

# VRISHAL ENGINEERING PRIVATE LIMITED



## Inspection and Test Plan (ITP) for Structural Fabrication & Erection

PROJECT : H2O2 STRUCTURE PROJECT

CLIENT: DCM SHRIRAM, JHAGADIA

PO For Site Work :- 4250010029

PO For Shop Work :- 4250010030

DOCUMENT NO : VEPL/DCM/ITP/001

*[Handwritten signatures]* 13.07.2022

3	09.07.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	<i>[Signature]</i> H.T NAIK	MADHUR SHARMA
02	25.06.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	<i>[Signature]</i> H.T NAIK	MADHUR SHARMA
01	30.05.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	<i>[Signature]</i> H.T NAIK	-
0	20.05.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	<i>[Signature]</i> H.T NAIK	-
REV	DATE	DESCRIPTION (ISSUE PURPOSE)	PREP'D BY / VEPL	REW'D BY / VEPL	APR'D BY / DCM

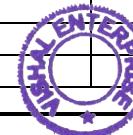




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Document no: VEPL/DCM/ITP/001		Revision: 03		Date :- 09.07.2022		
SR NO	Operation (Inspection / Test Activity)	Reference Document	Verification Document	Inspection Authority		REMARKS
				Manufacturer (VEPL)	CLIENT (DCM) / TPIA	
1.1	Pre-Fabrication Meeting	Scope Of Work / Geeneral Requirements	Minutes of Meeting	P	P	
<b>DOCUMENT VERIFICATION</b>						
2.1	Review of Drawing from client	GADS	GADS	H	-	
2.2	WPS & PQR	AWS D1.1 / ASME Sec IX	WPS/PQR	H	R	CLIENT/TPIA WILL WITNESS FOR NEW PROCEDURE
2.3	Welder Qualification Certificates	AWS D1.1 / ASME Sec IX	WQT Certificates	H	R	CLIENT/TPIA WILL WITNESS FOR NEW WPQ
2.4	Applicable Procedures	CLIENT SOPs, Contarct Documents	Procedures	H	R	
2.5	Review of fabrication drawings + Model	Fabrication drawings + Model	Fabrication drawings + Model	H	A	FABRICATION DRAWING APPROVAL FROM DCM TCE
<b>MATERIAL</b>						
3.1	Verification of Incoming Project Material	Purchase Order / Delivery Note / Client Spec / MTC	IMIR REPORT VE/QA/FORMAT/18	H	RW	IMIR DOCUMENT WILL BE REVEIWED BY DCM
3.2	Material & Welding Consumable Test Certificate	Purchase Order / Delivery Note / Client Spec / MTC	IMIR REPORT (WELDING CONSUMABLE) VE/QA/FORMAT/02	H	RW	
<b>FABRICATION</b>						
4.1	Material Identification	Review of Documents	-	H	S	
4.2	Weld-Edge Preparation & Fit-Up	Physical Verification	Fit-up Inspection Report VE/QA/FORMAT/19	H	RW	
4.3	Welding Surveillance	Approved WPS	Spot Check Report VE/QA/FORMAT/41	H	S	
4.4	Visual Examination of Welds	AWS D1.1 / Client Spec / Approved WPS	Weld Visual Inspection Report VE/QA/FORMAT/20	H	RW	
4.5	Final Dimensional Check	AWS D1.1 / Client Spec	Final Inspection Report VE/QA/FORMAT/20	H	W	
03	09.07.2022	ISSUED FOR CLIENT APPROVAL		HARDIK PRAJAPATI	H.T NAIK	MADHUR SHARMA
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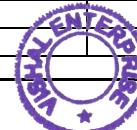




