

INSPECTION & TEST PLAN																	
CLIENT	ENER TECHNOLOGY			ITP NO : TBA		Rev. 00				DATE : 04.09.2024.							
PROJECT	TBA			JOB TITLE		REFRIGERATION SKID PACKAGE											
P.O.No & Date	TBA			SKID GA.		TBA											
W.O.NO	TBA			DRG. NO.													
VENDOR	TBA																
CLIENT																	
SL NO	QUALITY RELATED ACTIVITY	REFERENCE	CHARACTERISTICS TO	ACCEPTANCE	VERIFYING	AGENCY											
		DOCUMENTS	BE VERIFIED	STANDARD	DOCUMENTS	VENDOR	ENER								REMARKS		
INSPECTION & TEST PLAN (FOR PIPING)																	
1.0 ENGINEERING DOCUMENTATION & DRAWING																	
1.1	Review fabricaton drawing	Conformance to B31.3, Client Spec.	Drawings	ASME B 31.3, Client Spec	Project Documents.	H		R									
1.2	Welding Procedures & Procedure Qualification Records & Welding Repair Procedure	ASME Sec IX, ASME B31.3, Client Spec.	Approved WPS / PQR	ASME Sec IX ,Client Spec.	WPS / PQR	H		R									
						H		R									
1.3	Welder's Performance Qualification Records	ASME Sec IX, Client Spec.	Approved WPQR	ASME Sec IX, Client Spec.	WPQR	H		R									
1.4	NDE Procedures (RT , MT & PT), Hardness test procedure	ASME Sec V / Client Spec.	NDE Procedures, Hardness test procedure	ASME SEC V / Client Spec.	NDE Procedures, Hardness test procedure	H		R									
1.5	NDE Operator Qualification	ASME Sec V / Client Spec.	Qualification & Renewal of operators.	ASNT-SNT-TC-1A , Client Spec.	Certificates	H		R									
1.6	Visual Inspection procedure	Conformance to B31.3, Client Spec.	Visual Inspection procedure	Approved Drg - ASME B 31.3, Client Spec.	Visual Inspection procedure	H		R									
1.7	PMI Procedure	Approved drawing & ASME Sec II Part A	Elements to be confirmed	As per approved drawing & ASME Sec II Part A	PMI Procedure	H		R									
1.8	Hydro Test Procedure	Conformance to B31.3, Client Spec.	Pressure Testing of process piping	Approved Drg - ASME B 31.3, Client Spec.	Hydro Test Procedures	H		R									
1.9	Pickling & Passivation Procedure	ASTM A380	Pickling & Passivation Procedure	As per approved procedure, ASTM A380	Pickling & Passivation Procedure	H		R									

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1.10	Painting Procedure	As per approved procedure	Painting Procedure	As per approved procedure	Painting Procedure	H		R									
2.0	MATERIAL PREPARATION & PRE FABRICATION																
2.1	Material Test Certificates	ASME Sec II Part - A.	Chemical & Mechanical Properties , Markings, Minimum Thk and Surface Conditions.	As per Approved Drawing in accordance with ASME Sec II Part - A.	MTC & Inspection Report.	H		R									
2.2	Visual & dimensional of raw material	ASME Sec II Part - A.	Visual & dimensional inspection	As per Approved Drawing in accordance with ASME Sec II Part - A.	MTC & Inspection Report.	H		SW									
2.3	PMI for Stainless steel materials	Approved Drawings	Elements to be verified as per approved procedure	Approved Procedure	PMI Report	H		SW									
3.0	FABRICATION																
3.1	Internal Cleaning	Approved Procedure	Visual	Approved Procedure	Inspection Report.	H		SW									
3.2	Length Marking, Cutting	Approved Drawing	Approved Drawing , Length , Profile Cutting of plates dimensions and marking.	Approved Drawing	...	H		SW									
3.3	Material Traceability	Approved Drawing	Heat Number & Specification	Approved Drawing	Inspection Report.	H		SW									
3.4	Preparation of Piping with Attachments	Approved Drawing	Approved Drawing & Dimensions	Approved Drawing	...	H		SW									
3.5	Pipe with flanges Attachments fitup	Approved Drawing	Parellality, Perpendicularity Orientation, Dimensions& Alignment	Approved Drawing	...	H		SW									
4.0	VISUAL INSPECTION OF WELD																
4.1	WELDING & VISUAL INSPECTION	Approved Weld Visual Procedure ; Approved WPS	WELD SIZE. & Appearance	Approved Drawing & ASME B 31.3 Table 341.3.2	Inspection Report.	H		SW									
5.0	NDE																

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5.1	15 % RT On Butt welds 15 % MT / PT On other Wellds.		Approved RT, PT, MT procedure,	Weld Soundness & Quality	Approved Drawing & ASME B 31.3 Table 341.3.2, 344.4.2, 344.3.2	RT,MT,PT REPORTS	H		R									
6.0	Final Inspection (Before Hydro)		ASME B31.3, Approved Drawing,	Visual , Dimension & Orientation	Approved Drawing & ASME B 31.3	Inspection Report.	H		H									
7.0	Hydro test .		ASME B31.3, Approved Drawing,	Pressure & Holding Time	Approved Drawing & ASME B 31.3 Sec.345.4 & As per approved procedure	pressure Chart &Inspection Report.	H		H									
8.0	Pickling / Passivation on Stainless Steel & SDSS Pipe Spools (External Surface Only)		ASTM A380	CHECKING THE QUALITY	As per approved Pickling & Passivation Procedure	Pickling & Passivation Report	H		SW									
9.0	Coating																	
9.1	Blasting		As per approved procedure	Surface profile Measurement	Approved drawing & As per approved procedure	Inspection Report.	H		SW									
9.2	Final paint, Visual & DFT		As per approved procedure	DFT Measurement	Approved drawing & As per approved procedure	Inspection Report.	H		SW									
10.0	Identification marking & final inspection		Drawing	Visual	Drawing	Inspection Report	H		SW									
11.0	IRC(Inspection release certificate) & Final Document		Approved Final Data Book Index	Fianl Data Book	Fianl Data Book	Fianl Data Book	H		H									