full accordance with customer and/or contractual requirements.
- The Quality Control Department is responsible for providing control and assurance of quality within the Company. The objective is to verify that all products furnished to the customer, conforms to the quality standards specified by the customer and by Andritz.
- Elements of the program are implemented at each step of the manufacturing cycle, from the initial development of the product, to the final delivery and acceptance by the customer.

SECTION III: DOCUMENTATION AND RECORDS

- Records are considered one of the primary forms of objective evidence of quality. The Quality Program shall assure that records are complete and reliable.
- Records for monitoring work performance and inspection, shall indicate the acceptability of the work or products and the action taken in connection with deficiencies.

SECTION IV: DRAWING AND CHANGE CONTROL

- Andritz establishes actions necessary by the Quality Control and Engineering Departments to assure correct and complete engineering documentation.
- Company procedures related to the manufacturing process shall be reviewed and approved by Engineering and Quality Control Departments, and will be subject to periodic audits.
- Engineering drawings will be reviewed for compliance with contract requirements prior to release for manufacturing.

ANDRITZ-RUTHNER, INC.

1010 Commercial Blvd. S.
Arlington, Texas 76001
Tel. (817) 465-5611
Fax (817) 472-8589
environ.us@andritz.com

SECTION V: PURCHASING CONTROL

- The accuracy with which all pertinent data is transferred from the approved purchase requisition to the purchase order is verified through periodic Quality audits.
- Each purchase requisition is reviewed to ensure that it includes reference to applicable drawings, specifications, and other documents required for the supplier to meet purchase order requirements. Andritz will purchase supplies and services only from suppliers who meet acceptable minimum quality standards.

SECTION VI: RECEIVING INSPECTION CONTROL

- Andritz has established for the receipt and inspection of supplier furnished parts and materials purchased for end item application by assuring conformance to drawings, specifications and purchase order requirements.
- Materials and products purchased for end item application shall be subjected to inspection upon receipt to the extent necessary to assure conformance to quality and technical requirements. The amount and type of receiving inspection may be adjusted on the basis of the quality program exercised by the supplier.

SECTION VII: IN-PROCESS INSPECTION CONTROL

- Andritz has established procedures and responsibility for ensuring that quality control inspections are performed during various stages of in-process fabrication/assembly to assure the quality integrity of the end item.
- All fabrication, assembly, and other production processing shall be accomplished under controlled conditions. These shall include control over the materials, equipment processes, workmanship, and products to assure manufacture and delivery of an end item which conforms to all applicable quality standards and technical requirements. This shall be accomplished by measurement, test assessment and control of each operation by Production and Quality as required during manufacture.

SECTION VIII: FINAL INSPECTION CONTROL

- Andritz has established procedures and responsibility for final inspection and function/acceptance testing of assemblies and end item equipment. All manufactured assemblies and systems shall be subjected to final inspection and functional testing, in accordance with documented procedures, specifications and contractual requirements.
- A record of project numbers, serial numbers, etc, will document the actual configuration of the end item to be delivered.
- All functional assemblies or systems will be subjected to a final acceptance test to be witnessed by customer representatives when contractually required. Results of test performance will be documented and retained for historical records or contractual requirements.

SECTION IX: NONCONFORMING MATERIAL CONTROL

- Andritz had established procedures and responsibility for the identification, segregation, review and disposition of nonconforming parts and materials procured, processed or produced for end item application.
- The Quality Control Department maintains control of the nonconforming material through identification, segregation and disposition reporting.
- Repair of nonconforming items shall be in accordance with documented and approved instructions.
- All nonconforming items shall be stringently controlled to prevent inadvertent use, shipment, or unintended intermingling with conforming items.

SECTION X: CORRECTIVE ACTION

- Andritz has established documents and procedures for corrective action applicable to design, purchasing, manufacturing and test operations to correct conditions that have resulted in or might result in substandard or defective supplies, services, standards or other elements of contract performance. This corrective action extends to the company's suppliers of goods and services.

SECTION XI: MEASURING AND TEST EQUIPMENT CONTROL

- Andritz has established for the selection, calibration, and control of measurement and test equipment, used to verify product conformance 6to drawings, specifications, and contract requirements.
- The Quality Control Department shall maintain measuring and testing devices necessary to assure that products conform to technical requirements. These devices shall be calibrated using standards with accuracies traceable to the National Institute of Standards and Technology.

SECTION XII: INDICATION OF INSTPECTION STATUS

- The inspection status of materials is identified on appropriate documentation, and on the materials, in accordance with drawings, specifications, and or procedural requirements in a manner that will not damage the materials.

SECTION XIII: SAMPLING INSPECTION

- Andritz has established for the control and use of sampling plans for inspection by attributes in accordance with MIL-STD-105 when required.
- Sampling plans may be used for inspection when historical records, inherent characteristics of the product, or the noncritical application of the product indicates that a reduction in inspection can be achieved without jeopardizing quality. Inspection levels and sampling plans must be compatible with contractual requirements.

SECTION XIV: SOURCE INSPECTION

- Inspection at supplier facilities are performed as required for control and assurance that purchased materials, parts and services are in full compliance with all applicable requirements of the purchase order prior to shipment.

David B. McDonald
Quality Control Manager
Andritz-Ruthner, Inc.

ENVIRONMENT AND PROCESS TECHNOLOGIES

BELT PRESS CHECKLIST REPORT

Date:_____

Machine Type: RH LH	Project No.	Andritz S/N	Other S/N:
Project Name:		Inspector:	Request Date:

I. Verify all assemblies for compliance to Engineering specifications. Transfer all applicable in-process inspection stamp(s) for the following assemblies, functions and observations.

	YES	NO	N/A	COMMENTS
A ROLLER ASSEMBLIES				
1. Assembly aligned and complete				
2. Bearing assemblies lubricated				
3. Roller coatings undamaged				
B BELT TENSION ASSEMBLIES				
1. Assembly aligned and complete				
C DOCTOR BAR ASSEMBLIES				
1. Assembly aligned and complete				
D WEDGE AND GRAVITY ZONES				
1. Assembly aligned and complete				
E SHOWER ASSEMBLIES				
1. Assembly aligned and complete				
F HEADBOX ASSEMBLY				
1. Containment assembly complete				
2. Feed/Mixing assembly complete				
3. Chicanes aligned and marked				
G DRIVE ASSEMBLY				
1. Assembly aligned				
H CANTILEVERING ASSEMBLY				
1. Arms fitted and marked				

2. Any interference				

I MACHINE PNEUMATICS

1. Assembly complete				

J MECHANICAL ELECTRICAL –
Reference "Machine Wiring Report"

K MECHANICAL TEST RUN

1. Machine belt path measurements, in inches:
   a. Top: Min.____ Max. ____
   b. Bottom: Min. ____ Max. ____
2. Size of belt utilized for test:
   a. Top Belt: _____
   b. Bottom Belt: _____

	YES	NO	N/A	COMMENTS
3. Were project belts utilized?				
4. Will specified belts fit?				
5. Any belt damage?				
6. Do belt tract correctly?				
7. Any belt path interference?				
8. Any air leaks?				
9. Does drive(s) operate correctly?				
10. Any excessive vibration/noise?				
11. Plumbing pressure tested, OK?				

L MISCELLANEOUS:

1. Any noted loose fasteners?				
2. Required alignment pins installed?				
3. Unused holes suitably coated/plugged?				
4. Corrosion protective coatings complete?				
5. Stainless steel clean of rust, oversparay, etc.				
6. Specified safety guards installed?				
7. Specified legend plates/equipment tags installed?				

COMMENTS/OBSERVATIONS: _____

ENVIRONMENT AND PROCESS TECHNOLOGIES

II. STATUS:

☐ Approved incomplete ☐ _____ _____

Inspector Date

III. COPY DISTRIBUTION:

Project Manager (Project File)
Production manager
Quality Control Manager

ANDRITZ

ENVIRONMENT AND PROCESS TECHNOLOGIES

BELT PRESS INSPECTION REPORT

Date:_____

Incoming ☐

In Process ☐

Final/Shipping ☐

Machine Type: RH LH	Project No.	Andritz S/N	Other S/N:
Project Name:		Inspector:	Request Date:

	YES	NO	N/A	COMMENTS
A ROLLER ASSEMBLIES				
4. Are rolls leveled and parallel?				
a. "Roll alignment protocol" attached?				
b. "Frame alignment protocol" attached?				
5. Are bearing assemblies lubed and sealed?				Type Lube: _____
6. Are roll coatings complete and undamaged?				
7. Are roll coatings complete and undamaged?				
8. Are rolls balanced within specification?				
9. Do all rolls turn freely?				
B BELT TENSION ASSEMBLIES				
4. Assembly aligned and complete				
5. Are guide shaft brackets and bearings lubricated?				
6. Are required brackets and shafts pinned?				
7. Are required guards installed?				
8. Does the crank handle or wrench fit?				
9. Are shaft spacers required and supplied?				
C DOCTOR BAR ASSEMBLIES				
4. Assembly complete?				
5. Are blades aligned to roll surface?				

6. Is tensioning adjustable?				
a. Tensioning type:_____				
b. Blade materials: _____				
7. Are required brackets pinned?				

D WEDGE AND GRAVITY ZONES ASSEMBLY:

1. Type: _____
   (ex: Grid strip, roller, FRP, grates)

2. Assembly complete?				
3. Are wedges installed and aligned?				
4. Are the wedges adjustable?				
5. Are required seals installed?				
6. Is the upper wedge and gravity section adjustable?				
7. Is the Pre-"S" or Prepress zone adjustable?				

E SHOWER ASSEMBLIES

1. Type of shower pipes: _____

	YES	NO	N/A	COMMENTS
2. Assembly complete?				
3. Are seals installed and aligned?				
4. Are the shower boxes aligned with belt path?				
5. Are the drains to specification?				

Type of plumbing:_____
(ex. PVC pipe, hose, etc.)

F HEADBOX AND SIDEWALL ASSEMBLY

1. Type : _____
   (ex. Distribution chute, screw distributor, etc.)
2. Type of Mixer: _____
   (ex. Turbo, Venturi, Tank, etc.)

3. Are the brackets adjustable?				
4. Are the seals installed and aligned?				
5. Is the floating wedge installed and functional?				
6. Is the sludge leveler installed and functional?				

7.	Are the flanges installed and rotated correctly?			
8.	Are the mixing drum and screw shaft bearings lubricated?			
9.	Are the chicanes installed and aligned?			
	a. Are the brackets and bars stamped?			
	b. Are the chicanes free floating?			
G	DRIVE ASSEMBLIES:			
1.	Are the drives/gearboxes mounted?			
2.	Are all gearboxes lubricated?			
3.	Are the required couplings aligned?			
4.	Are the sprockets or spur gears aligned?			
5.	Is the chain tension adjusted?			
6.	Are the gears, chains, etc. lubricated?			
7.	Are the required guards in stalled?			
8.	Type of speed adjustment: _____ (ex. Servo, VFD, etc.)			
H	CANTILEVERING ASSEMBLY: (IF REQUIRED)			
1.	Are all adaptations made for cantilevering?			
2.	Are alignment pins installed and aligned?			
3.	Have arms been fitted and marked?			
I	CAKEBREAKER ASSEMBLY: (IF REQUIRED)			
1.	Is the assembly complete and aligned?			
2.	Are the bearings lubricated?			
3.	Is there proper clearance between components?			
4.	Are the required guards installed?			

ANDRITZ

ENVIRONMENT AND PROCESS TECHNOLOGIES

ANDRITZ-Ruthner, Inc.

Pittsburg, Texas – MFG. Division

QUALITY CONTROL MANUAL

ANDRITZ-RUTHNER, INC.

QUALITY CONTROL MANUAL

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ENVIRONMENT AND PROCESS TECHNOLOGIES

ANDRITZ-RUTHNER, INC.

PITTSBURG MANUFACTURING DIVISION PITTSBURG, TX 75686

QUALITY CONTROL MANUAL

Approved by:

Plant Manager	Mfg./Q.C. Manager
_____	_____
Name	Name
_____	_____
Signature	Signature
_____	_____
Date	Date

ANDRITZ-RUTHNER, INC.

QUALITY CONTROL MANUAL

REVISION RECORD

SECTION	REVISION	DATE REVISED	CHANGE DESCRIPTION
1.0	N/C	N/A	N/A
2.0	N/C	N/A	N/A
3.0	N/C	N/A	N/A
4.0	N/C	N/A	N/A
5.0	N/C	N/A	N/A
6.0	N/C	N/A	N/A
7.0	N/C	N/A	N/A
8.0	N/C	N/A	N/A
9.0	N/C	N/A	N/A
10.0	N/C	N/A	N/A
11.0	N/C	N/A	N/A
12.0	N/C	N/A	N/A
13.0	N/C	N/A	N/A
14.0	N/C	N/A	N/A
15.0	N/C	N/A	N/A
16.0	N/C	N/A	N/A
	N/C	N/A	N/A
Appendix A	N/C	N/A	N/A
Appendix B	N/C	N/A	N/A
Appendix C	N/C	N/A	N/A
Appendix D	N/C	N/A	N/A
Appendix E	N/C	N/A	N/A

ANDRITZ-RUTHNER, INC.

INTRODUCTION:

Andritz-Ruthner, Inc. is defined as Andritz-Ruthner, Inc., Pittsburg Manufacturing Division, Pittsburg, Texas 75686. Each division of Andritz-Ruthner, Inc. is an entity unto itself, in that, the Quality Control System is a closed loop system. Each division is responsible for employment of their respective Quality requirements.

This manual is issued to describe the Quality control System to be employed at Andritz-Ruthner, Inc. The policy of Andritz-Ruthner, Inc. is to apply the system to articles and materials received by Andritz-Ruthner, Inc. as well as to articles produced by Andritz-Ruthner, Inc. or its suppliers for end use. This manual provides personnel and customers of Andritz-Ruthner, Inc. with a description of company policy for maintaining an effective and economical Quality Control System planned and developed using MIL-I-45208A, as a basis.

Written procedures for implementing the policies described herein shall be established as dictated by complexity of the product design, manufacturing techniques employed and customer requirements.

No changes in the manual or supplementary Quality Control Procedures are valid until approved by the Plant Manager or his assignee.

ANDRITZ-RUTHNER, INC.

1.0 SCOPE

1.1 The Quality Control System encompasses receipt of parts and material, identification, stocking and issue of parts and material, the entire process of fabrication and manufacturing, packaging, storage and shipping.

1.2 The system is designed to assure that supplies or services performed at Andritz-Ruthner, Inc. or at Andritz-Ruthner's supplier facilities are subject to adequate control of quality to ensure customer satisfaction. This system is designed to provide for early detection of discrepancies and positive corrective action.

1.3 Written inspection and test procedures prepared to supplement applicable drawings and other specifications to the extent necessary.

2.0 RESPONSIBILITIES OF QUALITY CONTROL

2.1 The Quality Control Manager reports directly to the Plant Manager.

2.2 The quality Control Manager is responsible to ensure the following:

2.2.1. Interpretation of conformance to customer quality requirements.

2.2.2. Review of customer drawings and specifications.

2.2.3. Determination of necessary inspection points.

2.2.4. Documentation of necessary inspection and test instructions.

2.2.4.1 Establishing a change control procedure for such documents.

2.2.5. Planning, developing, initiating, coordinating, implementing and maintaining the most effective procedures for optimum quality assurance.

2.2.6. Maintenance of adequate quality control records.

2.2.7. Review of quality control records and internal corrective action follow-up.

2.2.8. Conduct Vendor quality Surveys and shall maintain a file on each subcontractor. Copies of all rejection memoranda pertinent to each subcontractor, shall be attached to the file and used for evaluation to accept or eliminate as an approved vendor. Advise Purchasing of any changes.

2.2.9. Original and continuing periodic inspection of all special and standard gauges, test equipment and tooling used to manufacture product.

2.2.10. Coordinate in-plant corrective action on items rejected by the customer, notify customer of the action taken and evaluate the action for effectiveness.

2.2.11. Assure that inspection personnel are capable of rendering an unbiased decision to accept or reject any material inspected.

2.2.12. Shall maintain a record of all inspection stamps issued and not reissue a stamp to another inspector for at least six months. Lost or stolen stamps will be treated in the same manner.

2.2.13. Company-owned gauges, nspection devices and test equipment will be made available to the customer when there is a need to verify product conformance.

3.0 PURCHASE ORDER CONTROL

3.1 All purchase orders to Andritz-Ruthner's suppliers require authorization by the Plant Manager or his authorized representative.

3.2 Upon release of a purchase order, the buyer will furnish Andritz-Ruthner's vendor with all required drawings, specifications and necessary customer requirements, such as material or process certification, physical and chemical analysis.

3.3 In the event of a drawing or specification change, the buyer will issue a purchase order change, incorporating the latest engineering changes and latest drawings or other specifications.

3.4 Copies of all the purchase orders are to be kept on file and made available for review upon request by the customer. The Customer's Representative will determine the need to impose a Customer Source Inspection (CSI) on the required parts/services. In general the following situations will require CSI:

3.4.1. Parts that cannot be inspected on receipt due to the nature or state of assembly or testing.

3.4.2. Special test equipment required that is not available at Andritz-Ruthner.

3.4.3. Parts shipped direct to consignee from a vendor or subcontractor.

3.5 Purchase orders shall be coordinated with the Quality Control Manager for verification to assure that the specifications and required inspection details are adequately covered in the written purchase order or package.

4.0 DRAWING AND SPECIFICATION CHANGE CONTROL

4.1 Andritz-Ruthner, Inc. fabricates and manufactures to customer drawings and/or specifications, which are filed in job folders.

4.2 Production Control is responsible for the charging out and controlling issuance of drawings and specifications. Production Control will issue shop travelers to route parts and materials and establish inspection and test points. The Quality Control Manager will review shop travelers prior to issue.

4.3 The Sales Department receives engineering changes, drawing changes and specification changes from Andritz-Ruthner's customers and is responsible to immediately forward customer changes to Production Control.

4.4 Production Control is responsible for issuing the latest shop travelers, engineering changes, drawings and specifications to the cognizant departments and voiding outdated shop travelers, engineering changes, drawings, specifications and maintaining job folders.

5.0 RECEIVING INSPECTION

5.1 All parts and materials are received and logged in by the Receiving Department

5.2 All parts are presented to Receiving Inspection after being logged in by the Receiving Department.

5.3 Receiving Inspection will not accept materials until it has been determined that the proper certifications have been received, for physical and chemical test data, special processes, Customer or Andritz-Ruthner's Source Inspection.

5.4 The Receiving Inspector shall document the results of all inspections and/or tests.

5.5 Accepted lots are identified by Inspection and sent to stock.

5.6 Rejected lots are identified and held segregated in Receiving Inspection until disposition is made by the Engineering Department.

5.7 The Purchasing Department and applicable vendors will receive a copy of all Receiving Department rejection reports.

5.8 Corrective action to prevent recurrence of discrepancies discovered by Receiving Inspection is the responsibility of the Purchasing Department.

5.9 Follow-up to ensure that corrective action taken by a vendor was effective is a Quality Department responsibility.

5.10 Receiving Inspection instructions are issued in written form, as applicable, with consideration given to complexity of the parts, material received and customer requirements.

5.11 A periodic review is made of Receiving Inspection records by the Quality Department to detect vendor process capability problems.

5.12 All inspection records will include the number inspected, number rejected, date of inspection and positive identification of the inspector.

5.13 Inspection records will include information as to the disposition of vendor supplied records and data.

6.0 RAW MATERIAL CONTROL

6.1 Raw material, bar stock, sheet stock and castings are identified to the proper certification and are stored in an area apart from the normal flow of in-process material.

6.2 Copies of all certifications are filed and are available for review at the customer's request.

6.3 Certified stock is issued from the raw material storage area to comply with the engineering requirements.

6.4 Verification of suppliers' certifications are accomplished by independent testing laboratories when deemed necessary by the Quality Department or Andritz-Ruthner's customer purchase order requirements.

6.5 All certifications will be identifiable to the applicable purchase order, date of receipt of the materials.

7.0 CUSTOMER FURNISHED MATERIAL

7.1 This section applies to all customer furnished materials unless excluded from these requirements by contractual agreement.

7.2 Receiving Inspection is to examine all customer furnished materials, upon receipt for transit damage, completeness, proper type, verification of quantity and proper identification.

7.3 Functional testing will take place either prior to or after installation or both, as required by contract to determine satisfactory operation.

7.4 Periodic inspection and precautions to assure adequate storage conditions to prevent damage will be conducted by the Quality Department.

7.5 All customer furnished material will be identified and kept segregated to prevent improper use or disposal.

7.6 All discrepancies shall be immediately reported to the proper Customer Representative.

8.0 IN-PROCESS INSPECTION (PIECE PARTS)

8.1 First piece inspection is performed by the Quality Department after setup is complete and okayed by Production.

8.2 No production runs are made until first piece inspection is completed and found acceptable.

8.3 After first piece inspection acceptance, in-process inspections are performed by Quality Department at adequate intervals to provide early detection of processes producing nonconforming material.

8.4 Records of all first piece and in-process inspections are maintained by the Quality Department.

8.5 Inspection records are stored in the job folder and are available for customer review.

8.6 Rejected items are clearly identified by a tag or other applicable means and moved to an area apart from the normal flow of in-process materials.

8.7 Obtaining corrective action and performing follow-up action to prevent recurrence of discrepant material is the responsibility of the Quality Department.

8.8 Inspection records will include the number of pieces accepted, number rejected, nature of defects and basic causes of rejection, date of inspection and positive identification of the inspector.

9.0 ASSEMBLY INSPECTION AND/OR VUNCTIONAL TESTING

9.1 Assembly inspection and any necessary functional testing is performed, as required, by Production personnel.

9.2 The Quality Department performs surveillance inspection of the functional tests in accordance with a specified sampling procedure.

9.3 Inspection records are maintained by Quality Department personnel.

9.4 Inspection records are filed in the job folder and will be available for customer review on request.

9.5 All nonconforming assemblies are identified and segregated to preclude any chance of accidentally being used.

9.6 Obtaining corrective action and performing follow-up action to prevent recurrence of discrepant material is the responsibility of Quality Department.

9.7 Inspection records will include the number accepted, number rejected, date of inspection and positive identification of the inspector.

9.8 The Customer Representative servicing this plant will be notified (5) five days in advance of the time of assembly and functional testing.

10.0 FINAL INSPECTION AND TESTS

10.1 Final inspection and tests are performed 100 percent or on a sample basis, as applicable to complexity of the items produced and/or customer requirements. Inspection will be in accordance with customer supplied procedures, when available.

10.2 Final inspection and test reports are maintained by the Quality Department.

10.3 Inspection and test records are filed in the job folder and will be available for review upon the request of the customer.

10.4 Corrective action and performing follow-up action to prevent recurrence of discrepant material is the responsibility of the Quality Department.

10.5 All nonconforming material is identified and segregated apart from the normal flow of finished material.

10.6 Nonconforming material is not released for shipment to the customer without specific instructions from the customer to submit the nonconforming material.

10.7 Rejected materials, which is subjected to any repair or sorting, is resubmitted to Final inspection for verification of the adequacy of the rework.

10.8 Inspection records will include the number of pieces accepted, number rejected, date of inspection and positive identification of the inspector.

11.0 NONCONFORMING MATERIAL CONTROL

11.1 All nonconforming supplies, parts and/or materials are placed in a segregated area. The items will be clearly identified to job number, part number, lot size, quantity rejected, discrepant characteristic, inspector's name and other identification, as required.

11.2 The nonconforming characteristic(s) are clearly indicated on a rejection tag attached to each part or container.

11.3 No one is authorized to remove nonconforming items from the segregated area until a review is completed by a Material Review Board consisting of the Plant Manager, an Engineering Representative, a Production Representative and Quality Department Representative. When there is a requirement for Customer Source Inspection, the applicable representative must be part of the review committee when the discrepancy is likely to affect form, fit, function or safety.

11.4 Nonconforming material will not be shipped, until concurrence from the customer from the customer is received.

11.4.1. All nonconforming material shipped to the customer shall have the discrepancy clearly indicated on the shipping documents.

11.5 The integrity of all lots submitted to acceptance inspection are maintained under the control of the Quality Department at all times and will be segregated from normal material flow.

11.6 During the processing of material, a system will be used to assure proper sequence and completion of production and inspection activities.

11.7 A system of inspection status will be used to identify the status of inspected material.

11.8 Unidentified material is segregated from the normal flow of production material until conformance of material to all specifications is established.

11.9 Reworked material is segregated from other material until conformance of material to all specifications is established by the Quality Department.

12.0 TOOL AND GAUGE CONTROL (see Measuring Equipment Control Procedures):

12.1 All special tools, jigs, fixtures, gauges and measuring equipment shall be properly identified.

12.2 Each new, or reworked toll, jig, fixture, gauge and items of measuring equipment are inspected prior to being issued for use.

12.3 All gauges, measuring test equipment are checked to standard which are traceable to the National Institute of Standards and Technology (formerly NBS).

12.4 Obsolete or out-of-service tools and gauges are identified by tags.

12.5 Calibration of personal or company owned inspection tools is required.

13.0 OVERRUN STOCK CONTROL

13.1 The Quality Department shall have the responsibility of surveillance of any overrun stock.

13.2 The Quality Department will assure that any overrun parts presented for stock are properly identified as to inspection status (acceptance), part number, latest drawing number and revision, specification revision, date of inspection acceptance, job number, quantity of parts, identification of inspector and that the parts are adequately packaged to prevent deterioration or damage.

