

TUV India Control No: (SAP Number)	010101085424/7 (8122464801)	Date:	18/01/2025
Project Name & Location:	10000 MT Ammonia Storage Tank at RCF Thal, raigad, Maharashtra, India Project (66-0246).	TUV India Branch Name:	Nashik
TUV India Client Name:	ThyssenKrupp Industrial Solutions	End User Name:	RCF Thal, raigad, Maharashtra
DEC / PMC / EPC Name: <small>(If applicable)</small>		DEC / PMC / EPC Assignment Number: <small>(If applicable)</small>	
Vendor Name & Location:	KIRLOSKAR PNEUMATIC COMPANY LTD.	P.O. Number: <small>(Client PO on Vendor)</small>	38030085/RKR Dated 23/10/2023
Sub Vendor Name & Location: <small>(If applicable)</small>		P.O. Number: <small>(If applicable - Vendor PO on Sub Vendor)</small>	

Item Description:

PO Item No.	Item Code	Item Description / Identification / MTC Number	UOM	P.O. Quantity	Offered Quantity	Accepted Quantity	Cumulative accepted Quantity
2	20-K01A/B	Billing Break No. 2 20-K01A/B (Ammonia Unloading Compressor Packages) - Lube oil console skid comprising of primary oil tank/separator, secondary oil separator, oil pumps/motors, oil cooler, oil filter, piping, valves, base frame, and instrumentation & cabling within the skid.	number	2	2	2	2

Reference Documents:

Sr. No.	Document Name	Client Document Number	Vendor Document Number	Approval Status
1	PR/MR/ARM	0246-EQM-20-EC-0004;Rev.00	Not Applicable	tkUIPL Document
2	QAP/ITP/QCP	0246-EQM-20-DZ-0002-048; Rev 02	PRJ/R5540/501 ;Rev 02	Approved by tkUIPL in code 1
3	Drawing(s)	1) P & ID For Unloading Compressor Package -A: 0246-EQM-20-DZ-0001-001 ; Rev 04 2) P & ID For Unloading Compressor Package -B:- 0246-EQM-20-DZ-0001-002; Rev 04 3) P& ID For Economiser Skid :- 0246-EQM-20-DZ-0001-003; Rev 03 4) Equipment layout for Package : 0246-EQM-20-DZ-0002-027 ; Rev 04 5) Foundation Layout Drawing for Package:- 0246-EQM-20-DZ-0002-028 ; Rev 03	1) PRJ-R5540-02;Rev.04 2) PRJ-R5540-03;Rev.04 3) PRJ-R5540-05;Rev.03 4) PRJ-R5540-45;Rev.04 5) PRJ-R5540-46;Rev.03	Approved by tkUIPL in code 1

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4	Datasheet(s)	NA	NA	NA
5	Procedure(s)	<p>1) NDT-0246-EQM-20-DZ-0002-063; Rev 00</p> <p>2) Weld Book for packing Pipe-0246-EQM-20-DZ-0002-059; Rev.00</p> <p>3) PMI Procedure:-0246-EQM-20-DZ-0002-069 ;Rev.00</p> <p>4) Pressure Test Procedure for package:-0246-EQM-20-DZ-0002-066 ; Rev 00</p> <p>5) Painting procedure:-0246-EQM-20-DZ-0001-030 ; Rev. 01</p> <p>6) Pickling & Passivation Procedure:-0246-EQM-20-DZ-0002-070; Rev.00</p>	<p>1) a) KPCL/ACR REF-PGS/NDE/RT/01 ; Rev 6 b) KPCL/ACR REF-PGS/NDE/PT/01; Rev 5</p> <p>2) PRJ-R5540-512;Rev.00</p> <p>3) PRJ -R5540-522;Rev.00</p> <p>4) PRJ -R5540-519;Rev.00</p> <p>5) PRJ -R5540-48;Rev.01</p> <p>6) PRJ -R5540-523;Rev.00</p>	<p>Approved by tkUIPL in code 1</p> <p>Approved by tkUIPL in code 5</p> <p>Approved by tkUIPL in code 5</p>
6	Others(Specify)	<p>1) Not Applicable</p> <p>2) Annexure -1 IRN List (Attached to IRN)</p> <p>3) Annexure -2 Photos Refer Separate Annexure</p>	<p>Billing Breakup No. :- Purchase Order No.: 38030085/RKR dated 23/10/2023.</p> <p>NA</p> <p>NA</p>	KPCL Document

Stages Witnessed:

- 1) All measuring instruments & equipment were verified for continued suitability for intended use, proper identification, calibration status, traceability to national standards & found acceptable.
- 2) ITP Stage no. E-2- Skid Base Frame (Skid Base Frame) :-
Visual and dimensional inspection carried out as per approved drawing-Found to meet approved drawing requirement.

