

Ref. PD(BBIAP)/6284/02/PD- 249

Dated: 9th July, 2011

Dear Sir,

PROCUREMENT OF REINFORCEMENT STEEL FOR BBIAP

1. Reinforcement steel at BBIAP as specified in contract should conform to ASTM A-615. This standard requires check of chemical composition for each heat of Billet produced such as Carbon, Manganese, Phosphorus and Sulfur but does not specify limits except phosphorus. Taking advantage of this situation few Rolling mills in Pakistan started to use Grade-40 Billet in making Grade-60 bars by increasing mechanical properties through TMT (Thermo Mechanical Treatment). Bars produced through TMT increases mechanical properties to meet G-60 requirement but chemical composition of steel remains the same as of Grade-40. To curb this practice it became necessary to specify chemical composition requirement for assurance of Grade-60 Billet use in rolling of steel bars.
2. Survey of the following approved steel mills was made to check process and discuss problem:-
 - 1- FF Peshawar
 - 2- Fazal Islamabad
 - 3- Nomee Hatt
 - 4- Pak Steel Islamabad
 - 5- Ittehad Steel Islamabad
 - 6- Karachi Steel Islamabad
 - 7- Ittefaq Steel Lahore
 - 8- City Steel Lahore
 - 9- Prime Steel Lahore
3. Out of 9 Mills 3 i.e. FF, Fazal and Ittefaq have TMT arrangement. Matter was discussed with Management of all three steel mills with particular reference to chemical composition requirement. All agreed to roll bars without TMT and to meet chemical composition requirement.
4. ASTM A-615 does not recommend TMT. Contractors of all packages are required to mention following requirement in purchase order:-
 - Deformed Grade-60 Billet Bars conforming to ASTM A-615.
 - TMT is not required
 - Use of Grade-60 must be ensured
 - Chemical composition test of bars will be part of acceptance tests along with unit weight, tensile strength, elongation, bend, deformation & finish. Required chemical composition are:-

○ Carbon	0.28% Min
○ Manganese	1.10% Min
○ Phosphorus	0.075% Max
 - Above requirement has been finalized with consultation of all 9-steel mill managers without extra cost.

Yours Sincerely,


(S.AKHTAR HASSAN)
Dy PD QA

Mr Robert Fluhr
Project Manager PMC
Louis Berger Group Inc
BBIAP

Copy to:-

- PD BBIAP
- PM LTH JV Package-1 & 8A
- PM ATL Package-6