13.3 No overrun parts are shipped to a customer until reinspection is accomplished to assure they are in acceptable condition and meet all the latest drawing and specification revisions.

14.0 PACKAGING AND SHIPPING

14.1 No order will be shipped to a customer until all shipping papers are identified by the Final Inspector's acceptance stamp, or Inspector's signature and date of inspection acceptance.

14.2 No material will be shipped until all required certifications, test reports, special samples, etc., have been packaged with the material in accordance to Andritz-Ruthner's customer requirements.

14.3 All items shall be packaged in a manner that prevents damage, deterioration or substitution.

14.4 Adequate marking shall appear on the packaging, parts and as otherwise necessary to provide positive identification to the applicable customer.

14.5 Any required special packaging will be controlled as specified by Andritz-Ruthner customer.

15.0 IDENTIFICATION OF PARTS

15.1 Parts will be marked in accordance with customer requirements and specifications.

15.2 Materials and articles having a critical application are also identified by a serial number or lot number.

ANDRITZ-RUTHNER, INC.

16.0 PROCESS CONTROLS

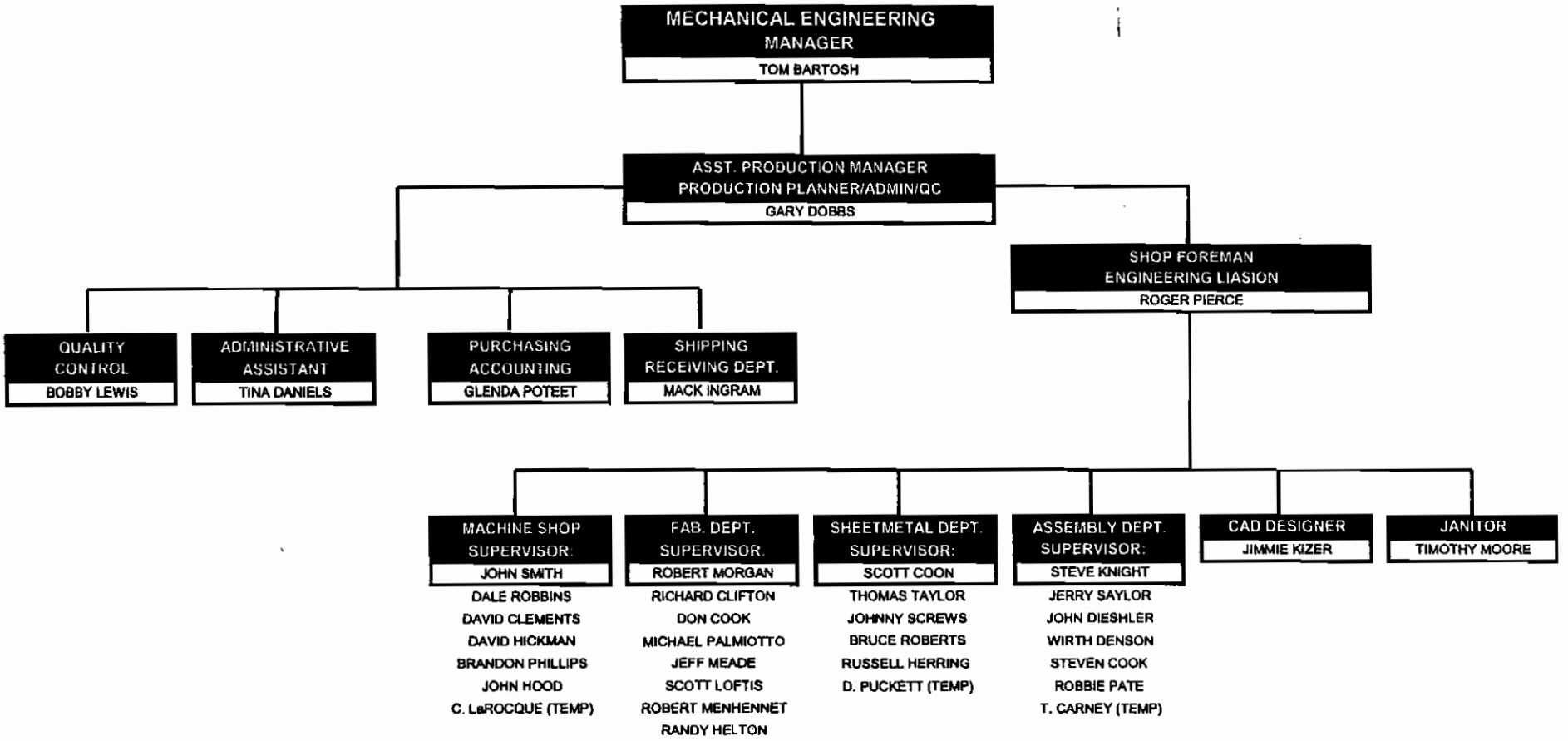
16.1 Process controls shall be an integral part of Andritz-Ruthner's inspection system when such inspections are part of the specification or contract. The shop traveler will indicate each inspection point.

16.2 Special Processes: only approved vendors will be used to do special processes. For example: welding, plating or radiography will be controlled by Vendor Surveys and Andritz-Ruthner's Source Inspections to ensure conformance to customer requirements.

ANDRITZ - RUTHNER, INC.

PITTSBURG MANUFACTURING DIVISION

ORGANIZATION CHART



APPENDIX A

Rev. 5/5/2006

ANDRITZ

1010 Commercial Blvd. South
Arlington, TX 76001 USA
Phone : 817.465.5611
Fax : 817.472.8754

MANUFACTURING DIVISION
110 Dickson Street
Pittsburg, TX 75686 USA
Phone : 903.856.0445
Fax : 903.856.3498

PURCHASE ORDER

PO Number: 49980

Vendor:
GREG GAMELIN
MOTION INDUSTRIES
625 STADIUM DRIVE
ARLINGTON TX 76011
United States

Phone: 817-277-5516
Fax: 817-277-8108

Ship To:

ANDRITZ-RUTHNER, INC
1010 COMMERCIAL BLVD. SO.
ARLINGTON TX 76001
United States

Freight Paid: No

Order Date: 05/11/2006
Terms: NET 30 DAYS
Resale No: 1-25-1342907

Required Date : 05/12/2006
Ship Via: UPS GROUND
F.O.B: ORIGIN, PPD&ADD

Line	Order Qty.	Part Number/Rev/Description	Unit Price	Ext Price	Tax
1	2.00 EA	V130A / 0 V-RING,NEOPRENE,BORE 4.9375"	7.26000	$14.52	No

NITRILE

- Shipping Release Requirement -	Due Date	Quantity		Job Number	M/S	Asm	Seq
	05/12/2006	2.00	EA				

Authorized By: LAW, DARREN

Total: **$14.52**

Buyer Signature | Mgr. Approval | Prj. Mgr. Approval | Pres. Approval

Confirm Delivery and Price only if different than noted on this Purchase Order. This information must be received prior to receipt of material. The attached Andritz-Ruthner, Inc. Terms and Conditions dated 03/18/1999 governs this Purchase Order unless there is a current signed Andritz-Ruthner, Inc. Terms and Conditions on file..

Vendor Acknowledgement :

Signature & Title | Date

IR#:

ANDRITZ

Pick-up For:
- ☐ Credit
- ☐ Exchange
- ☐ Rework
- ☐ Repair

INSPECTION REPORT

PURCHASE ORDER:				
VENDOR/CUSTOMER NANE:	PART #			PART OR ASSEM. NAME:
DWG. REV.	USED ON:	JOB # :	DATE:	PROJECT # :
QTY. EXAM.	QTY. REJECTED:	QTY. USE-AS-IS:	RMA#:	INSPECTED BY:

ITEM	QTY.	NON-CONFORMANCE

DISPOSITION

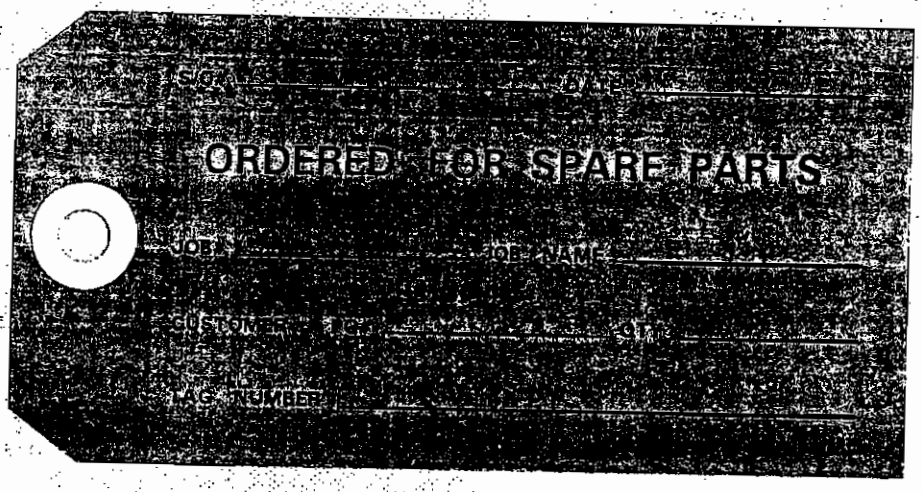
☐ USE AS IS ☐ REWORK ☐ SCRAP

IF REWORK, PROCEDURE & ROUTING:

SHIPPING INSTRUCTIONS

SHIP TO	NAME:	SHIP VIA: ☐ VENDER ☐ UPS ☐ BEST WAY
	ADDRESS:	FREIHT: ☐ PREPAID ☐ COLLECT ☐ BILLED
		VENDOR CONTACT/DATE:
VENDOR PHONE #	RETURN AUTHORIZATION NO.	SIGNATURE/DATE: AUTHORIZED AGENT OF VENDOR

APPROVAL - ENG. DATE	APPROVAL - MFG. DATE	APPROVAL - QC DATE
		Chuck Massie 10/11/01



DATE _____

JOB # _____ **QUANTITY** _____

PO/RA # _____

PART NUMBER _____

DESCRIPTION _____

Job: SOP32319-1AA Asm: 0 Part: DMM27295 Rev: 0 Drawing: DMM27295
Desc: DRIVE ROLL COVERING (ASHBROOK)

---- Production Quantities ---- - Scheduled Dates -
For Stock: 0.00 For Order: 1.00 Total: 1.00 Start: 02/17/06 Due: 03/10/06 Req. By: 03/10/06
611-169 AA 3-1-06 S032319

GREG
2.0M GBT (AQUABELT) DRIVE ROLL ROLL COVERING. ASHBROOK MODIFICATION.
++
RELEASED TO A/P SHOP 3/1/2006 BY GARYD WITH COMPLETION DATE OF 3/10/2006.

SHIPPING SCHEDULE:

Date	SO	Line	Rel	Order Qty	Qty from Job	Qty frm Stk	Whse	Ship Via	Ship to	Status
03/10/06	32319	1	1	1.00	1.00	0.00		CUSTOMER PICKUP	TRINITY RIVER AUTHORITY	(CLOSE

SUB-ASSEMBLY COMPONENTS:

Asm	Part Number	Description	Required Qty	Qty from Stk	Whse
1	DMM27296	DRIVE ROLL CORE ASSY	1.00EA	0.00	AA
11	DISASSEMBLE EXISTING	TEAR DOWN EXISTING ROLLER	1.00EA	0.00	
	DIS-ASSEMBLE EXISTING ASHBROOK ROLLER FOR ENGINEERING PURPOSES.				

RAW MATERIAL COMPONENTS:

Seq	Part Number	Description	Bubble Num	Required Qty	Whse	RelOp
20	913SXM10X12	SOC SET SCREW M10 X 12, 316SS	03	2.00EA	AP	10(ISSUE

OPERATIONS... No of -- Setup -- --- Production ---

Seq	WkCtr	Oper.	Description	Opr.Qty	Mach	Crew	Est. Hrs	Crew	Est. Hrs	Standard	Start	Due	Status
10	OP	OP	OP OUTSIDE PRODUCTION	1.00	ID:00004328		0001	FINZER ROLLER, L.L.C.			02/27/06	03/10/06	CMPL

APPLY BUNA-N ROLLER COVERING PER DRAWING DMM27295.
RETURN TO ANDRITZ-ARLINGTON UPON COMPLETION.

Seq	WkCtr	Oper.	Description	Opr.Qty	Mach	Crew	Est. Hrs	Crew	Est. Hrs	Standard	Start	Due	Status
20	14A	-	-	1.00	1	1	1.00	0.00	1.00	0.05	0.05000HP	03/10/06	03/10/06

INSPECT ROLLER COVERING AND INSTALL SET-SCREWS.

Seq	WkCtr	Oper.	Description	Opr.Qty	Mach	Crew	Est. Hrs	Crew	Est. Hrs	Standard	Start	Due	Status
30	12A	-	-	1.00	1	1	1.00	0.00	1.00	0.00	0.00000HP	03/10/06	03/10/06

SHIP TO CUSTOMER JOB-SITE.

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS001

BASE MATERIAL: ASTM A276, 316L,P# 8

FILLER MATERIAL: ASTM-SFA 5.22, E316LT-1, .035"

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (27-28)
CURRENT - D.C.; POSITIVE
AMPS - (150)

POSITION: VERTICAL, 3G

TORCH TYPE: TWECO #4

TORCH SHIELDING GASES:
ARGON/Co2
COMPOSITION -75/25
FLOW RATE -(35 CFH)

GAS CUP SIZE: 1/2"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - NA
DEGREES FAHRENHEIT
PREHEAT MAINTENANCE -

JOINT DESIGN: SKETCH
(SEE ATTACHED)

1) BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.500"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

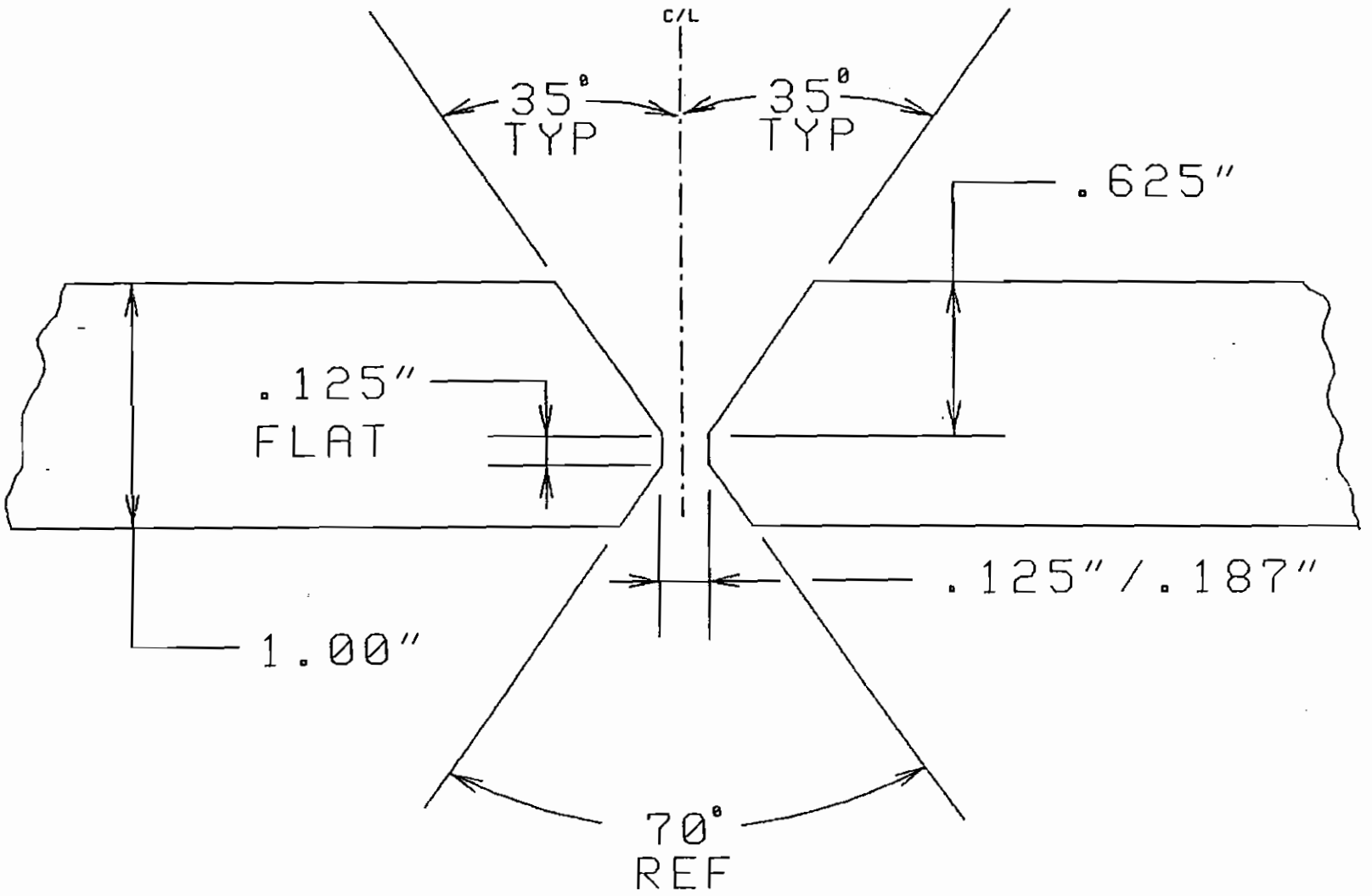
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



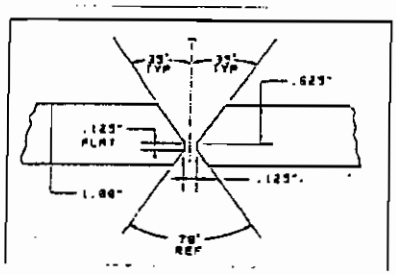
(FILE NAME:TEST)

ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS001 — (PLATE), PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM — FILLER MATERIAL: AWS A5.22, E316LT-1
(2) GRADE A276 — ASTM-SFA 5.22 DIAMETER: .035"
(3) THICKNESS 1" — (MAXIMUM SIZES TO BE USED IN PRODUCTION)
(4) GROUP NO. 8 — JOINT DESIGN: 3G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with 1/8" Lip
WELDING POSITION: Vertical
POWER SOURCE: Miller Delta Weld 300
ARC VOLTAGE: 28 RANGE: 27-28
AMP RANGE: 150

WIRE SPEED RANGE: (WPM) 60-62
TORCH GAS: ARGON/CO2 — MINIMUM PREHEAT TEMPERATURE None
TORCH TIP SIZE: NA" — MAXIMUM INTERPASS TEMPERATURE NA
CUP SIZE: 1/2" — POST WELD HEAT TREATMENT/
SHIELDING GAS: — TEMPERATURE: NA
(1) COMPOSITION 75/25 — TIME: NA
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

WELDER/WELDING OPERATOR: STEVE TERREL # 0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA

VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY
BEND TEST RESULTS: _____ (SEE ATTACHED)

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

TEST APPROVED BY _____ (NAME) — LABORATORY: _____

DATE OF CERTIFICATION: _____ — VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

THE ESAB GROUP, INC.
1500 Karen Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

6/7/94

Langdon Oxygen
Mt. Pleasant, TX

Attn: Scott

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.22-80, ASME SFA 5.22

Trade Name
or Trademark: Alloy Rods Shield-Bright 316 ELC

Diameter Size: .035"

Type: E 316LT-1

Weight:

Test No.: 5-35184-00

Lot Number: 37398

Carbon:	.03
Manganese:	1.37
Chromium:	19.06
Nickel:	11.63
Silicon:	.89
Columbium+:	.02
Tantalum:	<.01
Molybdenum:	2.72
Tungsten:	
Copper:	.26
Titanium:	.04
Phosphorus:	.027
Sulphur:	.008
Vanadium:	.09
Cobalt:	.10
Aluminum:	<.01

Ferrite: 13.3 FN Delong
8.7 FN WRC
10.1% Schaeffler

The chemistry and ferrite values (if applicable) are made from actual determinations made from weld pads deposited with this lot of electrodes.

The undersigned certifies that this report is correct and that no significant change has been made in any of the elements described in the qualification approval.

By: O. A. Smith

O. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994 OUR REPORT NO.: 348-48264-2 5 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A216-T316L / P8	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	WPS 001	0	☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	Welding Procedure Data by: ☐ PSI Witnessed (Tech):		AMPS: 150	☒ Others:

FILLER METAL

Specification No. * EXXXT-X	Classification	5.22
Backing Weld Metal after Back Gouge	Diameter/F No.	.045" / 6
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 3G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for the variables stated.

EMARKS: * Electrode-E316LT-1
** Shielding Gas-75% AR / 25% Co2

Respectfully submitted,
Professional Service Industries, Inc.

317 West Harrison Road • Longview, TX 75604 • Phone: 903/759-4192 • Fax: 903/759-5859

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

WPS No. 001
PQR No.- PQR001
PO# 701437

QW-483 (Back)

August 23, 1994

Report# 348-48264-6

Tensile Test (QW-150)

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.747"	.958"	.716	64,500	90,100	Break/Base Mat'l.
T2	.751"	.982"	.737	66,600	90,400	Break/Base Mat'l.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-6

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Date 8-23-94

Manufacturer Andritz-Ruthner, Inc.

By Lloyd Robinson

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS002

BASE MATERIAL: ASTM A36
P#1, GROUP 1a

FILLER MATERIAL: ASTM A5.20, .035" DIAMETER
AWS A5.20, ASME-SFA 5.20, E71T-1

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (22-23)
CURRENT - D.C.
AMPS - (170-180)

POSITION: VERTICAL, 3G

TORCH TYPE: WELDCRAFT MIG GUN

TORCH SHIELDING GASES:
GAS: ARGON/Co2
COMPOSITION: 75/25
FLOW RATE: 35(CFH)

GAS CUP SIZE: NA

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - 300
DEGREES FAHRENHEIT (+/-25 DEGREES)

JOINT DESIGN:

1) STRING BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

SKETCH
(SEE ATTACHED)

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

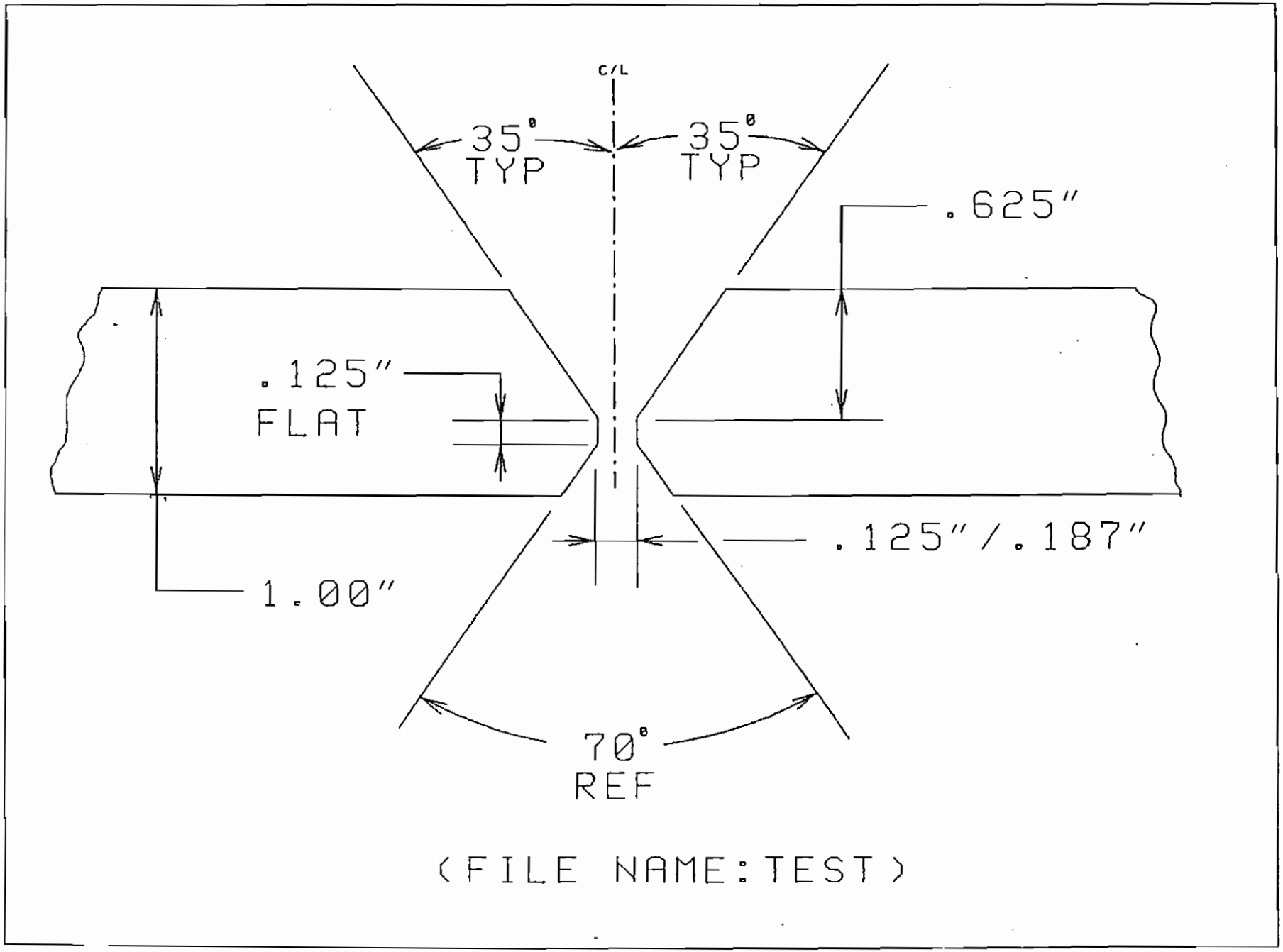
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

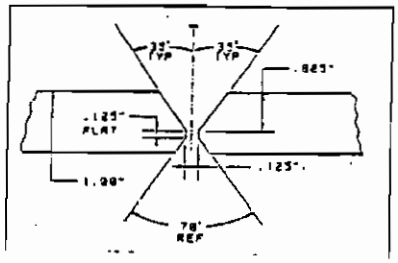
ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS002 (PLATE), PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A36
(3) THICKNESS 1"
(4) GROUP NO. 1a

FILLER MATERIAL: ASTM A5.20, E71T-1, AWS A5.20 DIAMETER: .035
(MAXIMUM SIZES TO BE USED IN PRODUCTION)
JOINT DESIGN: 3G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with 1/8" Lip
WELDING POSITION: VERTICAL
POWER SOURCE: Miller Delta Weld 300
ARC VOLTAGE: 22 RANGE: 22-23
AMP RANGE: 170-180

WIRE SPEED RANGE: (WPM) 35
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: NA
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE 300°(+/-25°)
POST WELD HEAT TREATMENT/
TEMPERATURE: None
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERRE / # 0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA

VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ (NAME)
LABORATORY: _____

DATE OF CERTIFICATION: _____
VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

THE ESAB GROUP, INC.
1500 Karen Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

6/9/94

Langdon Oxygen
Mt. Pleasant, TX

Attn: Scott

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.20-79, ASME SFA 5.20

Trade Name
or Trademark: Alloy Rods Dual Shield 7000

Diameter Size: .035 .035

Type: E 71T-1

Weight:

X-Rays Satisfactory

Lot Number: 36315 36191

Typical Chemical Properties		(Specification Requirements)
		(Amount Shall
Carbon:	.07	be Determined)
Manganese:	1.29	(.75 Max.)
Chromium:	.02	(.20 Max.)
Nickel:	.01	(.50 Max.)
Silicon:	.54	(.90 Max.)
Columbium+:		
Tantalum:		
Molybdenum:	.01	(.30 Max.)
Tungsten:		
Copper:	.01	
Titanium:		
Phosphorus:	.014	(.04 Max.)
Sulphur:	.012	(.03 Max.)
Vanadium:	.02	(.08 Max.)

