

VRISHAL ENGINEERING PRIVATE LIMITED



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

PROJECT : H2O2 STRUCTURE PROJECT

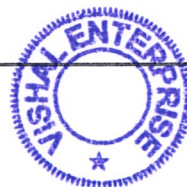
CLIENT: DCM SHRIRAM, JHAGADIA

PO For Site Work :- 4250010029

PO For Shop Work :- 4250010030

DOCUMENT NO : VEPL/DCM/ITP/001

<div><div><div></div><div></div><div></div></div><div>13.07.2022</div></div>					
3	09.07.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	H.T NAIK	MADHUR SHARMA
02	25.06.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	H.T NAIK	MADHUR SHARMA
01	30.05.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	H.T NAIK	-
0	20.05.2022	ISSUED FOR CLIENT APPROVAL	HARDIK PRAJAPATI	H.T NAIK	-
REV	DATE	DESCRIPTION (ISSUE PURPOSE)	PREP'D BY / VEPL	REW'D BY / VEPL	APR'D BY / DCM
PAGE 1 OF 3					

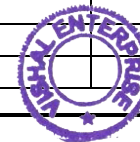




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CLIENT: DCM SHRIRAM, JHAGADIA			PROJECT: H2O2 STRUCTURE PROJECT		PO For Site Work :- 4250010029 PO For Shop Work :- 4250010030	
Document no: VEPL/DCM/ITP/001			Revision: 03		Date :- 09.07.2022	
SR NO	Operation (Inspection / Test Activity)	Reference 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	
DOCUMENT VERIFICATION						
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
MATERIAL						
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 REVEIUED 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	
FABRICATION						
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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Document no: VEPL/DCM/ITP/001			Revision: 03		Date :- 09.07.2022	
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				Manufacturer (VEPL)	CLIENT (DCM) / TPIA	
SURFACE PREPARATION: BLASTING & PAINTING						
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	
INSPECTION CLEARANCE						
6.1	Inspection Clearance	Document Verification / Final Dimension Report / Painting Report	Inspection Release Note (IRN) VE/QA/FORMAT/30	H	H	
ERECTION						
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)
Abbreviation :						
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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REV	DATE	DESCRIPTION (ISSUE PURPOSE)	PREP'D BY / VEPL	REW'D BY / VEPL	APR'D BY / DCM	



QA/QC



QA/QC



VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES

FIT-UP INSPECTION REPORT (STRUCTURAL)

CLIENT		Report No	
PROJECT		Date	
WO NO			

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

QC CHECK SHEET

CHECKED

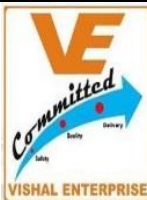
X NOT APPLICABLE

DOCUMENT VERIFICATION	VERIFICATION OF MARKINGS	INSPECTION CHECK
<input type="checkbox"/> APPROVED DRG./ DCN WITH LATEST REV. <input type="checkbox"/> MAT.PART IDENTIFICATION REPORT DULY SIGNED <input type="checkbox"/> APPROVED WPS	<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"/> DIRECTION & ORIENTATION <input type="checkbox"/> SLOPE <input type="checkbox"/> LEVEL <input type="checkbox"/> STRAIGHTNESS <input type="checkbox"/> DIAGONAL <input type="checkbox"/> ELEVATION <input type="checkbox"/> PERPENDICULARITY

Remark:-

	VE QC	CLIENT QC / TPI
Signature		
Name		
Date		





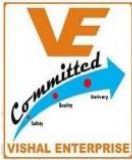
SPOT CHECK REPORT

Observation Made By :		Location/Area :		Date/ Shift :				
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?	Y	N	NA	
Welding Position				Qualified to Weld?	Y	N	NA	
M/C Calibration Valid?		Y	N	NA	Portable Oven hot?	Y	N	NA
Welding Cable/ Earthing Lug		OK	NOT OK		Is Stub In Available?	Y	N	NA
Post Heating Temperature OK?		Y	N	NA	Is Joint clean?	Y	N	NA
Electrode Stub Length OK?		Y	N	NA	Restart ground?	Y	N	NA
Any Arc Strike?		Y	N	NA	Welder Stamp Punched?	Y	N	NA
Thermal Check Available for Preheat/Inter-pass?		Y	N	NA	High Frequency Unit Available for GTAW?	Y	N	NA
Welder Identification Card Available?					Y	N	NA	
CORRECTIVE ACTION TO BE TAKEN:								
Witness Engineer								
Correction Done								





