



Alabama Port Authority
Requisition and Proposal

Project Name McDuffie Terminal Dock 2 Refurbishment – Supply of New Fenders

Location Mobile, Alabama

Project # 11703

Task # 2

MARCH 2026

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SPECIFICATIONS AND CONTRACT DOCUMENTS



Douglas C. Otto, Jr., Director & CEO

Kay Ivey, Governor of Alabama

ISSUED BY

Engineering Services Department



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INVITATION TO BID

Sealed bid proposals will be received via courier to the Alabama Port Authority, 250 North Water Street, Mobile, Alabama 36602 by 1:30 P.M., on Thursday, April 30, 2026. Sealed bid proposals can also be hand delivered from 1:45 P.M. to 2:00 P.M., on April 30, 2026 to the Alabama Port Authority in the International Trade Center building, 250 North Water Street, first floor – Killian Room, Mobile, Alabama. Faxed or electronically submitted bids will not be accepted. The right is reserved, as the interest of the Alabama Port Authority may require, to reject all bids through a Notice of Non-award or otherwise, and to waive informalities in bids received.

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SUPPLY OF NEW FENDERS
MOBILE, ALABAMA

The work consists principally of the supply and delivery of the specified fender components to the APA McDuffie Terminal facility in Mobile, Alabama in accordance with the attached contract documents.

Specifications, proposal forms, bid and performance bond forms, and plans are available on the Alabama Port Authority website at www.alports.com. For additional project contractual information, please contact the APA Project Manager, Brandon Taylor (251) 441-7243 (email to brandon.taylor@alports.com). For technical information, please contact the APTIM Project Manager, Mike Dye at (251) 380-1224 (email to mike.dye@aptim.com).

Each Bidder shall satisfy oneself as to the character, quality, and quantities of work to be performed, and as to the requirements of the proposed contract. The submission of a proposal shall be proof that the bidding Contractor has made such examination and is satisfied as to the conditions to be encountered in performing the work and as to the requirements of the proposed Contract.

The Alabama Port Authority will utilize its sales tax exemption status on this project. The Contractor will be responsible for the purchase of all materials and will be required to apply for a sales and use tax certificate of exemption upon contract award.

A Guarantee will be required with each bid as follows: At least five (5%) percent of the amount bid, but no more than Ten Thousand (\$10,000) Dollars, shall be furnished in the form of a certified check or Bid Bond payable to the Alabama Port Authority.

A Performance Bond in an amount not less than the sum bid will be required at the signing of the contract.

Bids will be publicly opened at 2:00 P.M., April 30, 2026, in the International Trade Center Building, 250 North Water Street, first floor – Killian Room, Mobile, AL.



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IMPORTANT NOTICE REGARDING EMPLOYMENT PRACTICES:

Effective October 1, 2011, the Beason-Hammon Alabama Taxpayer and Citizen Protection Act (“the Act”) requires that any business entity contracting with or providing any grant or incentives to the state, including the Alabama Port Authority, certify compliance with the Act. All Contractors must certify such compliance by executing the enclosed “Certificate of Compliance” and returning it to the Alabama Port Authority with your proposal. In addition, the company shall submit with their proposal evidence that the company is enrolled in the E-Verify system. The following E-Verify website link is provided for convenience: <https://www.e-verify.gov/>

IMPORTANT NOTICE REGARDING ACCESS TO APA FACILITIES:

All individuals needing access to McDuffie Terminal must have a valid Transportation Worker Identification Credential (TWIC) card, APA badge and an APA vehicle decal with no exceptions. Information regarding APA’s access policy is provided on the APA website at the following link: <https://www.alports.com/port-access>

Unloading of the delivered fender components and hardware will be coordinated by APA on-site. The Contractor must provide APA advance notice of deliveries. APA will not be responsible for unsuccessful delivery attempts due to lack of advance notice.

Time is an essential element in the Contract. Therefore, for each day the equipment delivery is delayed beyond the date specified in the Delivery Schedule provided with the bid, \$500.00 shall be paid by the Contractor to APA as liquidated damages for the loss sustained by the Port Authority because of failure of the Contractor to complete the work within the specified time.

Subsequent to the final acceptance of this project by the Owner, the following requirements must be satisfied by the Contractor before final payment can be made.