Diffusible Hydrogen:
6.5 ml/100 gr. CO_2
8.1 ml/100 gr. 75% AR/ 25% CO_2

Fillets: OK Vertical-Up/Overhead

Typical Mechanical Properties

	As Welded	MPa
Yield Strength (Psi)	81,000	558
Tensile Strength (Psi)	92,000	634
Elongation (2"), %	25.0	
Red. of Area, %	55.7	
Charpy V-Notch Impacts		
@ 0°F. (ft.-lbs.)	30	
@ -18°C. (Joules)	41	

(Specification Requirements)

Minimum Unless Otherwise Stated	As Welded	MPa
Yield Strength (Psi)	60,000	414
Tensile Strength (Psi)	72,000	497
Elongation (2"), %	22.0	22
Red. of Area, %	----	--
Charpy V-Notch Impacts		
@ 0°F. (ft.-lbs.)	20	
@ -18°C. (Joules)	27	

The undersigned certifies that the product supplied will meet the requirements of the applicable AWS Filler Metal Specification when tested in accordance with that specification, and that no significant change has been made in the elements described in the qualification approval.

By: D. A. Smith

D. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994 OUR REPORT NO.: 348-48264-2 4 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A 36 / P1	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G / 3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***	0	☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	Welding Procedure Data by: ☐ PSI Witnessed (Tech):		AMPS: ****	☒ Others:

FILLER METAL

Specification No. * EXXT-X	Classification 5.20	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed		1-X 3G	Passed	
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for variables stated.

REMARKS: * Electrode-E71T-1
** Shielding Gas-75% AR / 25% Co2

*** 1G-WPS 009
2G-WPS 007
3G-WPS 002

**** 1G-280-290
2G-220-230
3G-170-180

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

WPS No. 002
PQR No.-PQR002
PO# 701437

QW-483 (Back)

August 23, 1994

Report# 348-48264-9

Tensile Test (QW-150)

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.741"	.904"	.670	54,100	80,700	Break/Base Matl.
T2	.746"	.931"	.695	56,300	81,000	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-9

We certify that the statements in this record are correct and that the test welds were preprared, welded and testad in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date _____ By _____

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS003

BASE MATERIAL: ASTM A276, 316L,P# 8

FILLER MATERIAL: ASTM-SFA 5.22, E316LT-1,
AWS A5.22, .045" DIAMETER

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (30)
CURRENT - D.C.; POSITIVE
AMPS - (220-230)

POSITION: FLAT; 1G

TORCH TYPE: TWECO #4

TORCH SHIELDING GASES:
ARGON/Co2
COMPOSITION -75/25
FLOW RATE -(35 CFH)

GAS CUP SIZE: 5/8"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - NA
DEGREES FAHRENHEIT
PREHEAT MAINTENANCE - NONE

JOINT DESIGN: SKETCH
(SEE ATTACHED)

1) BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

WELDERS NAME: STEVE TERREL

ID # 0351

TEST CONDUCTED BY: PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY: LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

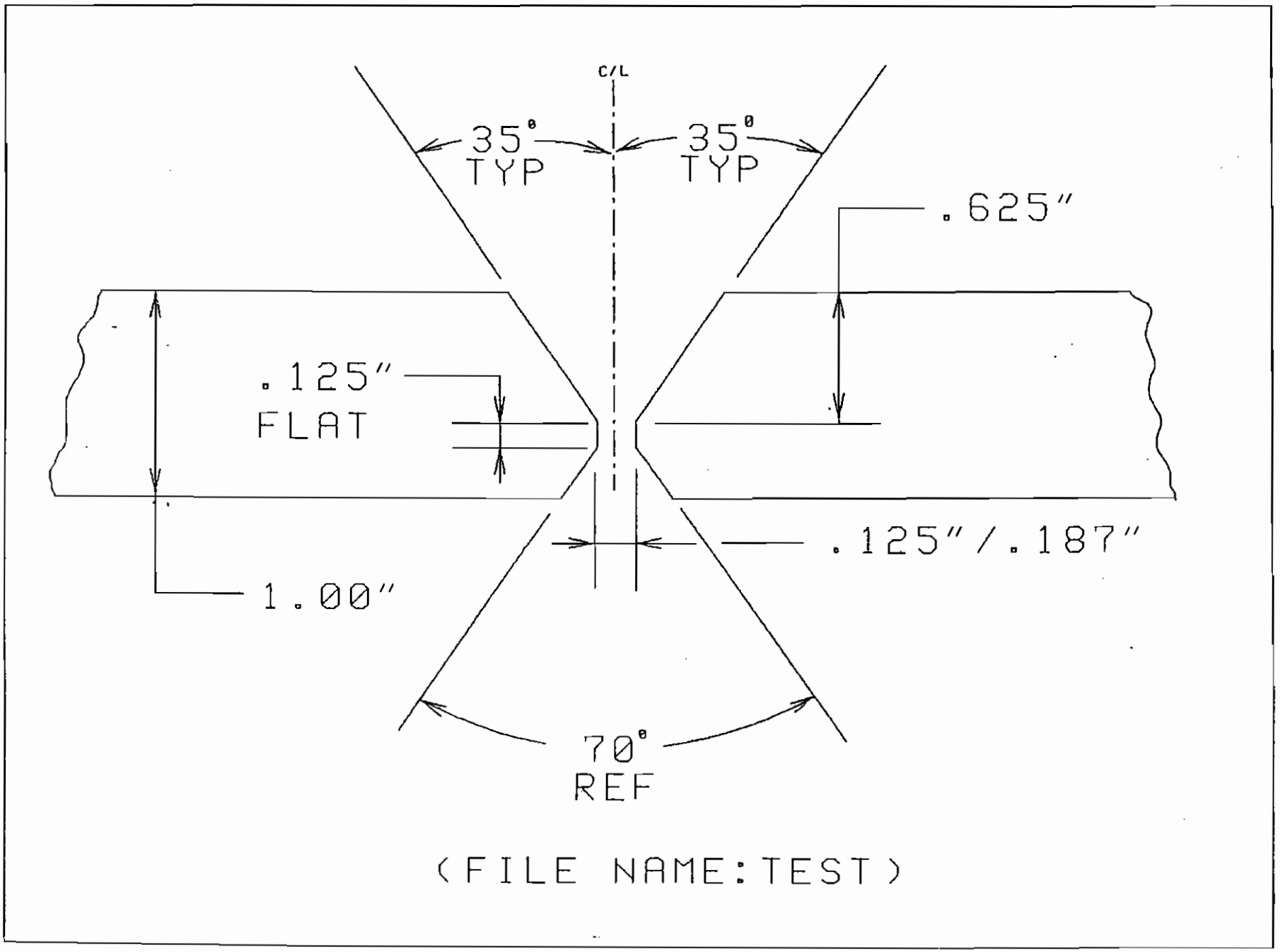
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

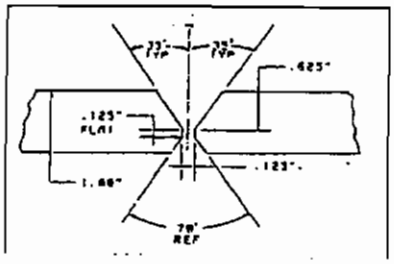
ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS003 (PLATE), PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A276
(3) THICKNESS 1"
(4) GROUP NO. 8

FILLER MATERIAL: AWS A5.22, E316LT-1, ASTM-SFA 5.22 DIAMETER: .045
(MAXIMUM SIZES TO BE USED IN PRODUCTION)
JOINT DESIGN: 1G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined 70° Double V with 1/8" LIP
WELDING POSITION: Flat
POWER SOURCE: Miller Deltaweld 300
ARC VOLTAGE: 30 RANGE: 29-30
AMP RANGE: 220-230

WIRE SPEED RANGE: (WPM) 62-63
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: 3/8"
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE NA
POST WELD HEAT TREATMENT/
TEMPERATURE: NA
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERREL #0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA
VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ LABORATORY: _____
(NAME)

DATE OF CERTIFICATION: _____ VERIFIED BY: _____
(QUALIFYING ACTIVITY)

APPROVED BY: _____
(AUTHORIZED AGENT)

THE ESAB GROUP, INC.

1500 Karen Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

LANGDON OXYGEN
MT. PLEASANT, TX

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.22-80, ASME SFA 5.22

Trade Name
or Trademark: Alloy Rods Shield-Bright 316 ELC

Diameter Size: .045"

Type: E 316LT-1

Weight:

Test No.: 5-34838-00

Lot Number: 37168

Carbon:	.03
Manganese:	1.37
Chromium:	18.96
Nickel:	11.62
Silicon:	.93
Columbium+:	.03
Tantalum:	<.01
Molybdenum:	2.88
Tungsten:	
Copper:	.42
Titanium:	.06
Phosphorus:	.025
Sulphur:	.009
Vanadium:	.10
Cobalt:	.12
Aluminum:	<.01

Ferrite: 14.0 FN Delong
9.3 FN WRC
10.7% Schaeffler

The chemistry and ferrite values (if applicable) are made from actual determinations made from weld pads deposited with this lot of electrodes.

The undersigned certifies that this report is correct and that no significant change has been made in any of the elements described in the qualification approval.

By: D. A. Smith

D. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: June 30, 1994 OUR REPORT NO.: 348-48264-1 3 of 5

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A276-T316L /P8	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***		☐ AC ☒ DC AMPS: 220-230	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	Welding Procedure Data by: ☐ PSI Witnessed (Tech):			☒ Others:

FILLER METAL

Specification No. * EXXXT-X	Classification 5.22	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed				
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for the variables stated.

REMARKS: * Electrode-E316LT-1
** Shielding Gas- 75% AR / 25% Co2
*** 1G - WPS 003
2G - WPS 004

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686

Attn: Ms. Pat Boyd

WPS No. 003
PQR No.-PQR003
PO# 701437

QW-483 (Back)

August 23, 1994

Tensile Test (QW-150)

Report# 348-48264-4

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.750"	.971"	.728	63,200	86,800	Break/Base Matl.
T2	.746"	.982"	.733	63,500	86,600	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-4

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date 8-23-94 By Lloyd Anderson

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS004

BASE MATERIAL: ASTM A276, 316L,P# 8

FILLER MATERIAL: ASTM-SFA 5.22, E316LT-1,
AWS A5.22, .045" DIAMETER

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (30)
CURRENT - D.C.; POSITIVE
AMPS - (220-230)

POSITION: HORIZONTAL, 2G

TORCH TYPE: TWECO #4

TORCH SHIELDING GASES:
ARGON/Co2
COMPOSITION -75/25
FLOW RATE -(35 CFH)

GAS CUP SIZE: 5/8"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - NA
DEGREES FAHRENHEIT
PREHEAT MAINTENANCE - NONE

JOINT DESIGN: SKETCH
(SEE ATTACHED)

1) BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

WELDERS NAME: STEVE TERREL

ID # 0351

TEST CONDUCTED BY: PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY: LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

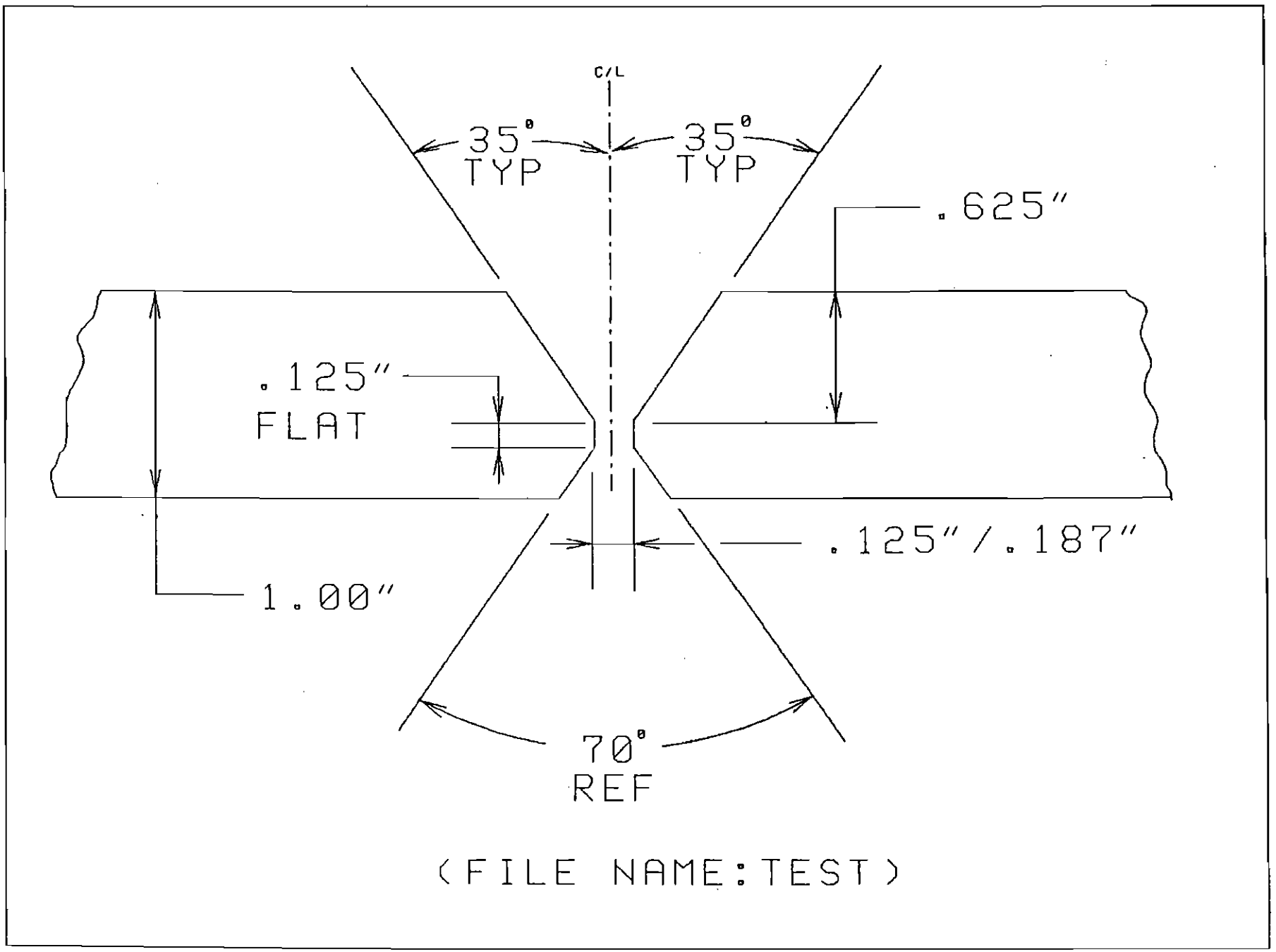
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

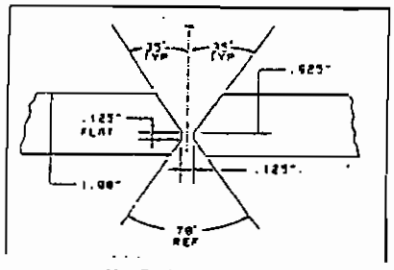
ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS004 (PLATE), PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A276
(3) THICKNESS 1"
(4) GROUP NO. 8

FILLER MATERIAL: AWS A5.22, E316LT-1, ASTM-SFA 5.22 DIAMETER: .045
(MAXIMUM SIZES TO BE USED IN PRODUCTION)
JOINT DESIGN: 2G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined 20° Double V with ⅛" Lip
WELDING POSITION: Horizontal
POWER SOURCE: Miller Deltaweld 300
ARC VOLTAGE: 30 RANGE: 29-30
AMP RANGE: 220-230

WIRE SPEED RANGE: (WPM) 62-63
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: 3/8"
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE NA
POST WELD HEAT TREATMENT/
TEMPERATURE: NA
TIME: NA

WELDER/WELDING OPERATOR: Steve Terrel # 0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA

VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY
BEND TEST RESULTS: _____ (SEE ATTACHED)

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

TEST APPROVED BY _____ (NAME)
LABORATORY: _____

DATE OF CERTIFICATION: _____
VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

THE ESAB GROUP, INC.

1500 Karen Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

LANGDON OXYGEN
MT. PLEASANT, TX

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.22-80, ASME SFA 5.22

Trade Name
or Trademark: Alloy Rods Shield-Bright 316 ELC

Diameter Size: .045"

Type: E 316LT-1

Weight:

Test No.: 5-34838-00

Lot Number: 37168

Carbon:	.03
Manganese:	1.37
Chromium:	18.96
Nickel:	11.62
Silicon:	.93
Columbium+:	.03
Tantalum:	<.01
Molybdenum:	2.88
Tungsten:	
Copper:	.42
Titanium:	.06
Phosphorus:	.025
Sulphur:	.009
Vanadium:	.10
Cobalt:	.12
Aluminum:	<.01

Ferrite: 14.0 FN Delong
9.3 FN WRC
10.7% Schaeffler

The chemistry and ferrite values (if applicable) are made from actual determinations made from weld pads deposited with this lot of electrodes.

The undersigned certifies that this report is correct and that no significant change has been made in any of the elements described in the qualification approval.

By: D. A. Smith

D. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: June 30, 1994 OUR REPORT NO.: 348-48264-1 3 of 5

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A276-T316L /P8	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***		☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L			AMPS: 220-230	
	Welding Procedure Data by: ☐ PSI Witnessed (Tech):			☒ Others:

FILLER METAL

Specification No. * EXXXT-X	Classification 5.22	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance ☐ Pass ☐ Fail	Fillet Size Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed				
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for e variables stated.

REMARKS: * Electrode-E316LT-1
** Shielding Gas- 75% AR / 25% Co2
*** 1G - WPS 003
2G - WPS 004

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

QW-483 (Back)

WPS No. 004
PQR No. -PQR004
PO# 701437

August 23, 1994

Tensile Test (QW-150)

Report# 348-48264-5

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.740"	.937"	.693	61,100	88,200	Break/in Weld
T2	.749"	.942"	.706	61,900	87,700	Break/in Weld

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____
Macro—Results _____

Other Tests

Type of Test _____
Deposit Analysis _____
Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____
Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-5

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.
Date 8-23-94 By Lloyd Anderson

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS007

BASE MATERIAL: ASTM A36
P#1, GROUP 1a

FILLER MATERIAL: ASTM A5.20, .045" DIAMETER
AWS A5.20, ASME-SFA 5.20

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER CP300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (30-31)
CURRENT - D.C.
AMPS - (220-230)

POSITION: HORIZONTAL, 2G

TORCH TYPE: WELDCRAFT MIG GUN

TORCH SHIELDING GASES:
GAS: ARGON/Co2
COMPOSITION: 75/25
FLOW RATE: (35CFH)

GAS CUP SIZE: 1/2"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - 300
DEGREES FAHRENHEIT (+/-25 DEGREES)

JOINT DESIGN:

1) STRING BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

SKETCH
(SEE ATTACHED)

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

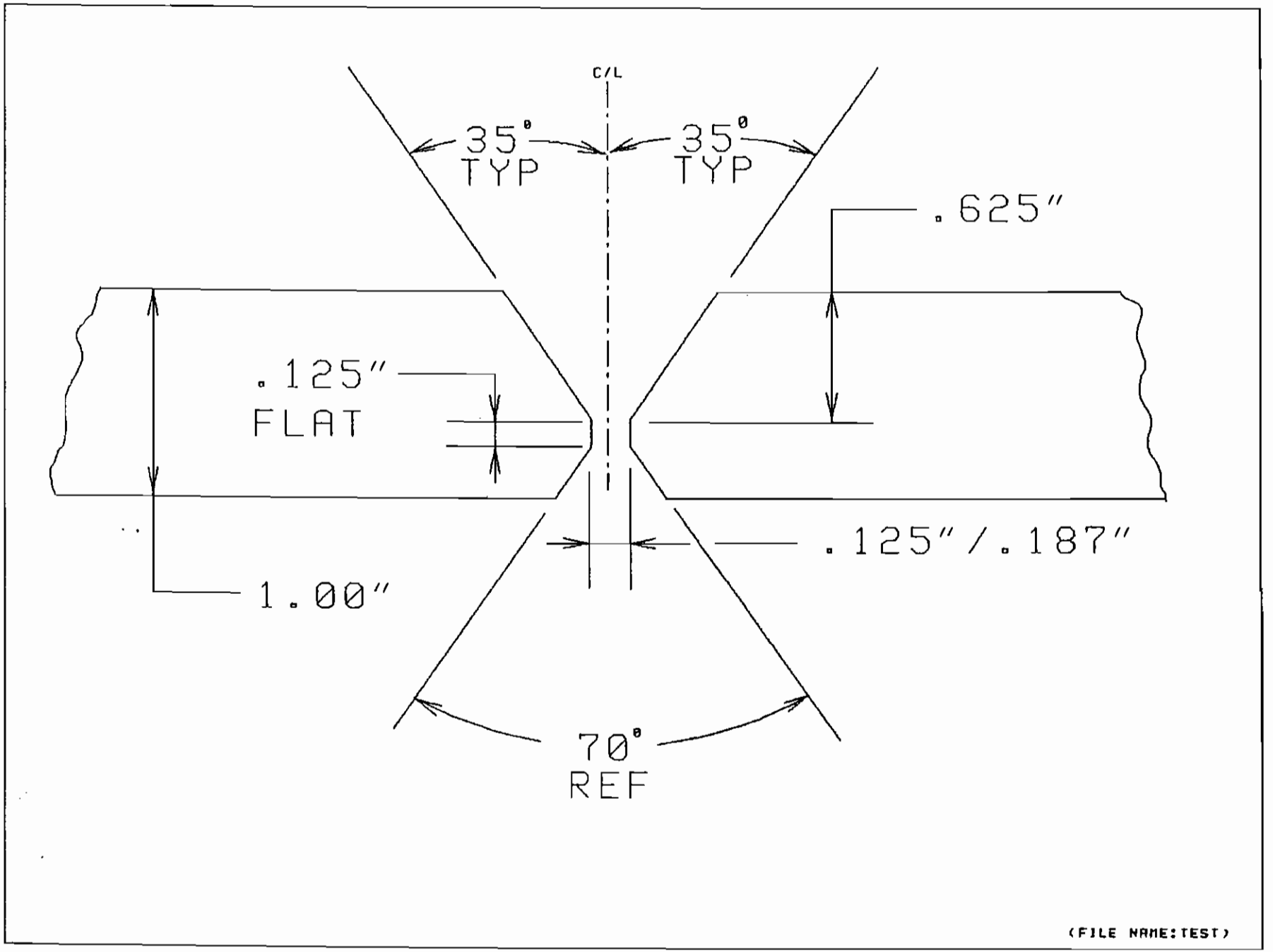
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager


C/L
35°
TYP
35°
TYP
.625"
.125"
FLAT
.125"/.187"
1.00"
70°
REF
(FILE NAME:TEST)

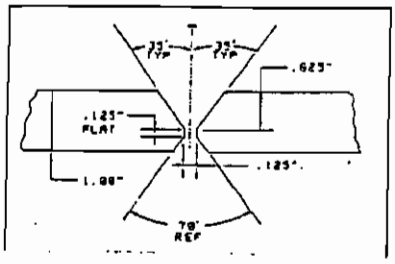
ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS007 (PLATE,) PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A36
(3) THICKNESS 1"
(4) GROUP NO. 1a

FILLER MATERIAL: AWS A5.20 E71T-1, ASME-SFA 5.20 DIAMETER: .045"
(MAXIMUM SIZES TO BE USED IN PRODUCTION)
JOINT DESIGN: 2G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with 1/8" Lip
WELDING POSITION: Horizontal
POWER SOURCE: Miller CP300
ARC VOLTAGE: 30 RANGE: 30-31
AMP RANGE: 220-230

WIRE SPEED RANGE: (WPM) 48
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: 1/2"
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE None
MAXIMUM INTERPASS TEMPERATURE 300°(+/-25°)
POST WELD HEAT TREATMENT/
TEMPERATURE: None
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERREL #0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA

VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ LABORATORY: _____
(NAME)

DATE OF CERTIFICATION: _____ VERIFIED BY: _____
(QUALIFYING ACTIVITY)

APPROVED BY: _____
(AUTHORIZED AGENT)

TRI-MARK, INC.
8585 Industry Park Drive
Piqua, OH 45356
(513-773-2010

CERTIFICATE OF COMPLIANCE
TO REQUIREMENTS FOR WELDING ELECTRODE

Supplied To: Langdon Oxygen Company
3503 West 7th Street
Texarkana, TX 75501

Customer Order No. : 2275
Tri-Mark Invoice No. : 2576-1
Date : 11-5-87
Type : TM-711
Diameter : 1/16, .045"
Diameter Tested : 1/16"
Classification : E71T-1
Test Specification : AWS A5.20
Production No. : see other side
Lab Test No. : AG456
Test Plates and Assembly : per AWS A5.20

Test Assembly Welding Procedure:
Amperage: 275 DCEP Voltage: 27
Stickout: 3/4" Shielding Gas: 40 cfh of CO_2
3/4" Diameter Nozzle

Interpass Temp.: 300 ± 25°F.
Layer Buildup: Six layers; two stringer beads on each of layers one and two; two weave beads on each of layers three through six; direction of travel reversed on each layer.

