

VISIT REPORT

TUV Control No.: --	TUV SAP No: 8117891439	Branch: HYDERABAD	Report No: LTHE-RUF-32682-IR-144				
OWNER:	M/s. Hindustan Petroleum Corporation Limited (HPCL)	Inspection Notification Number(s)	HPCLRUF/NOI/6224 -R0				
Client : Contractor	M/s. L & T Hydrocarbon Engineering(LTHE), Vadodara	Project:	VISAKH REFINERY MODERNIZATION PROJECT (VRMP)				
PMC Name (if any)	M/s. Engineers India Limited.	Package:	Residue Up-gradation Facility, (RUF) (EPCC-03 PACKAGE)				
Vendor Name:	M/s. Larsen & Turbo MMH SBG	Client's PO No.(on vendor):	REFINERY/74000-32682/NDS				
Sub Vendor Name: (if applicable) :	M/s. Srujana Engineering Works	Vendor's PO No. on sub Vendor:	EK716WOD1000010 Date: 08.04.2021				
Place/Address of Inspection:	Parawada - Visakhapatnam	Inspection Date:	23.08.2021				
Stage of inspection:							
<input type="checkbox"/> Kick-off/ Pre-inspection meeting		<input checked="" type="checkbox"/> Material Identification	<input checked="" type="checkbox"/> Interim stage				
<input type="checkbox"/> Document review		<input type="checkbox"/> Final	<input type="checkbox"/> Re-inspection				
Sr. No.	P. O. Item No.	BBU SI No	Item Description	PO Quantity (MT)	Quantity Offered (MT)	Quantity Accepted (MT)	Remarks
I	2	C.2.1	Fabricated structure steel including chq plate and handrail (BLACK INSPECTION AND NDT OF WELDS Annexure-1 Dated 18.08.2021 for details)	4314	25.017	Nil	
II	2	C.2.1	Raw material Identification	--	93.148	Nil	
A	--	--	Plate 8 X 1500 X 6300mm IS 2062 E 350 BR	--	28.520		
B	--	--	Plate 6 X 1500 X 6300mm IS 2062 E 350 BR	--	3.60		
C	--	--	Plate 56 X 2000 X 2500mm IS 2062 E 350 BR	--	2.160		
D	--	--	Plate 16 X 2500 X 1200mm IS 2062 E 350 BR	--	3.907		
E	--	--	Plate 10 X 2500 X 12000mm IS 2062 E 350 BR	--	9.688		
F	--	--	Plate 12 X 2500 X 2500mm IS 2062 E 350 BR	--	8.542		
G	--	--	Plate 32 X 3500 X 2500mm IS 2062 E 350 BR	--	2.198		
H	--	--	Plate 50 X 2500 X 2500mm IS 2062 E 350 BR	--	2.453		
I	--	--	ISMC150 X 75mm IS 2062 E 350 BR	--	5.000		
J	--	--	ISMC200 X 75mm IS 2062 E 350 BR	--	3.479		
K	--	--	ISA 150 X 150 X 12mm IS 2062 E 350 BR	--	4.914		
L	--	--	ISA 100 X 100 X 10mm IS 2062 E 350 BR	--	5.137		
M	--	--	ISA 75 X 75 X 8mm IS 2062 E 350 BR	--	2.80		
N	--	--	Beam 254 X 146 X 37mm IS 2062 E 350 BR	--	5.250		
O	--	--	WPB 700 X 300 X 149.9mm IS 2062 E 350 BR	--	5.500		

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REFERENCE DOCUMENTS:

Sr. No.	LTHE Document Title	LTHE Document No.	Approver	Approval Status	Date
1	Drawings	B016-RUF-LT-504-MP-GA-LMMH(1) - 13777 Rev.01	LTHE EIL	Code-1 Code-2	16-07-2021 09.08.2021
		B016-RUF-LT-504-MP-GA-LMMH(1) - 13778 Rev.01	LTHE EIL	Code-1 Code-2	16-07-2021 09.08.2021
2	QAP/ITP	B016-RUF-LT-504-QC-QDLMMH(1)-13074 Rev 0	LTHE	Code-1	18-03-2021
3	Specification	--	--	--	--