ITP Stage no. E-4- Surface Preparation & Painting inspection of Skid Base Frame:-
 - Visual check for painting surface after final paint coat application - No injurious defects observed.
 - DFT checked after final paint coat application - Found to meet approved painting procedure requirement.
 - Colour shades verified by comparing with shade card - Found to meet approved painting procedure requirement.
- 3) ITP Stage no. F-3 - Package Piping Items :-Pipes , Fitting, (BW & SW), Flanges :- Dimension and Visual Inspection, Verification of Marking:-
 - Visual check for surface condition of 10% randomly selected pipes, flanges & fittings from offered quantity as per PO Sr. No. (from outside and inside visible accessible portion) carried out – Found free of injurious defects
 - Dimensions inspection carried out for 10% randomly selected pipes, flanges & fittings from offered quantity as per PO Sr. No. - Found to meet material Specification/QAP/Technical Spec. requirements
 - Manufacturer Marking Verified for 10% randomly selected pipes, flanges & fittings from offered quantity per PO Sr. No. & co-related with MTC as declared by vendor – Found in order.
ITP Stage no. F-4 :- PMI of SS & AS Items :-
PMI test carried out from offered complet lot 10% Qty. of SS Items - Main alloying elements ,material grade found to meet material specification requirement.
- 4) ITP Stage no. G-9:- Valves (Gate, Globe, Check & Ball & Dual Plate Check valves) Hydro/Pneumatic Test Witness:-

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Hydro and pneumatic test carried out from offered complete lot on 10% as per approved drawing and procedure - No leakage, no pressure drop & no air bubble observed during holding time.

ITP Stage no. G-13:- Verification Of Marking, Tagging & Locking Arrangement:-

Marking, Tagging and locking arrangement verified for offered package - Found to meet approved drawing requirement.

- 5) ITP Stage no. H-Safety Valves :-
For safety valve TPIA IRN issued at sub vendor location reviewed as per ITP requirement, found satisfactory. Refer Attached annexure-1 for tag no. and IRN no.
- 6) ITP Stage no. I- Coupling Of Compressor :-
Not Applicable to Lube Oil Console.
- 7) ITP Stage no. L- Y Type suction strainer :-
TPIA IRN issued at sub vendor location reviewed as per ITP requirement. Found satisfactory. Refer annexure-1 for Tag no. and IRN no.
- 8) ITP Stage no. M-Duplex oil filter:-
TPIA IRN issued at sub vendor location reviewed as per ITP requirement, Found satisfactory. Refer annexure-1 for tag no. and IRN no.
- 9) ITP Stage no. N-2.3- Packaging Of Skids at KPCL Works - DP Test of Socket & Branch Weld Joints:-
As per approved test procedure DP test of final run weld joints carried out from offered complete lot for randomly selected 10% Qty. - No any relevant indication observed.

ITP Stage no. N-2.5- Tie -In Point Dimensional Inspection :-

As per approved drawing offered tie in point dimensional inspection carried out - Found to meet approved drawing requirement.

ITP Stage no. N-3.1-Final Inspection - (Final Visual, Dimensional along with all the auxiliaries):-

In assembly condition Final visual inspection of all offered items accessible area carried out - Found free from injurious surface defects. In assembly condition offered dimensions accessible area including tie-in points, foundation holes, skid base frame dimensions checked - Found to meet approved drawing requirements.

TP Stage no. N-3.2- P & ID Check :-

completeness of Mechanical, E&I items checked and marking, tagging, name plates verified - Found to meet approved drawing requirement. All offered lines items along with instruments checked as per approved P & ID drawings - Found to meet drawing requirement.

ITP Stage no. N-3.3- PMI Testing of skid for SS & AS Material Including Piping Items, Weld Joints:-

PMI test carried on SS Items & Weld - Main alloying elements found to meet material specification requirement.

ITP Stage no. N-3.4-Pressure Test of Assembled Skid Package Piping:-

As per approved procedure Pneumatic test carried out on process fluid & lube oil line at pressure mentioned in approved hydro test procedure-No leakage, no pressure drop & no air bubble observed during holding time.

As per approved procedure Hydro test of cooling water circuit along with lube oil cooler witnessed at pressure mentioned in hydro test procedure. No leakage and no pressure drop observed during test. Test result found satisfactory.

