

INSPECTION TEST PLAN

ITP No.	ITP/ Water Wall Panel/EUROASIATIC		
REVISION NO	REV-01		
PAGE NO	1 OF 3		
NAME OF PROJECT	SBI		
NAME OF PRODUCT	WATER WALL PANELS		
PROJECT NUMBER	PT-609/ PT-612		
CUSTOMER	EUROASIATIC		
CONSULTANT		
DESIGN CODE	ASME SECTION I EDITION 2015 (WITHOUT STAMPING)		
INSPECTION AGENCY	TUV SUD		

Abbreviations:

H: HOLD POINT	Insp : INSPECTIONS	WPS: WELDING PROCEDURE SPECIFICATION	
W: WITNESS POINT	Drg: : DRAWING	PQR: PROCEDURE QUALIFICATION RECORD	
R: DOCUMENTS REVIEW	MTC: MATERIAL TEST CERTIFICATE	WPQ: WELDER'S PERFORMANCE QUALIFICATION	
RW: RANDOM WITNESS	MOM: MINUTES OF MEETING	Spec.: SPECIFICATION	

Client can waive this inspection based on his discretion and informs TPI Inspector accordingly.



[Signature]

1

S M KUMBHAR

GANESH AHIRE

REV NO/ DATE

PREPARED BY

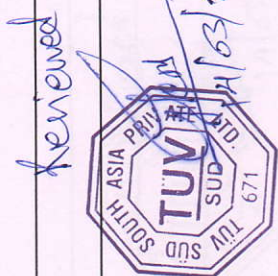
CHECKED BY

ACCEPTED BY

Reviewed by *[Signature]*
 Approved dated 09/03/2017
[Signature]
 milind S. Gole
 14/03/2017



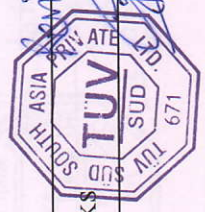
Sr No.	Activity	Characteristics To be checked	Extent of Checked	Acceptance Criteria	Verifying Documents	Activity By			Remark
						Manuf.	TPI	Client	
Before Manufacturing									
1.1	Pre-Inspection Meeting	Client Spec..	Client Spec..	MOM	H	H		
1.2	Drg, Design, Calculation Documents	As per ASME Sec I, Edition 2015	100%	ASME, Client Spec, Approved Drawing	Calculations, Approved Drawing	H	R		
1.3	Quality Plan	All Stages, Corrections & Sequences	100%	Approved Drawing	Approved QAP	H	R		
1.4	WPS & PQR	Review of Procedures	100%	ASME IX, Approved Procedures	WPS, PQR	H	R		
1.5	Welder Qualification Certificates	Review of Procedures	100%	ASME IX, Approved Procedures	WPQ	H	R		
1.6	NDT Procedure	Review of Procedures	100%	ASME V.I, IX Approved Procedures	Std. Documents	H	R		
1.7	PWHT Procedure	Review of Procedures	100%	Approved Procedures	Std. Documents	H	R		
1.8	Hydro-Statics Testing Procedure	Pressure Drop, Leakage to be Check	100%	Approved Drawing, PG-99	Std. Documents	H	R		
1.9	Painting Scheme	Review of Procedures	100%	Spec.	Std. Documents	H	R		
									
									
				S M KUMBHAR					
REV NO/ DATE				PREPARED BY	CHECKED BY	ACCEPTED BY		REMARKS	
								Reviewed	



During Manufacturing

Water Wall Panels [LHS, RHS, REAR, FRONT, MIDDLE]

Sr No.	Activity	Characteristics To be checked	Extent of Checked	Acceptance Criteria	Verifying Documents	Activity By			Remark
						Manuf.	TPI	Client	
2.1	Alloments & Inspection of Raw materials	Visual & Dimensional Insp., Sample Markings, MTC	10%	Approved Drawing, Spec., PG-76, PG-77,	Insp Report	H	H		Stamp Transfer
2.2	Bend Sample Inspection on Layout	Ovality, Bend Thinning	2% per Nos. of Coil	ASME, SPEC, Approved Drawing	Insp Report	H	R		
2.3	Header Pipe to Pipe Butt Jts S/up [If Applicable]	Root Gap, Allignment V Preparation,	100%	PG-79, PG-80 & PG-33 Approved Drawing	Insp Report	H	R		
2.4	Hdr to Tube & Tube to Tube S/up	Root Gap, Allignment V Preparation, Orientation	100%	PG-79, PG-80 & PG-33 Approved Drawing	Insp Report	H	R		
2.5	Radiography Test <i>as per drawing requirements</i> Visual Inspection of Complete Equipment	Review of Radiography films & Reports	10%	PW-51	RT Films & Reports	H	R		
2.6		Visual Inspection of Fillets, Surface & Welding Finishing	100%	Approved Drawing	Insp Report	H	R		
2.7	Heat Treatment	Review of Heat Charts	100%	Approved Drawing	H T CHART	H	R		
2.8	Closing of NCR, If Any	H	R		
2.9	Hydro Statics Test	Pressure Drop, Leakage to be Check	100%	PG-99 Approved Drawing	Insp Report	H	H		
2.10	Final Dimension Inspection [Where as Nozzle End Preparation after Hydro]	Verification of Dimensions & Visual Inspection of Fillets, Surface & Welding Finishing	100%	As per tolerance in Approved Drawing	Insp Report	H	H		
2.11	Painting Inspection	Surface finish, DFT- Reports	100%	Paint DFT	Insp Report	H	R		
		<i>Signature</i> Uman Energy Systems Ltd.	<i>Signature</i> S M KUMBHAR						
		<i>Signature</i> Babbar							
	REV NO/ DATE	PREPARED BY	CHECKED BY	ACCEPTED BY	REMARKS				



14/03/2017