











OWNER:  شرکت سست و سویی گستر ایران (سهامی خاص)	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT						EPC CONTRACTOR:  Chagalesh-Enerchimi-Steam Joint Venture BUPC-MEG PLANT PROJECT		
	MC :  شرکت سست و سویی گستر ایران (سهامی خاص)	Hydrostatic/ pneumatic test procedure for reciprocating compressor							
Owner Document Number: 17811-17		Project	Area	Phase	Unit	Dis.	Doc.	Seq.	Contract No : 52-98/445
	BU	20	VD	303	QC	PRC	0006	Rev.: 01	Page 1 of 5

Hydrostatic/ pneumatic test procedure for reciprocating compressor

		BUSHEHR PETROCHEMICAL COMPANY MEG PLANT
Document Review		
Issue Purpose:	AFC	
Result Code: AP,AN,CM,RE,NC	AP	
Next Status : IFC,IFA,IFI,AFC,AB,IFR	~	
Responsible Department	INSPECTION	
Commented Date	12/1/2021	
Approval or review hereunder shall not be construed to relieve Vendor / Subcontractor of his responsibilities and liability under the contract.		





01	16/11/2021	Approve For Construction	KP	JR	PW	
00	16/11/2020	For approval	KP	JR	PW	
Rev.	Date	Purpose of Issue	Prepared	Checked	Approved	AC Code
					Class: 1	Phase: P

OWNER:  شرکت مست و سویی گیس ایران (سهامی خاص)	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT						EPC CONTRACTOR:  Chagalesh-Enerchimi-Steam Joint Venture BUPC-MEG PLANT PROJECT		
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MC :  شرکت سست و سویی توود ایران (سهامی خاص) SSTI	Hydrostatic/ pneumatic test procedure for reciprocating compressor						Contract No : 52-98/445		
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Hydrostatic test

This procedure is applicable to all items subject to a hydrostatic test. Refer to project Inspection & Test Plan for the items subject to a hydrostatic test.

Following procedures will be maintained before and during testing:

- Before test, tested equipment will be inspected properly by the Airpack quality manager.
- Two calibrated pressure gauges will be installed on the **highest and lowest position** clearly readable. **Calibration is valid for one year as per ISO9001 procedures.**
- Test pressure will be between 50% and 75% of range of used pressure gauges (where possible)
- Used gauges are direct reading type and pressure should be stable during testing.
- Duration of test will be 30 minutes as required per authorities code (ASME B31.3 for piping and ASME VIII latest edition for vessels)
- Prior to carrying out the hydrostatic test, weld of reinforcing pad will be leak tested (max 1 bar(g)) by air via tell tail hole and inspected with soap and water (if applicable).
- All oil, grease, dirt and foreign material will be removed.
- Start and end pressure will be recorded by hand during hydro test.
- **Gaskets used during the hydrostatic should be of the same design as the ones used for final assembly**
- **During the Hydrostatic test no pressure drop and leakage should be observed.**

Below Items are tested separately, no complete hydrostatic test of package is done.

Air piping (carbon steel)





This test is executed by Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 200 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure: 1.5x design pressure.

Vessels (carbon steel)

This test is executed by sup-supplier or Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 200 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.





Hydrostatic test pressure: 1.5x design pressure.

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After test,

- o Equipment must be free from any unexpected condition
- o Equipment will be dried and cleaned appropriately. Stainless steel will be cleaned by pressurized air.
- o Witnessed test report shall be issued by QA department.

Hydrostatic test will be done after completion of all welding and before any painting activities

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AIRPACK NEDERLAND B.V.
 GROENEWEEGJE 25
 4301 RN ZIERIKZEE
 THE NETHERLANDS

HYDROSTATIC TEST CERTIFICATE

Customer :
 Purchase Order number :
 Equipment :
 Airpack reference :
 Serial number :
 Date :

We certify that the here under mentioned test data is true and correct.
 The test procedure is in accordance with ASME B31.3 & Hydrostatic Test Procedure doc number :
 18377-17

Subject name :
 Subject number :
 Drawing no. :
 Test no. : 01 of 0X

HYDROSTATIC TEST:

Fluid :
 Test date :
 Constant during : 30 min.
 Test pressure :

RECORDED PRESSURES

Start pressure :
 End pressure :
 Test pressure gauge number :
 Remarks (If any) :
 In presence of :

Airpack Approval:

Customer Approval: