





**Gachsaran Polymer Industries Company  
HDPE Plant**



SHEET: 1 OF 5

DATE: 21.Jan.2025



REV.: 00

BY : MO

P.O. No: GPIC-PT-MA-PO-000-3029

**Inspection And Test Plan (ITP) for Refrigerator Package**

P.O. Title: Refrigeration Unit Package

**VENDOR DOC. NO.: VD-GPIC-MA-3029-3029-0003**

**ITEM NO(S): PK6101**

1	<b>SCOPE</b>	This Inspection and Test plan covers all activities that will be carried out in design and fabrication of equipment.
2	<b>LEGEND OF THE TECHNICAL SURVEILLANCE</b>	<p>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 (see inspection activity) of the dedicated inspection activity at least fifteen (15) days in advance.</p> <p>2) (SW)=10% OF TYPE/LOT WITNESSED. Action performed only on a certain number of pieces.</p> <p>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.</p> <p>4) (R/A)=REVIEW OF TECHNICAL DOCUMENTS BEFORE COMMENCEMENT OF CONSTRUCTION. The technical documents shall be reviewed and approved before the commencement of construction</p> <p>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.</p> <p>6) (D) = Vendor Inspection</p>
3	<b>Abbreviations</b>	O= Owner (GPIC)      C= Contractor (EIED)      V= Vendor (HSE/RHINE)      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	R E V
					SUB-VENDOR (SV)	VENDOR (V)	EIED(C)	O/TPI		

**B MATERIAL SELECTION / SUBCONTRACTOR ORDERING (CONTINUE)**

B6	RECEIVER	ASME VIII DIV 1 (U-STAMP NOT REQUIRED) (Welding_Standard)	1) MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS 2.2 WELD FILLER AND NON PRESSURE RETAINING PARTS WPS/PQR – WELDER QUALIFICATIONS WELDING CHECK NDE REPORTS CLEANLINESS TREATMENT RT REQUIREMENT FULL (on pressure retaining parts) PAINTING INSPECTION DIMENSIONAL CHECK HYDROSTATIC TEST	VD-GPIC-MA-3029-3029-0024	H	H	R	R		
	OIL SEPARATOR (WITH COALESCERS)	ASME VIII DIV 1 (U-STAMP NOT REQUIRED)	1) MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS 2.2 WELD FILLER AND NON PRESSURE RETAINING PARTS WPS/PQR – WELDER QUALIFICATIONS WELDING CHECK NDE REPORTS CLEANLINESS TREATMENT RT REQUIREMENT FULL (on pressure retaining parts) DIMENSIONAL CHECK HYDROSTATIC TEST PAINTING INSPECTION	VD-GPIC-MA-3029-3029-0024	H	W	R	R		
	OIL FILTER	ASME VIII DIV 1 (U-STAMP NOT REQUIRED)	1) MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS NDE REPORTS CLEANLINESS TREATMENT INTERNAL INSPECTION (Visual Examination) VISUAL CHECK DIMENSIONAL CHECK HYDROSTATIC TEST PAINTING INSPECTION	VD-GPIC-MA-3029-3029-0024	H	H	R	R		
			MATERIAL CERTIFICATES 3.1 FOR PRESSURE RETAINING PARTS 2.2 WELD FILLER AND NON PRESSURE RETAINING PARTS		H	W	R	R		



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**B MATERIAL SELECTION / SUBCONTRACTOR ORDERING (CONTINUE)**

B7	HEAT EXCHANGERS 1. CONDENSER 2. OIL COOLER 3. ECONOMIZER 4. CHILLER (EVAPORATOR)	ASME VIII DIV 1 (U-STAMP NOT REQUIRED) TEMA	WPS/PQR – WELDER QUALIFICATIONS WELDING CHECK NDE REPORTS CLEANLINESS TREATMENT RT REQUIREMENT FULL (on pressure retaining parts) PAINTING INSPECTION	VD-GPIC-MA-3029-3029-0027	H	H	R	R		
			DIMENSIONAL CHECK		H	H	W	W		
			HYDROSTATIC TEST		H	H	H	H		
B8	BASE FRAME	MANUFACTURER STANDARD Design Suitable for This Series of Compressor	PT -10 % OF MAJOR STRUCTURAL CONNECTIONS 100 % PT LIFTING LUG WELDS 100 % RT BUTT WELDS IN MAJOR SUPPORTING BEAMS	ACC. Vendor DATASHEET/DRAWING  SKID CONNECTION POINTS – ANCHOR BOLT POSITIONS  INSPECTION /CERTIFICATE	D	R	R	R		
B9	VALVES	ASME/MFR STD For Special Valves	MATERIAL CERTIFICATES 3.1 FOR MAJOR PARTS HYDROSTATIC REPORT PAINTING INSPECTION	ACC. Vendor DATASHEET/DRAWING  INSPECTION /CERTIFICATE	D	R	R	R		
B10	PIPING	ASTM	1) CARBON OIL AND REFRIGERANT PIPING 10% . 2) SS Oil AND REFRIGERANT PIPING 10% . 3) INSTRUMENT AIR HEADER10% . AMOUNT WILL BE BASED ON TOTAL AMOUNT OF WELDED INCHES.	MATERIAL CERTIFICATES	D	R	R	R		
B11	SAFETY VALVES	ASME VIII DIV 1 without U-Stamp	MATERIAL CERTIFICATES 2.2 SET PRESSURE TEST REPORT CALCULATIONS TEST REPORT	INSPECTION CERTIFICATE VD-GPIC-MA-3029-3029-0041	D	R	R	R		
B12	Smaller components within instrumentation routing, such as TUBING AND GASKETS and bolting .		MATERIAL CERTIFICATES 3.1	INSPECTION CERTIFICATE	D	R	R	R		
B13	INSTRUMENTATION	Pressure, Temperature and Level Guages and Transmitters are provided with 2.2 material certificates.	MATERIAL CERTIFICATES 2.2 HAZARDOUS AREA CERTIFICATE CALIBRATION REPORT	INSPECTION CERTIFICATE VD-GPIC-MA-3029-3029-0038	D	R	R	R		

