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|  | **Inspection & Test Plan (ITP)**  **Doc No: Area Code:** | JOB NUMBER  PVE1049 |

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| **Process Steps** | | | | | | | | | |
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| **Fabrication** | **Machining** | | **Automation** | | **QA / QC** | | **Stores** |
| **No** | **Activity** | **Reference Documents** | | **Quality** | | | | | |
| **Hold**  **Point** | **Sign** | **ID** | | **Witness** | **Date** |
| 1 | Inspect all pipe & fittings are correct to job requirements and no signs of damage |  | | W | LS |  | | AG | 8/01/2024 |
| 2 | Familiarise yourself with the job |  | |  | AK |  | |  | 12/01/2024 |
| 3 | Setup worksite, welding equipment & rollers |  | |  | AK |  | |  | 12/01/2024 |
| 4 | Load length into rollers |  | |  | AK |  | |  | 14/01/2024 |
| 4 | Bevel pipe ends |  | |  | AK |  | |  | 14/01/2024 |
| 5 | Tack weld 6m lengths into instructed lengths |  | |  | AK | AK1 | |  | 20/01/2024 |
| 6 | Check for straightness alignment |  | | C | AK |  | | AG | 18/01/2024 |
| 7 | Setup purge baloons & purge with nitrogen |  | | C | AK |  | | AG | 18/02/2024 |
| 8 | Peform butt welds |  | |  | AK | AK1 | |  | 18/02/2024 |
| 9 | Tack flanges on spool lengths & check for square |  | | C | AK | AK1 | | AG | 18/02/2024 |
| 10 | Weld flanges on ends |  | |  | AK | AK1 | |  | 18/02/2024 |
| 11 | Passivate all welds |  | |  | AK |  | |  | 18/02/2024 |
| 12 | Remove from rollers and move to lay down area |  | |  | AK |  | |  | 8/03/2024 |
| 13 | Final inspection |  | | H | AG |  | |  | 20/06/2024 |
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