

Jensen Steel Fabricators Limited	OPERATING PROCEDURES SITE	OPE 009	Rev:0
QMS - E	Inspection and Test Plan - Erection (ITP-E)	Approved: LT	Date: 11.03.2024

Project	ESM #:	Engineer	Client			Prepared by: Approved by:			
Abbreviations	C = Client, CNC = client nominated consultant, F = Fabricator, I = Client Nominated Inspector								
Control categories	H= Hold Point, I= Inspect, W= Witness, R= Review, S= Survey, A = Approve								
DESCRIPTION	CONTROL	ACCEPTANCE CRITERIA	QMS Ref	RESPONSIBILITY	ESM/STAGE/Frequency	RECORDS/REPORTS	Inspected by: signature & date		
Risk assessment	H	AS/NZS 5131 11.2.4	OPE 004			Site Safety Plan	F	C/I	
Erection design (stability check)	H	11.4	OPE 007	Site Supervisor	All				
Site survey	S	11.3	OPE 007 / OPE 017	Site Operations Manager, Site Supervisor/ Independent Surveyor		Record			
Delivery and storage	I	11.5.6	OPE 007, OPE 008	Site Supervisor					
Temporary erection	R	11.5.10	OPE 007 / OPE 018						
Permanent supports	H, S, I	11.6.1	OPE 007 / OPE 018			Report			
Temporary supports, props – doc survey and inspection report	S, R	11.5.2, 3 11.6	OPE 007 / OPE 018 / OPE 011			Report			

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Installation of bolted connections - Snug tightening (S)	I	8.3, 8.5.1, 13.7	OPE 008 / OPE 011-5 / OPE 023	Bolting Supervisor		Report		
Tensioning of bolted connections – Bearing Type (TB)	I	8.3, 8.5.1, 13.7	OPE 008 / OPE 011-5 / OPE 023	Bolting Supervisor		Report		
Tensioning of bolted connections – Friction Type (TF)	I	8.4.2, 13.7	OPE 008 / OPE 011-5 / OPE 023	Bolting Supervisor		Report		
Mechanical and chemical anchors	I	8.8.3	OPE 008 / OPE 023/ OPE 011	Site Supervisor		Report		
Thin gauge components	I	8.6	OPE 008 / OPE 023/ OPE 011	Site Supervisor		Report		
Removal of braces, props, frames etc.	H, A	11.5.5	OPE 008 / OPE 011	Site Operations Manager / Site Supervisor		Record		
Site welding	I	7	OPE 008 / OPE 017	Site Supervisor				
Erection and Assembly tolerances	I	13.4 Appendix F	OPE 008 / OPE 011 / OPE 017	Site Supervisor		Report		

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Repairs to painted surfaces	I	9.12	OPE 017	Site Supervisor		Report		
Completion Final inspection	I	13.11	OPE 011	Site Supervisor / Client / Quality Manger		Report		
Completed QA documentation	I	Client's specification	OPE 015, OPE 011	Quality Manager		Report		
Final sign off	P							