



## Vendor Document Review Sheet (DECAL)



PROJECT TITLE:

BS IV PROJECT, IOCL BARAUNI REFINERY

VENDOR NAME:

HEURTEY PETROCHEM INDIA PVT. LTD

DOCUMENT TITLE:

INSPECTION AND TEST PLAN (FOR RADIANT CASTINGS)

VENDOR DOCUMENT NO:

0900-FQ-606

VENDOR REVISION NO:

1

### VENDOR DOCUMENT REVIEW FEEDBACK

Permission to proceed does not constitute acceptance or approval of Design Detail, Calculations, Analysis, Test Methods or Materials developed OR selected by Vendor, and does NOT relieve Vendor from FULL compliance with Contractual Obligations

By: \_\_\_\_\_

Date: \_\_\_\_\_

Discipline:

Equipment No.

902-F-01 & 903-F-01/02/03/04

MR Number

0 6 8 1 0 7 C 0 0 1 9 0 3 S R 0 1 1 9 0 0 1 B

Project No

068107C001

MRP No

0 6 8 1 0 7 C 0 0 1

9 0 3

M R

0 1 1 9

0 0 1

Standard Code

B 1 0 0 2

Seq. No.

0 5 6

Rev No

0 1

# HEURTEY PETROCHEM

PROJECT : IOCL BARAUNI  
BARAUNI, BIHAR - INDIA

REF. HPC : NI17008

REF. CLIENT : -


REF. SUPPLIER : 305045 / HASTALLOY INDIA LIMITED

DOCUMENT : INSPECTION AND TEST PLAN (FOR RADIANT CASTINGS)

DOC N° 916

DOCUMENT N° : NI17008-0900-FQ-606


REVISION : 1


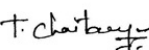


 <b>HEURTEY PETROCHEM</b>	<input checked="" type="checkbox"/>	A - REVIEWED WITHOUT COMMENTS Manufacturing may proceed	BY : Sawant SANDEEP				
		B - REVIEWED WITH COMMENTS / RESUBMIT Manufacturing may proceed if comments are incorporated	DATE : 30/05/2018				
		C - REVIEWED WITH COMMENTS / RESUBMIT Resubmit before manufacturing	PO N° 305045				
		D - FOR INFORMATION ONLY	EQUIPMENT TAG 902-F-01/903-F-01/02/03/04				
HEURTEY STATUS							
<small>Review and/or comments made by HPC on any documents submitted by Vendor shall not relieve Vendor of any of its obligations under the Purchase Order. Under no circumstances can Vendor rely on HPC review or comment in case of rejection or non compliance of the material with the terms and conditions of the purchase order. Please comply for each document with status requirements as indicated by letters A, B, C, or D.</small>			REFERENCE	CODE	TYPE	CLASS	REVISION
			NI17008	0900	FQ	606	1

<input checked="" type="checkbox"/> Project Manager DATE : 25/05/2018 BY : S SANDEEP	<input checked="" type="checkbox"/> Inspection - Expediting DATE : 25/05/2018 BY : M DHARMESH	<input type="checkbox"/> Process DATE : BY :
<input type="checkbox"/> Heaters & Boilers DATE : BY :	<input type="checkbox"/> Instrumentation DATE : BY :	<input type="checkbox"/> Commissioning DATE : BY :
<input type="checkbox"/> Subcontractor DATE : BY :	<input type="checkbox"/> Piping & Pressure vessels DATE : BY :	<input type="checkbox"/> QA/QC DATE : BY :