Test Specimens: per AWS A5.20
Testing Procedures: per AWS A5.20

CHEMICAL ANALYSIS (Undiluted Weld Metal)

% C	.037
Mn	1.08
P	.010
S	.021
Si	.812
Cr	.042
Ni	.025
Mo	.009
V	.023
Cu	.019
Al	.007

MECHANICAL PROPERTIES (All Weld Metal)

Tensile Strength, psi	88,890
Yield Strength, psi	77,510
Elongation, % in 2"	26
Charpy V-Notch Impact Values Ft-lb at 0 °F., Average	24.5, 24.5, 25.5 24.8

Radiographic Inspection: Radiographic results of actual weld acceptable.
Overhead and vertical fillet tests: Acceptable

This is to certify that TM-711, classification E71T-1, supplied on the above order, is of the same classification, manufacturing process, and material requirements as the electrode tested on March 3, 1987.

All tests required by specification AWS A5.20 were performed in conformance with that specification, and the above electrode met all requirements.

[redacted]
STATE OF OHIO

M. T. Merlo, Techn. Director

J. K. O'Leary, Q.A. Manager

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994 OUR REPORT NO.: 348-48264-2 4 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A 36 / P1	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G / 3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***	0	☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	Welding Procedure Data by: ☐ PSI Witnessed (Tech):		AMPS: ****	☒ Others:

FILLER METAL

Specification No. * EXXT-X	Classification	5.20
Backing Weld Metal after Back Gouge	Diameter/F No.	.045" / 6
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	**Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)**

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed		1-X 3G	Passed	
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for the variables stated.

REMARKS: * Electrode-E71T-1
** Shielding Gas-75% AR / 25% Co2

*** 1G-WPS 009
2G-WPS 007
3G-WPS 002

**** 1G-280-290
2G-220-230
3G-170-180

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

QW-483 (Back)

WPS No. 007
PQR No.-PQR007
PO# 701437

August 23, 1994

Report# 348-48264-8

Tensile Test (QW-150)

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.739"	.937"	.692	56,200	81,200	Break/Base Matl.
T2	.747"	.898"	.671	54,700	81,500	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-8

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date _____ By _____

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS009

BASE MATERIAL: ASTM A36
P#1, GROUP 1a

FILLER MATERIAL: ASTM A5.20, .045" DIAMETER
AWS A5.20, ASME-SFA 5.20

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER CP300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (31-32)
CURRENT - D.C.
AMPS - (280-290)

POSITION: FLAT, 1G

TORCH TYPE: WELDCRAFT MIG GUN

TORCH SHIELDING GASES:
GAS: ARGON/Co2
COMPOSITION: 75/25
FLOW RATE: 35(CFH)

GAS CUP SIZE: NA

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - 300
DEGREES FAHRENHEIT (+/-25 DEGREES)

JOINT DESIGN:

1) STRING BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

SKETCH
(SEE ATTACHED)

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

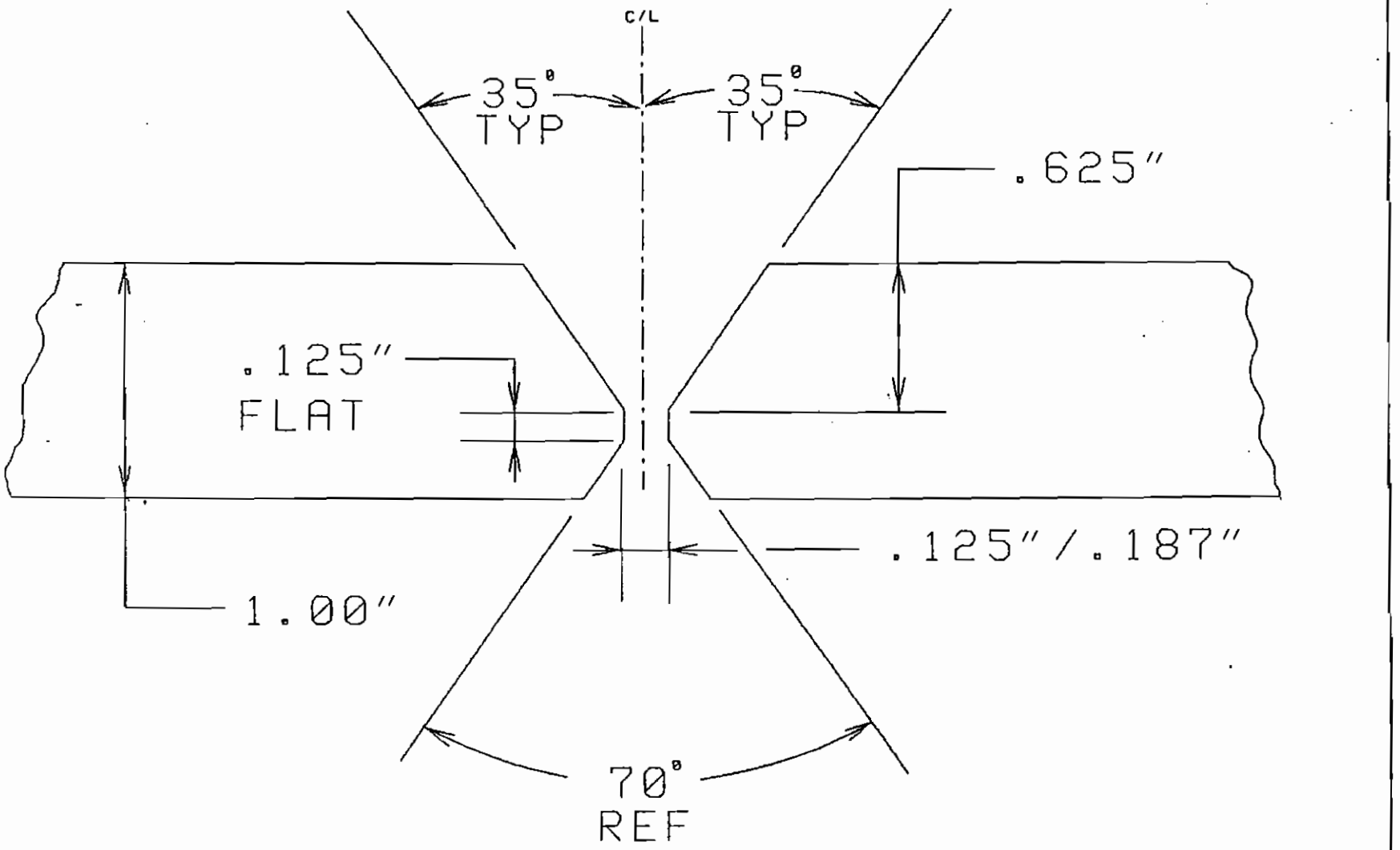
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

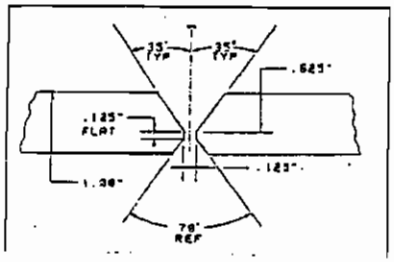
ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS009 (PLATE) PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A36
(3) THICKNESS 1"
(4) GROUP NO. 1a

FILLER MATERIAL: AWS A5.20 E71T-1,
ASTM-SFA 5.20 DIAMETER: .045
(MAXIMUM SIZES TO BE USED IN PRODUCTION)
JOINT DESIGN: 1G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with 1/8" Lip
WELDING POSITION: Flat
POWER SOURCE: Miller CP 300
ARC VOLTAGE: 31 RANGE: 31-32
AMP RANGE: 280-290

WIRE SPEED RANGE: (WPM) 63
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: NA
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35 (CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE 300° (+/- 1025°)
POST WELD HEAT TREATMENT/
TEMPERATURE: NA
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERREL #0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA

VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY
BEND TEST RESULTS: _____ (SEE ATTACHED)

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

TEST APPROVED BY _____ (NAME)
LABORATORY: _____

DATE OF CERTIFICATION: _____
VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

TRI-MARK, INC.
8585 Industry Park Drive
Piqua, OH 45356
513-773-2010

CERTIFICATE OF COMPLIANCE TO REQUIREMENTS FOR WELDING ELECTRODE

Supplied To: Langdon Oxygen Company
3503 West 7th Street
Texarkana, TX 75501

Customer Order No.	: 3375
Tri-Mark Invoice No.	: 2576-1
Date	: 11-5-87
Type	: TM-711
Diameter	: 1/16, .045"
Diameter Tested	: 1/16"
Classification	: E71T-1
Test Specification	: AWS A5.20
Production No.	: see other side
Lab Test No.	: AG456
Test Plates and Assembly	: per AWS A5.20

Test Assembly Welding Procedure:
Amperage: 275 DCEP Voltage: 27
Stickout: 3/4" Shielding Gas: 40 cfh of CO_2
3/4" Diameter Nozzle

Interpass Temp.: 300 ± 25°F.
Layer Buildup: Six layers; two stringer beads on each of layers one and two; two weave beads on each of layers three through six; direction of travel reversed on each layer.

Test Specimens: per AWS A5.20
Testing Procedures: per AWS A5.20

CHEMICAL ANALYSIS (Undiluted Weld Metal)

% C	.037
Mn	1.08
P	.010
S	.021
Si	.812
Cr	.042
Ni	.025
Mo	.009
V	.023
Cu	.019
Al	.007

MECHANICAL PROPERTIES (All Weld Metal)

Tensile Strength, psi	88,890
Yield Strength, psi	77,510
Elongation, % in 2"	26
Charpy V-Notch Impact Values Ft-lb at 0 °F., Average	24.5, 24.5, 25.5 24.8

Radiographic Inspection: Radiographic results of actual weld acceptable.
Overhead and vertical fillet tests: Acceptable

This is to certify that TM-711, classification E71T-1, supplied on the above order, is of the same classification, manufacturing process, and material requirements as the electrode tested on March 3, 1987.

All tests required by specification AWS A5.20 were performed in conformance with that specification, and the above electrode met all requirements.

[redacted]
STATE OF OHIO

M. T. Merlo, Technical Director

J. K. O'Leary, Q.A. Manager

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994 OUR REPORT NO.: 348-48264-2 4 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A 36 / P1	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G / 3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***	0	☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	Welding Procedure Data by: ☐ PSI Witnessed (Tech):		AMPS: ****	☒ Others:

FILLER METAL

Specification No. * EXXT-X	Classification 5.20	Appearance	Good
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	Undercut	None
Shielding ☒ Gas: ** ☐ Flux	Trade Name	Piping Porosity	None

VISUAL INSPECTION (AWS ONLY)

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results	**Fracture Test Results (Describe location, nature & size of any cracks or teanng of the specimen)**
☐ Pass ☐ Fail	

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed		1-X 3G	Passed	
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for e variables stated.

REMARKS: * Electrode-E71T-1
** Shielding Gas-75% AR / 25% Co2

*** 1G-WPS 009
2G-WPS 007
3G-WPS 002

**** 1G-280-290
2G-220-230
3G-170-180

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

QW-483 (Back)

WPS No. 009
PQR No.-PQR009
PO# 701437

August 23, 1994

Report# 348-48264-7

Tensile Test (QW-150)

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.748"	.934"	.699	56,800	81,300	Break/Base Matl.
T2	.750"	.943"	.707	57,800	81,800	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-7

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date _____ By _____

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

FORMAL QUOTATION NO.:Q-060117

LEE COUNTY, FLORIDA
PROPOSAL QUOTE FORM
FOR BELT PRESS REBUILT FOR KLAMPRESS SIZE 3
(2.0 METER) TYPE 85 FOR LEE COUNTY UTILITIES

DATE SUBMITTED: May 15, 2006

VENDOR NAME: Andritz Ruthner, Inc.

TO: The Board of County Commissioners
Lee County
Fort Myers, Florida

Having carefully examined the "General Conditions", and the "Detailed Specifications", all of which are contained herein, the Undersigned proposes to furnish the following which meet these specifications:

The undersigned acknowledges
receipt of Addenda numbers: One (1) Pages 19, 20 & 22

GRAND TOTAL COST $ 112,670.00

NOTE: SUBMITTALS ARE REQUIRED WITH THIS QUOTE. SEE PAGE 25 DIVISION 3 CONTRACTORS QUALIFICATIONS. ALL REQUESTED SUBMITTALS SHALL BE SUBMITTEDWITH YOUR FIRMS QUOTATION.

TO BE COMPLETED WITHIN 70 CALENDAR DAYS AFTER RECEIPT OF AWARD AND PURCHASE ORDER.

Is your firm interested in being considered for the Local Vendor Preference?
Yes X No _____

If yes, then read the paragraph entitled "Local Vendor Preference" included in these specifications. Also complete the Local Vendor Preference Questionnaire and return with your quotation.

Quoters should carefully read all the terms and conditions of the specifications. Any representation of deviation or modification to the quote may be grounds to reject the quote.

Are there any modifications to the quote or specifications:
Yes _____ No X

Failure to clearly identify any modifications in the space below or on a separate page may be grounds for the quoter being declared nonresponsive or to have the award of the quote rescinded by the County.

MODIFICATIONS:

Quoter shall submit his/her quote on the County's Proposal Quote Form, including the firm name and authorized signature. Any blank spaces on the Proposal Quote Form, qualifying notes or exceptions, counter offers, lack of required submittals, or signatures, on County's Form may result in the Quoter/Quote being declared non-responsive by the County.

ANTI-COLLUSION STATEMENT

THE BELOW SIGNED QUOTER HAS NOT DIVULGED TO, DISCUSSED OR COMPARED HIS QUOTE WITH OTHER QUOTERS AND HAS NOT COLLUDED WITH ANY OTHER QUOTER OR PARTIES TO A QUOTE WHATSOEVER. NOTE: NO PREMIUMS, REBATES OR GRATUITIES TO ANY EMPLOYEE OR AGENT ARE PERMITTED EITHER WITH, PRIOR TO, OR AFTER ANY DELIVERY OF MATERIALS. ANY SUCH VIOLATION WILL RESULT IN THE CANCELLATION AND/OR RETURN OF MATERIAL (AS APPLICABLE) AND THE REMOVAL FROM THE MASTER BIDDERS LIST.

FIRM NAME ANDRITZ RUTHNER, INC.

BY (Printed): JOHN MADDEN

BY (Signature):

TITLE: PRESIDENT

FEDERAL ID # OR S.S.# TX-25-1342907

ADDRESS: 1010 COMMERCIAL BLVD. SOUTH

ARLINGTON, TX 76001

PHONE NO.: 817-419-1728

FAX NO.: 817-419-1928

CELLULAR PHONE/PAGER NO.: 817-266-9512

LEE COUNTY OCCUPATIONAL LICENSE NUMBER:

E-MAIL ADDRESS ARMONDO.ALVARADO@ANDRITZ.COM

REVISED: 7/28/00

The Surety shall be rated as "A-" or better as to General Policyholders Rating and Class VII or better as to financial category by the most current Best's Key Rating Guide, published by A.M. Best Company.

Surety must have fulfilled all of its obligations on all other bonds previously given to the County. Surety must have a minimum underwriting limitation of $5,000,000 published in the latest

edition of the Federal Register for Federal Bonds (U.S. Dept. of Treasury).

1.06 Patents

The bidder warrants that the machine components for rebuilding the existing equipment will not infringe any U.S. or foreign patents or patents pending. In the event of any claim of infringement the bidder shall defend and indemnify the owner free from any liabilities associated with the use of the patented equipment or process.

The bidder hereby grants to the owner, in perpetuity, a paid-up license to use any inventions covered by patent or patents pending, owned, or controlled by the bidder in the operation of the facility being constructed in conjunction with the equipment supplied under this contract, but without the right to grant sublicenses.

Can your firm meet and abide by the Division 1 General Requirements? ___**X**_ YES or _____No

DIVISION 2: MECHANICAL REQUIREMENTS

2.01 Recondition Rollers

Roller reconditioning, Reconditioning of solid rollers shall consist of removing the existing coating then recoating. The existing coating will be machined off to the true roller diameter prior to applying new coating. No other method of removing existing coating will be acceptable. Drive rollers shall be recoated with ¼ inch Buna N rubber. All other solid rollers shall be recoated with 30 mils. of nylon (Rilsan). Roller shall be coated up to the point of insertion into the bearing block. Perforated dandy roller shall be sandblasted, cleaned and inspected. If the skin of this roller is cracked beyond repair replacement of the roller will be needed. The new roller shall have improved thicker design outer skin.

Preparation of rollers prior to applying new coatings shall be as specified above.

The heat setting thermoplastic nylon (Rilsan) coating shall have the following properties. Nylon coating shall be applied by means of fluidized bed process. Spray-on method will also be acceptable. Any rollers beyond repair will be replaced. Any wedge plates beyond repair will be replaced.

Maximum system pressure shall be set equal to the highest pressure required to obtain the desired operating belt tension. The maximum system operating pressure is 1,000 PSI.

Hydraulic system controls shall be grouped for easy access and ease of operation. There shall be means provided to retract the belt tension cylinders for service. The valves, fittings, manifold and associated parts shall be of non-corroding materials such as FRP, glass filled Nylon and stainless steel.

The oil pressure gauges, one for each belt tension cylinders (upper & lower belt) shall indicate oil pressure in PSI and the belt tension in PLI. Normal operating limits shall be indicated on the face of each gauge. Low-pressure switches shall be provided to sense the absence of belt tension pressure.

Customer's electrician shall be responsible for electrical wiring/conduit between new press mounted motor/pressure switches and Belt Press Control Panel.
Hydraulic unit shall meet the latest original equipment manufacture **(O.E.M.)** design standards. All parts will be made to the O.E.M's standard level of quality.

Can your firm meet and abide by the Division 2 General Mechanical Requirements? __x__YES or _____No

DIVISION 3: CONTRACTOR'S QUALIFICATIONS (SUBMITTALS)

The bid shall be awarded to a responsible bidder, qualified by experience to provide the work specified. The bidder shall submit the following information with his bid.

A. Experience record showing the bidder's experience in similar work.
B. List and brief description of similar work satisfactorily completed with location, dates, contact names, addresses of owners and phone numbers.
C. List of equipment and facilities available to do the work.
D. List of personnel, by name and title, contemplated to perform the repairs and modifications to the equipment.
E. Provide proof of ability to obtain a Performance/maintenance bond, if you do not have a formal quality system inplace.

The bidder is required list all equipment that does not meet O.E.M Specification. Supporting documentation must also be provided to verify that material tbat does not meet O.E.M. specification is of equal quality. (Insert additional pages as required).

Can your firm meet and abide by the Division 3 Contractor's Qualification Requirements? _____YES or _____No

DIVISION 4: WARRANTY

The contractor shall warrant that the Klampress shall be free from defects in material and workmanship for a period of five years from date of recommissioning equipment, unless noted otherwise within the specifications.

Can your firm meet and abide by the Division 4 Warranty Requirements? __**X**__YES or _____No

LOCAL BIDDER'S PREFERENCE

Note: In order for your firm to be considered for the local vendor preference, you must complete and return the attached "Local Vendor Preference Questionnaire" with your quotation.

The Lee County Local Bidder's Preference Ordinance No. 00-10 is being included as part of the award process for this project. As such, Lee County at its sole discretion, may choose to award a preference to any qualified "Local Contractor/Vendor" in an amount not to exceed 3 % of the total amount quoted by that firm.

"Local Contractor / Vendor" shall mean: a) any person, firm, partnership, company or corporation whose principal place of business in the sole opinion of the County, is located within the boundaries of Lee County, Florida; or b) any person, firm, partnership, company or corporation that has provided goods or services to Lee County on a regular basis for the preceding consecutive five (5) years, and that has the personnel, equipment and materials located within the boundaries of Lee County sufficient to constitute a present ability to perform the service or provide the goods.

The County reserves the exclusive right to compare, contrast and otherwise evaluate the qualifications, character, responsibility and fitness of all persons, firms, partnerships, companies or corporations submitting formal bids or formal quotes in any procurement for goods or services when making an award in the best interests of the County.

FORMAL QUOTATION NO.:Q-060117

ATTACHMENT A

LOCAL VENDOR PREFERENCE QUESTIONNAIRE
(LEE COUNTY ORDINANCE NO. 00-10)

Instructions: Please complete either Part A or B whichever is applicable to your firm

PART A: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS LOCATED WITHIN LEE COUNTY (Only complete Part A if your principal place of business is located within the boundaries of Lee County)

1. What is the physical location of your principal place of business that is located within the boundaries of Lee County, Florida?

_____

_____

2. What is the size of this facility (i.e. sales area size, warehouse, storage yard, etc.)

_____

_____

_____

PART B: VENDOR'S PRINCIPAL PLACE OF BUSINESS IS NOT LOCATED WITHIN LEE COUNTY OR DOES NOT HAVE A PHYSICAL LOCATION WITHIN LEE COUNTY (Please complete this section.)

1. How many employees are available to service this contract? _____

2. Describe the types and amount of equipment you have available to service this contract.

CRANES, FABRICATION & PRODUCTION FACILITIES, FORKLIFTS

_____

_____

LOCAL VENDOR PREFERENCE QUESTIONNAIRE CONTINUED

3. Describe the types and amount of material stock that you have available to service this contract.

BELTS, BEARINGS, SEALS, SHOWER BRUSHES, GEARS, PLOWS

4. Have you provided goods or services to Lee County on a regular basis for the preceding, consecutive five years?

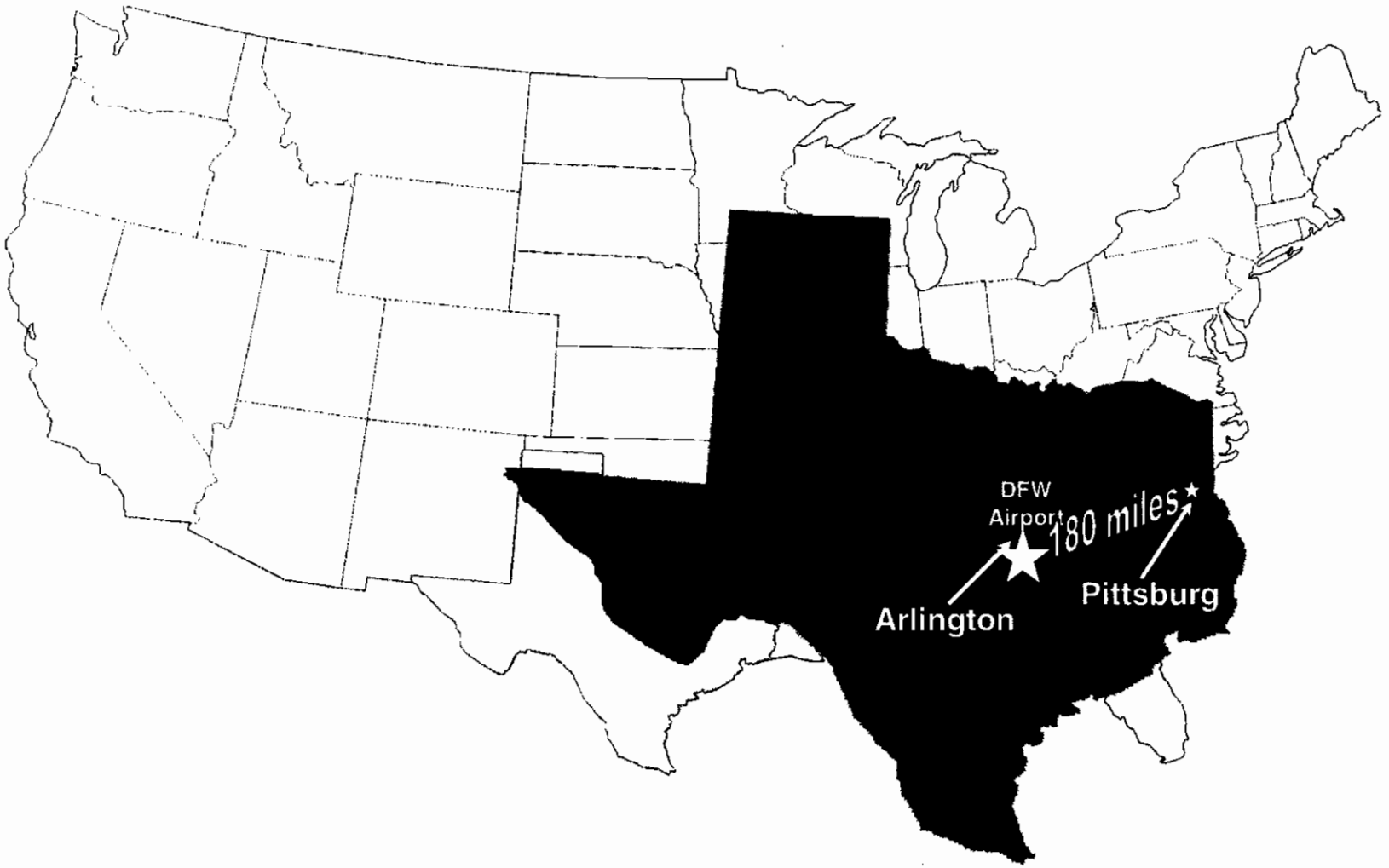
Yes _____ No ____X___

If yes, please provide your contractual history with Lee County for the past five, consecutive years. Attach additional pages if necessary.