- a) The Contractor must execute copies of CONTRACTOR’S AFFIDAVIT OF PAYMENT OF CLAIMS AND DEBTS on the form furnished by the Project Manager.
- b) The Contractor must have their surety execute copies of CONSENT OF SURETY TO FINAL PAYMENT on the form furnished by the Project Manager.
- c) The Contractor must furnish a letter on their letterhead acknowledging that acceptance of final payment by the Contractor constitutes a waiver of all claims, present or future, in connection with this project.
- d) The Contractor must furnish a written guarantee on their letterhead covering all defects in material and workmanship for a period of two (2) years commencing on the date of final acceptance.
- e) If any purchased items have been incorporated in the work, the Contractor must furnish a letter on their letterhead assigning those warranties to the OWNER. Copies of said warranties shall be bound in one binder and submitted along with the letter assignment.



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INSTRUCTIONS TO BIDDERS

1.0 ADDENDA AND INTERPRETATIONS

All questions about the meaning or intent of the Contract Documents shall be submitted to the Project Manager in writing. Replies will be issued by Addenda posted to the Port's website. All addenda so issued shall become part of the Contract Documents. Only questions answered by formal written Addenda will be binding. Oral and other interpretations or clarifications will be without legal effect. Deadline to submit questions is seven (7) calendar days before the Bid Opening date.

2.0 SUBMISSION OF PROPOSALS

Before submitting a proposal, the Contractor shall comply with the following:

- a) Signed Proposal shall be filled in ink on the form provided herein and all blank spaces in the form shall be fully filled, including the acknowledgement of Addenda. The signature shall be in long hand and the complete form shall be without interlineations, alteration or erasure.
- b) Attach a certified check or Bid Bond in the amount of 5% of the Proposal, but not more than \$10,000, made payable to the Alabama Port Authority.
- c) Signed Certificate of Compliance with the Beason-Hammon Alabama Taxpayer and Citizen Protection Act (see page I-8)
- d) Include a Delivery Schedule for the new fender components and associated hardware

One copy of Items (a) through (d) shall be placed in a sealed envelope with the bidder's name, the project name, and the time and date of bid opening shown on the outside.

All mailed submissions, including those sent via courier service, must be delivered to the following address in accordance with the Invitation to Bid:

Alabama Port Authority
Attn: Brandon Taylor, Facilities Engineer
250 N. Water Street
Mobile, AL 36602
(251) 441-7243

No faxed or electronic bid submissions will be accepted. Conditional bids will not be accepted. Responding bidders are responsible for effective delivery by the above deadline, and late submissions will be rejected without opening and returned to the sender. APA accepts no responsibility for misdirected or lost proposals.



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PROPOSAL

Proposal of:

Address:

Date:

To: STATE OF ALABAMA, Alabama Port Authority, Mobile, Alabama

Gentlemen:

The undersigned, as Bidder, hereby declares that he has examined the site of the work and informed himself fully in regard to all conditions pertaining to the place where the work is to be done; that he has examined the plans and specifications for the work and contractual documents relative thereto, and has read all Special Provisions and Specifications furnished; and that he has satisfied himself relative to all aspects of the work to be performed and especially to those factors affecting cost, progress, or performance.

The Bidder proposes and agrees, if this bid is accepted, to contract with the Owner in the form of contract specified, to furnish all necessary materials, equipment, tools, apparatus, means of transportation, labor and incidentals to perform in a satisfactory manner, the work described in the Contract Specifications and Drawings for the Alabama Port Authority, for the prices listed below to complete:

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MOBILE, ALABAMA

In full and complete accordance with the shown, noted, described and reasonable intended requirements of the plans, specifications and contract documents to the full and entire satisfaction of the Owner with a definite understanding that no money will be allowed for extra work except as set forth in the attached contract documents.

It is agreed that the description under each item, being briefly stated, implies, although it does not mention, all incidentals and that the prices stated are intended to cover all such work materials and incidentals as constitute Bidder's obligation as described in the specifications and any details not specifically mentioned, but evidently included in the contract shall be compensated for the item which most logically includes it.

Bidder agrees that he will commence the work within the time allotted by the Contract Documents with an adequate force, plant, and equipment and that the fender components and hardware will be delivered within time schedules outlined in the Delivery Schedule, provided by the Bidder.



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Bidder accepts the provisions of the Contract Documents as to liquidated damages in the event of failure to complete the work on time.

The Bidder further agrees that, in case of failure on his part to execute the Contract and required bonds within ten (10) calendar days from the date written notice of award if mailed or otherwise delivered to the Bidder, the certified check or Bid Bond accompanying this bid and the monies payable thereon shall be paid into the funds of the Owner not as penalty, but as a liquidation of a reasonable portion of the damages incurred by the Owner due to the Bidder’s failure to execute the Contract.

Items not specifically noted in the schedule of prices shall be considered ancillary to the project and be absorbed in the bid items, no separate payment shall be made for these items.

Bids will be evaluated on a Best Value basis, considering both the proposed cost and Delivery Schedule provided with the bid.