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Document no: VEPL/DCM/ITP/001			Revision: 03			Date :- 09.07.2022			
SR NO	Operation (Inspection / Test Activity)	Reference Document	Verification Document	Inspection Authority		REMARKS			
				Manufacturer	CLIENT (DCM) / (VEPL)				
<b>SURFACE PREPARATION: BLASTING &amp; PAINTING</b>									
5.1	Verification Incoming Paint Material	Purchase Order / Delivery Note / Client Spec / Product Data sheet / MTC	IMIR REPORT (PAINT MATERIAL) VE/QA/FORMAT/03	H	RW				
5.2	Surface Preparation	CLIENT Specs / Procedures	Surface Preparation & Painting report VE/QA/FORMAT/23	H	W				
5.3	Paint Application	CLIENT Specs / Procedures		H	W				
5.4	Final DFT	CLIENT Specs / Procedures		H	W				
5.5	Final Visual Check	CLIENT Specs / Procedures		H	W				
<b>INSPECTION CLEARANCE</b>									
6.1	Inspection Clearance	Document Verification / Final Dimension Report / Painting Report	Inspection Release Note (IRN) VE/QA/FORMAT/30	H	H				
<b>ERCTION</b>									
7.1	Ensure readiness of civil foundations/ pedestals prior to structure erection. Verification of pedestal dimensions and level.	As per the applicable Code / Client Requirements	-	H	W				
7.2	Alignment and Verticality of each column segment and tightness of foundation bolts	As per the applicable Code / Client Specs	Alignment Inspection Report VE/QA/FORMAT/31	H	RW	SAMPLE SIZE WILL BE DECIDED BY DCM			
7.3	Tightening of erection bolts between the structure members	As per the applicable Code / Client Specs	Torquing Inspection Report VE/QA/FORMAT/32	H	RW				
7.4	Field welding of column splice plates, tie-beam/ bracing supports	As per the applicable Code / As per Contract	Site Fitup-Welding Inspection Report VE/QA/FORMAT/34	H	RW				
7.5	Structure release for erection of piping and equipments	As per the applicable Code / As per Contract	Structural Steel Release Note For Equipment/Piping/Structural Erection VE/QA/FORMAT/33	H	H	IRN WILL BE APPROVED BY DCM (FINAL HAND OVER CLEARANCE)			
<b>Abbreviation :</b>									
1	W : Witness Point : Activity shall be performed in presence of CLIENT, If CLIENT/TPI is present. If the CLIENT is absent Activity will proceed. CLIENT/TPI shall be given intimation in either writing or verbal.								
2	RW : Random Witness : Activity shall be 10% Randomly witnessed by CLIENT, If CLIENT/TPI is present. If the CLIENT is absent Activity will proceed. CLIENT/TPI shall be given intimation in either writing or verbal.								
3	R : Review : Documents shall be reviewed 100%								
4	S : Surveillance : QC will do surveillance during yard/site visit		A : Approval of Document						
5	H : Hold : Work shall not proceed without written clearance of QC.								
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**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED  
GROUP OF COMPANIES  
INWARD MATERIAL INSPECTION REPORT (STRUCTURAL)**

CLIENT			PROJECT				IMIR NO				
PO/WO NO			ITP NO				DATE				
SR. NO.	ITEM	DESCRIPTION	SIZE & THK	SPECIFICATION	MANUFACTURER / VENDOR	UNIT	QTY	HEAT / LOT NO	TC NO.	PO / INVOICE NO	REMARKS
<b>REMARK</b>											
	VE -QC			CLIENT QC / ENGINEER							
SIGNATURE											
NAME											
DATE											
VE/QA/FORMAT/18 REV.2											





## VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES

### INWARD MATERIAL INSPECTION REPORT (WELDING CONSUMABLES)

CLIENT :		PROJECT:			IMIR NO			
PO / WO NO. :		PROCEDURE NO.:			DATE			
SR. NO.	CONSUMABLE	BRAND	DESCRIPTION	SIZE	BATCH NO	SFA NO	DATE OF MANUFACTURE	REMARKS
REMARK:								
	VE-QC				CLIENT QC / TPI			
SIGNATURE								
NAME								
DATE								