ITP Stage no. N-3.6- Painting Inspection of Skid Piping & Spool After Piping Dismantling:-

- Visual check for painting surface after final paint coat application - No injurious defects observed.
- DFT checked after final paint coat application - Found to meet approved painting procedure requirement.
- Cross scratch test carried out and found satisfactory.
- Colour shades verified by comparing with shade card - Found to meet approved painting procedure requirement.

ITP Stage no. N-3.7-Pickling and passivation test for SS parts :-

-Pickling and passivation witnessed for SS skid un-insulated piping spools including pipes, fittings, flanges, valves and weld joints- Found to meet approved Pickling and passivation procedure requirement.

Documents Reviewed:

- 1) Reviewed & verified calibration status of test & measuring instrument used was verified & found valid.
- 2) ITP Stage No. A:- Inspection & Test Plan :-
tkUIPL approved final code-1 ITP verified & same ITP followed during inspection for all inspection stages.
- 3) ITP Stage No. C:- Inspection & Test Procedure For Packages:-
tkUIPL approved NDE & other procedures verified & same followed during inspection for all test stages.
- 4) ITP Stage No. D-1:- Welding Procedure for package piping :-
tkUIPL approved Welding documents like WPS.PQR & WPQ verified & same followed during inspection .
- 5) ITP Stage no. E- Skid Base frame (Lube Oil Console Skid Base Frame):-
E-1-Raw MTC for skid base frame as declared by manufacturer reviewed and endorsed -Found to meet material specification, drawing and ITP requirement.

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E-3-Loose item assembly inspection report reviewed-Found in order.

ITP Stage no. E 4 -(Painting)


Surface preparation report of Base frame & Piping reviewed as per approved painting procedure: Found satisfactory.

- 6) ITP Sr No F 1 - Packaging Piping items -Pipes , Fittings Review of MTC:-
 - As submitted pipes, fittings and flanges MTC's photocopy verified with original MTC EN10204-3.1/3.2 and reviewed Chemical Composition & Mechanical Properties, Material grade, Hydro test pressure, heat treatment, NDE, hardness value etc. found to meet acceptance standard requirement as per material specification/QAP/Technical Spec.
- ITP Stage no. F-2-DP Test of BW Flanges & Fittings on Bevel Ends:-
 As submitted DP test report of BW flanges & fittings reviewed- Found in order.
- 7) ITP Stage no. G- Valves document review :-
 1- As submitted WPS, WPQ, PQR reviewed as per ASME SEC. IX -Found in order.
 2- As submitted MTC for body, bonet, cover and gasket as declared by manufacturer reviewed and endorsed -Found to meet material specification, drawing and ITP requirement.
 3-As submitted Lab TC for trim bar reviewed-Found in order.
 4- As submitted MTCs for fasteners as declared by manufacturer reviewed and endorsed -Found to meet material specification, drawing and ITP requirement.
 5-As submitted RT reports of valves casting reviewed-Found in order.
 6-As submitted IGC Lab test reports for SS valves body, bonet, cover reviewed-Found in order.
 7-As submitted PMI test reports for SS valves body, bonet, cover reviewed-Found in order
 8-As submitted DP test reports of SW & BW valves on both ends reviewed-Found in order.
 9-As submitted Body, Seat, Shell Hydro and pneumatic test certificates reviewed-Found in order.
 10-As submitted Strip test report for gate and globe valve reviewed-Found in order.
 11- As submitted Type test certificate for fire, fugitive emission, cryo reviewed-Found in order.
 12-As submitted Inspection reports reviewed for dimension, completeness of valves-Found in order
 14-As submitted Surface preparation report for valves reviewed-Found in order.
- 8) ITP Stage no. H-Safety Valves :-
 For safety valve TPIA IRN issued at sub vendor location reviewed as per ITP requirement, found satisfactory. Refer Attached annexure-1 for tag no. and IRN no.
- 9) ITP Stage no. I- Coupling Of Compressor :-
 Not Applicable to Lube Oil Console.
- 10) ITP Stage no. J- Fasteners & Gasket For Package Piping MTC's Review:-
 1-MTC for fasteners and gaskets as declared by manufacturer reviewed and endorsed -Found to meet material specification, drawing and ITP requirement.
- 11) ITP Stage no. K- Miscellaneous Items Document Review:-
 1-Insulation material, base frame grating & other structural material MTC /inspection reports reviewed- Found in order
- 12) ITP Stage no. L- Y Type suction strainer :-
 TPIA IRN issued at sub vendor location reviewed as per ITP requirement. Found satisfactory. Refer annexure-1 for Tag no. and IRN no.
- 13) ITP Stage no. M-Duplex oil filter:-
 TPIA IRN issued at sub vendor location reviewed as per ITP requirement, Found satisfactory. Refer annexure-1 for tag no. and IRN no.
- 14) ITP Stage no. N-Packaging Of Skids at KPCL Works Documents Review:-
 1.1-TPIA IRN reviewed w.r.t. approved ITP issued at sub vendor location for bought out items found in line with requirement. Refer Annexure-1 for list of bought out items/Tag no./TPIA IRN no.
 1.2- Equipments mounting on skid base frame report reviewed-Found in order.
 2.1-Piping weld joints fit up report reviewed-Found satisfactory.
- ITP Stage no. N-2.4- RT Films review:-
 RT films and reports for the piping weld joints reviewed - No significant discontinuity observed.
 RT summary sheet for holding compressor package tag. No. 20K01A reviewed-Found in order.
- ITP Stage no. N 3.6-Painting Report review:-
 Surface preparation report of Base frame & Piping reviewed as per approved painting procedure: Found satisfactory.
- 15) -- Refer Annexure -1 for bought out items/Tag no/ TPIA IRN no.,attached with IRN.
 --Photo Annexure -2 attached with IRN.