SCHEDULE OF PRICES

ITEM	DESCRIPTION	APPROX QUANTITY	UNIT PRICE	AMOUNT
1	Project Bonds & Insurance	Lump Sum	L.S.	
2	Supply of Frontal Panels and Associated Hardware as required for mounting to 28 cell elements	14	\$_____ /Panel	
3	Supply of Specified Cell Elements and Associated Hardware for mounting to the concrete (existing embedded anchors)	20	\$_____ /Cell	
4	Supply of Hardware: Bolts and Washers for mounting existing cell elements to existing embedded anchors in the concrete	27	\$_____ /Assembly	
5	Supply of Hardware: Bolts, Washers, and Stainless Steel Embedded Anchors for mounting existing cell elements to the concrete	21	\$_____ /Assembly	
6	Delivery to the site	Lump Sum	L.S.	
TOTAL BASE ESTIMATED COST				



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I, the undersigned bidder, hereby acknowledge receipt of the following addenda:

ADDENDUM NO. _____

ADDENDUM NO. _____

ADDENDUM NO. _____

Contractor's Signature:

Contractor Company _____

Name

Title

Date



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BID BOND

KNOW ALL MEN BY THESE PRESENTS, that we, undersigned, _____

_____ as Principal, and _____ as Surety, are hereby held and bound unto The Alabama Port Authority as **OWNER** in the Penal sum of _____ for the payment of which will and truly be made, we hereby jointly and severally bind ourselves, successors and assigns. Signed, the _____ day of _____, 20__.

The Condition of the above obligation is such that whereas the Principal has submitted to the Alabama Port Authority a certain BID, attached hereto and hereby made a part hereof to enter into a contract in writing, for the McDuffie Terminal Dock 2 Refurbishment – Supply of New Fenders, Project 11703 Task 2.

NOW, THEREFORE,

- (a) If said BID shall be rejected, or
- (b) If said BID shall be accepted and the Principal shall execute and deliver a contract in the form of Contract attached hereto (Properly completed in accordance with said BID) and shall furnish a BOND for his faithful performance of said contract, and for the payment of all persons performing labor or furnishing materials in connection therewith, and shall in all other respects perform the agreement created by the acceptance of said BID, then this obligation shall be void, otherwise the same shall remain in force and effect; it being expressly understood and agreed that the liability of the Surety for any and all claims hereunder shall, in no event, exceed the panel amount of this obligation as herein stated.

The Surety, for value received, hereby stipulates and agrees that the obligations of said Surety and its **BOND** shall in no way be impaired or affected by any extension of time within which the **OWNER** may accept such BID; and said Surety does hereby waive notice of any such extension.

IN WITNESS WHEREOF, the Principal and the Surety have hereunto set their hands and seals, and such of them as are corporations have caused their corporate seals to be hereto affixed and these presents to be signed by their proper officers, the day and year first set forth above.

Principal	
Surety	
By	



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State of _____

County of _____

**CERTIFICATE OF COMPLIANCE WITH THE BEASON-HAMMON ALABAMA TAXPAYER AND
CITIZEN PROTECTION ACT (ACT 2011-535, as amended by Act 2012-491)**

DATE: _____

RE Contract/Grant/Incentive (describe by number or subject):

_____ by and between

_____ (Contractor/Grantee) and

_____ (State Agency, Department or Public Entity)

The undersigned hereby certifies to the State of Alabama as follows:

1. The undersigned holds the position of _____ with the Contractor/Grantee named above, and is authorized to provide representations set out in this Certificate as the official and binding act of that entity, and has knowledge of the provisions of THE BEASON-HAMMON ALABAMA TAXPAYER AND CITIZEN PROTECTION ACT (ACT 2011-535 of the Alabama Legislature, as amended by Act 2012-491) which is described herein as "the Act".
2. Using the following definitions from Section 3 of the Act, select and initial either (a) or (b), below, to describe the Contractor/Grantee's business structure.

BUSINESS ENTITY. Any person or group of persons employing one or more persons performing or engaging in any activity, enterprise, profession, or occupation for gain, benefit, advantage, or livelihood, whether for profit or not for profit. "Business entity" shall include, but not be limited to the following:

- a. Self-employed individuals, business entities filing articles of incorporation, partnerships, limited partnerships, limited liability companies, foreign corporations, foreign limited partnerships, foreign limited liability companies authorized to transact business in this state, business trusts, and any business entity that registers with the Secretary of State.



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b. Any business entity that possesses a business license, permit, certificate, approval, registration, charter, or similar form of authorization issued by the state, any business entity that is exempt by law from obtaining such a business license and any business entity that is operating unlawfully without a business license.