REFURBISHMENT REFERENCE LIST

CUSTOMER	LOCATION	EQUIPMENT	CONTACT	COMMENTS
City of Erie WTP	Erie, PA	2ea BFP 2.2 SMX S-7	Mark Ventresca 814/870-1360	Completed turnkey refurbishment of belt presses on-site.
City of Riverside	Riverside, CA	2ea BFP 2.2 SMX S-7	Ben Urquiza 951-351-6259	Turnkey refurbishment of 2 belt presses 1st BFP complete, 2nd BFP shipping 7-22
City of Vacaville	Vacaville, CA	1ea BFP 2.0 SMX S-8	Grover Wright 707-330-7243	Turnkey refurbishment, in our facility been refurbished.
Dow Chemicals	Plaquemine, LA	1ea CPF SDM 80-S5	Joe Benson 225-353-6055	Turnkey refubishment with SS Frame
Metro Sewer District Bissell Point	St. Louis, MO	15ea BFP 2.0 SMX S-8	Ed Cope 314/436-8749	Converting 2.0 SMX S-8 to 2.0 SMX S-14 to improve cake dryness between 3 to 5 %.
Trinity River Authority	Dallas, TX	3ea Winkle Press 3ea Aquabelts	Greg Mikus 972-263-2251	Replacement of rolls and service on both Ashbrook's BFP & GBT.
St. Johns County	St. Agustine FL	1ea Ashbrook Klampress Klampress	Greg James 904/824-2942	Completed on-site turnkey refurbishment BFP

Andritz-Ruthner, Inc.



Andritz-Ruthner, Inc.
Arlington, TX

Employees:	100 (6 in NJ)
Office Area:	15,000 ft^2 (1,394 m^2)
Shop Area:	30,000 ft^2 (1,787 m^2)

ANDRITZ

Andritz-Ruthner, Inc.
Pittsburg, TX

Employees:	40
Office Area:	5,000 ft^2 (465 m^2)
Shop Area:	34,000 ft^2 (3,158 m^2)

List of Personnel

Name	Title
Armondo Alvarado	Project Manager
Gary Dobbs	Productions Manager
Roger Pierce	Shop Foreman
Steve Knight	Assembly Supervisor

ENVIRONMENT AND PROCESS TECHNOLOGIES

Andritz-Ruthner, Inc.

Quality Policy Overview

SECTION I: SCOPE

This document is meant to serve as an overview of the Andritz-Ruthner Quality Program. A Program Designed To Meet The Requirements Of Commercial Standards Currently Dominant In Our Industry. The Quality System is implemented within the scope of customer and/or contractual requirements.

SECTION II: RESPONSIBILITY

- The basic responsibility of Andritz is to manufacturer and/or deliver a quality product to it's customers on a timely basis, at a competitive price, in full accordance with customer and/or contractual requirements.
- The Quality Control Department is responsible for providing control and assurance of quality within the Company. The objective is to verify that all products furnished to the customer, conforms to the quality standards specified by the customer and by Andritz.
- Elements of the program are implemented at each step of the manufacturing cycle, from the initial development of the product, to the final delivery and acceptance by the customer.

SECTION III: DOCUMENTATION AND RECORDS

- Records are considered one of the primary forms of objective evidence of quality. The Quality Program shall assure that records are complete and reliable.
- Records for monitoring work performance and inspection, shall indicate the acceptability of the work or products and the action taken in connection with deficiencies.

SECTION IV: DRAWING AND CHANGE CONTROL

- Andritz establishes actions necessary by the Quality Control and Engineering Departments to assure correct and complete engineering documentation.
- Company procedures related to the manufacturing process shall be reviewed and approved by Engineering and Quality Control Departments, and will be subject to periodic audits.
- Engineering drawings will be reviewed for compliance with contract requirements prior to release for manufacturing.

ANDRITZ-RUTHNER, INC.

1010 Commercial Blvd. S.
Arlington, Texas 76001
Tel. (817) 465-5611
Fax (817) 472-8589
environ.us@andritz.com

SECTION V: PURCHASING CONTROL

- The accuracy with which all pertinent data is transferred from the approved purchase requisition to the purchase order is verified through periodic Quality audits.
- Each purchase requisition is reviewed to ensure that it includes reference to applicable drawings, specifications, and other documents required for the supplier to meet purchase order requirements. Andritz will purchase supplies and services only from suppliers who meet acceptable minimum quality standards.

SECTION VI: RECEIVING INSPECTION CONTROL

- Andritz has established for the receipt and inspection of supplier furnished parts and materials purchased for end item application by assuring conformance to drawings, specifications and purchase order requirements.
- Materials and products purchased for end item application shall be subjected to inspection upon receipt to the extent necessary to assure conformance to quality and technical requirements. The amount and type of receiving inspection may be adjusted on the basis of the quality program exercised by the supplier.

SECTION VII: IN-PROCESS INSPECTION CONTROL

- Andritz has established procedures and responsibility for ensuring that quality control inspections are performed during various stages of in-process fabrication/assembly to assure the quality integrity of the end item.
- All fabrication, assembly, and other production processing shall be accomplished under controlled conditions. These shall include control over the materials, equipment processes, workmanship, and products to assure manufacture and delivery of an end item which conforms to all applicable quality standards and technical requirements. This shall be accomplished by measurement, test assessment and control of each operation by Production and Quality as required during manufacture.

SECTION VIII: FINAL INSPECTION CONTROL

- Andritz has established procedures and responsibility for final inspection and function/acceptance testing of assemblies and end item equipment. All manufactured assemblies and systems shall be subjected to final inspection and functional testing, in accordance with documented procedures, specifications and contractual requirements.
- A record of project numbers, serial numbers, etc, will document the actual configuration of the end item to be delivered.
- All functional assemblies or systems will be subjected to a final acceptance test to be witnessed by customer representatives when contractually required. Results of test performance will be documented and retained for historical records or contractual requirements.

SECTION IX: NONCONFORMING MATERIAL CONTROL

- Andritz had established procedures and responsibility for the identification, segregation, review and disposition of nonconforming parts and materials procured, processed or produced for end item application.
- The Quality Control Department maintains control of the nonconforming material through identification, segregation and disposition reporting.
- Repair of nonconforming items shall be in accordance with documented and approved instructions.
- All nonconforming items shall be stringently controlled to prevent inadvertent use, shipment, or unintended intermingling with conforming items.

SECTION X: CORRECTIVE ACTION

- Andritz has established documents and procedures for corrective action applicable to design, purchasing, manufacturing and test operations to correct conditions that have resulted in or might result in substandard or defective supplies, services, standards or other elements of contract performance. This corrective action extends to the company's suppliers of goods and services.

SECTION XI: MEASURING AND TEST EQUIPMENT CONTROL

- Andritz has established for the selection, calibration, and control of measurement and test equipment, used to verify product conformance 6to drawings, specifications, and contract requirements.
- The Quality Control Department shall maintain measuring and testing devices necessary to assure that products conform to technical requirements. These devices shall be calibrated using standards with accuracies traceable to the National Institute of Standards and Technology.

SECTION XII: INDICATION OF INSTPECTION STATUS

- The inspection status of materials is identified on appropriate documentation, and on the materials, in accordance with drawings, specifications, and or procedural requirements in a manner that will not damage the materials.

SECTION XIII: SAMPLING INSPECTION

- Andritz has established for the control and use of sampling plans for inspection by attributes in accordance with MIL-STD-105 when required.
- Sampling plans may be used for inspection when historical records, inherent characteristics of the product, or the noncritical application of the product indicates that a reduction in inspection can be achieved without jeopardizing quality. Inspection levels and sampling plans must be compatible with contractual requirements.

SECTION XIV: SOURCE INSPECTION

- Inspection at supplier facilities are performed as required for control and assurance that purchased materials, parts and services are in full compliance with all applicable requirements of the purchase order prior to shipment.

_____

David B. McDonald
Quality Control Manager
Andritz-Ruthner, Inc.

ENVIRONMENT AND PROCESS TECHNOLOGIES

BELT PRESS CHECKLIST REPORT

Date:_____

Machine Type: RH / LH	Project No.	Andritz S/N	Other S/N:
Project Name:		Inspector:	Request Date:

I. Verify all assemblies for compliance to Engineering specifications. Transfer all applicable in-process inspection stamp(s) for the following assemblies, functions and observations.

	YES	NO	N/A	COMMENTS
A ROLLER ASSEMBLIES				
1. Assembly aligned and complete				
2. Bearing assemblies lubricated				
3. Roller coatings undamaged				
B BELT TENSION ASSEMBLIES				
1. Assembly aligned and complete				
C DOCTOR BAR ASSEMBLIES				
1. Assembly aligned and complete				
D WEDGE AND GRAVITY ZONES				
1. Assembly aligned and complete				
E SHOWER ASSEMBLIES				
1. Assembly aligned and complete				
F HEADBOX ASSEMBLY				
1. Containment assambly complete				
2. Feed/Mixing essembly complete				
3. Chicanes aligned and marked				
G DRIVE ASSEMBLY				
1. Assembly aligned				
H CANTILEVERING ASSEMBLY				
1. Arms fitted and marked				

2. Any interference				

I MACHINE PNEUMATICS

1. Assembly complete				

J MECHANICAL ELECTRICAL –
Reference "Machine Wiring Report"

K MECHANICAL TEST RUN

1. Machine belt path measurements, in inches:
   a. Top: Min.____ Max. ____
   b. Bottom: Min. ____ Max. ____
2. Size of belt utilized for test:
   a. Top Belt: _____
   b. Bottom Belt: _____

	YES	NO	N/A	COMMENTS
3.	Were project belts utilized?			
4.	Will specified belts fit?			
5.	Any belt damage?			
6.	Do belt tract correctly?			
7.	Any belt path interference?			
8.	Any air leaks?			
9.	Does drive(s) operate correctly?			
10.	Any excessive vibration/noise?			
11.	Plumbing pressure tested, OK?			

L MISCELLANEOUS:

	YES	NO	N/A	COMMENTS
1.	Any noted loose fasteners?			
2.	Required alignment pins installed?			
3.	Unused holes suitably coated/plugged?			
4.	Corrosion protective coatings complete?			
5.	Stainless steel clean of rust, oversparay, etc.			
6.	Specified safety guards installed?			
7.	Specified legend plates/equipment tags installed?			

COMMENTS/OBSERVATIONS: _____

ENVIRONMENT AND PROCESS TECHNOLOGIES

II. STATUS:

☐ Approved incomplete ☐ _____ _____

Inspector Date

III. COPY DISTRIBUTION:

Project Manager (Project File)
Production manager
Quality Control Manager

ENVIRONMENT AND PROCESS TECHNOLOGIES

BELT PRESS INSPECTION REPORT

Date:_____

Incoming ☐

In Process ☐

Final/Shipping ☐

Machine Type: RH / LH	Project No.	Andritz S/N	Other S/N:
Project Name:		Inspector:	Request Date:

	YES	NO	N/A	COMMENTS
A ROLLER ASSEMBLIES				
4. Are rolls leveled and parallel?				
a. "Roll alignment protocol" attached?				
b. "Frame alignment protocol" attached?				
5. Are bearing assemblies lubed and sealed?				Type Lube: _____
6. Are roll coatings complete and undamaged?				
7. Are roll coatings complete and undamaged?				
8. Are rolls balanced within specification?				
9. Do all rolls turn freely?				
B BELT TENSION ASSEMBLIES				
4. Assembly aligned and complete				
5. Are guide shaft brackets and bearings lubricated?				
6. Are required brackets and shafts pinned?				
7. Are required guards installed?				
8. Does the crank handle or wrench fit?				
9. Are shaft spacers required and supplied?				
C DOCTOR BAR ASSEMBLIES				
4. Assembly complete?				
5. Are blades aligned to roll surface?				

6. Is tensioning adjustable?				
a. Tensioning type:_____				
b. Blade materials: _____				
7. Are required brackets pinned?				

D WEDGE AND GRAVITY ZONES ASSEMBLY:

1. Type: _____
(ex: Grid strip, roller, FRP, gretes)

2. Assembly complete?				
3. Are wedges installed and aligned?				
4. Are the wedges adjustable?				
5. Are required seals installed?				
6. Is the upper wedge and gravity section adjustable?				
7. Is the Pre-"S" or Prepress zone adjustable?				

E SHOWER ASSEMBLIES

1. Type of shower pipes: _____

	YES	NO	N/A	COMMENTS
2. Assembly complete?				
3. Are seals installed and aligned?				
4. Are the shower boxes aligned with belt path?				
5. Are the drains to specification?				

Type of plumbing:_____
(ex. PVC pipe, hose, etc.)

F HEADBOX AND SIDEWALL ASSEMBLY

1. Type : _____
(ex. Distribution chute, screw distributor, etc.)
2. Type of Mixer: _____
(ex. Turbo, Venturi, Tank, etc.)

3. Are the brackets adjustable?				
4. Are the seals installed and aligned?				
5. Is the floating wedge installed and functional?				
6. Is the sludge leveler installed and functional?				

7. Are the flanges installed and rotated correctly?
8. Are the mixing drum and screw shaft bearings lubricated?
9. Are the chicanes installed and aligned?
   a. Are the brackets and bars stamped?
   b. Are the chicanes free floating?

G DRIVE ASSEMBLIES:

1. Are the drives/gearboxes mounted?
2. Are all gearboxes lubricated?
3. Are the required couplings aligned?
4. Are the sprockets or spur gears aligned?
5. Is the chain tension adjusted?
6. Are the gears, chains, etc. lubricated?
7. Are the required guards in stalled?
8. Type of speed adjustment: _____ (ex. Servo, VFD, etc.)

H CANTILEVERING ASSEMBLY: (IF REQUIRED)

1. Are all adaptations made for cantilevering?
2. Are alignment pins installed and aligned?
3. Have arms been fitted and marked?

I CAKEBREAKER ASSEMBLY: (IF REQUIRED)

1. Is the assembly complete and aligned?
2. Are the bearings lubricated?
3. Is there proper clearance between components?
4. Are the required guards installed?

ENVIRONMENT AND PROCESS TECHNOLOGIES

ANDRITZ-Ruthner, Inc.

Pittsburg, Texas – MFG. Division

QUALITY CONTROL MANUAL

ANDRITZ-RUTHNER, INC.

QUALITY CONTROL MANUAL

TABLE OF CONTENTS

ENVIRONMENT AND PROCESS TECHNOLOGIES

ANDRITZ-RUTHNER, INC.

PITTSBURG MANUFACTURING DIVISION PITTSBURG, TX 75686

QUALITY CONTROL MANUAL

Approved by:

Plant Manager	Mfg./Q.C. Manager
_____	_____
Name	Name
_____	_____
Signature	Signature
_____	_____
Date	Date

ANDRITZ-RUTHNER, INC.

QUALITY CONTROL MANUAL

REVISION RECORD

SECTION	REVISION	DATE REVISED	CHANGE DESCRIPTION
1.0	N/C	N/A	N/A
2.0	N/C	N/A	N/A
3.0	N/C	N/A	N/A
4.0	N/C	N/A	N/A
5.0	N/C	N/A	N/A
6.0	N/C	N/A	N/A
7.0	N/C	N/A	N/A
8.0	N/C	N/A	N/A
9.0	N/C	N/A	N/A
10.0	N/C	N/A	N/A
11.0	N/C	N/A	N/A
12.0	N/C	N/A	N/A
13.0	N/C	N/A	N/A
14.0	N/C	N/A	N/A
15.0	N/C	N/A	N/A
16.0	N/C	N/A	N/A
	N/C	N/A	N/A
Appendix A	N/C	N/A	N/A
Appendix B	N/C	N/A	N/A
Appendix C	N/C	N/A	N/A
Appendix D	N/C	N/A	N/A
Appendix E	N/C	N/A	N/A

ANDRITZ-RUTHNER, INC.

INTRODUCTION:

Andritz-Ruthner, Inc. is defined as Andritz-Ruthner, Inc., Pittsburg Manufacturing Division, Pittsburg, Texas 75686. Each division of Andritz-Ruthner, Inc. is an entity unto itself, in that, the Quality Control System is a closed loop system. Each division is responsible for employment of their respective Quality requirements.

This manual is issued to describe the Quality control System to be employed at Andritz-Ruthner, Inc. The policy of Andritz-Ruthner, Inc. is to apply the system to articles and materials received by Andritz-Ruthner, Inc. as well as to articles produced by Andritz-Ruthner, Inc. or its suppliers for end use. This manual provides personnel and customers of Andritz-Ruthner, Inc. with a description of company policy for maintaining an effective and economical Quality Control System planned and developed using MIL-I-45208A, as a basis.

Written procedures for implementing the policies described herein shall be established as dictated by complexity of the product design, manufacturing techniques employed and customer requirements.

No changes in the manual or supplementary Quality Control Procedures are valid until approved by the Plant Manager or his assignee.

ANDRITZ-RUTHNER, INC.

1.0 SCOPE

1.1 The Quality Control System encompasses receipt of parts and material, identification, stocking and issue of parts and material, the entire process of fabrication and manufacturing, packaging, storage and shipping.

1.2 The system is designed to assure that supplies or services performed at Andritz-Ruthner, Inc. or at Andritz-Ruthner's supplier facilities are subject to adequate control of quality to ensure customer satisfaction. This system is designed to provide for early detection of discrepancies and positive corrective action.

1.3 Written inspection and test procedures prepared to supplement applicable drawings and other specifications to the extent necessary.

2.0 RESPONSIBILITIES OF QUALITY CONTROL

2.1 The Quality Control Manager reports directly to the Plant Manager.

2.2 The quality Control Manager is responsible to ensure the following:

2.2.1. Interpretation of conformance to customer quality requirements.

2.2.2. Review of customer drawings and specifications.

2.2.3. Determination of necessary inspection points.

2.2.4. Documentation of necessary inspection and test instructions.

2.2.4.1 Establishing a change control procedure for such documents.

2.2.5. Planning, developing, initiating, coordinating, implementing and maintaining the most effective procedures for optimum quality assurance.

2.2.6. Maintenance of adequate quality control records.

2.2.7. Review of quality control records and internal corrective action follow-up.

2.2.8. Conduct Vendor quality Surveys and shall maintain a file on each subcontractor. Copies of all rejection memoranda pertinent to each subcontractor, shall be attached to the file and used for evaluation to accept or eliminate as an approved vendor. Advise Purchasing of any changes.

2.2.9. Original and continuing periodic inspection of all special and standard gauges, test equipment and tooling used to manufacture product.

2.2.10. Coordinate in-plant corrective action on items rejected by the customer, notify customer of the action taken and evaluate the action for effectiveness.

2.2.11. Assure that inspection personnel are capable of rendering an unbiased decision to accept or reject any material inspected.

2.2.12. Shall maintain a record of all inspection stamps issued and not reissue a stamp to another inspector for at least six months. Lost or stolen stamps will be treated in the same manner.

2.2.13. Company-owned gauges, nspection devices and test equipment will be made available to the customer when there is a need to verify product conformance.

3.0 PURCHASE ORDER CONTROL

3.1 All purchase orders to Andritz-Ruthner's suppliers require authorization by the Plant Manager or his authorized representative.

3.2 Upon release of a purchase order, the buyer will furnish Andritz-Ruthner's vendor with all required drawings, specifications and necessary customer requirements, such as material or process certification, physical and chemical analysis.

3.3 In the event of a drawing or specification change, the buyer will issue a purchase order change, incorporating the latest engineering changes and latest drawings or other specifications.

3.4 Copies of all the purchase orders are to be kept on file and made available for review upon request by the customer. The Customer's Representative will determine the need to impose a Customer Source Inspection (CSI) on the required parts/services. In general the following situations will require CSI:

3.4.1. Parts that cannot be inspected on receipt due to the nature or state of assembly or testing.

3.4.2. Special test equipment required that is not available at Andritz-Ruthner.

3.4.3. Parts shipped direct to consignee from a vendor or subcontractor.

3.5 Purchase orders shall be coordinated with the Quality Control Manager for verification to assure that the specifications and required inspection details are adequately covered in the written purchase order or package.

4.0 DRAWING AND SPECIFICATION CHANGE CONTROL

4.1 Andritz-Ruthner, Inc. fabricates and manufactures to customer drawings and/or specifications, which are filed in job folders.

4.2 Production Control is responsible for the charging out and controlling issuance of drawings and specifications. Production Control will issue shop travelers to route parts and materials and establish inspection and test points. The Quality Control Manager will review shop travelers prior to issue.

4.3 The Sales Department receives engineering changes, drawing changes and specification changes from Andritz-Ruthner's customers and is responsible to immediately forward customer changes to Production Control.

4.4 Production Control is responsible for issuing the latest shop travelers, engineering changes, drawings and specifications to the cognizant departments and voiding outdated shop travelers, engineering changes, drawings, specifications and maintaining job folders.

5.0 RECEIVING INSPECTION

5.1 All parts and materials are received and logged in by the Receiving Department

5.2 All parts are presented to Receiving Inspection after being logged in by the Receiving Department.

5.3 Receiving Inspection will not accept materials until it has been determined that the proper certifications have been received, for physical and chemical test data, special processes, Customer or Andritz-Ruthner's Source Inspection.

5.4 The Receiving Inspector shall document the results of all inspections and/or tests.

5.5 Accepted lots are identified by Inspection and sent to stock.

5.6 Rejected lots are identified and held segregated in Receiving Inspection until disposition is made by the Engineering Department.

5.7 The Purchasing Department and applicable vendors will receive a copy of all Receiving Department rejection reports.

5.8 Corrective action to prevent recurrence of discrepancies discovered by Receiving Inspection is the responsibility of the Purchasing Department.

5.9 Follow-up to ensure that corrective action taken by a vendor was effective is a Quality Department responsibility.

5.10 Receiving Inspection instructions are issued in written form, as applicable, with consideration given to complexity of the parts, material received and customer requirements.

5.11 A periodic review is made of Receiving Inspection records by the Quality Department to detect vendor process capability problems.

5.12 All inspection records will include the number inspected, number rejected, date of inspection and positive identification of the inspector.

5.13 Inspection records will include information as to the disposition of vendor supplied records and data.

6.0 RAW MATERIAL CONTROL

6.1 Raw material, bar stock, sheet stock and castings are identified to the proper certification and are stored in an area apart from the normal flow of in-process material.

6.2 Copies of all certifications are filed and are available for review at the customer's request.

6.3 Certified stock is issued from the raw material storage area to comply with the engineering requirements.

6.4 Verification of suppliers' certifications are accomplished by independent testing laboratories when deemed necessary by the Quality Department or Andritz-Ruthner's customer purchase order requirements.

6.5 All certifications will be identifiable to the applicable purchase order, date of receipt of the materials.

7.0 CUSTOMER FURNISHED MATERIAL

7.1 This section applies to all customer furnished materials unless excluded from these requirements by contractual agreement.

7.2 Receiving Inspection is to examine all customer furnished materials, upon receipt for transit damage, completeness, proper type, verification of quantity and proper identification.

7.3 Functional testing will take place either prior to or after installation or both, as required by contract to determine satisfactory operation.

7.4 Periodic inspection and precautions to assure adequate storage conditions to prevent damage will be conducted by the Quality Department.

7.5 All customer furnished material will be identified and kept segregated to prevent improper use or disposal.

7.6 All discrepancies shall be immediately reported to the proper Customer Representative.

8.0 IN-PROCESS INSPECTION (PIECE PARTS)

8.1 First piece inspection is performed by the Quality Department after setup is complete and okayed by Production.

8.2 No production runs are made until first piece inspection is completed and found acceptable.

8.3 After first piece inspection acceptance, in-process inspections are performed by Quality Department at adequate intervals to provide early detection of processes producing nonconforming material.