Inspection Activities carried out / Remarks:

Black verification as per Clause 4.1 of ITP/QAP:

1.	Weld visual check on offered material – No injurious surface defects were observed in GL 6, GL 11, GL 12, GL 13 & GL 14
2.	Dimensional Inspection carried out for GL 6, GL 11, GL 12, GL 13 & GL 14 material and found meet the drawing requirements. Shape, size, Ø22 Hole pitch, straightness & section thickness verified and found as per drawing requirements.
3.	Witnessed PT 10% at randomly on weld joints from offered material and found no recordable indications.
4.	Visual check for surface finish on offer material – no injurious defects were observed.
5.	Verified Material Identification - Correlation with manufacturer material test certificates found satisfactory
6.	Dimension Inspection carried 10% on offered material in assembled condition and found satisfactory with the drawing.
7.	IS 2062 Gr E 350 Size 16 X 2500 X 12000mm Plate Identified and Correlated with Manufacturer (Sail) Material Test Certificate with Heat Numbers 2110672.
8.	IS 2062 Gr E 350 Size 10 X 2500 X 12000mm Plate Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers A10981/28DO, A10981/29AO, A10981/29BO & A10981/29DO
9.	IS 2062 Gr E 350 Size 12 X 2500 X 12000mm Plate Identified and Correlated with Manufacturer (Sail) Material Test Certificate with Heat Numbers 2108686 & 2110554. 1 Sample identified for check testing.
10.	IS 2062 Gr E 350 Size 254 X 146 X 37mm Beam Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers 3116618. 1 Sample identified for check testing.
11.	IS 2062 Gr E 350 Size 700 X 300 X 149.9mm WPB Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers 2116300 & 3116390. 1 Sample identified for check testing.
12.	IS 2062 Gr E 350 Size 150 X 75mm ISMC Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers 4117005. 1 Sample identified for check testing.
13.	IS 2062 Gr E 350 Size 200 X 75mm ISMC Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers 4115246. 1 Sample identified for check testing.
14.	IS 2062 Gr E 350 Size 150 X 150 X12 Angle Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers 3116735 1 Sample identified for check testing.

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15. IS 2062 Gr E 350 Size 100 X 100 X 10 Angle Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers 4117054 1 Sample identified for check testing.
16. IS 2062 Gr E 350 Size 75 X 75 X 8 Angle Identified and Correlated with Manufacturer (Jindal) Material Test Certificate with Heat Numbers 4115580 17. 1 Sample identified for check testing.
18. 6mm, 8mm, 32mm, 50mm & 56mm Plates manufacturer identifications not available on plates. Each section one sample identified for check testing.

Documents Reviewed / Remarks:

1. Manufacturer material test certificates – Found meet the specification requirements.
2. Reviewed internal inspection reports and found in order.

Details of Instrument / Equipment used in Inspection:

SR NO.	INSTRUMENT / EQUIPMENT DETAIL	RANGE	INSTRUMENT ID	VALIDITY UPTO	CERTIFICATE No. WITH DATE	NABL / OTHER CERTIFYING BODIES	NON-NABL
						Please Tick whichever is applicable	
						See Note : 1	See Note: 2
1.	Measuring tape	0-5000mm	SEW/MT-02	22.11.21	YEA(C)-201121A/S2161/003 Date: 23.11.2020	✓	
2	Measuring tape	0-15000mm	SEW/MT-01	22.11.21	YEA(C)-201121A/S2161/001 Date: 23.11.2020	✓	
3	Vernier caliper	0-300mm	SEW/VC-01	02.05.22	YEA(C)-210503A/S2161/001 Date: 03.05.2021	✓	
4	Weld Gauge	--	SEW/WG-01	03.12.21	YEA(C)-201203A/S2161/003 Date: 04.12.2020	✓	

*Notes :

- 1) Other Certifying bodies are: NPL-India, CIPM (International Committee for Weights & Measures), ILAC & APLAC MRA Signatories.
- 2) In case of Non-NABL, please write the acceptance clause, as per TUV Work Instructions:WI-INS-63, R0 (Work Instructions - Policy on Measurement Traceability as per NABCB)

Conclusion (Accepted/ Accepted with comments /Rejected/ Other comments (please specify): Material GL 6, GL 11, GL 12, GL 13 & GL 14 acceptable subjected to Code 1 approval.