EMPLOYER. Any person, firm, corporation, partnership, joint stock association, agent, manager, representative, foreman, or other person having control or custody of any employment, place of employment, or of any employee, including any person or entity employing any person for hire within the State of Alabama, including a public employer. This term shall not include the occupant of a household contracting with another person to perform casual domestic labor within the household.

a. The Contractor/Grantee is a business entity or employer as those terms are defined in Section 3 of the Act.

b. The Contractor/Grantee is not a business entity or employer as those terms are defined in Section 3 of the Act.

3. As of the date of this Certificate, Contractor/Grantee does not knowingly employ an unauthorized alien within the State of Alabama and hereafter it will not knowingly employ, hire for employment, or continue to employ an unauthorized alien within the State of Alabama.

4. Contractor/Grantee is enrolled in E-Verify unless it is not eligible to enroll because of the rules of that program or other factors beyond its control.

Certified this ____ day of _____, 20____

Name of Contractor/Grantee/Recipient

By: _____

Its _____



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The above Certification was signed in my presence by the person whose name appears above,

on this _____ day of _____ 20_____

WITNESS:

Signature

Printed Name of Witness



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INDEMNIFICATION AND INSURANCE REQUIREMENTS

INDEMNIFICATION

The Contractor shall assume all liability for and shall indemnify and save harmless the State of Alabama, the Alabama Port Authority and its officers and employees, and Engineer from all damages and liability for injury to any person or persons, and injury to or destruction of property, including the loss of use thereof, by reason of an accident or occurrence arising from operations under the Contract, whether such operations are performed by himself or by any subcontractor or by anyone directly or indirectly employed by either of them, occurring on or about the premises, or the ways and means adjacent, during the term of the Contract, or any extension thereof, and shall also assume the liability for injury and/or damages to adjacent or neighboring property by reason of work done under the Contract.

CONTRACTOR COVERAGE

The Contractor shall not commence work under the Contract until he has obtained all insurance required under the following paragraphs and until such insurance has been approved by the Owner, nor shall the Contractor allow any subcontractor to commence work on his subcontract until all similar applicable insurance required of the subcontractor has been obtained and approved. If the subcontractor does not take out insurance in his own name, then the principal Contractor shall provide such insurance protection for subcontractor and his employees by endorsement to the Contractor's policies or by taking out separate policies in the name of the subcontractor.

COMMERCIAL GENERAL LIABILITY

The Contractor shall take out and maintain during the life of the Contract Commercial General Liability insurance, including Blanket Contractual and Completed Operations coverage, in an amount not less than \$3,000,000 for any one occurrence for bodily injury, including death, and property damage liability. Policy shall include endorsement identifying the Owner and Engineer as Primary and Non-contributory Additional Insureds as respects the Contractor's work for the Owner, to the extent required by written Contract, including a waiver of all rights of subrogation.

BUSINESS AUTOMOBILE LIABILITY

The Contractor shall take out and maintain during the life of the Contract Business Automobile Liability insurance covering owned, non-owned and hired vehicles in an amount not less than \$1,000,000 for any one occurrence for bodily injury, including death, and property damage liability. The Owner and Engineer shall be identified as Additional Insureds, to the extent required by written Contract.

WORKERS COMPENSATION – AL WC/EL

The Contractor shall take out and maintain during the life of the Contract Workers Compensation and Employers Liability insurance providing coverage under the Alabama Workers Compensation Act in an amount not less than that required by Alabama Law.

Where applicable, Contractor shall take out and maintain during the life of the Contract insurance providing coverage as required by Federal statute, including but not limited to U.S. Longshoremen and Harbor Workers Act (USL&H), Jones Act, and Railroad Federal Employers Liability Act (FELA).



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PROFESSIONAL LIABILITY COVERAGE

The Contractor shall take out and maintain during the life of the contract Professional Liability insurance including design with limits not less than \$2,000,000 per occurrence.

PROOF OF CARRIAGE OF INSURANCE

The Contractor shall furnish to the Owner, in triplicate, Certificates of Insurance, signed by the licensed agent, evidencing the required coverage, along with letter of transmittal giving date of delivery. A copy of this letter shall also be delivered to the Engineer. The Owner reserves the right to require certified copies of any and all policies.

All coverage and bonds shall be provided by companies acceptable to the Owner. Each policy of insurance shall provide, either in body of the policy or by endorsement, that such policy cannot be substantially altered or cancelled without thirty (30) days' written notice to the Owner and insured.