8.4 Records of all first piece and in-process inspections are maintained by the Quality Department.

8.5 Inspection records are stored in the job folder and are available for customer review.

8.6 Rejected items are clearly identified by a tag or other applicable means and moved to an area apart from the normal flow of in-process materials.

8.7 Obtaining corrective action and performing follow-up action to prevent recurrence of discrepant material is the responsibility of the Quality Department.

8.8 Inspection records will include the number of pieces accepted, number rejected, nature of defects and basic causes of rejection, date of inspection and positive identification of the inspector.

ANDRITZ-RUTHNER, INC.

9.0 ASSEMBLY INSPECTION AND/OR VUNCTIONAL TESTING

9.1 Assembly inspection and any necessary functional testing is performed, as required, by Production personnel.

9.2 The Quality Department performs surveillance inspection of the functional tests in accordance with a specified sampling procedure.

9.3 Inspection records are maintained by Quality Department personnel.

9.4 Inspection records are filed in the job folder and will be available for customer review on request.

9.5 All nonconforming assemblies are identified and segregated to preclude any chance of accidentally being used.

9.6 Obtaining corrective action and performing follow-up action to prevent recurrence of discrepant material is the responsibility of Quality Department.

9.7 Inspection records will include the number accepted, number rejected, date of inspection and positive identification of the inspector.

9.8 The Customer Representative servicing this plant will be notified (5) five days in advance of the time of assembly and functional testing.

10.0 FINAL INSPECTION AND TESTS

10.1 Final inspection and tests are performed 100 percent or on a sample basis, as applicable to complexity of the items produced and/or customer requirements. Inspection will be in accordance with customer supplied procedures, when available.

10.2 Final inspection and test reports are maintained by the Quality Department.

10.3 Inspection and test records are filed in the job folder and will be available for review upon the request of the customer.

10.4 Corrective action and performing follow-up action to prevent recurrence of discrepant material is the responsibility of the Quality Department.

10.5 All nonconforming material is identified and segregated apart from the normal flow of finished material.

10.6 Nonconforming material is not released for shipment to the customer without specific instructions from the customer to submit the nonconforming material.

10.7 Rejected materials, which is subjected to any repair or sorting, is resubmitted to Final inspection for verification of the adequacy of the rework.

10.8 Inspection records will include the number of pieces accepted, number rejected, date of inspection and positive identification of the inspector.

11.0 NONCONFORMING MATERIAL CONTROL

11.1 All nonconforming supplies, parts and/or materials are placed in a segregated area. The items will be clearly identified to job number, part number, lot size, quantity rejected, discrepant characteristic, inspector's name and other identification, as required.

11.2 The nonconforming characteristic(s) are clearly indicated on a rejection tag attached to each part or container.

11.3 No one is authorized to remove nonconforming items from the segregated area until a review is completed by a Material Review Board consisting of the Plant Manager, an Engineering Representative, a Production Representative and Quality Department Representative. When there is a requirement for Customer Source Inspection, the applicable representative must be part of the review committee when the discrepancy is likely to affect form, fit, function or safety.

11.4 Nonconforming material will not be shipped, until concurrence from the customer from the customer is received.

11.4.1. All nonconforming material shipped to the customer shall have the discrepancy clearly indicated on the shipping documents.

11.5 The integrity of all lots submitted to acceptance inspection are maintained under the control of the Quality Department at all times and will be segregated from normal material flow.

11.6 During the processing of material, a system will be used to assure proper sequence and completion of production and inspection activities.

11.7 A system of inspection status will be used to identify the status of inspected material.

11.8 Unidentified material is segregated from the normal flow of production material until conformance of material to all specifications is established.

11.9 Reworked material is segregated from other material until conformance of material to all specifications is established by the Quality Department.

ANDRITZ-RUTHNER, INC.

12.0 TOOL AND GAUGE CONTROL (see Measuring Equipment Control Procedures):

12.1 All special tools, jigs, fixtures, gauges and measuring equipment shall be properly identified.

12.2 Each new, or reworked toll, jig, fixture, gauge and items of measuring equipment are inspected prior to being issued for use.

12.3 All gauges, measuring test equipment are checked to standard which are traceable to the National Institute of Standards and Technology (formerly NBS).

12.4 Obsolete or out-of-service tools and gauges are identified by tags.

12.5 Calibration of personal or company owned inspection tools is required.

13.0 OVERRUN STOCK CONTROL

13.1 The Quality Department shall have the responsibility of surveillance of any overrun stock.

13.2 The Quality Department will assure that any overrun parts presented for stock are properly identified as to inspection status (acceptance), part number, latest drawing number and revision, specification revision, date of inspection acceptance, job number, quantity of parts, identification of inspector and that the parts are adequately packaged to prevent deterioration or damage.

13.3 No overrun parts are shipped to a customer until reinspection is accomplished to assure they are in acceptable condition and meet all the latest drawing and specification revisions.

14.0 PACKAGING AND SHIPPING

14.1 No order will be shipped to a customer until all shipping papers are identified by the Final Inspector's acceptance stamp, or Inspector's signature and date of inspection acceptance.

14.2 No material will be shipped until all required certifications, test reports, special samples, etc., have been packaged with the material in accordance to Andritz-Ruthner's customer requirements.

14.3 All items shall be packaged in a manner that prevents damage, deterioration or substitution.

14.4 Adequate marking shall appear on the packaging, parts and as otherwise necessary to provide positive identification to the applicable customer.

14.5 Any required special packaging will be controlled as specified by Andritz-Ruthner customer.

15.0 IDENTIFICATION OF PARTS

15.1 Parts will be marked in accordance with customer requirements and specifications.

15.2 Materials and articles having a critical application are also identified by a serial number or lot number.

ANDRITZ-RUTHNER, INC.

16.0 PROCESS CONTROLS

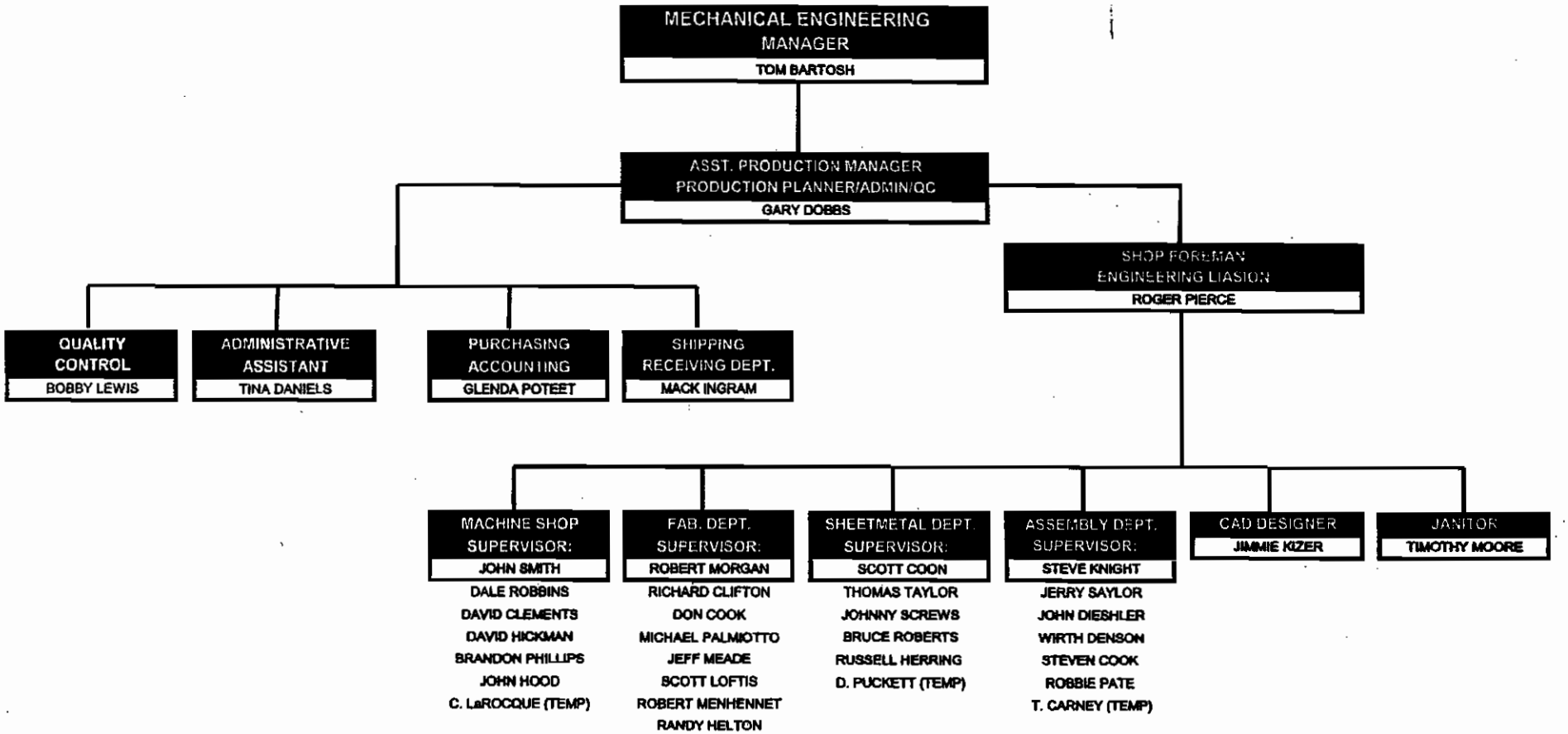
16.1 Process controls shall be an integral part of Andritz-Ruthner's inspection system when such inspections are part of the specification or contract. The shop traveler will indicate each inspection point.

16.2 Special Processes: only approved vendors will be used to do special processes. For example: welding, plating or radiography will be controlled by Vendor Surveys and Andritz-Ruthner's Source Inspections to ensure conformance to customer requirements.

ANDRITZ - RUTHNER, INC.

PITTSBURG MANUFACTURING DIVISION

ORGANIZATION CHART



APPENDIX A

Rev. 5/5/2006

ANDRITZ

1010 Commercial Blvd. South
Arlington, TX 76001 USA

Phone : 817.465.5611
Fax : 817.472.8754

MANUFACTURING DIVISION
110 Dickson Street
Pittsburg, TX 75686 USA

Phone : 903.856.0445
Fax : 903.856.3498

PURCHASE ORDER

PO Number: 49980

Page: 1

Vendor:
GREG GAMELIN
MOTION INDUSTRIES
625 STADIUM DRIVE
ARLINGTON TX 76011
United States

Phone: 817-277-5516
Fax: 817-277-8108

Ship To:

ANDRITZ-RUTHNER, INC
1010 COMMERCIAL BLVD. SO.
ARLINGTON TX 76001
United States

Freight Paid: No

Order Date: 05/11/2006 Terms: NET 30 DAYS Resale No: 1-25-1342907

Required Date : 05/12/2006 Ship Via: UPS GROUND F.O.B: ORIGIN, PPD&ADD

Line	Order Qty.	Part Number/Rev/Description	Unit Price	Ext Price	Tax
1	2.00 EA	V130A / 0 V-RING,NEOPRENE,BORE 4.9375"	7.26000	$14.52	No

NITRILE

- Shipping Release Requirement -	Due Date	Quantity	Job Number	M/S	Asm	Seq
	05/12/2006	2.00 EA				

Authorized By: LAW, DARREN **Total:** **$14.52**

Buyer Signature | Mgr. Approval | Prj. Mgr. Approval | Pres. Approval

Confirm Delivery and Price only if different than noted on this Purchase Order. This information must be received prior to receipt of material. The attached Andritz-Ruthner, Inc. Terms and Conditions dated 03/18/1999 governs this Purchase Order unless there is a current signed Andritz-Ruthner, Inc. Terms and Conditions on file..

Vendor Acknowledgement :

Signature & Title | Date

IR#:

ANDRITZ

Pick-up For:
- ☐ Credit
- ☐ Exchange
- ☐ Rework
- ☐ Repair

INSPECTION REPORT

PURCHASE ORDER:

VENDOR/CUSTOMER NANE:		PART #		PART OR ASSEM. NAME:
DWG. REV.	USED ON:	JOB # :	DATE:	PROJECT # :
QTY. EXAM.	QTY. REJECTED:	QTY. USE-AS-IS:	RMA#:	INSPECTED BY:

ITEM	QTY.	NON-CONFORMANCE

DISPOSITION

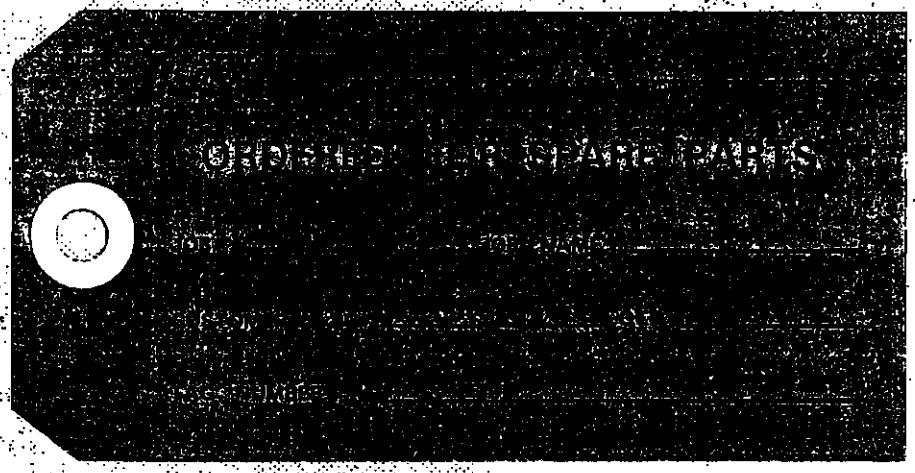
☐ USE AS IS ☐ REWORK ☐ SCRAP

IF REWORK, PROCEDURE & ROUTING:

SHIPPING INSTRUCTIONS

SHIP TO	NAME:	SHIP VIA: ☐ VENDER ☐ UPS ☐ BEST WAY	
	ADDRESS:	FREIHT: ☐ PREPAID ☐ COLLECT ☐ BILLED	
		VENDOR CONTACT/DATE:	
VENDOR PHONE #	RETURN AUTHORIZATION NO.	SIGNATURE/DATE: AUTHORIZED AGENT OF VENDOR	

APPROVAL - ENG.	DATE	APPROVAL - MFG.	DATE	APPROVAL - QC	DATE
				Chuck Massie	10/11/01



DATE _____

JOB # _____ QUANTITY _____

PO/RA # _____

PART NUMBER _____

DESCRIPTION _____

Job: SOP32319-1AA Asm: 0 Part: DMM27295 Rev: 0 Drawing: DMM27295
Desc: DRIVE ROLL COVERING (ASHBROOK)

---- Production Quantities ---- - Scheduled Dates -
For Stock: 0.00 For Order: 1.00 Total: 1.00 Start: 02/17/06 Due: 03/10/06 Req. By: 03/10/06
611-169 AA 3-1-06 S032319

GREG
2.0M GBT (AQUABELT) DRIVE ROLL ROLL COVERING. ASHBROOK MODIFICATION.
++
RELEASED TO A/P SHOP 3/1/2006 BY GARYD WITH COMPLETION DATE OF 3/10/2006.

SHIPPING SCHEDULE:

Date	SO	Line	Rel	Order Qty	Qty from Job	Qty frm Stk	Whse	Ship Via	Ship to	Status
03/10/06	32319	1	1	1.00	1.00	0.00		CUSTOMER PICKUP	TRINITY RIVER AUTHORITY	(CLOSE

SUB-ASSEMBLY COMPONENTS:

Asm	Part Number	Description	Required Qty	Qty from Stk	Whse
1	DMM27296	DRIVE ROLL CORE ASSY	1.00EA	0.00	AA
11	DISASSEMBLE EXISTING	TEAR DOWN EXISTING ROLLER	1.00EA	0.00	
	DIS-ASSEMBLE EXISTING ASHBROOK ROLLER FOR ENGINEERING PURPOSES.				

RAW MATERIAL COMPONENTS:

Seq	Part Number	Description	Bubble Num	Required Qty	Whse	RelOp
20	913SXM10X12	SOC SET SCREW M10 X 12, 316SS	03	2.00EA	AP	10(ISSUE

OPERATIONS... No of -- Setup -- --- Production ---

Seq	WkCtr	Oper.	Description	Opr.Qty	Mach	Crew	Est. Hrs	Crew	Est. Hrs	Standard	Start	Due	Status
10	OP	OP	OP OUTSIDE PRODUCTION	1.00	ID:00004328					0001 FINZER ROLLER, L.L.C.	02/27/06	03/10/06	CMPL
	APPLY BUNA-N ROLLER COVERING PER DRAWING DMM27295.												
	RETURN TO ANDRITZ-ARLINGTON UPON COMPLETION.												
20	14A	-	-	1.00		1	1.00	0.00	1.00	0.05	0.05000HP	03/10/06	03/10/06
	INSPECT ROLLER COVERING AND INSTALL SET-SCREWS.												
30	12A	-	-	1.00		1	1.00	0.00	1.00	0.00	0.00000HP	03/10/06	03/10/06
	SHIP TO CUSTOMER JOB-SITE.												

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS001

BASE MATERIAL: ASTM A276, 316L,P# 8

FILLER MATERIAL: ASTM-SFA 5.22, E316LT-1, .035"

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (27-28)
CURRENT - D.C.; POSITIVE
AMPS - (150)

POSITION: VERTICAL, 3G

TORCH TYPE: TWECO #4

TORCH SHIELDING GASES:
ARGON/Co2
COMPOSITION -75/25
FLOW RATE -(35 CFH)

GAS CUP SIZE: 1/2"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - NA
DEGREES FAHRENHEIT
PREHEAT MAINTENANCE -

JOINT DESIGN: SKETCH
(SEE ATTACHED)

1) BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.500"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

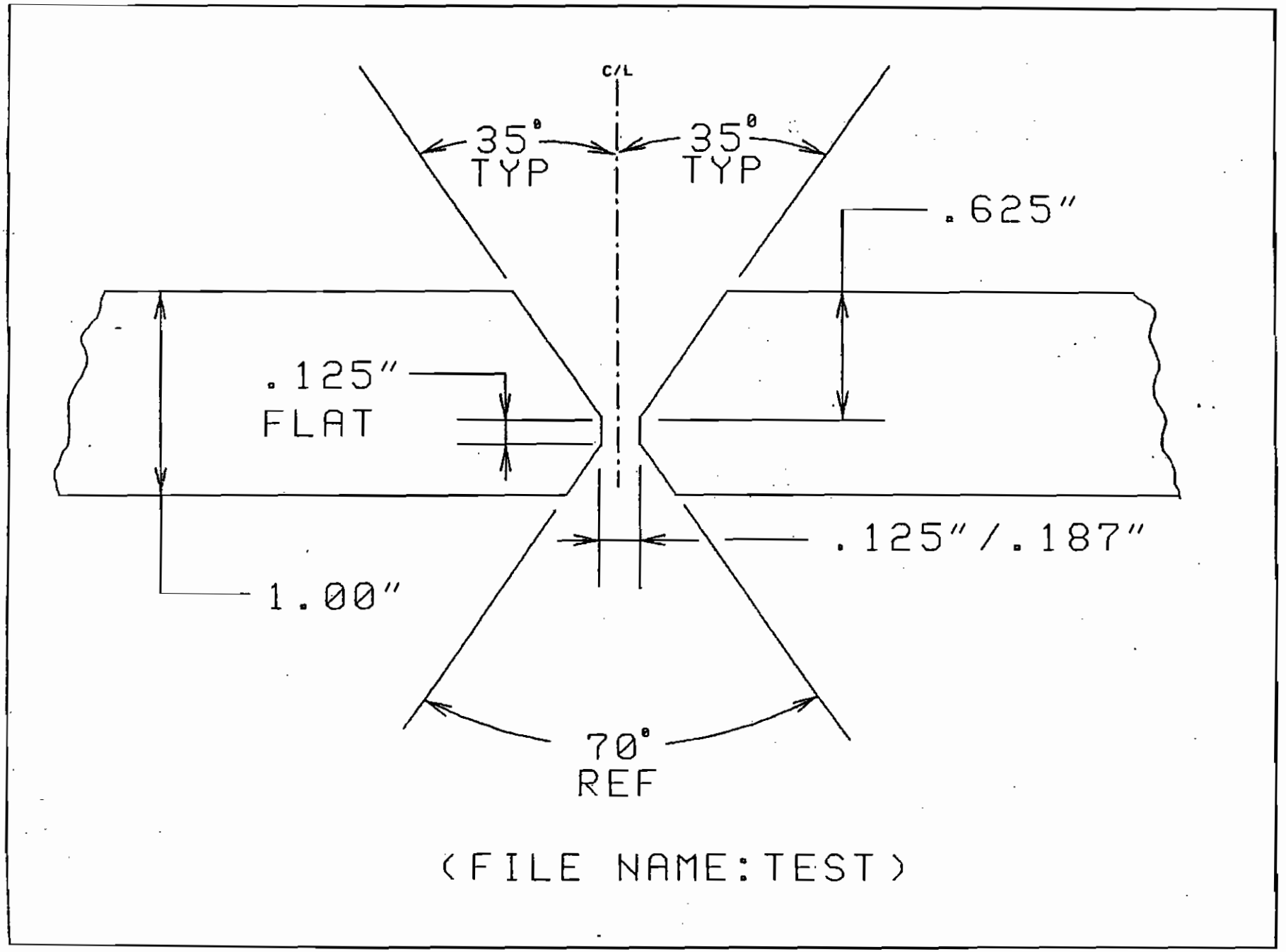
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



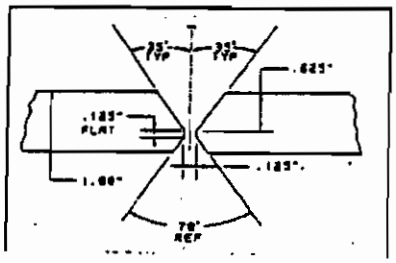
(FILE NAME:TEST)

ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS001 — PLATE, PIPE, CASTING, OTHER ____
NOTE: SPECIFY OTHER ____

BASE MATERIAL: (1) SPEC. ASTM — FILLER MATERIAL: AWS A5.22, E316LT-1
(2) GRADE A276 — ASTM-SFA 5.22 DIAMETER: .035"
(3) THICKNESS 1" — (MAXIMUM SIZES TO BE USED IN
(4) GROUP NO. 8 — PRODUCTION)
JOINT DESIGN: 3G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with 1/8" Lip
WELDING POSITION: Vertical
POWER SOURCE: Miller Delta Weld 300
ARC VOLTAGE: 28 RANGE: 27-28
AMP RANGE: 150

WIRE SPEED RANGE: (WPM) 60-62
TORCH GAS: ARGON/Co2 — MINIMUM PREHEAT TEMPERATURE None
TORCH TIP SIZE: N/A" — MAXIMUM INTERPASS TEMPERATURE NA
CUP SIZE: 1/2" — POST WELD HEAT TREATMENT/
SHIELDING GAS: — TEMPERATURE: NA
(1) COMPOSITION 75/25 — TIME: NA
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

WELDER/WELDING OPERATOR: STEVE TERREL # 0351

NONDESTRUCTIVE TEST RESULTS — DESTRUCTIVE TEST RESULTS:
APPLICABLE ACCEPTANCE STANDARD — (2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

R.T. ____
BASE MATERIAL: ____
P.T. NA — WELD METAL TESTS: ____
M.T. NA
U.T. NA

VISUAL ____
(#): NDT TEST RESULTS SATISFACTORY
BEND TEST RESULTS: ____ (SEE ATTACHED) ____

TEST APPROVED BY ____ (NAME) — LABORATORY: ____

DATE OF CERTIFICATION: ____ — VERIFIED BY: ____ (QUALIFYING ACTIVITY)

APPROVED BY: ____ (AUTHORIZED AGENT)

THE ESAB GROUP, INC.
1500 Karan Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

6/7/94

Langdon Oxygen
Mt. Pleasant, TX

Attn: Scott

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.22-80, ASME SFA 5.22

Trade Name
or Trademark: Alloy Rods Shield-Bright 316 ELC

Diameter Size: .035"

Type: E 316LT-1

Weight:

Test No.: 5-35184-00

Lot Number: 37398

Carbon:	.03
Manganese:	1.37
Chromium:	19.06
Nickel:	11.63
Silicon:	.89
Columbium+:	.02
Tantalum:	<.01
Molybdenum:	2.72
Tungsten:	
Copper:	.26
Titanium:	.04
Phosphorus:	.027
Sulphur:	.008
Vanadium:	.09
Cobalt:	.10
Aluminum:	<.01

Ferrite: 13.3 FN Delong
8.7 FN WRC
10.1% Schaeffler

The chemistry and ferrite values (if applicable) are made from actual determinations made from weld pads deposited with this lot of electrodes.

The undersigned certifies that this report is correct and that no significant change has been made in any of the elements described in the qualification approval.

By: D. A. Smith

D. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994 OUR REPORT NO.: 348-48264-2 5 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A216-T316L / P8	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	WPS 001	0	☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L			AMPS: 150	
Welding Procedure Data by: ☐ PSI Witnessed (Tech):				☒ Others:

FILLER METAL

Specification No. * EXXXT-X	Classification 5.22	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 3G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for the variables stated.

