



DEHDASHT PETROCHEMICAL INDUSTRY COMPANY
DEHDASHT HIGH DENSITY POLYETHYLENE PROJECT



Contract No.: DPIC/98-12

DOCUMENT TITLE: Inspection & Test Plan (ITP) for Refrigeration Unit (PK-6101)

POI: IFA

Rev. D2

DOCUMENT No: DPIC9812-000-VD-1002-ME-ITP-0008

Sheet 1 of 15

Please see commented ITP for electric motors.

Inspection & Test Plan (ITP) for Refrigeration Unit (PK-6101)

PURCHASER'S COMMENT/APPROVAL STATUS

Purchaser: NARGAN

- | | |
|------|--|
| 1. | AP: Approved (Released for Manufacturing) |
| 2. ✓ | AN: Approved With Minor Comments (Fabrication may Proceed) |
| 3. | NF: Approved With Comments (Fabrication not Proceed) |
| 4. | RJ: Rejected |
| 5. | NR: Not be Returned |

Requisition No.: DPIC98-12-001-000-ME-MR- 4150-0001-D1

Item No. (Tag No.): PK-6101

Date: 27-08-2023

Signature:

Vendor Doc. No.: DPIC9812-000-VD-1002-ME-ITP-0008

REV.	DATE ISSUE	Purpose of Issue	PREPARED	CHECKED	APPROVED
D2	27-Aug-2023	Issue for Approval	M. R	M. M	A.V
D1	04-Jan-2022	Issue for Approval	M. R	M. M	A.V
D0	16-Nov-2021	Issue for Approval	M. R	M. M	A.V





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		ITEM NO(S): DEHDASHT PETROCHEMICAL Refrigeration Package	MANUFACTURER SERIAL NUMBER:							
1	Scope	This Inspection and Test plan covers all activities that will be carried out in design and fabrication of equipment.					Date:			
2	LEGEND OF THE TECHNICAL SURVEILLANCE	1) (H)= INSPECTION NOTIFICATION will be issued by manufacturer and inspection shall be performed at presence of notified party. Next fabrication stage is subject to acceptance of inspection. Vendor must notify parties activity) of the defecated inspection activity at least fifteen (15) days in advance.					Rev.: D0			
		2) (SW)=10% OF TYPE/LOT WITNESSED. Action performed only on a certain number of pieces.					By:			
		3) (W)=WITNESSING. The Supplier shall inform the NOTIFIED PARTY of the date of the activity and the NOTIFIED PARTY reserves the right to witness the test. If the test is conducted at the notified date, the Supplier may proceed with the subsequent phase, even if the NOTIFIED did not witness the test.								
		4) (R/A)=REVIEW OF TECHNICAL DOCUMENTS BEFORE COMMENCEMENT OF CONSTRUCTION. The technical documents shall be reviewed and approved before the commencement of construction								
		5) (R)=REVIEW OF DOCUMENTS. Materials certificates, statement of compliance and reports of inspection and tests conducted by the Supplier shall be revised to assess their conformance with the requirements specified in the Code and Standards, Specifications and/or Purchase Order.								
		6) (M) = KASRAVAND(Manufacturer) Inspection								
3	Abbreviations	O = Owner (Dehdasht PC/PIDMCO) N = NARGAN V = Vendor SV = Sub Vendor TPI = Third Party Inspection on behalf of owner								
Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY					REMARKS
					SV	V	N	TPI	O/MC	

A PROJECT PREPARATION											
A1	VERIFY CUSTOMER SPECIFICATION	ASME VIII DIV 1 (U-STAMP NOT REQUIRED) (Welding Standard) DETAILS AS PER QUALITY PLAN			Type	H	H				
					Date						
					Sign						
A2	PRE-INSPECTION MEETING		MOM & ITP		Type	H	H	H		H	
					Date						
					Sign						