Samples identified for check testing.

Identification of inspected item/ Equipment: NILL

Areas of Concern:

1. GA drawing approved by EIL- code 2.
2. Rust observed in all structural material.
3. Project specification and technical specifications not available with vendor, at the time of inspection.
4. Check test reports not available for review.
5. 6mm, 8mm, 32mm, 50mm & 56mm Plates manufacturer identifications not available on plates. Each section one sample identified for check testing.


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6. 10mm Plate MTC not visible (Chemical and Mechanical) 7. 6mm, 8mm, 56mm material test certificates tractability missing. All MTC's address to Narmada Iron and associates private limited and VK Industrial corporation limited.	
Non Conformities Raised (if any)(mention NCR nos.): <u>NIL</u>	
Attachments (Vendor records, NCR's, Deviation requests etc.): <u>NIL</u>	
Name of Inspector : A C Ramana	Date: 23.08.2021
Signature & TUV stamp: 	Vendor signature & stamp (where applicable) :

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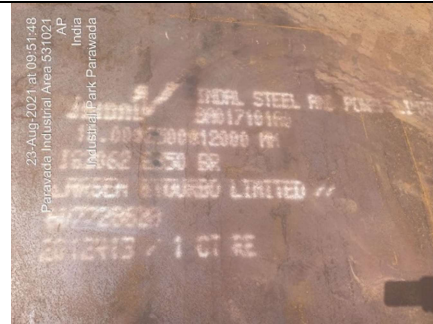
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Inspection Photos:

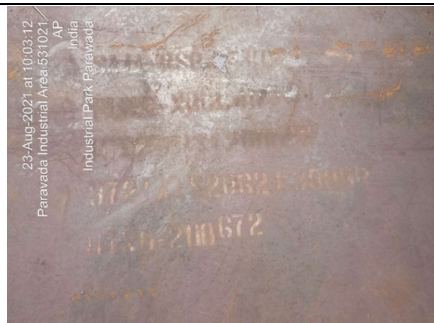
Material Identification



Material Identification



Material Identification



Material Identification



Material Identification



Material Identification



Thickness verification



Thickness Verification





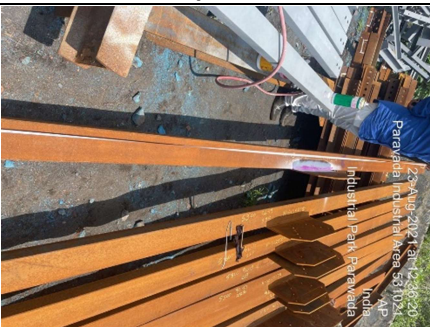
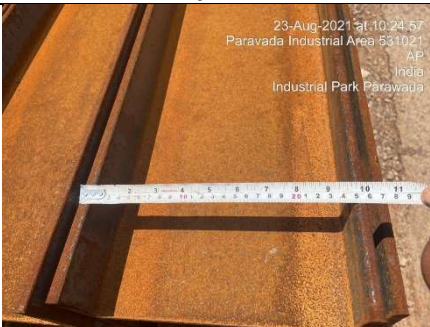
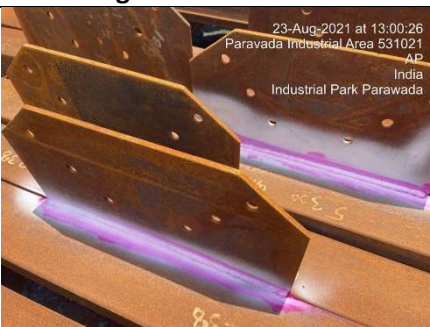



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<p>Dimensional inspection</p> 	<p>Dimensional inspection</p> 
<p>Dimensional inspection</p> 	<p>Dimensional inspection</p> 
<p>DP Testing</p> 	<p>DP Testing</p> 
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