EMARKS: * Electrode-E316LT-1
** Shielding Gas-75% AR / 25% Co2

Respectfully submitted,
Professional Service Industries, Inc.

317 West Harrison Road • Longview, TX 75604 • Phone: 903/759-4192 • Fax: 903/759-5859

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

WPS No. 001
PQR No.- PQR001
PO# 701437

QW-483 (Back)

August 23, 1994

Tensile Test (QW-150)

Report# 348-48264-6

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.747"	.958"	.716	64,500	90,100	Break/Base Mat.
T2	.751"	.982"	.737	66,600	90,400	Break/Base Mat.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-6

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Date 8-23-94

Manufacturer Andritz-Ruthner, Inc.

By Lloyd Robinson

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS002

BASE MATERIAL: ASTM A36
P#1, GROUP 1a

FILLER MATERIAL: ASTM A5.20, .035" DIAMETER
AWS A5.20, ASME-SFA 5.20, E71T-1

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (22-23)
CURRENT - D.C.
AMPS - (170-180)

POSITION: VERTICAL, 3G

TORCH TYPE: WELDCRAFT MIG GUN

TORCH SHIELDING GASES:
GAS: ARGON/Co2
COMPOSITION: 75/25
FLOW RATE: 35(CFH)

GAS CUP SIZE: NA

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - 300
DEGREES FAHRENHEIT (+/-25 DEGREES)

JOINT DESIGN:

1) STRING BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

SKETCH
(SEE ATTACHED)

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

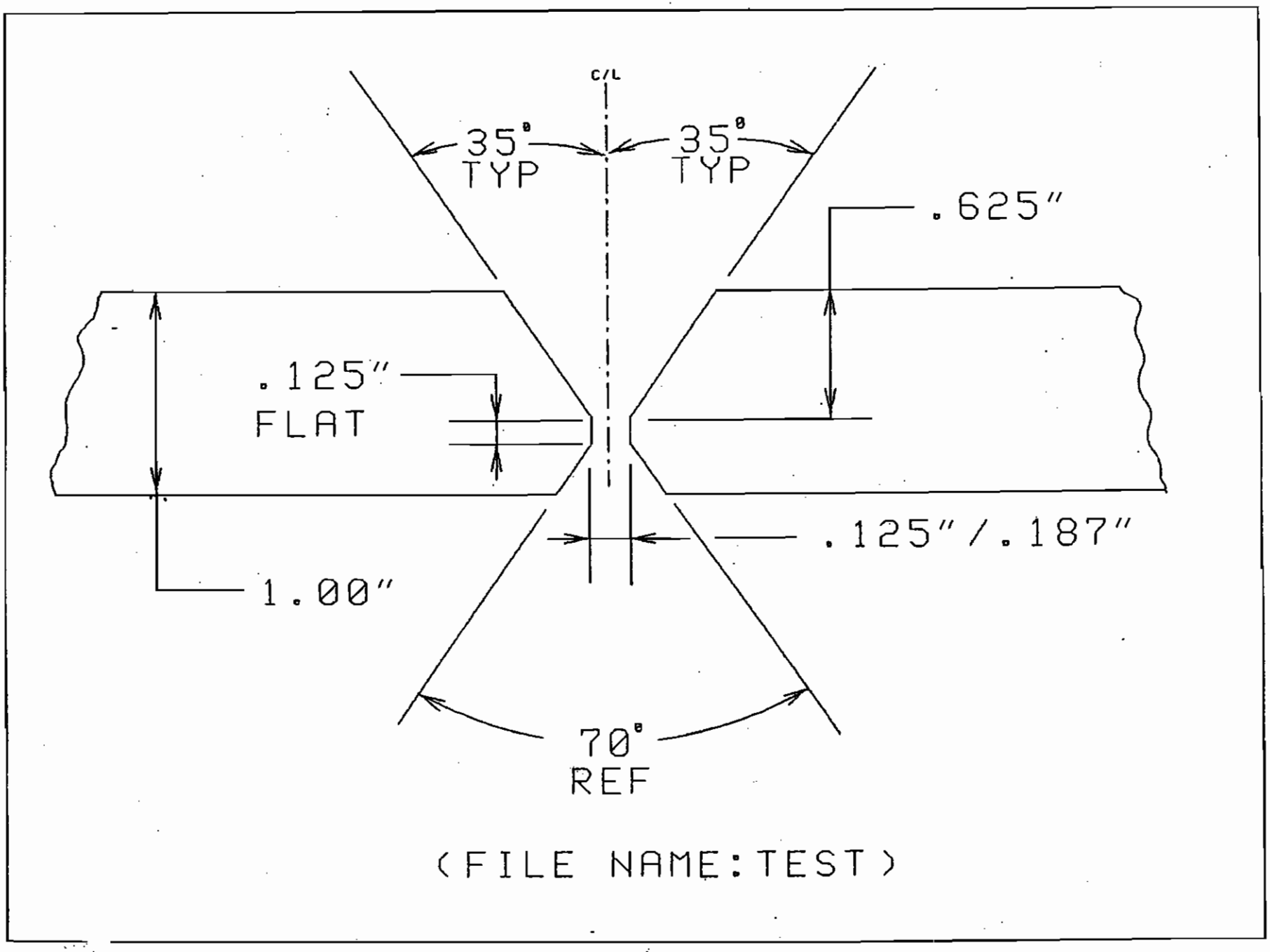
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

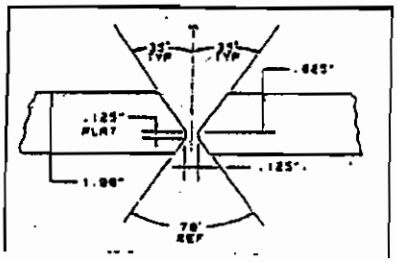
WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS002 (PLATE), PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A36
(3) THICKNESS 1"
(4) GROUP NO. 1a

FILLER MATERIAL: ASTM A5.20, E71T-1, AWS A5.20 DIAMETER: .035
(MAXIMUM SIZES TO BE USED IN PRODUCTION)

JOINT DESIGN: 3G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with 1/8" Lip
WELDING POSITION: VERTICAL
POWER SOURCE: Miller Delta Weld 300
ARC VOLTAGE: 22 RANGE: 22-23
AMP RANGE: 170-180

WIRE SPEED RANGE: (WPM) 35
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: NA
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE 300°(+/-25°)
POST WELD HEAT TREATMENT/
TEMPERATURE: None
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERRE / # 0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA
VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ (NAME)
LABORATORY: _____

DATE OF CERTIFICATION: _____
VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

THE ESAB GROUP, INC.
1500 Karen Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

6/9/94

Langdon Oxygen
Mt. Pleasant, TX

Attn: Scott

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.20-79, ASME SFA 5.20

Trade Name
or Trademark: Alloy Rods Dual Shield 7000

Diameter Size: .035 .035

Type: E 71T-1

Weight:

X-Rays Satisfactory

Lot Number: 36315 36191

Typical Chemical Properties		(Specification Requirements) (Amount Shall be Determined)
Carbon:	.07	
Manganese:	1.29	(.75 Max.)
Chromium:	.02	(.20 Max.)
Nickel:	.01	(.50 Max.)
Silicon:	.54	(.90 Max.)
Columbium+: Tantalum:		
Molybdenum:	.01	(.30 Max.)
Tungsten:		
Copper:	.01	
Titanium:		
Phosphorus:	.014	(.04 Max.)
Sulphur:	.012	(.03 Max.)
Vanadium:	.02	(.08 Max.)

Diffusible Hydrogen:
6.5 ml/100 gr. CO_2
8.1 ml/100 gr. 75% AR/ 25% CO_2

Fillets: OK Vertical-Up/Overhead

Typical Mechanical Properties

	As Welded	MPa
Yield Strength (Psi)	81,000	558
Tensile Strength (Psi)	92,000	634
Elongation (2"), %	25.0	
Red. of Area, %	55.7	
Charpy V-Notch Impacts		
@ 0°F. (ft.-lbs.)	30	
@ -18°C. (Joules)	41	

(Specification Requirements)

Minimum Unless Otherwise Stated	As Welded	MPa
Yield Strength (Psi)	60,000	414
Tensile Strength (Psi)	72,000	497
Elongation (2"), %	22.0	22
Red. of Area, %	----	--
Charpy V-Notch Impacts		
@ 0°F. (ft.-lbs.)	20	
@ -18°C. (Joules)	27	

The undersigned certifies that the product supplied will meet the requirements of the applicable AWS Filler Metal Specification when tested in accordance with that specification, and that no significant change has been made in the elements described in the qualification approval.

By: D. A. Smith

D. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994

OUR REPORT NO.: 348-48264-2 4 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A 36 / P1	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G / 3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***	0	☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	**Welding Procedure Data by:** ☐ PSI Witnessed (Tech):		AMPS: ****	☒ Others:

FILLER METAL

Specification No. * EXXT-X	Classification 5.20	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	**Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)**

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed		1-X 3G	Passed	
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for the variables stated.

REMARKS: * Electrode-E71T-1
** Shielding Gas-75% AR / 25% Co2

*** 1G-WPS 009
2G-WPS 007
3G-WPS 002

**** 1G-280-290
2G-220-230
3G-170-180

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

QW-483 (Back)

WPS No. 002
PQR No.-PQR002
PO# 701437

August 23, 1994

Tensile Test (QW-150)

Report# 348-48264-9

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.741"	.904"	.670	54,100	80,700	Break/Base Matl.
T2	.746"	.931"	.695	56,300	81,000	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-9

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date _____ By _____

(Detail of record of tests are illustretive only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS003

BASE MATERIAL: ASTM A276, 316L, P# 8

FILLER MATERIAL: ASTM-SFA 5.22, E316LT-1,
AWS A5.22, .045" DIAMETER

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (30)
CURRENT - D.C.; POSITIVE
AMPS - (220-230)

POSITION: FLAT; 1G

TORCH TYPE: TWECO #4

TORCH SHIELDING GASES:
ARGON/Co2
COMPOSITION -75/25
FLOW RATE -(35 CFH)

GAS CUP SIZE: 5/8"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - NA
DEGREES FAHRENHEIT
PREHEAT MAINTENANCE - NONE

JOINT DESIGN: SKETCH
(SEE ATTACHED)

1) BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

WELDERS NAME: STEVE TERREL

ID # 0351

TEST CONDUCTED BY: PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY: LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

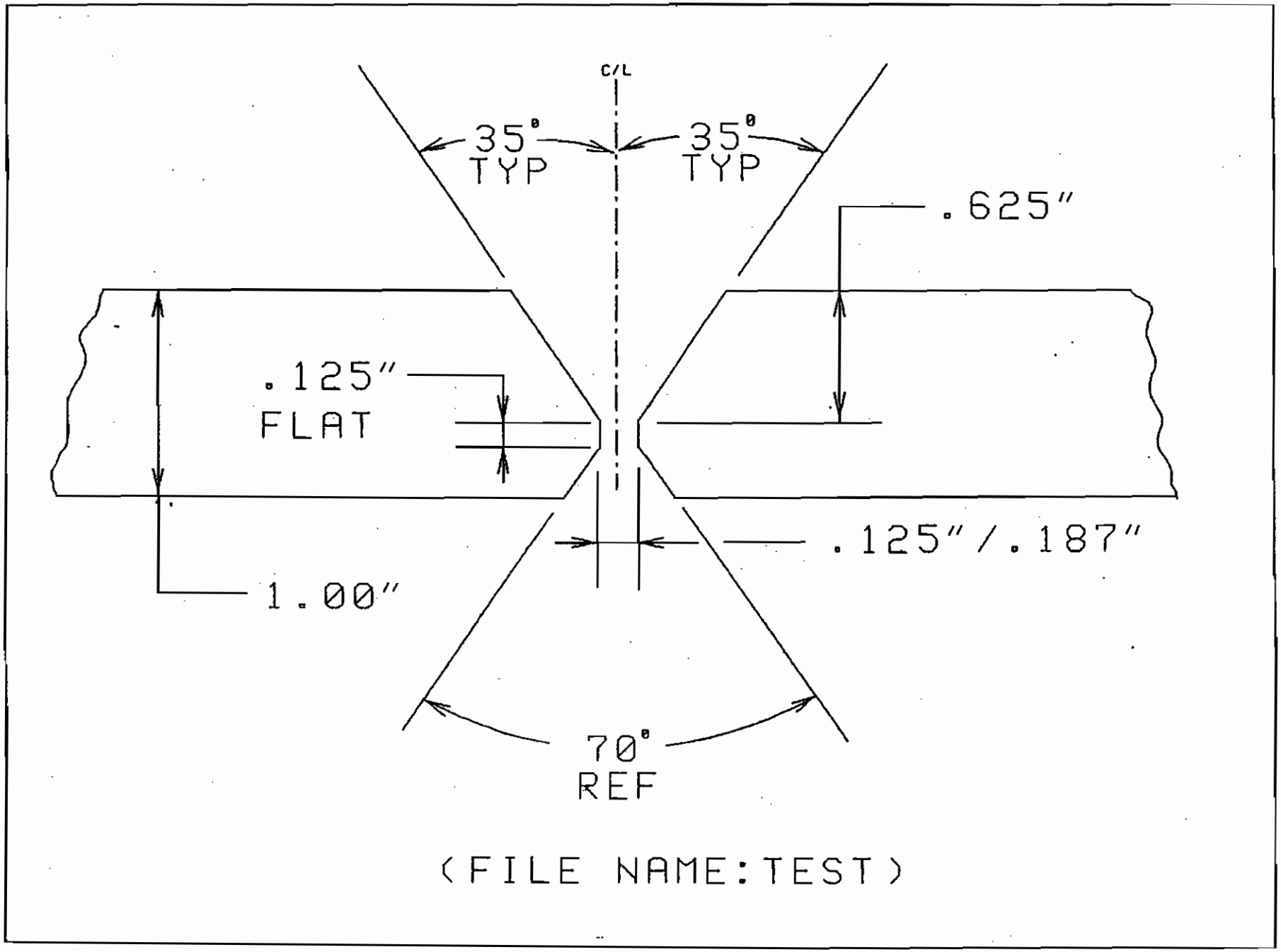
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

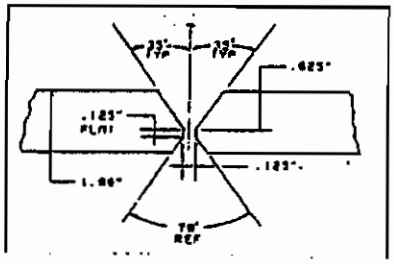
ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS003 (PLATE), PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A276
(3) THICKNESS 1"
(4) GROUP NO. 8

FILLER MATERIAL: AWS A5.22, E316LT-1, ASTM-SFA 5.22 DIAMETER: .045
(MAXIMUM SIZES TO BE USED IN PRODUCTION)
JOINT DESIGN: 1G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined 70° Double V with ⅛" Lip
WELDING POSITION: Flat
POWER SOURCE: Miller Delta weld 300
ARC VOLTAGE: 30 RANGE: 29-30
AMP RANGE: 220-230

WIRE SPEED RANGE: (WPM) 62-63
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: 3/8"
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE NA
POST WELD HEAT TREATMENT/
TEMPERATURE: NA
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERREL #0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA
VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ LABORATORY: _____
(NAME)

DATE OF CERTIFICATION: _____ VERIFIED BY: _____
(QUALIFYING ACTIVITY)

APPROVED BY: _____
(AUTHORIZED AGENT)

THE ESAB GROUP, INC.

1500 Karen Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

LANGDON OXYGEN
MT. PLEASANT, TX

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.22-80, ASME SFA 5.22

Trade Name
or Trademark: Alloy Rods Shield-Bright 316 ELC

Diameter Size: .045"

Type: E 316LT-1

Weight:

Test No.: 5-34838-00

Lot Number: 37168

Carbon:	.03
Manganese:	1.37
Chromium:	18.96
Nickel:	11.62
Silicon:	.93
Columbium+:	.03
Tantalum:	<.01
Molybdenum:	2.88
Tungsten:	
Copper:	.42
Titanium:	.06
Phosphorus:	.025
Sulphur:	.009
Vanadium:	.10
Cobalt:	.12
Aluminum:	<.01

Ferrite: 14.0 FN Delong
9.3 FN WRC
10.7% Schaeffler

The chemistry and ferrite values (if applicable) are made from actual determinations made from weld pads deposited with this lot of electrodes.

The undersigned certifies that this report is correct and that no significant change has been made in any of the elements described in the qualification approval.

By: D. A. Smith

D. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: June 30, 1994 OUR REPORT NO.: 348-48264-1 3 of 5

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A276-T316L /P8	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***		☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L			AMPS: 220-230	
	Welding Procedure Data by: ☐ PSI Witnessed (Tech):			☒ Others:

FILLER METAL

Specification No. * EXXXT-X	Classification 5.22	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed				
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for the variables stated.

REMARKS: * Electrode-E316LT-1
** Shielding Gas- 75% AR / 25% Co2
*** 1G - WPS 003
2G - WPS 004

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

WPS No. 003
PQR No.-PQR003
PO# 701437

QW-483 (Back)

August 23, 1994

Tensile Test (QW-150)

Report# 348-48264-4

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.750"	.971"	.728	63,200	86,800	Break/Base Matl.
T2	.746"	.982"	.733	63,500	86,600	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-4

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date 8-29-94 By Lloyd Anderson

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS004

BASE MATERIAL: ASTM A276, 316L,P# 8

FILLER MATERIAL: ASTM-SFA 5.22, E316LT-1,
AWS A5.22, .045" DIAMETER

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER DELTAWELD 300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (30)
CURRENT - D.C.; POSITIVE
AMPS - (220-230)

POSITION: HORIZONTAL, 2G

TORCH TYPE: TWECO #4

TORCH SHIELDING GASES:
ARGON/Co2
COMPOSITION -75/25
FLOW RATE -(35 CFH)

GAS CUP SIZE: 5/8"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - NA
DEGREES FAHRENHEIT
PREHEAT MAINTENANCE - NONE

JOINT DESIGN: SKETCH
(SEE ATTACHED)

1) BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

WELDERS NAME: STEVE TERREL

ID # 0351

TEST CONDUCTED BY: PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY: LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

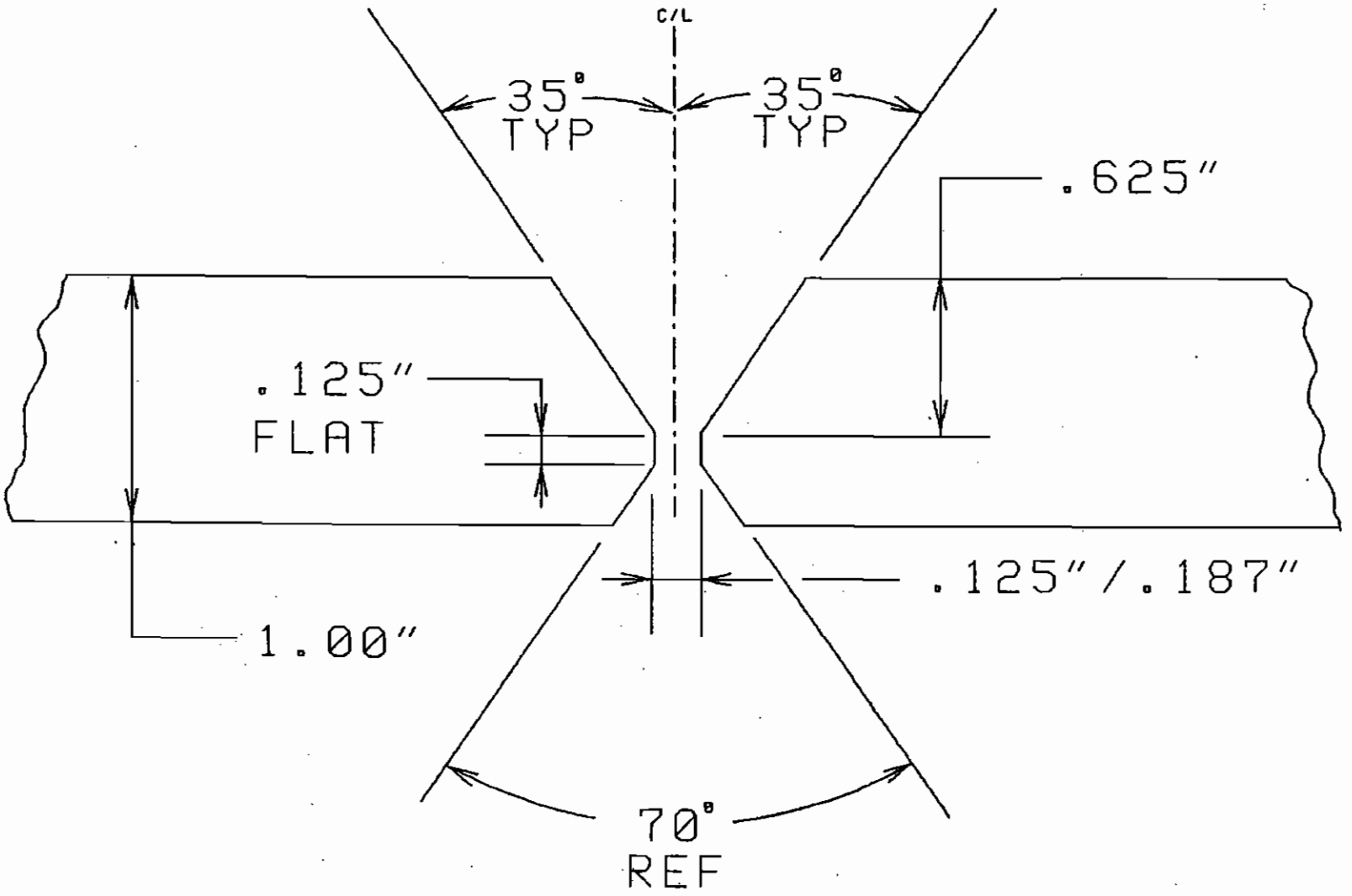
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

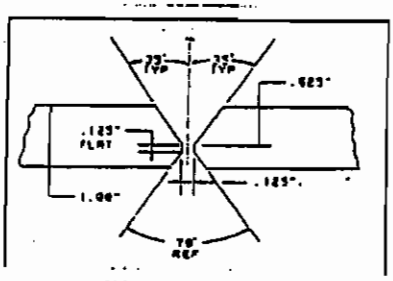
WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS004 (PLATE) PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A276
(3) THICKNESS 1"
(4) GROUP NO. 8

FILLER MATERIAL: AWS A5.22, E316LT-1, ASTM-SFA 5.22 DIAMETER: .045
(MAXIMUM SIZES TO BE USED IN PRODUCTION)

JOINT DESIGN: 2G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined 70° Double V with 1/8" Lip
WELDING POSITION: Horizontal
POWER SOURCE: Miller Deltaweld 300
ARC VOLTAGE: 30 RANGE: 29-30
AMP RANGE: 220-230

WIRE SPEED RANGE: (WPH) 62-63
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: 3/8"
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35(CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE NA
POST WELD HEAT TREATMENT/
TEMPERATURE: NA
TIME: NA

WELDER/WELDING OPERATOR: Steve Terrel # 0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA
VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)
BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ (NAME)
LABORATORY: _____

DATE OF CERTIFICATION: _____
VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

THE ESAB GROUP, INC.

1500 Karen Lane, Hanover, PA 17331

CERTIFICATE OF TYPICAL ANALYSIS

LANGDON OXYGEN
MT. PLEASANT, TX

Customer Order No.:

Order No.:

This Material Conforms to Specification
AWS A5.22-80, ASME SFA 5.22

Trade Name
or Trademark: Alloy Rods Shield-Bright 316 ELC

Diameter Size: .045"

Type: E 316LT-1

Weight:

Test No.: 5-34838-00

Lot Number: 37168

Carbon:	.03
Manganese:	1.37
Chromium:	18.96
Nickel:	11.62
Silicon:	.93
Columbium+:	.03
Tantalum:	<.01
Molybdenum:	2.88
Tungsten:	
Copper:	.42
Titanium:	.06
Phosphorus:	.025
Sulphur:	.009
Vanadium:	.10
Cobalt:	.12
Aluminum:	<.01

Ferrite: 14.0 FN Delong
9.3 FN WRC
10.7% Schaeffler

The chemistry and ferrite values (if applicable) are made from actual determinations made from weld pads deposited with this lot of electrodes.

The undersigned certifies that this report is correct and that no significant change has been made in any of the elements described in the qualification approval.

By: D. A. Smith

D. A. Smith, Supervisor, Q. A. Services

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: June 30, 1994

OUR REPORT NO.: 348-48264-1 3 of 5

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A276-T316L /P8	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***		☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L			AMPS: 220-230	
	Welding Procedure Data by: ☐ PSI Witnessed (Tech):			☒ Others:

FILLER METAL

Specification No. * EXXXT-X	Classification 5.22	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results	**Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)**
☐ Pass ☐ Fail	

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed				
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for e variables stated.