NCR / Waiver: (If Any)

None.

Identification:

Package Attached Name Plate TUV Hard stamp as "  "

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Order status: ☐ Complete ☒ Incomplete

Date(s) of Inspection: , 02/09/2024, 03/09/2024, 04/09/2024, 05/09/2024, 06/09/2024,07/09/2024,, 03/10/2024,04/10/2024,, 09/11/2024,11/11/2024,, 10/09/2024, 11/09/2024, 12/09/2024, 13/09/2024,14/09/2024,, 10/09/2024,11/09/2024,, 10/10/2024,11/10/2024,, 11/12/2024,12/12/2024,, 12/08/2024, 13/08/2024,14/08/2024,, 14/10/2024,15/10/2024,, 14/10/2024,16/10/2024,, 15/11/2024,16/11/2024,, 16/09/2024,17/09/2024,, 18/09/2024,19/09/2024,, 20/09/2024,21/09/2024,, 21/08/2024, 22/08/2024,23/08/2024,, 21/10/2024,22/10/2024,, 22/08/2024,23/08/2024,, 22/11/2024,23/11/2024,, 23/08/2024,24/08/2024,, 23/09/2024,24/09/2024,, 25/09/2024,26/09/2024,, 25/10/2024,26/10/2024,, 26/09/2024, 27/09/2024, 23/09/2024, 25/09/2024, 24/09/2024,28/09/2024,, 28/10/2024,30/10/2024,, 29/07/2024,30/07/2024,, 29/08/2024,30/08/2024,, 30/08/2024,31/08/2024,01/10/2024,02/08/2024,02/09/2024,03/10/2024,05/12/2024,08/08/2024,08/11/2024,09/09/2024,09/12/2024,10/10/2024,10/12/2024,11/11/2024,13/11/2024,14/10/2024,15/10/2024,17/08/2024,18/09/2024,18/11/2024,21/10/2024,23/09/2024,23/10/2024,26/09/2024,26/10/2024,27/09/2024,27/11/2024,27/12/2024,28/08/2024,28/10/2024,29/10/2024,29/11/2024,30/09/2024

Conclusion: All items were inspected within the scope defined in PO, approved QAP/ITP/QCP & specifications - found to meet the specified requirements. .

Scan For Verification



(Code Valid For 1 Year)

NAVNATH SHINDE

On behalf of ANI BABY,VIKASH ANAND,ABHISHEK
GHADIGAONKAR,PAWAN PANDEY,GIRISHKUMAR
BRAHMBHATT,DASHARATH GAIKWAD,KAUSHIL PANCHOLI,YOGESH
AVAD,RAJESHKUMAR RAKKAPPAN,PRAVIN KOCHARINAN,ANAND
KUMBAR,ATUL GAIKWAD,SUSHIL GHATKAR,SRIKANTH P,AMOL
JAMDAR,PARTEEK SINGH,VIKAS SHARMA,SHANKARRAO
PISAL,RUSHIKESH BHAMBURE,DINESH DENGAL,VISHAL
KAWARE,SHANKAR BARHE,ATUL SHARMA,GANPATRAO YADAV,SOLAI
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