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					SV	V	N	TPI	O/MC						
B MATERIAL SELECTION / SUBCONTRACTOR ORDERING															
B0	GENERAL	ALL ITEMS SUITABLE FOR AMBIENT TEMPERATURE / OUTDOOR ALL ITEMS TO BE CONFORM ZONE 2 GROUP IIB T3	MATERIAL SUPPLY FABRICATION SCHEDULE QA / QC		Type	H	H								
					Date										
					Sign										
B1	COMPRESSOR – SUBCONTRACTED MAYEKAWA FACTORY JAPAN	DETAILS AS PER COMPRESSOR QUALITY PLAN MANUFACTURER STANDARD	TEST REPORT: -Noise test. - Vibration test - Performance test - Running test - Hydro test	MATERIAL CERTIFICATES	Type	See ITP of Compressor									
				Date											
				Sign											
B2	MAIN MOTOR - SUBCONTRACTED	Refer to MOTOR ITP	TEST REPORT - Unwitnessed routine test report		Type	H	H	R	R						
					Date										
					Sign										
B3	OIL PUMP MAYEKAWA FACTORY	MYCOM STANDARD	TEST REPORT incl; Hydro test result and performance test result	MATERIAL CERTIFICATES	Type	H	H	R	R						
					Date										
					Sign										
B4	PUMP MOTOR	MANUFACTURER STANDARD with protection class as per Exn HAZARDOUS AREA CERTIFICATE IECex / Exn Zone 2 IIB T3	TEST REPORT (Manuf. Std) - Unwitnessed routine test report		Type	H	H	R	R						
					Date										
					Sign										
B5	MAIN COUPLING	MYCOM STANDARD (Flexible disc type coupling)	SUITABLE FOR HAZARDOUS AREA	Material certificate, visual and dimensional inspection report	Type	H	H	R	R						
					Date										
					Sign										



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					SV	V	N	TPI	O/MC		
B 6 PRESSURE VESSELS Double Oil filter (with element) Oil separator (with coalescer)											
B6-1	Material Inspection & Certificate review (Pressure Part)	App DWG Project Documents, Material Standards	Material Certificate / Inspection report 2.2 Certificate for non-pressure Parts	Approved drawings. EN 10204-3.1 Project Documents, Material Standards	Type	H	H	W	W	R	
					Date						
					Sign						
B6-2	Visual and dimensional check of fabricated heads	App. DWG	Head Dim. Report	Drawing Welding Map	Type	H	H	W	W	R	
					Date						
					Sign						
B6-3	Fit-up and welding of shells and heads	WPS/PQR, WELD MAP	Inspection Report	ASME SEC VIII,IX, Project job specification	Type	H	H	SW	SW	R	
					Date						
					Sign						
B6-4	Marking of nozzles on heads prior to cutting	App. DWG	Inspection Report	Drawing	Type	H	H	W	W	R	
					Date						
					Sign						
B6-5	Fit-up and welding of nozzles to heads	App. DWG	Inspection Report	Drawing	Type	H	H	SW	SW	R	
					Date						
					Sign						
B6-6	PWHT (if any)	Procedure	Inspection Report	Procedure	Type	H	H	SW	SW	R	
					Date						
					Sign						



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					SV	V	N	TPI	O/MC		
B6-7	PMI test (if any)	Procedure	Inspection Report	Procedure	Type	H	H	SW	SW	R	
					Date						
					Sign						
B6-8	NDT	Procedure + NDT Map	Inspection Report	Procedure + NDT Map	Type	H	H	RA	R	R	100% RTI & 20% W for Other NDT
					Date						
					Sign						
B6-9	Final Visual & Dimensional Check	App DWG/ ASME Sec VIII,IX	Inspection Report	App DWG/ ASME Sec VIII,IX	Type	H	H	W	W	R	
					Date						
					Sign						
B6-10	Hydrostatic and Leak Test	Hydrostatic test procedure	Inspection Report	Hydrostatic test procedure	Type	H	H	H	H	R	
					Date						
					Sign						
B6-11	Final Painting Inspection	App. Painting Procedure Painting project specification	Inspection Report	App. Painting Procedure Painting project specification	Type	H	H	H	H	R	
					Date						
					Sign						
B7 HEAT EXCHANGERS CONDENSOR ECONOMIZER OIL COOLER EVAPORATOR											
B7-1	Material Inspection & Certificate review (Pressure Part)	App DWG Project Documents, Material Standards	Material Certificate / Inspection report 2.2 Certificate for non-pressure Parts	Approved drawings. EN 10204-3.1 Project Documents, Material Standards	Type	H	H	W	W	R	
					Date						
					Sign						