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PERFORMANCE BOND

KNOW ALL MEN BY THESE PRESENTS:

That: _____
(Name of Contractor)

(Address of Contractor)

(City, State, Zip)

I, a(n) _____ corporation, hereinafter called Principal, and
(State of domicile)

(Name of Surety)

(Address of Surety)

hereinafter called Surety, are held and firmly bound unto the Alabama Port Authority hereinafter called OWNER, in the penal sum of _____ DOLLARS, (\$ _____) (100% of the Contract Amount) in lawful money of the United States, for the payment of which sum well and truly to be made, we bind ourselves, successors, and assigns, jointly and severally, firmly by these presents.

THE CONDITION OF THIS OBLIGATION is such that whereas, the Principal entered into a certain contract with the OWNER, dated the _____ day of _____, 20 ____, a copy of which is hereto attached and made a part hereof for the construction of:

MCDUFFIE TERMINAL DOCK 2 REFURBISHMENT
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MOBILE, ALABAMA

NOW, THEREFORE, if the Principal shall promptly make payments to all persons, firms, SUBCONTRACTORS, and corporations furnishing materials or performing labor in the prosecution of the WORK provided for in such contract, and any authorized extension or modification thereof, including all amounts due for materials, lubricants, fuel, repairs on machinery, equipment and tools, consumer or used in connection with the construction of such WORK, and all insurance premiums on said WORK, and for all labor performed in such WORK whether by SUBCONTRACTOR or otherwise, then this obligation shall be void; otherwise to remain in full force and effect.



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PROVIDED FURTHER, that the said Surety, for value received hereby stipulates and agrees that no change, extension of time, alteration, or addition to the terms of the contract of the WORK to be performed thereunder or the SPECIFICATIONS accompanying the same shall in any way affect its obligation on this BOND, and it does hereby waive notice of any such change, extension of time, alteration, or addition to the terms of the contract or to the WORK or to the SPECIFICATIONS.

PROVIDED, FURTHER, that no final settlement between the OWNER and the CONTRACTOR shall abridge the right of any beneficiary hereunder, whose claim may be unsatisfied.

IN WITNESS WHEREOF, this instrument is executed this _____ day of _____, 20____.

ATTEST:

(Principal) Secretary

(SEAL)

Witness as to Surety Principal

(Address)

ATTEST:

Witness as to Surety

(Address)

Principal

BY: _____ (s)

(Address)

Surety

BY: _____
Attorney-In-Fact

(Address)

NOTE: Date of BOND must not be prior to date of CONTRACT.
If CONTRACTOR is Partnership, all partners should execute BOND.



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ACKNOWLEDGEMENT FOR CHANGE ORDERS

TO: ALABAMA PORT AUTHORITY

**RE: MCDUFFIE TERMINAL DOCK 2 REFURBISHMENT – SUPPLY OF NEW FENDERS
MOBILE, ALABAMA**

Gentlemen:

In order to avoid the necessity of extensive amendment to the referenced Contract, the undersigned hereby acknowledges that the following conditions are those for which change orders are allowed under the Bid law:

1. Unusual and difficult circumstances which arise during the course of the execution of the Contract which could not have been reasonably foreseen.
2. Where competitive bidding for the new work will be to the serious detriment of the Owner.
3. Emergencies arising during the course of work.
4. Changes or alterations provided for in the original bid and original Contract.
5. The Contractor also acknowledges and agrees that if for any reason the Contractor deems that additional compensation is due him for work or materials not clearly provided in the Contract, plans, or specifications or previously authorized as extra work, he shall notify the Engineer in writing of his intention to claim such additional compensation before he begins the work on which he bases his claim.

CONTRACTOR

BY: _____

DATE

TITLE



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CONTRACT

THIS AGREEMENT, made and executed on this _____ day of the month of _____, Two Thousand and _____ (20____), by and between The Alabama Port Authority, and _____ Contractor, domiciled in the state of _____, Party of the Second Part, and hereinafter designated as “CONTRACTOR,” WITNESSETH, that in consideration of the covenants and agreements herein contained, to be performed by the parties hereto and of the payments hereinafter agreed to be made, it is mutually agreed as follows:

The CONTRACTOR shall and will provide and furnish all equipment and labor, and perform the work required to build, construct, and complete in a thorough and workmanlike manner, to the satisfaction of the Alabama Port Authority:

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Hereinafter called the project, for the base Contract price of _____ DOLLARS, (\$ _____) and all extra work in connection therewith, and in accordance with plans, specifications, and Proposal, which are made a part thereof as fully as is set out herein, and hereby becomes a part of this Contract.

It is agreed and understood that the Alabama Port Authority shall pay, and the Contractor shall receive, the full compensation for the work performed in accordance with the Specifications.

