

VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED



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

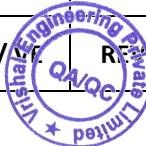
CLIENT : NAVIN FLUORINE ADVANCED SCIENCES LTD.

**PROJECT :- EPCM SERVICES FOR NEW HYDRO FLUORIC
ACID PLANT**

PO NO : 6400000018 Dt. 20.08.2024

DOCUMENT NO : VEPL-NFASL-EPCM-ITP-001

0	11.08.2024	ISSUED FOR REVIEW & APPROVAL	SURAJ SINGH	SHIVANG DIWAKAR	
REV	DATE	DESCRIPTION (ISSUE PURPOSE)	PREP'D BY / VE	REVIEW'D BY / VE	APR'D BY / NFASL





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Document no: VEPL-NFASL-EPCM-ITP-001			Revision: 00		Date :- 09.08.2024		
Sr No	Description/Control Activity	Applicable Documents	Acceptance Criteria	Verification Documentation Format	Inspection Authority	REMARKS	
					VE		
DOCUMENT VERIFICATION							
1	Availability of IFC drawings	IFC Drawings	-	Transmittal/ List of Drawings	H	R	
2	WPS & PQR	AWS D1.1	AWS D1.1	WPS/PQR	H	R	
3	Structural Welder Master List	AWS D1.1	AWS D1.1	WQT Certificates	H	R	
MATERIAL							
4	Dimensional, Visual Inspections of incoming materials	BATCH NUMBER/MATERIAL TEST CERTIFICATE	Applicable Codes	IMIR REPORT VE/QA/FORMAT/18	H	R	1)MTC shall be endorsed by supplier with quantity supplied.
5	Verification of welding consumables	Batch Certificates	ASME Sec-II, Div-C	MTC	H	R	MTC Review
6	Storage & preservation of incoming materials, pre-fabricated and fabricated materials	-	-	Procedure For Material Control - Storage & Segregation	H	S	
FABRICATION							
7	FIT-UP						
7.1	Marking, Cutting & Gridning of material	IFC Drawings	AWS D1.1	FIT-UP REPORT VE/QA/FORMAT/34A	H	S	
7.2	Fit-up Inspection- Joint Preparation, Mismatch, Alignment, Dimensions, Orientations, etc...	IFC Drawings	AWS D1.1		H	R	



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					VE	NFASL/TPI	
8	WELDING, NDT & FINAL DIMENSION						
8.1	Weld Visual Inspection	AWS D1.1	AWS D1.1	Weld visual report VE/QA/FORMAT/34A	H	R	
9	Non Destructive Examination, DP Testing of weld	AWS D1.1	AWS D1.1 / Approved Drawings / General Specification	DPT Report VE/QA/FORMAT/21	H	R	10% DPT of Sub assembly of weld
10	Final Dimensional Check	AWS D1.1 / Client Spec	AWS D1.1	Final Inspection Report VE/QA/FORMAT/20A	H	R	
11	Surface Preparation: Blasting & Painting						
11.1	Verification Incoming Paint Material	Purchase Order / Delivery Note / Client Spec	Product Data sheet	MTC	H	R	
11.2	Surface Preparation	As per VEPL Painting Specification	Product Data sheet	SURFACE PREPARATION & PAINTING REPORT (STRUCTURAL) VE/QA/FORMAT/23	H	R	
11.3	Paint Application	As per VEPL Painting Specification	Product Data sheet		H	S	# Final Paint touch up to be done at Erection site.
11.4	Final DFT	As per VEPL Painting Specification	As per VEPL Painting Specification		H	R	
11.5	Final Visual Check	As per VEPL Painting Specification	As per VEPL Painting Specification		H	R	
CLEARANCE FOR SITE DISPATCH							
12	Inspection Release Note	Packing List / IRN	Compliance to Purchase order	Packing List / IRN VE/QA/FORMAT/30	H	R	
ERCTION							
13	Ensure readiness of civil foundations/ pedestals prior to structure erection. Verification of pedestal dimensions and level. Available of Civil Foundation Release Note (HOTO)	Drawing/ AWS D1.1	AWS D1.1	Civil Foundation Release Note	H	H	
14	Identification of structure members and verification of BOP Level, alignment and verticality of each column segment and tightness of foundation bolts, Orientation and Elevation during erection.	Drawing/ AWS D1.1	AWS D1.1	Alignment Inpsection Report VE/QA/FORMAT/31	H	R	



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					VE	NFASL/TPI	
15	Torque tightening of erection bolts between the structure members	Specification / Drawing	Specification / Drawing	Torquing Inspection Report VE/QA/FORMAT/32	H	R	
16	Field welding of column splice plates, tie-beam/ bracing supports	WPS	WPS	Site Fit-up / welding Inspection Report VE/QA/FORMAT/34	H	R	
17	Structure release for erection of piping and equipments	Drawing/ AWS D1.1	AWS D1.1	Structural Steel Release Note for Equipment / Piping VE/QA/FORMAT/33	H	R	

Abbreviation :

1	H : Hold : Work shall not proceed without written clearance of QC.
2	W : Witness Point : Activity shall be witnessed by CLIENT, If CLIENT/TPI is present. If the CLIENT is absent activity will proceed as planned. CLIENT/TPI shall be given intimation in either writing or verbal.
3	RW : Random Witness : Activity shall be Randomly 10% witnessed by CLIENT, If CLIENT/TPI is present. If the CLIENT is absent activity will proceed as planned. CLIENT/TPI shall be given intimation in either writing or verbal.
4	R : Review : Documents shall be reviewed 100%
5	S : Surveillance : Random Inspection at Site, No signature required on the Inspection Report by TPI/CLIENT

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