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					SV	V	N	TPI	O/MC		
B7-2	Visual and dimensional check of fabricated heads	App. DWG	Head Dim. Report	Drawing Welding Map	Type	H	H	W	W	R	
					Date						
					Sign						
B7-3	Fit-up and welding of shells and heads	WPS/PQR, WELD MAP	Inspection Report	ASME SEC VIII,IX, Project job specification	Type	H	H	SW	SW	R	
					Date						
					Sign						
B7-4	Marking of nozzles on heads prior to cutting	App. DWG	Inspection Report	Drawing	Type	H	H	W	W	R	
					Date						
					Sign						
B7-5	PWHT (if any)	Procedure	Inspection Report	Procedure	Type	H	H	SW	SW	R	
					Date						
					Sign						
B7-6	PMI test (if any)	Procedure	Inspection Report	Procedure	Type	H	H	SW	SW	R	
					Date						
					Sign						
B7-7	Fit-up and welding of nozzles to heads	App. DWG	Inspection Report	Drawing	Type	H	H	SW	SW	R	
					Date						
					Sign						
B7-8	NDT	Procedure + NDT Map	Inspection Report	Procedure + NDT Map	Type	H	H	RA	R	R	100% RTI & 20% W for Other NDT
					Date						
					Sign						
B7-9	Final Visual & Dimensional Check	App DWG/ ASME Sec VIII,IX	Inspection Report	App DWG/ ASME Sec VIII,IX	Type	H	H	W	W	R	
					Date						
					Sign						



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					SV	V	N	TPI	O/MC		
B7-10	Hydrostatic and Leak Test	Hydrostatic test procedure	Inspection Report	Hydrostatic test procedure	Type	H	H	H	H	R	
					Date						
					Sign						
B7-11	Final Painting Inspection	App. Painting Procedure Painting project specification	Inspection Report	App. Painting Procedure Painting project specification	Type	H	H	H	H	R	
					Date						
					Sign						
B8	BASE FRAME		PT -10 % OF MAJOR STRUCTURAL CONNECTIONS 100 % PT LIFTING LUG WELDS VT and DT	ACC. DATASHEET/ DRAWINGSKID CONNECTION POINTS ANCHOR BOLT POSITIONS INSPECTION /2.2 CERTIFICATE, AWS D1.1	Type	H	H	W	W	R	
					Date						
					Sign						
B9	VALVES		MATERIAL CERTIFICATES 3.1 FOR MAJOR PARTS MANUFACTURER INSPECTION AND TEST RECORD HYDROSTATIC REPORT VT and DT	ACC. DATASHEET/ DRAWING INSPECTION /CERTIFICATE	Type	H	H	SW	SW	R	
					Date						
					Sign						



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						SV	V	N	TPI	O/MC	
B10	PIPING		1. Carbon oil and refrigerant piping 10%. 2. SS Oil and refrigerant piping 10%. 3. Instrument air header 10%. Amount will be based on total amount of welded inches. VT and DT and welding visual check and PMI 100% of Process Piping will be Hydrostatic Tested in Presence of inspector	Material certificates	Type	H	H	W	W	R	100% RTI & 20% W for Other NDT
					Date						
					Sign						
B11	SAFETY VALVES	ASME VIII DIV 1 without U-Stamp	MATERIAL CERTIFICATES 3.1 SET POINT CERTIFICATE CALCULATIONS TEST REPORT	Material certificates	Type	H	H	W	W	R	
					Date						
					Sign						
B12	Smaller components within instrumentation routing, such AS TUBING and GASKETS and bolting.		MATERIAL CERTIFICATES 3.1	Material certificates	Type	H	H	SW	SW	R	
					Date						
					Sign						