The project shall commence and will be completed in accordance with the Contract Documents and Delivery Schedule.

This contract shall become effective immediately upon, and as of the date all necessary parties hereto have approached and signed the same.

By signing this contract, the contracting parties affirm, for the duration of the agreement, that they will not violate federal immigration law or knowingly employ, hire for employment, or continue to employ an unauthorized alien within the State of Alabama. Furthermore, a contracting party found to be in violation of this provision shall be deemed in breach of the agreement and shall be responsible for all damages resulting therefrom.

IN WITNESS WHEREOF, the parties of these presents have executed this Agreement in the year and day first above written.

WITNESS: _____ Alabama Port Authority

WITNESS: _____ BY: _____ Contractor Party of the Second Part

_____ BY: _____



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FENDER SPECIFICATIONS

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SUPPLY OF NEW FENDERS

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1.0 GENERAL

1.1 Introduction

The Alabama Port Authority is refurbishing the existing McDuffie Terminal Dock II Structure and as such desires to install an updated fender system for the dock for handling the required vessels that will utilize the facility. The work included under this section shall consist of the Design, Fabrication and Delivery to the Owner’s facility of all components required for the complete installation of the fender system as specified herein and/or indicated on the drawings.

2.0 PANEL FENDER SYSTEM

2.1 Arrangement

The proposed fender system shall be comprised of rubber fender units with a steel frontal frame complete with weight, and tension chains if deemed necessary by the Supplier and all related hardware including anchor plates, bolts, threaded rods, and any related hardware required for a complete installation.

2.2 Each system shall be capable of the following rated performance:

Rated Energy Absorption	933 ft.-kips
Hull Pressure	4.2 ksf

Fender manufacturer shall verify the load requirements shown based on the system replacing the original Bridgestone SUC1250h RE systems.

Fender system shall account for barge contact forces to occur close to the water line.

Above performance values may be subject to a manufacturing tolerance of no more than +/-10%.

Each system shall be capable of absorbing a horizontal shearing force equal to 30% of its rated reaction while simultaneously absorbing the above-defined minimum energy without exceeding the defined maximum reaction.

Maximum reaction force from fender system to the dock structure is 519 kips. Undelected standoff of the system is approximately 5 ft.



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3.0 MATERIALS (RUBBER UNITS)

3.1 The rubber for proposed fender to be used must be of vulcanized natural or synthetic rubber or a mixture of them. These shall be reinforced with carbon black and resistant to aging, seawater, abrasion, and ultraviolet rays.

The rubber must be homogenous in quality and free from foreign materials, bubbles, injuries, cracks and other harmful defects.

The embedded fixing steel plates shall be firmly bonded into the rubber body through the process of vulcanization, and completely encapsulated so that no steel is exposed. The steel shall be encased with a minimum rubber thickness of 1/16”.

3.2 Rubber Properties

Property Tested	Test Method	Acceptance Requirements
Hardness (Before Aging)	ASTM D2240 Shore A	78° Max
Tensile Strength (Before Aging)	ASTM D412 Die C	16 MPa (2320 psi) Min
Ultimate Elongation (Before Aging)	ASTM D412 Die C	300% Min
Change in Hardness (After Aging)	ASTM D573 96 hrs @ 70°C	+10° Max
Change in Tensile Strength (After Aging)	ASTM D573 96 hrs @ 70°C	-20% Max
Change in Ultimate Elongation (After Aging)	ASTM D573 96 hrs @ 70°C	-20% Max
Compression Set	ASTM D395 Method B 22 hours at 70°C	30% Max
Ozone Resistance	ASTM D1171 Method B	100%
Water Resistance	ASTM D471 70 hours at 100°C	+10% Max by Volume
Low Temperature Resistance	ASTM D2137 Method A 3 minutes at -40°C	No Cracks
Adhesion	ASTM D429 Method B	7 kN/m (40 lb/in) Min
Tear Resistance	ASTM D624 Die B	70 kN/m (400 lb/in) Min



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3.3 Rubber Composition

Test	Standard	Specification
Density	ISO 2781	Max 1.20 g/cc
Polymer (rubber)	ASTM D6370	Min 45%
Carbon Black	ASTM D6370	Min 20%
Ash Content	ASTM D297	Max 5%
Rubber Filler Ratio		> 1:2*

* “Rubber Filler Ratio” is defined as Polymer % / (Ash content % + Carbon black %)

3.4 Performance Verification

Full scale load deflection tests shall be conducted on 10% of the fender elements supplied. The performance of the fender is expressed by the value of the energy absorbed during compression of the fender up to the designed deflection and the maximum value of the reaction load thus generated.