VE/QA/FORMAT/02 REV.2





**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED  
GROUP OF COMPANIES**

**FIT-UP INSPECTION REPORT (STRUCTURAL)**

<b>CLIENT</b>		<b>Report No</b>	
<b>PROJECT</b>		<b>Date</b>	
<b>WO NO</b>			

<b>S No</b>	<b>Drawing No</b>	<b>Rev</b>	<b>ITEM NO</b>	<b>Qty (Nos)</b>	<b>JOINT NO</b>	<b>ITEM 1</b>			<b>ITEM 2</b>			<b>WPS NO</b>	<b>Remarks</b>
						<b>ITME 1</b>	<b>HEAT NO</b>	<b>IMIR NO</b>	<b>ITME 2</b>	<b>HEAT NO</b>	<b>IMIR NO</b>		

**QC CHECK SHEET**

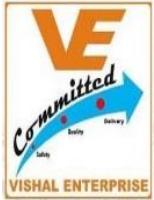
**CHECKED**

**X NOT APPLICABLE**

<b>DOCUMENT VERIFICATION</b>		<b>VERIFICATION OF MARKINGS</b>			<b>INSPECTION CHECK</b>				
<input type="checkbox"/> APPROVED DRG./ DCN WITH LATEST REV.	<input type="checkbox"/> DRG. No.& REV.	<input type="checkbox"/> PART No	<input type="checkbox"/> JOINT NO.		<input type="checkbox"/> DIMENSIONS / WRAP DIMENSION	<input type="checkbox"/> PHYSICAL CONDITION	<input type="checkbox"/> VERTICALITY		
<input type="checkbox"/> MAT.PART IDENTIFICATION REPORT DULY SIGNED					<input type="checkbox"/> DIRECTION & ORIENTATION	<input type="checkbox"/> SLOPE	<input type="checkbox"/> LEVEL	<input type="checkbox"/> STRAIGHTNESS	
<input type="checkbox"/> APPROVED WPS					<input type="checkbox"/> DIAGONAL	<input type="checkbox"/> ELEVATION		<input type="checkbox"/> PERPENDICULARITY	

**Remark:-**

	<b>VE QC</b>		<b>CLIENT QC / TPI</b>
<b>Signature</b>			
<b>Name</b>			
<b>Date</b>			
VE/QA/FORMAT/19 REV.1			



# SPOT CHECK REPORT

<b>Observation Made By :</b>		<b>Location/Area :</b>		<b>Date/ Shift :</b>																									
Manpower Supplier																													
Project Number																													
Applicable WPS																													
Welder Name/ Stamp																													
Welding Process		SMAW/SAW/FCAW/GTAW/GMAW/Others																											
Description of weld/Welding																													
Materials/ Thickness (mm)																													
PARAMETERS	SPECIFIED IN SWP/WPS/ DRG.		ACTUAL OBSERVATION																										
Consumable Type/Size																													
Preheat Temperature (°C)																													
Inter-pass Temperature (°C)																													
Current (A)																													
Voltage (V)																													
Travel Speed (mm/min)																													
Bevel Angle (degree)																													
Fillet Size (mm)																													
Shielding Gas Flow (LPM)		Purging?		<b>Y</b>	<b>N</b>	<b>NA</b>																							
Welding Position		Qualified to Weld?		<b>Y</b>	<b>N</b>	<b>NA</b>																							
M/C Calibration Valid?		<b>Y</b>	<b>N</b>	<b>NA</b>	Portable Oven hot?		<b>Y</b>	<b>N</b>	<b>NA</b>																				
Welding Cable/ Earthing Lug		<b>OK</b>	<b>NOT OK</b>		Is Stub In Available?		<b>Y</b>	<b>N</b>	<b>NA</b>																				
Post Heating Temperature OK?		<b>Y</b>	<b>N</b>	<b>NA</b>	Is Joint clean?		<b>Y</b>	<b>N</b>	<b>NA</b>																				
Electrode Stub Length OK?		<b>Y</b>	<b>N</b>	<b>NA</b>	Restart ground?		<b>Y</b>	<b>N</b>	<b>NA</b>																				
Any Arc Strike?		<b>Y</b>	<b>N</b>	<b>NA</b>	Welder Stamp Punched?		<b>Y</b>	<b>N</b>	<b>NA</b>																				
Thermal Check Available for Preheat/Inter-pass?		<b>Y</b>	<b>N</b>	<b>NA</b>	High Frequency Unit Available for GTAW?		<b>Y</b>	<b>N</b>	<b>NA</b>																				
Welder Identification Card Available?						<b>Y</b>	<b>N</b>	<b>NA</b>																					
<b>CORRECTIVE ACTION TO BE TAKEN:</b>																													
Witness Engineer																													
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**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED  
GROUP OF COMPANIES**