**NOTE :** **CERTIFIED COMPLETE:** **ENDORSEMENTS:**



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**C SUBVENDOR INSPECTION DOCUMENTS, PIPING**

C1	WELDING DOCUMENTS (WPS/PQR/WELD MAP)	ASME VIII Div 1, ASME IX Not Applicable			R/A	R	-	-		
C2	WELDER'S QUALIFICATION	ASME IX	CERTIFICATES		R/A	R	R	R		
C3	NDE PROCEDURES (UT/RT/MT/PT/HT)	ASME V 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.	NDT Map		R/A	R	R/A	R		
C4	NDT OPERATORS AND INTERPRETERS QUALIFICATION	ASME V	CERTIFICATES		R/A	R	R	R		
C5	LEAK TEST PROCEDURE (PNEUMATIC AND/OR HYDRAULIC)	ASME VIII DIV. 1	MANUFACTURING STANDARD		R	R	R	R		
C6	MYCOM STANDARD / VENDOR PROCEDURES COATING PROCEDURE	MYCOM STANDARD / VENDOR PAINTING PROCEDURE		VD-GPIC-MA-3029-3029-0063	R	R	R	R		
C7	RUST PRESERVATION PROCEDURE	MANUFACTURER STANDARD			R	R	R	R		

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**E INSPECTION (CONTINUE)**

E3	PMI TEST (WELDS)	According to weld-NDT Map (If applicable)	INSPECTION CERTIFICATE	ASTM	D	W	SW	SW	Time period of PMI will be informed.No specific dates are consider to be informed in advance by Vendor	
E4	PAINTING	MYCOM STANDARD / VENDOR PAINTING PROCEDURE	THICKNESS VISUAL INSPECTION AND MEASUREMENT VIA INSTRUMENT. PAINT INSPECTION REPORT	VD-GPIC-MA-3029-3029-0063	D	W	R	W		
E5	INSTRUMENT WIRING	MANUFACTURER STANDARD	Instrument, Junction Box and Local Control Panel location and Cable Routing Layout	VD-GPIC-MA-3029-3029-0047	D	W	R	R		
E6	INSPECTION OF JUCTION BOX, LOCAL PANEL AND PLC	FACTORY ACCEPTANCE TEST FOR PLC 1) VISUAL INSPECTION JUNCTION BOX, LOCAL PANEL AND PLC 2) CONTINUITY, POWER UP & WET LOOP CHECK	TEST REPORT FAT TEST PROCEDURE	VD-GPIC-MA-3029-3029-0037	D	W	W	W		
E7	RUST PREVENTION FOR STORAGE	VENDOR STANDARD	NITROGEN CHARGING -0.5 BAR	VD-GPIC-MA-3029-3029-0007	D	D	R	R		
E8	FINAL INSPECTION		NAME PLATES CONFIRMATION	RELEASE NOTE	D	H	H	H		
E9	APPROVAL OF CONCESSION REQUEST AND NON-CONFORMANCE REPORTS				D	R	R/A	R/A		

**F SHIPMENT AND LOADING**

F1	PACKING AND MARKING PREPARATION FOR SHIPMENT DETAILED PACKING LIST AND LOOSE DELIVERY LIST	PACKING INSPECTION	PACKING INSPECTION: VISUAL INSPECTION COMPLETENESS CHECK PACKING LIST	VD-GPIC-MA-3029-3029-0007	D	H	R	R		
F2	DOCUMENTATION	S PER APPROVED VPIS INCLUDING FINAL DATA BOOK, ITP, ET	A COMPLETE PACKAGE OF INSPECTION AND TEST RECORD/CERTIFICATE MANUFACTURED RECORD	VPIS & REPORTS	D	R/A	R/A	R/A		

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