In the performance test of the fender, compression shall be applied toward the top face of the fender. The compression speed shall follow current PIANC Fender Performance Testing guidelines and shall be recorded during testing. Deflection of the fender is to be repeated for three times up to the designed deflection. A fourth cycle shall be conducted, after a minimum 1 hour wait period, and used for the performance of the fender. The fourth cycle performance value shall be more than the designed performance value for the energy absorption and less than the designed performance value for the maximum reaction load.

For the performance test of the fender, the room temperature at the time of the tests shall be recorded.

All testing must be conducted in the United States of America and shall either be witnessed by a recognized accreditation agency such as Lloyds Register or conducted by a 3rd party independent laboratory. Velocity corrections will not be allowed nor will scale model tests



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be allowed as an alternative. The Port Authority reserves the right to retest selected fender elements.

Certified performance curves for each fender shall be supplied and the owner reserves the right to witness testing and/or test the fenders again upon delivery.

3.5 Hardware

All hardware for mounting of the fender to the panel shall be supplied by the fender manufacturer. All hardware for mounting the fender to the concrete face including threaded rods, nuts, and washers shall be included. At required locations, Manufacturer shall be responsible for recommending the desired core hole depth for the retrofit in the existing dock structure and the type of epoxy bonding agent to use. All mounting hardware shall be 316 stainless steel. Any socket type embedment shall have a 316 stainless steel female socket. The size and grade of the mounting hardware shall be according to the fender manufacturers published information.

All bolts, nuts, and washers for attaching fender elements to the contact panels, steel structures and to embedded anchor sleeves shall be of the size required per the manufacturer's published data. All exposed hardware shall be 316 stainless steel.

4.0 PANEL

4.1 Design and Construction

The proposed panel shall be of the size and shape as shown on the drawings. The panel shall be designed and constructed according to the AISC Steel Construction Manual Specifications. All welding shall be in accordance with AWS D1.1 latest edition standards. All fillet welds shall be seal welds to prevent corrosion. All steel shall be ASTM A-36, or as necessary from stress calculations. All bolt holes shall be drilled.

Panel design shall be as shown on the drawings. Panel tops shall not be higher than elevation (+)13.73' and panel bottom shall extend to elevation (-) 1.00'. Face of panel shall be approx. 5' stand off from face of dock as shown on the drawings.

Minimum steel thickness shall be 1/2" for external plate and 3/8" for internal plates if of a closed box design and 1/2" if an open grillage design.

Consider the following cases in determining maximum moment to be resisted by panels:

- a Vertical line load in middle of panel or middle of span between elements



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- b Any other load case which generates stresses exceeding the stresses from the above load cases

4.2 Coating

The proposed panel shall be coated with a two coat coal tar epoxy such as International Intertuf® 708 or an approved equal. All preparation and application shall be in compliance with the coating manufacturer's recommendations for immersion service. Surface preparation shall be by abrasive blast to SSPC-SP10 "Near White Blast Cleaning" with an anchor profile of 50 to 75 microns. The D.F.T. of the coating shall be 400 microns minimum. The finish coat shall be free of sags, voids, and orange peel and resistant to impact and abrasion. Minimum accepted rated adhesion strength of the coating system shall be 800 psi.

4.3 Hardware

4.3.1 Chains (If deemed required by Supplier)

The proposed chain system shall prevent excessive top tension, bottom tension, horizontal shear, vertical shear and weight-induced deflection of the fender. All hardware such as shackles and turnbuckles/Dogbone shackles required for attaching the chains shall be included and supplied by fender manufacturer. All chains and related hardware shall be hot dipped galvanized.

The chains and related hardware shall be sized considering the maximum possible shearing and tension forces on the fender. Shearing forces on the panel shall be calculated from the maximum reaction of the fender and the coefficient of friction of the proposed UHMW face pads.

Sizing of the weight chains shall include the shearing force from friction as well as the weight of the panel and one-half the weight of the proposed fenders. All metal chains and components shall be galvanized per ASTM A123 or A153. No chain assembly shall have a breaking strength of less than 50,000 pounds no shall metal chains have a stock size of less than $\frac{3}{4}$ ".

4.3.2 Anchor Plates

All anchor plates for attaching the proposed chains to the concrete face shall be included and supplied by the fender manufacturer prior to pouring of concrete as well as proper plates for installation into the existing dock concrete. All hardware for attaching the anchor plates including threaded rods, nuts, and washers shall be provided. All hardware shall be hot dipped galvanized.