**WELD VISUAL & FINAL DIMENSION INSPECTION REPORT (STRUCTURAL)**

CLIENT:								REPORT NO:			
PROJECT:			PO/WO NO.:					DATE:			
SR NO	FAB. DRAWING NO. & REVISION NO.	ITEM NO. / TAG NO	TYPE OF JOINT	WELDING PROCESS	WPS NO.	WELDER NO.	ACTUAL DIMENSION	FIT-UP REPORT NO.	RESULT	REMARKS	
QC CHECK SHEET			<input checked="" type="checkbox"/> CHECKED	<input type="checkbox"/> X NOT APPLICABLE							
DOCUMENT VERIFICATION		MARKING VERIFICATION CHECK	WELD SURFACE DEFECT CHECK						VISUAL CHECK		
<input type="checkbox"/> APPROVED NDT DRG./TESTPLAN WITH LATEST REV. <input type="checkbox"/> QUALIFIED WELDER LIST <input type="checkbox"/> APPROVED WPS		<input type="checkbox"/> JOINT NO. <input type="checkbox"/> WELDER NO.	<input type="checkbox"/> SPATTER <input type="checkbox"/> REINFORCEMENT <input type="checkbox"/> UNDER CUT <input type="checkbox"/> LUMPS/HIGH SPOT	<input type="checkbox"/> POROSITY/PIN HOLES <input type="checkbox"/> BEAD APPEARANCE/WEAVING	<input type="checkbox"/> SLAG <input type="checkbox"/> CRACK <input type="checkbox"/> WELD SIZE <input type="checkbox"/> UNDER FILL	<input type="checkbox"/> ARC STRIKE <input type="checkbox"/> DISTORTION <input type="checkbox"/> CLEAT MARK <input type="checkbox"/> CORNER SEALING/ROUNDING <input type="checkbox"/> PHYSICAL CONDITION					
		STATUS		SR NO.							
		ACCEPT									
		RECTIFY & REOFFER									
REJECT											
VE QC		CLEMENT-QC/TPI									
SIGNATURE											
NAME											
DATE											
VE/QA/FORMAT/20 REV.2											





## VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES

### INWARD MATERIAL INSPECTION REPORT (PAINT)

CLIENT :		PROJECT:						IMIR NO			
PO / WO NO. :		PROCEDURE NO.:						DATE			
SR. NO.	ITEM DESCRIPTION	PAINT DETAILS	SHADE	BATCH NO.	BASE/HARDNER	MANUFACTURER / VENDOR	UNIT	QTY.	T.C NO./ INVOICE NO.	P.O NO	REMARKS
<b>REMARK</b>											
	VE-QC				CLIENT-QC/TPI						
SIGNATURE											
NAME											
DATE											
VE/QA/FORMAT/03 REV.2											

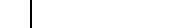




**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED  
GROUP OF COMPANIES**

# **SURFACE PREPARATION & PAINTING REPORT (STR)**

**NOTE:**

	VE QC	CLIENT QC / TPIA
SIGN		
NAME		
DATE		
VE/QA/FORMAT/23 REV.2		

VE/QA/FORMAT/23 REV.2





**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED**  
**GROUP OF COMPANIES**  
**INSPECTION RELEASE NOTE**

CLIENT				REPORT NO.			
PROJECT				DATE			
WO NO.							
SR. NO	DRAWING NO.	REV NO.	TAG NO	QTY	FINAL INSPECTION REPORT	PAINTING REPORT	REMARKS
	VE QC			CLIENT QC/TPI			
SIGNATURE							
NAME							
DATE							
VE/QA/FORMAT/30 REV.2							





# VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED

## GROUP OF COMPANIES

### ALIGMENT INSPECTION REPORT OF STRUCTURE

LOCATION :				UNIT			REPORT NO :				
DRAWING NO :				TITLE			DATE :				
FOUNDATION PEDESTALS: Bench mark/Datum Mark is Avilable Orientation,level, Distance and Diognal of The pedestal were cheked Foundation bolt condition and Pitch Distance were cheked								(V/x)			
PLUMNESS/VERTICALITY AND ELEVATION OF COLUMNS:											
COLUMN NO	COLUMN HEIGHT	COLUMN TOP ACTUAL IN MM	PLUMBING/VERTICALITY/Difference in MM				PLUMBING/ VERTICALITY/ Difference in MM	BOBP ELEVATION		RESULT	REMARK
			N	S	E	W		Required (MTR)	Actual (MTR)		
Acceptance limit: verticality : 1mm per 1mtr up to maximum of 35mtr, maximum limit is 35mm beyond 35mtr BOBP Elevation : ± 5mm(Max)										(V/x)	
All field weld done and fillet weld thikness cked Non - Destructive testing was done on field joints ,if any Tourqeing of high tensile bolts cheked as per drawing/desgin requirments Gourting of column pockets and base plate complted										(V/x)	
Note: final inspection was done: The structure is releas for piping and Equipments eaection											
	VE EXECUTION		VE QC			CLIENT / TPI					
SIGNATURE											
NAME											
DATE											
VE/QA/FORMAT/31 REV.2											



**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED  
GROUP OF COMPANIES**

**TORQUING INSPECTION REPORT**

CLIENT		AREA/BLOCK		REPORT NO	
PROJECT		WO NO		DATE	
Bolt diameter for Bolt class 8.8 of IS 3757	Torque to be Applied (Nm)				

Machine used for Torquing (Tick) : Electrical / Torque wrench

Physical Observation : Please mention Column / Floor wise details

Column No	Splice Joint Torque	Base Plate Joint torque	Column Height	Torque to be Applied Bolt size	Torque to be Applied (Nm)/Range	Torque Machine By Named to Apply	OBSERVATION	ACCEPT REJECTED
Released for :								

Remarks :

	VE EXECUTION	VE QC	CLIENT / TPI
signature :			
Name :			
Date :			





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**SITE FITUP-WELDING INSPECTION REPORT**



# VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED

## GROUP OF COMPANIES

### Structural Steel Release Note For Equipment/Piping/Structural Erection

PROJECT :		CLIENT:		
REPORT NO :		DATE :		
DRG NO :		AREA :		
SR NO	ACTIVITY DESCRIPTION	OBSERVATION	Acc/Rej	Remarks
1	Availability of civil foundation released for Erection of structural member, piping and Equipments			
2	Pre-Erection Damage check of stell			
3	Structural Steel items Marking, orientation and erection of steel work as erection deg.			
4	Material Type And Anchor fasteners, bolts and nuts, bolts, as per drg			
5	Anchor fasteners tightened and locknuts provide as per drg			
6	Torquing of high strengthen bolts if reqired			
7	Verticality of erected structural member (records readings)			
8	All load bearing members related to the strength of the structural installed as per drg			
9	visual inspection of filed welds. Ndt if applicable			
10	Grouting complted to base plates			
11	Painting of underside of base plates and incaccessible surfacees			
12	Final dimension inspection of steel structural installed as per drg			
Released For				

MARKS:

	HANDED OVER BY	TAKEN OVER BY
SIGNATURE :		
NAME :		
Date :		
DEPARTMENT :	CLIENT	
SIGNATURE :		
NAME :		
Date :		


  
 VE VISHAL ENTERPRISE  
 QA/QC

VE/QA/FORMAT/33 REV.1