HEURTEY PETROCHEM Internal transmittal table for comments - DO NOT FILL MANUALLY

 <b>Hastalloy India Ltd,</b> NH-16, IDA, JNPC(PO) Anakapalle - 531 001 Visakhapatnam Dist.(AP)		<b>INSPECTION AND TEST PLAN</b> For Cast Tube Support Hangers, Tube Spacer, U Bolt + 2 Nut + 5 Thk Washer & Seal Plates			Format No.	: HAIL/QC/14 Rev-1		
					Purchaser	: M/s.Heurtey Petrochem India Pvt Ltd., Mumbai.		
					P.O No	: 305045 Dt 19-03-2018		
					Owner	: M/s .Indian Oil Corporation Limited, Barauni Refinery.		
					Project	: Radiant - CCR Platforming Section		
Sr No	Description	Reference Document	Control Requirements	Type of Certificate	HAIL	TPIA	HPIP/TECHNIP	Remarks
1	<u>Heurtey Petrochem Documents</u>				----	----	----	
2.1	Drawings	As per Heurtey FNs	----	----	----	----	----	
2.2	Technical Specification (Technip)	068107C001 000 JSS 0125 001 R0	----	----	----	----	----	
2.3	PMI Specification (Technip)	068107C001 000 0000 PP 509 R0	----	----	----	----	----	
3	<u>Document Submission</u>							
3.1	ITP	ITP No 916	---	---	P	A	A	
3.2	RT Procedure	WO-829-RT	ASME Sec-V	Record	P	A	A	
3.3	PT Procedure	WO-829-PT	ASME Sec-V	Record	P	A	A	
3.4	General Weld Repair Procedure	WO-829-GWR	ASTM A488	Record	P	A	A	
3.5	WPS for 50Cr-50Ni Nb	HQC/005/WPS/4	ASME Sec-IX	Record	P	R	R	
3.6	PQR for 50Cr-50Ni Nb	HQC/005/PQR/4	ASME Sec-IX	Record	P	R	R	
3.7	WPQ for 50Cr-50Ni Nb	HQC/005/WPQ/4	ASME Sec-IX	Record	P	R	R	
4	<u>Pilot Casting</u>							Remarks
4.1	Test Bar Identification	----	----	Pouring Report	P	W	W	Each Heat Test Bar shall be integral Part of Casting.
4.2	Chemical Testing	ASTM A 560 Gr.50Cr-50Ni Cb		MTC	P	R	R	Each Heat
4.3	Mechanical Testing	ASTM A 560 Gr.50Cr-50Ni Cb		MTC	P	W	W	Each Heat
4.4	Radiography Testing	Approved Procedure, Approved Drgs , Technip Spec. No.068107C001 000 JSS 0125 001 R0, ASTM E 446(Level2)		RT Report	P	Review of RT Films		<u>Pilot Casting</u> : 100% Area
4.5	Dimensional Check	As per Approved Drawings & Technip Spec. No.068107C001 000 JSS 0125 001 R0, for un-tolerance Dimensions IS:4897 Cl-II is applicable.		Dimensional Inspection Report	P	W	W	100% Perform by HAIL 100% Witness by TPJA/HPIP/TECHNIP
4.6	PT	As per Procedure, ASTM E165, E433 & Technip Spec. No.068107C001 000 JSS 0125 001 R0,		PT Report	P	W	W	100% Perform by HAIL 100% Witness by TPJA/HPIP/TECHNIP
4.7	Visual Check	MSS SP-55		Visual Inspection Report	P	W	W	100% Perform by HAIL 100% Witness by TPJA/HPIP/TECHNIP
5	<u>Production Castings</u>							Remarks
5.1	Test Bar Identification	----	----	Pouring Report	P	W	W	Each Heat Test Bar shall be integral Part of Casting.
5.2	Chemical Testing	ASTM A 560 Gr.50Cr-50Ni Cb		MTC	P	R	R	Each Heat
5.3	Mechanical Testing	ASTM A 560 Gr.50Cr-50Ni Cb		MTC	P	W	W	Each Heat
5.4	Radiography Testing	Approved Procedure, Approved Drgs , Technip Spec. No.068107C001 000 JSS 0125 001 R0, ASTM E 446(Level2)		RT Report	P	Review of RT Films		100% radiography on 5% of each type production casting (min. 2 per pattern)
5.5	Dimensional Check	As per Approved Drawings & Technip Spec. No.068107C001 000 JSS 0125 001 R0, for un-tolerance Dimensions IS:4897 Cl-II is applicable.		Dimensional Inspection Report	P	RI	RI	100% Perform by HAIL 5% Witness by TPJA/HPIP/TECHNIP 10% Documentation for U-Bolts, Nuts and Washers
5.6	PT	As per Procedure, ASTM E165, E433 & Technip Spec. No.068107C001 000 JSS 0125 001 R0,		PT Report	P	RI	RI	100% Perform by HAIL 10% Witness by TPJA/HPIP/TECHNIP
5.7	Visual Check	MSS SP-55		Visual Inspection Report	P	RI	RI	100% Perform by HAIL 10% Witness by TPJA/HPIP/TECHNIP

 <b>Hastalloy India Ltd,</b> NH-16, IDA, JNPC(PO) Anakapalle - 531 001 Visakhapatnam Dist.(AP)		<b>INSPECTION AND TEST PLAN</b> For Cast Tube Support Hangers, Tube Spacer, U Bolt + 2 Nut + 5 Thk Washer & Seal Plates		Format No. : HAIL/QC/14 Rev-1				
	HAIL Work Order No : <b>WO/829/17</b>	QAP No. : <b>916 Rev-1 Dt 17-05-2018</b>	Purchaser : <b>M/s.Heurtey Petrochem India Pvt Ltd., Mumbai.</b>					
		P.O No : 305045 Dt 19-03-2018	Owner : M/s .Indian Oil Corporation Limited, Barauni Refinery.					
		Project : Radiant - CCR Platforming Section						
Sr No	Description	Reference Document	Control Requirements	Type of Certificate	HAIL	TPIA	HPIP/TECHNIP	Remarks
5.8	PMI 100% of All Castings for Alloy Verification	ASTM A 560 Gr.50Cr-50Ni Cb		PMI Inspection Report	P	RI	RI	Ni, Cr, Cb/Nb Elements only. 100% Perform by HAIL 10% Witness by TPIA/HPIP/TECHNIP 10% Documentation for U-Bolts, Nuts and Washers
6	<b>Final Inspection</b>	P.O Requirements & Project Specs.		Inspection Release Note	H	H	H	HPC Shall Review the TPIA IRN, Test Reports.
7	<b>Inspection Release Note</b>	P.O Requirements		Dispatch Clearance	H	---	Issue	
Legend: A :APPROVAL, W:WITNESS, R:REVIEW, H:HOLD POINT, P:PERFORM, RI: RANDOM INSPECTION., MTC : MATERIAL TEST CERTIFICATE								
 								Notes : 1) 50-50 Cr-Ni castings to ASTM Spec. A560 shall be Nb/Cb stabilised type. 2) Castings may be slightly hammered to find out blisters, cavities, etc., if any.
HASTALLOY INDIA LTD		TUV NORD (TPIA)		HEURTEY PETROCHEM		TECHNIP		