QA/QC



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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
REMARK											
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)

CLIENT		PROJECT		REPORT NO	
WO NO		ITP NO		DATE	

WEATHER CONDITION											
TIME	8:30	9:30	10:30	11:30	12:30	13:30	14:30	15:30	16:30	17:30	18:30
DEW POINT° C											
METAL TEMP° C											
REL. HUMIDITY %											
AMBIENT TEMP° C											

SURFACE CONDITION					
ORIGINAL STATUS		METAL CONDITION		METAL RUST GRADE	

SURFACE PREPARATION					
METHOD		PREP. STANDARD			
ABRASIVE TYPE		ABRASIVE BRAND		ABRASIVE BATCH	
SURFACE PROFILE		PROFILE RANGE		INSTRUMENT	
MILL SCALE		SALT TEST REQUIRED		SALT TEST READING	
DUST LEVEL					

PRIMER COATING					
PRIMER PAINT/SHADE		APP. METHOD		PRIMER DATE	
PAINT MANUFACTURER		BASE		HARDNER	
PRIMER PAINT IMIR NO		MANUFACTURE DATE		SHELF LIFE	
DFT RANGE		PAINTING SYSTEM			

INTERMEDIATE COATING					
INTERMEDIATE PAINT/SHADE		APP. METHOD		PRIMER DATE	
PAINT MANUFACTURER		BASE		HARDNER	
PAINT IMIR NO		MANUFACTURE DATE		SHELF LIFE	
DFT RANGE		PAINTING SYSTEM			

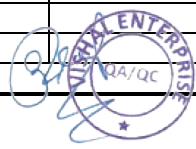
FINAL COATING					
FINAL PAINT/SHADE		APP. METHOD		PRIMER DATE	
PAINT MANUFACTURER		BASE		HARDNER	
PAINT IMIR NO		MANUFACTURE DATE		SHELF LIFE	
DFT RANGE		PAINTING SYSTEM			

SR. NO.	DRAWING NO.	TAG NO	QTY	Average DFT			REMARKS
				PRIMER	INTERMEDIATE	FINAL	

NOTE:

VE QC		CLIENT QC / TPIA	
SIGN			
NAME			
DATE			

VE/QA/FORMAT/23 REV.2





QA/QC



**VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED
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ALIGNMENT INSPECTION REPORT OF STRUCTURE

LOCATION :		UNIT		REPORT NO :	
DRAWING NO :		TITTLE		DATE :	

FOUNDATION PEDESTALS:
Bench mark/Dutum Mark is Available
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)	Difference In MM	ACCEPT	

Acceptance limit:

verticality : 1mm per 1mtr up to maximum of 35mtr, maximum limit is 35mm beyond 35mtr

BOBP Elevation : $\pm 5\text{mm}(\text{Max})$

	(V/x)	
All field weld done and fillet weld thickness chkd		
Non - Dustructive 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		

Note:

final inspection was done:

The structure is releasd for piping and Equipments eaction

	VE EXECUTION	VE QC	CLIENT / TPI
SIGNATURE			
NAME			
DATE			





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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 Joint torque	Plate 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 :			

VE/QA/FORMAT/32 REV.2





VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED

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SITE FITUP-WELDING INSPECTION REPORT

CLIENT		DRAWING NO :		REPORT NO:	
PROJECT:		WPS NO :		DATE :	

SR NO	ITEM DESCRIPTION/ MOC	TYPE OF JOINT	SIZE MM/ MTR	THIKNES	NO OF QTY	WELDER NO	FITUP INSPECTIO N BY	FITUP INSPECTION DATE	WELD VISUAL	WELD VISUAL /DATE	REMARK

	VE QC	VE Execution Engineer	CLIENT / TPI
SINGNATURE:			
NAME :			
DATE :			





VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED

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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 strenghen bolts if required			
7	Verticality of erected structral member (records readings)			
8	All load bearing members related to the strenght 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 inaccessible 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/QA/FORMAT/33 REV.1