REMARKS: * Electrode-E316LT-1
** Shielding Gas- 75% AR / 25% Co2
*** 1G - WPS 003
2G - WPS 004

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

QW-483 (Back)

WPS No. 004
PQR No. -PQR004
PO# 701437

August 23, 1994

Tensile Test (QW-150)

Report# 348-48264-5

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.740"	.937"	.693	61,100	88,200	Break/in Weld
T2	.749"	.942"	.706	61,900	87,700	Break/in Weld

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-5

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date 8-23-94 By Lloyd Johnson

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS007

BASE MATERIAL: ASTM A36
P#1, GROUP 1a

FILLER MATERIAL: ASTM A5.20, .045" DIAMETER
AWS A5.20, ASME-SFA 5.20

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER CP300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (30-31)
CURRENT - D.C.
AMPS - (220-230)

POSITION: HORIZONTAL, 2G

TORCH TYPE: WELDCRAFT MIG GUN

TORCH SHIELDING GASES:
GAS: ARGON/Co2
COMPOSITION: 75/25
FLOW RATE: (35CFH)

GAS CUP SIZE: 1/2"

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - 300
DEGREES FAHRENHEIT (+/-25 DEGREES)

JOINT DESIGN: SKETCH
(SEE ATTACHED)

1) STRING BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

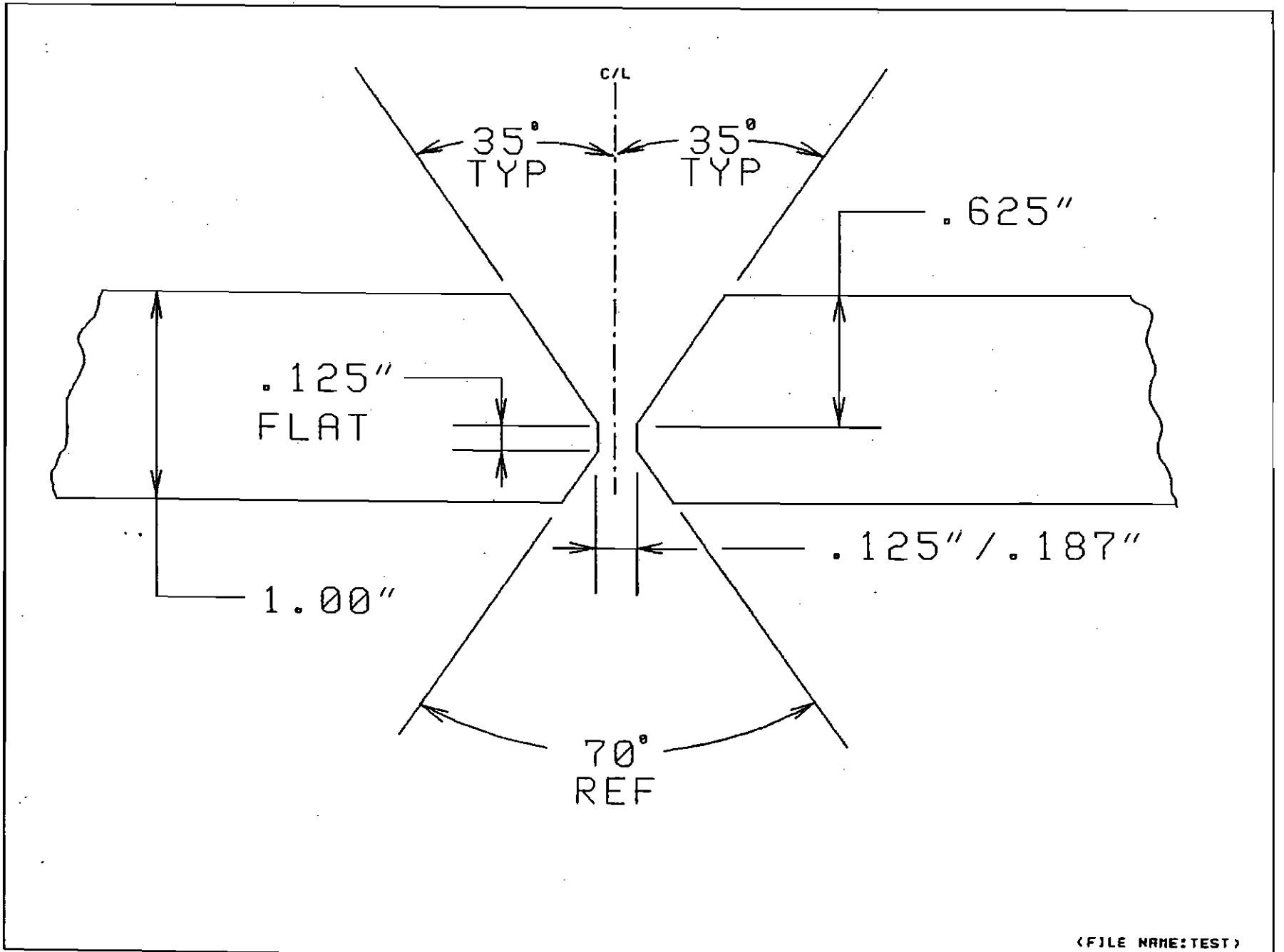
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager


C/L
35° TYP
35° TYP
.625"
.125" FLAT
1.00"
.125"/.187"
70° REF
(FILE NAME:TEST)

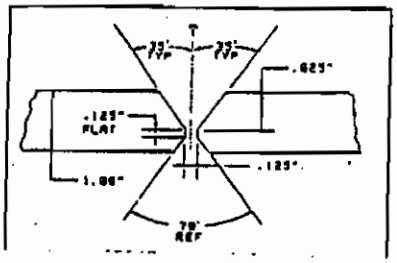
ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS007 (PLATE) PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A36
(3) THICKNESS 1"
(4) GROUP NO. 1a

FILLER MATERIAL: AWS A5.20 E71T-1, ASME-SFA 5.20 DIAMETER: .045"
(MAXIMUM SIZES TO BE USED IN PRODUCTION)
JOINT DESIGN: 2G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with ⅛" Lip
WELDING POSITION: Horizontal
POWER SOURCE: Miller CP300
ARC VOLTAGE: 30 RANGE: 30-31
AMP RANGE: 220-230

WIRE SPEED RANGE: (WPM) 48
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: ½"
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35 (CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE None
MAXIMUM INTERPASS TEMPERATURE 300° (+/- 25°)
POST WELD HEAT TREATMENT/
TEMPERATURE: None
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERREL #0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA
VISUAL _____
(#): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ (NAME)
LABORATORY: _____

DATE OF CERTIFICATION: _____
VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

TRI-MARK, INC.
4585 Industry Park Drive
Piqua, OH 45356
513-773-2010

CERTIFICATE OF COMPLIANCE TO REQUIREMENTS FOR WELDING ELECTRODE

Supplied To: Langdon Oxygen Company
3503 West 7th Street
Texarkana, TX 75501

Customer Order No. : 3275
Tri-Mark Invoice No. : 2576-1
Date : 11-5-87
Type : TM-711
Diameter : 1/16, .045"
~~Diameter Tested~~ : ~~1/16"~~
Classification : E71T-1
Test Specification : AWS A5.20
Production No. : see other side
Lab Test No. : AG456
Test Plates and Assembly : per AWS A5.20

Test Assembly Welding Procedure:
Amperage: 275 DCEP Voltage: 27
Stickout: 3/4" Shielding Gas: 40 cfh of CO_2
3/4" Diameter Nozzle

Interpass Temp.: 300 ± 25°F.
Layer Buildup: Six layers; two stringer beads on each of layers one and two; two weave beads on each of layers three through six; direction of travel reversed on each layer.

Test Specimens: per AWS A5.20
Testing Procedures: per AWS A5.20

CHEMICAL ANALYSIS (Undiluted Weld Metal)

% C	.037
Mn	1.08
P	.010
S	.021
Si	.812
Cr	.042
Ni	.025
Mo	.009
V	.023
Cu	.019
Al	.007

MECHANICAL PROPERTIES (All Weld Metal)

Tensile Strength, psi	88,890
Yield Strength, psi	77,510
Elongation, % in 2"	26
Charpy V-Notch Impact Values Ft-lb at 0 °F., Average	24.5, 24.5, 25.5 24.8

Radiographic Inspection: Radiographic results of actual weld acceptable.
Overhead and vertical fillet tests: Acceptable

This is to certify that TM-711, classification E71T-1, supplied on the above order, is of the same classification, manufacturing process, and material requirements as the electrode tested on March 3, 1987.

All tests required by specification AWS A5.20 were performed in conformance with that specification, and the above electrode met all requirements.

[redacted]
STATE OF OHIO

Mr. T. Merlo, Technical Director

J. K. O'Leary, Q.A. Manager

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994 OUR REPORT NO.: 348-48264-2 4 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A 36 / P1	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G / 3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***	0	☐ AC ☒ DC	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	**Welding Procedure Data by:** ☐ PSI Witnessed (Tech):		AMPS: ****	☒ Others:

FILLER METAL

Specification No. * EXXT-X	Classification 5.20	
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	
Shielding ☒ Gas: ** ☐ Flux	Trade Name	

VISUAL INSPECTION (AWS ONLY)

Appearance	Good
Undercut	None
Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance ☐ Pass ☐ Fail	Fillet Size Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results ☐ Pass ☐ Fail	Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed		1-X 3G	Passed	
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for the variables stated.

REMARKS: * Electrode-E71T-1
** Shielding Gas-75% AR / 25% Co2

*** 1G-WPS 009
2G-WPS 007
3G-WPS 002

**** 1G-280-290
2G-220-230
3G-170-180

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

QW-483 (Back)

WPS No. 007
PQR No.-PQR007
PO# 701437

August 23, 1994

Report# 348-48264-8

Tensile Test (QW-150)

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.739"	.937"	.692	56,200	81,200	Break/Base Matl.
T2	.747"	.898"	.671	54,700	81,500	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-8

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date _____ By _____

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ANDRITZ-RUTHNER, INC.

WELDING PROCEDURE #WPS009

BASE MATERIAL: ASTM A36
P#1, GROUP 1a

FILLER MATERIAL: ASTM A5.20, .045" DIAMETER
AWS A5.20, ASME-SFA 5.20

BASE MATERIAL CLEANING
DEGREASE AND BRUSH AS REQUIRED

PROCESS: FCAW

MACHINE, MODEL OR TYPE:
MILLER CP300

ELECTRICAL CHARACTERISTICS:
ARC VOLTAGE - (31-32)
CURRENT - D.C.
AMPS - (280-290)

POSITION: FLAT, 1G

TORCH TYPE: WELDCRAFT MIG GUN

TORCH SHIELDING GASES:
GAS: ARGON/Co2
COMPOSITION: 75/25
FLOW RATE: 35(CFH)

GAS CUP SIZE: NA

PURGE GAS: NONE

POST HEAT TREATMENT:
NONE

PREHEAT AND INTERPASS TEMPERATURE:
PREHEAT TEMPERATURE MINIMUM - NONE
INTERPASS TEMPERATURE MAXIMUM - 300
DEGREES FAHRENHEIT (+/-25 DEGREES)

JOINT DESIGN:

1) STRING BEAD
2) INITIAL AND INTERPASS CLEANING, BRUSH, CHIP OR GRIND TO REMOVE ANY MATERIAL DETRIMENTAL TO WELD.
3) CONTACT TO WORK DISTANCE -.750"
4) MULTIPLE OR SINGLE ELECTRODE- SINGLE

SKETCH
(SEE ATTACHED)

NONDESTRUCTIVE TEST: VISUAL
RADIOGRAPHY

ANDRITZ-RUTHNER, INC.

NONDESTRUCTIVE TEST:
VISUAL
RADIOGRAPHY

WELDERS NAME: STEVE TERREL
ID # 0351

TEST CONDUCTED BY:
PSI, INC.
317 W. HARRISON ROAD
LONGVIEW, TEXAS 75608

TEST WITNESSED BY:
LLOYD ANDERSON

LAB TEST REPORT NO.: SEE ATTACHED

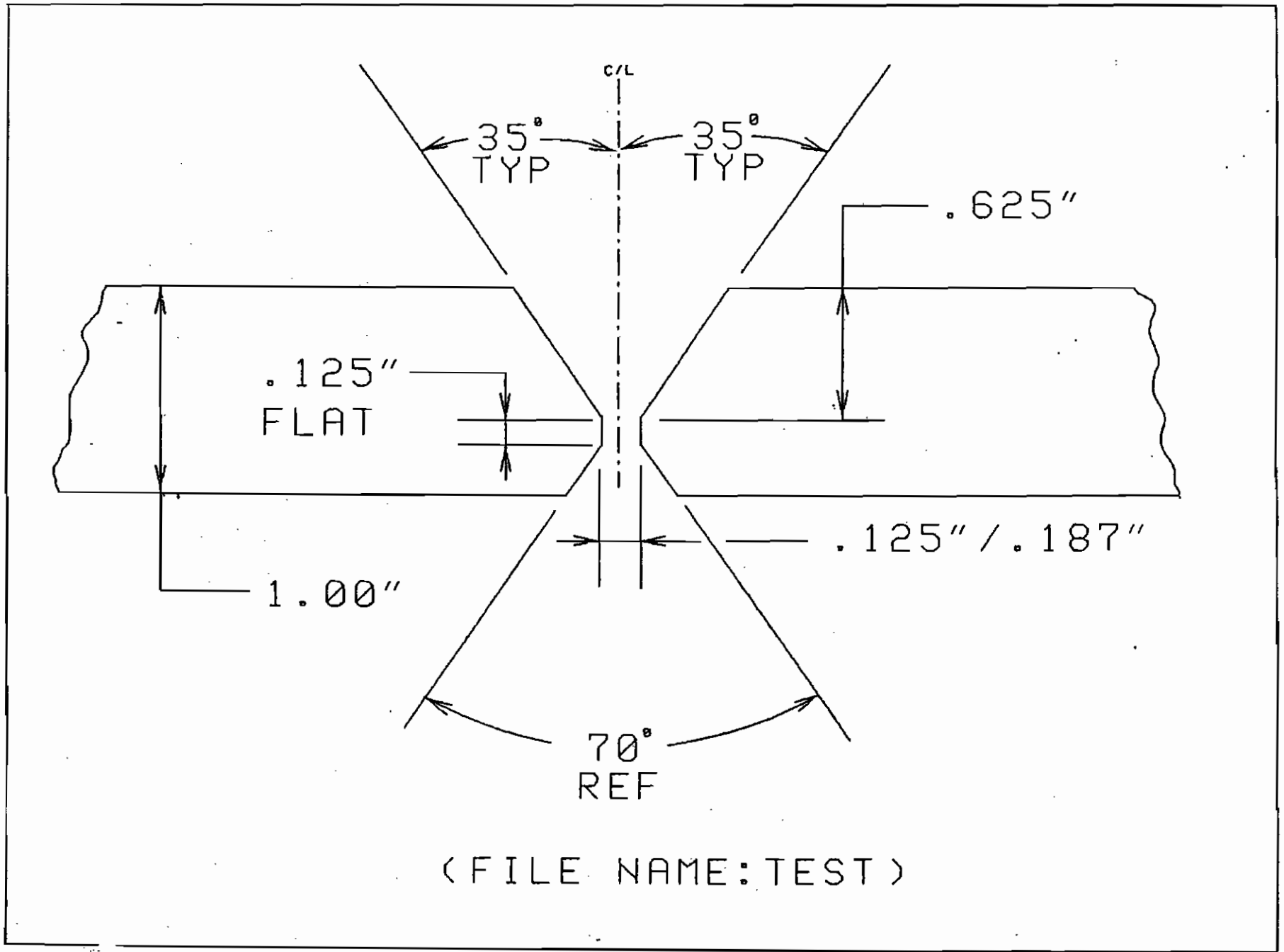
DATE: _____

WE CERTIFY THAT THE STATEMENTS IN THIS RECORD ARE CORRECT AND THAT THE TEST WELD WERE PREPARED, WELDED AND TESTED IN ACCORDANCE WITH THE REQUIREMENTS OF STANDARD ASME SECTION 9.

DATE: 8-23-94

SIGNED: _____

BY: _____
Plant Manager



(FILE NAME:TEST)

ANDRITZ-RUTHNER, INC.
110 DICKSON STREET, PITTSBURG, TEXAS 75686

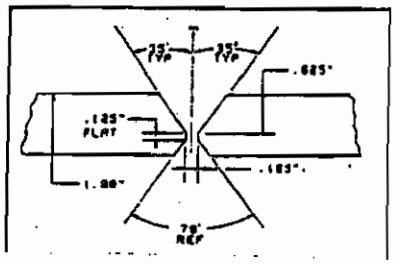
WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS: WPS009 (PLATE) PIPE, CASTING, OTHER _____
NOTE: SPECIFY OTHER _____

BASE MATERIAL: (1) SPEC. ASTM
(2) GRADE A36
(3) THICKNESS 1"
(4) GROUP NO. 1a

FILLER MATERIAL: AWS A5.20, E71T-1, ASTM-SFA 5.20 DIAMETER: .045
(MAXIMUM SIZES TO BE USED IN PRODUCTION)

JOINT DESIGN: 1G (SEE SKETCH)



SKETCH OF JOINT

METHOD OF EDGE PREPARATION: Machined Double "V" with 1/8" Lip
WELDING POSITION: Flat
POWER SOURCE: Miller CP 300
ARC VOLTAGE: 31 RANGE: 31-32
AMP RANGE: 280-290

WIRE SPEED RANGE: (WPM) 63
TORCH GAS: ARGON/CO2
TORCH TIP SIZE: NA
CUP SIZE: NA
SHIELDING GAS:
(1) COMPOSITION 75/25
(2) FLOW RATE RANGE 35 (CFH)
PURGE GAS:
(1) COMPOSITION NA
(2) FLOW RATE RANGE NA

MINIMUM PREHEAT TEMPERATURE NONE
MAXIMUM INTERPASS TEMPERATURE 300° (+/- 10°)
POST WELD HEAT TREATMENT/
TEMPERATURE: NA
TIME: NA

WELDER/WELDING OPERATOR: STEVE TERREL #0351

NONDESTRUCTIVE TEST RESULTS
APPLICABLE ACCEPTANCE STANDARD

R.T. _____
P.T. NA
M.T. NA
U.T. NA
VISUAL _____
(≠): NDT TEST RESULTS SATISFACTORY

DESTRUCTIVE TEST RESULTS:
(2) TENSILES:
(4) SIDE BENDS (SEE ATTACHED)

BASE MATERIAL: _____
WELD METAL TESTS: _____

BEND TEST RESULTS: _____ (SEE ATTACHED) _____

TEST APPROVED BY _____ (NAME) LABORATORY: _____

DATE OF CERTIFICATION: _____ VERIFIED BY: _____ (QUALIFYING ACTIVITY)

APPROVED BY: _____ (AUTHORIZED AGENT)

TRI-MARK, INC.
1585 Industry Park Drive
Piqua, OH 45356
513-773-2010

CERTIFICATE OF COMPLIANCE
TO REQUIREMENTS FOR WELDING ELECTRODE

Supplied To: Langdon Oxygen Company
3503 West 7th Street
Texarkana, TX 75501

Customer Order No. : 2275
Tri-Mark Invoice No. : 2576-1
Date : 11-5-87
Type : TM-711
Diameter : 1/16, .045"
~~Diameter Tested~~ : ~~1/16"~~
Classification : E71T-1
Test Specification : AWS A5.20
Production No. : see other side
Lab Test No. : AG456
Test Plates and Assembly : per AWS A5.20

Test Assembly Welding Procedure:
Amperage: 275 DCEP Voltage: 27
Stickout: 3/4" Shielding Gas: 40 cfh of CO_2
3/8" Diameter Nozzle

Interpass Temp.: 300 ± 25°F.
Layer Buildup: Six layers; two stringer beads on each of layers one and two; two weave beads on each of layers three through six; direction of travel reversed on each layer.

Test Specimens: per AWS A5.20
Testing Procedures: per AWS A5.20

CHEMICAL ANALYSIS (Undiluted Weld Metal)

% C	.037
Mn	1.08
P	.010
S	.021
Si	.812
Cr	.042
Ni	.025
Mo	.009
V	.023
Cu	.019
Al	.007

MECHANICAL PROPERTIES (All Weld Metal)

Tensile Strength, psi	88,890
Yield Strength, psi	77,510
Elongation, % in 2"	26
Charpy V-Notch Impact Values Ft-lb at 0 °F., Average	24.5, 24.5, 25.5 24.8

Radiographic Inspection: Radiographic results of actual weld acceptable.
Overhead and vertical fillet tests: Acceptable

This is to certify that TM-711, classification E71T-1, supplied on the above order, is of the same classification, manufacturing process, and material requirements as the electrode tested on March 3, 1987.

All tests required by specification AWS A5.20 were performed in conformance with that specification, and the above electrode met all requirements.

[signature]
STATE OF OHIO

[signature]
Mr T. Merlo, Technical Director

[signature]
J. M. O'Leary, Q.A. Manager

Professional Service Industries, Inc.

REPORT OF WELDER AND WELDING OPERATOR QUALIFICATION TEST REPORT

TESTED FOR: Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

PROJECT: Welder Qualification
PO# 701437

DATE: July 05, 1994 OUR REPORT NO.: 348-48264-2 4 of 6

Welder/Welder Operator's Name	Welding Code (ID & year)	Client Order No.	Specimen	PSI Lab. No.
Steve Terrel	ASME SEC. IX	701437	☒ Plate ☐ Pipe	
Welder Identification No.	**Base Material Specification**	**Diameter & Wall Thickness**	**Joint**	**Plate Thickness**
0351	A 36 / P1	N/A	☒ Groove ☐ Fillet	1.00"
Process	**Position**	**Specimen Furnished By**	**Specimen Machined By**	**Thickness Range Qualified**
FCAW	1G / 2G / 3G	☐ PSI ☒ Others	☐ PSI ☐ Others N/A	.1875"-Unlimited
Weld Progression	**Welding Procedure No.**	**Rev. No.**	**Current**	**Polarity**
☐ Up ☐ CW ☐ L to R	***	0	☐ AC ☒ DC AMPS: ****	☐ Direct ☒ Reverse
☐ Down ☐ CCW ☐ R to L	Welding Procedure Data by: ☐ PSI Witnessed (Tech):			☒ Others:

FILLER METAL		VISUAL INSPECTION (AWS ONLY)	
Specification No. * EXXT-X	Classification 5.20	Appearance	Good
Backing Weld Metal after Back Gouge	Diameter/F No. .045" / 6	Undercut	None
Shielding ☒ Gas: ** ☐ Flux	Trade Name	Piping Porosity	None

GUIDED BEND TEST RESULTS

TYPE	RESULTS	TYPE	RESULTS

FILLET TEST RESULTS

Weld Appearance	Fillet Size
☐ Pass ☐ Fail	Leg: in. x in. ☐ Concavity: in. ☐ Convexity: in.
Macro Etch Test Results	**Fracture Test Results (Describe location, nature & size of any cracks or tearing of the specimen)**
☐ Pass ☐ Fail	

RADIOGRAPHIC TEST RESULTS

FILM IDENTIFICATION	RESULTS	REMARKS	FILM IDENTIFICATION	RESULTS	REMARKS
1-X 1G	Passed		1-X 3G	Passed	
1-X 2G	Passed				

QUALIFICATION RESULTS

The Welder/Operator identified above ☒ DOES ☐ DOES NOT meet the performance qualifications specified in the Code identified above for 3 variables stated.

REMARKS: * Electrode-E71T-1
** Shielding Gas-75% AR / 25% Co2

*** 1G-WPS 009
2G-WPS 007
3G-WPS 002

**** 1G-280-290
2G-220-230
3G-170-180

Respectfully submitted,
Professional Service Industries, Inc.

Andritz-Ruthner, Inc.
P.O. Box 343
Pittsburg, Texas 75686
Attn: Ms. Pat Boyd

QW-483 (Back)

WPS No. 009
PQR No.-PQR009
PO# 701437

August 23, 1994

Report# 348-48264-7

Tensile Test (QW-150)

Specimen No.	Width	Thickness	Area	Ultimate Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
T1	.748"	.934"	.699	56,800	81,300	Break/Base Matl.
T2	.750"	.943"	.707	57,800	81,800	Break/Base Matl.

Guided Bend Tests (QW-160)

Type and Figure No.	Result
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed
Side Bend QW 462.2	Passed

Toughness Tests (QW-170)

Specimen No.	Notch Location	Notch Type	Test Temp.	Impact Values	Lateral Exp.		Drop Weight	
					% Shear	Mils	Break	No Break

Fillet Weld Test (QW-180)

Result — Satisfactory: Yes _____ No _____ Penetration Into Parent Metal: Yes _____ No _____

Macro—Results _____

Other Tests

Type of Test _____

Deposit Analysis _____

Other _____

Welder's Name Steve Terrell Clock No. 0351 Stamp No. _____

Tests conducted by: Professional Service Industries, Inc. Laboratory Test No. 348-48264-7

We certify that the statements in this record are correct and that the test welds were preprared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

Manufacturer Andritz-Ruthner, Inc.

Date _____ By _____

(Detail of record of tests are illustrative only and may be modified to conform to the type and number of tests required by the Code.)

ATTACHMENT 4

ANDRITZ REFURBISHMENT REFERENCE CHECKS

1. City of Erie Pa. WTP, Mark Kwitowski, Presses 20 yrs old, very happy with Andritz work," Excellent Work "
2. City of Vacaville, Ca. Grover Wright, Presses 10 yrs old, Spoke very highly of Andritz, "They set the Standard", "Professional"
3. Metro Sewer District St. Louis, MO. Mike Hanlin, No Complaints
4. St. Johns County St. Augustine Fl. John Casteel. Everything went fine, they did a good job.

Chris,
These are my reference checks as of 5-18-06 and 5-19-06. I also included their comments briefly. It is my recommendation to proceed with Andritz for the work to be done. Thanks Larry