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4.4 Face Pads

UHMW face pads shall cover the face of the panel including the faces of the bevels. The pads shall be minimum of 1 ½" thick and yellow in color. The proposed UHMW must be UV stabilized. UHMW materials must meet the following minimum standards. Test data for proposed UHMW must be submitted as part of bid submittal documentation.

4.4.1 Properties

Property	Test Method	Acceptance Requirements
Specific Gravity	ASTM D792	0.926 gm/cc
Ultimate Tensile Strength	ASTM D638A	4,000 psi, min
Izod Impact, Double Notch	ASTM D256A	18 ft-lbs/in, min
Abrasion Wear (carbon stl = 100)	Sand Slurry	18 max.
Water Absorption	ASTM D570	Nil
Coefficient of Friction	ASTM D1894	0.20 max
Color	Not Applicable	yellow

*Industry Standard testing method using slurry of 60% aluminum oxide and 40% water at a rotation speed of 1750 rpm for 2 hours. A lower number indicates better abrasion resistance.

4.4.2 UHMW Installation

The pads shall be drilled and counter bored for the mounting bolts. Mounting bolts shall be a minimum of 5/8" diameter and shall be 316 stainless steel. The face of the bolt head shall be a minimum of 1/2" below the face of the UHMW pad. All exposed edges of the UHMW shall include 3/4" X 3/4" bevels.

5.0 PACKAGING

The rubber fenders shall be packaged while being delivered to the Port so as to prevent damage to the fenders. The fender manufacturer, prior to shipment to the jobsite shall install the UHMW for the panels on the steel panels. All chain and hardware shall be packaged for shipment to the customer. Fender sections shall be safely stacked and blocked



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to provide safe storage until the marine contractor shall collect the materials for installation. All labor, equipment, and wood cribbing required to deliver and provide storage on the site shall be included in the supplier's proposal. The supplier shall make arrangements for offload prior to arrival of materials at the jobsite.

6.0 SCHEDULE

6.1 Schedule

Supplier shall submit a delivery schedule with his Bid which shall be utilized in Bid Evaluation.

7.0 SUBMITTALS (Panel Fender System)

7.1 Submittals Due with Bid

Items to be included with the bid proposal shall include at a minimum the following items:

- 7.1.1 A bill of materials drawing showing the general arrangement of the fender system and noting all included hardware with quantities.
- 7.1.2 Performance curves for reaction, energy, and deflection for the proposed fender.
- 7.1.3 Recently conducted same size element fender test reports
- 7.1.4 Price for supply of all fender systems required number and all items required to complete and mount the system including all crating and shipping to jobsite.
- 7.1.5 Confirmation of on-site installation supervision by manufacturer's engineer for 2 days during installation.
- 7.1.6 Supply list demonstrating that the manufacturer has been in the business of manufacturing molded/bonded buckling type rubber marine fenders for at least 10 years and show proof of 5 buckling type fender installations within the USA each having been in service for at least 5 years.
- 7.1.7 List of references including contact name and phone numbers.
- 7.1.8 Proposal shall be inclusive of all costs, duties, inland transportation to jobsite as directed by the Owner.



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7.2 Submittals Due Prior to Award

Items to be provided prior to award of the project shall include at a minimum the following items:

- 7.2.1 Final drawings of the complete proposed fender system with weld details, material dimensions, thicknesses, and fabrication specifications.
- 7.2.2 Calculations justifying the proposed design for the steel panels, link pieces and chains.
- 7.2.3 Welding procedures and individual qualifications and certifications.
- 7.2.4 Submittal must include drawings stamped by a P.E. within the United States.
- 7.2.5 UHMW material test data.
- 7.2.6 Fender performance curves and material specifications.
- 7.2.7 Test certificates for the rubber material properties as required in this specification.

7.3 Submittals Due with Delivery

Items to be provided upon delivery of the fender systems shall include at a minimum the following items:

- 7.3.1 Performance test certificates for fender performance as required in this specification.
- 7.3.2 Detailed installation procedures for the supplied fender system. (For both the new dock and the retrofit on the existing dock)

8.0 GENERAL SUPPLIER REQUIREMENTS

8.1 Bonding

Manufacturer shall provide a performance bond upon notification of a Letter of Intent. Bond shall be for the value of the complete proposal of all fenders, hardware, and weldments. Proof of adequate bonding capacity shall be submitted with the supplier's proposal at bid time.



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8.2 Warranty

Manufacturer shall provide a two (2) year warranty on supplied materials from damage caused by normal use.

8.3 Other

The Alabama Port Authority reserves the right to award to the bidder determined to best suit the requirements of this installation if other than the lowest bidder.

8.4 Payment

Payment shall be in accordance with the Schedule of Prices.