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						SV	V	N	TPI	O/MC	
B13	INSTRUMENTATION	MANUFACTURER STANDARD (Pressure and temperature gauges are provided with 2.2 material certificates)	MATERIAL CERTIFICATES 3.1 (Manifolds are provided with 3.1 Material certificates) DIMENSIONAL AND CONSTRUCTION DWG HAZARDOUS AREA CERTIFICATE CALIBRATION REPORT (3.1 material certificates). 3 point calibration		Type	H	H	W	W	R	
					Date						
					Sign						
B14	PLC	MANUFACTURER STANDARD: 1. Software Redundancy 2. Redundancy required for CPU, power supply, communication card 3. Solenoid and On/Off valves will be executed in Exd. 4. Approved project document	BOM, Panel DWG, wiring DWG SAFE AREA project document Number: DPIC9812-000-VD-1002-ME-DIA-0040		Type	H	H	W	W	R	
					Date						
					Sign						
B15	Local control Panel	LCS Wiring and Drawing	Documents Number: DPIC9812-000-VD-1002-ME-DWG-0027		Type	H	H	W	W	R	
					Date						
					Sign						
B16	ELECTRICAL ITEMS	LCS Wiring and Drawing	HAZARDOUS AREA CERTIFICATE Zone 2, IIB T3		Type	H	H	W	W	R	
					Date						
					Sign						



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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY					REMARKS	
					SV	V	N	TPI	O/MC		
C INSPECTION DOCUMENTS, PIPING											
C1	WELDING DOCUMENTS (WPS/PQR/WELDMAP)	ASME B31.3	Report		Type	H	H	R	R	R	
					Date						
					Sign						
C2	WELDER'S QUALIFICATION	ASME IX	Report		Type	H	H	R	R	R	
					Date						
					Sign						
C3	NDE PROCEDURES (UT/RT/MT/PT/HT)	ASME IX	NDT Map		Type	H	H	R/A	R	R	
					Date						
					Sign						
C4	NDT OPERATORS	ASME V	Certificates		Type	H	H	R	R	R	
					Date						
					Sign						
C5	Hydrostatic test procedure	ASME B31.3	Report	Hydrostatic Test Procedure	Type	H	H	R	R	R	
					Date						
					Sign						
C6	SURFACE PREPARATION & PAINTING COATING PROCEDURE	OEM STANDARD / SUPPLIER PROCEDURES	Report	Vendor Specification	Type	H	H	R	R	R	
					Date						
					Sign						



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Item No.	Inspection Description	References / Specifications / Codes	Verifying Document	Acceptance Criteria	INSPECTION ACTIVITY					REMARKS	
					SV	V	N	TPI	O/MC		
D MATERIALS											
D1	VISUAL EXAMINATION AND DIMENSIONAL CHECK OF MATERIALS THICKNESS VERIFICATION	ASME II SA20 / ASME II Part A & C	REPORT OF DIMENSIONAL INSPECTION REPORT	DIMENSIONS SURFACE CONDITION	Type	H	H	W	W	R	
					Date						
					Sign						
D2	MATERIAL CERTIFICATION AND MARKING	ACC. TO PROJECT REQUIREMENTS (REFER TO PROJECT PACKAGE DATASHEET)	MATERIAL MAP	3.1. CERTIFICATE (For pressurized parts) 2.2 CERTIFICATE (For Non-pressurized parts)	Type	H	H	R	R	R	
					Date						
					Sign						
D3	WELDING CONSUMABLES	MANUFACTURER STANDARD	3.1 MATERIAL CERTIFICATE	ASME Sec. II, part C	Type	H	H	W	W	R	
					Date						
					Sign						
D4	NON-PRESSURE RETAINING PARTS	ASMEVIII DIV1 (U-STAMP NOT REQUIRED)	2.2 MATERIAL CERTIFICATE (No PMI requirement for Valves/Internals and equipment)	MANUFACTURING STANDARD	Type	H	H	R	R	R	
					Date						
					Sign						
D5	BOLTING MATERIAL	As per relevant drawings	3.1 MATERIAL CERTIFICATE	Certificate	Type	H	H	W	W	R	
					Date						
					Sign						



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					SV	V	N	TPI	O/MC		
E INSPECTION											
E1	DIMENSIONAL INSPECTION OF SKID CONNECTION POINTS	Drawings	SKID CONNECTION POINTS – ANCHOR BOLT POSITIONS	WITHIN TOLERANCE REPORT / AS BUILT DRAWING	Type	H	H	W	W	R	
					Date						
					Sign						
E2	PARTS AND COMPONENT INSPECTION	MAYEKAWA STANDARD	P&ID COMPONENT (ORDER) LIST		Type	H	H	W	W	R	
					Date						
					Sign						
E3	Air Leak Test of Whole Package	Relevant Procedure	PRESS REPORT ME-F-7.6.0-01-SO72522- Leak test report	MANUFACTURING STANDARD	Type	H	H	W	W	R	
					Date						
					Sign						
E4	PMI Test (Welds)	According to Weld Map-NDT Map (If Applicable)	Report	ASME Sec II Part A & C	Type	H	H	W	W	R	
					Date						
					Sign						
E5	PAINTING	OEM STANDARD/SUPPLIER_ (Painting Standard) PAINT SPECIFICATION	THICKNESS VISUAL INSPECTION and measurement via instrument. PAINT INSPECTION REPORT	ACC SPECIFICATION	Type	H	H	W	W	R	
					Date						
					Sign						
E6	ELECTRICAL WIRING	WIRING CHECK			Type	M	W	W	W	R	
					Date						
					Sign						
E7	INSPECTION OF junction BOX, LOCAL PANEL AND PLC	FACTORY ACCEPTANCE TEST 1.VISUAL INSPECTION JUNCTION BOX, LOCAL PANEL AND PLC 2. CONTINUITY, POWER UP & WET LOOP CHECK 3. FUNCTION TEST (REDUNDANCY, LOGIC)	TEST REPORT FAT TEST PROCEDURE	LOGIC DIAGRAM CONTROL NARRATIVE DRAWINGS, DATA SHEETS	Type	M	H	H	H	R	
					Date						
					Sign						



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					SV	V	N	TPI	O/MC		
E8	FINAL INSPECTION	Vendor STANDARD	NAME PLATES CONFIRMATION	RELEASE NOTE	Type	M	H	H	H	R	
					Date						
					Sign						
F Spare Part											
F1	Material Inspection & Certificate review	App. Spare Part List	Material Certificate / Inspection report	EN 10204-3.1 Project Documents, Material Standards	Type	H	H	W	W	R	
					Date						
					Sign						
G SHIPMENT AND LOADING											
G1	PACKING AND MARKING PREPARATION FOR SHIPMENT DETAILED PACKING LIST AND LOOSE DELIVERY LIST	Packing Procedure	PACKING INSPECTION VISUAL INSPECTION COMPLETENESS CHECK	PACKING LIST	Type	H	H	H	H	R	
					Date						
					Sign						
G2	Inspection of preservation check	-	Report	VENDOR STANDARD	Type	H	H	W	W	R	
					Date						
					Sign						
G3	Manufacturer compliance certificate	-	MCC	-	Type	H	R	R	-	R	
					Date						
					Sign						
G4	Issue of shipping release note	-	SRN	-	Type	R	R	R	H	R	
					Date						
					Sign						
G5	Vendor data book	Final data book, ITP, etc.	A COMPLETE PACKAGE OF INSPECTION AND TEST RECORD/CERTIFICATE MANUFACTURED RECORD	VDB index list	Type	H	H	R/A	R	R	
					Date						
					Sign						



Specification of routine tests on asynchronous machines with squirrel cage rotors

Test item	Standard	Measurement device
Visual control		
Measurement of the DC-resistance of the stator winding at ambient temperature	EN/IEC 60034-2-1	- Microhmmeter - Thermometer
Measurement of the insulation resistance of the stator winding and accessories	EN/IEC 60204-1 EN/IEC 60204-11	- Megaohmmeter - Thermometer
Measurement of the polarisation index of the stator winding (only high voltage machines)	-	- Megaohmmeter
Function test of accessories and sensors	specific	- Multimeter
Direction of rotation	EN/IEC 60034-8	- Visual
Measurement of the shaft voltage at rated voltage and rated frequency at no-load condition	-	- Voltmeter
Measurement of the vibration severity at no-load condition	EN/IEC 60034-14	- Vibration meter
Measurement of the short-circuit characteristic at partial voltage	EN/IEC 60034-2-1	- Power analyser
Measurement of the no-load characteristics	EN/IEC 60034-2-1	- Power analyser
Bearing temperature rise test at rated speed (sleeve bearings only)	-	- Power analyser - Thermometer
Withstand voltage test (high-voltage test) on stator winding (according to customer agreement)	EN/IEC 60034-1	- AC High voltage source
Issuing of a test report / inspection certificate	EN/IEC 60034-1 EN 10204	

Type	Identification	Prepared	Date	Checked	Revision	Status	Sheet
Test Specification	STE01	EB	16/03/2016	PSt	0	C	1/1