



به نام خدا

شرکت توسعه پلیمر یادجم  
مجری محترم پروژه‌های آفسایت مجتمع  
جناب آقای مهندس مساوات

**موضوع: ارسال ITP اصلاحی برای بسته خرید ایستگاه تقلیل فشار گاز  
پروژه خرید، ساخت، نصب، پیش راه اندازی و راه اندازی تأسیسات بخش مشترک (آفسایت) پارک  
استاین شرکت توسعه پلیمر یادجم، شماره قرارداد: PJPC-98-36**

با سلام

احتراماً حسب دستور آن کارفرمای محترم ITP اصلاحی برای بسته خرید ایستگاه تقلیل فشار گاز با اعمال نقطه نظرات کارفرما به حضور ارسال می‌گردد.

با تشکر

مدیریت پروژه

اسماعیل جلیلی





Procure, Construct, Pre commissioning & commissioning of  
Styrene Park (off-site Facilities & Utilities)



Document Title : Inspection Test Plan (ITP) For GAS  
PRESSURE REDUCING STATIONS

Document No. : E1027-THECO-VD-QC-ITP-007-R01

Rev. R1

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## Inspection and Test Plan (ITP)

1Set Flat Type Gas Pressure Reducing  
T.B.S Station 450-145-6270scmh  
PO No.: OFFSIT-09



*Handwritten signature*



REV.	DATE	REVISION MEMO.	CREATED BY	CHECKED BY	APPROVED BY
01	September 26, 2020	Issue	N.Gholami	M. Garivani	Kh.Mahmoodi
00	September 19, 2020	First Issue	S.Kamrani	M. Garivani	Kh.Mahmoodi



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	00	01	02	03	04	05	06	07	08	00		01	02	03	04	05	06	07	08		
1	X	X									51										
2	X	X									52										
3	X	X									53										
4	X	X									54										
5	X	X									55										
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## 1. General

### 1.1 Introduction

This document covers Inspection & Test Plan for "Reducing and Measuring Station" to be utilized in pipelines or other.

### 1.2 Definitions

The following terms and abbreviations are used in the present document.

ITEM	Correspondences
Project	Reducing and Measuring Station
Client	Pad Jam Polymer Development Company
Contractor	Petro electric Energy Development Company
Consultant	Bina Design and Construction Company
Vendor	Toos Hengam Engineering Co.

## 2. Applicable Documents (Spec & Standards)

- ASME
- IGS
- ASTM





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### 3. Abbreviations

**H:** Vendor shall not carry out:

- any fabrication and/ or repair work and any shipment without having inspector's confirmation / comments
  - any controls and test without inspector attendance
- inspector attendance is mandatory. Vendor must notify contractor by E-mail as per defined communication line at least 2 weeks before the test date for domestic manufacturers and 20 days for overseas. No deviation is allowed from the above mentioned issues unless specially approved by Client / Contractor in writing.

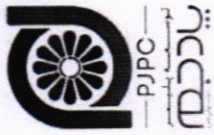
**W:** Vendor must notify contractor of the dedicated inspection activity at least 2 weeks before the test date for domestic manufacturers and 20 days for overseas. Inspector's attendance is not mandatory.

**SW:** At least inspection of 15% of each subjected item shall be done under the supervision of involved inspectors. Relevant inspection notification shall be submitted at the beginning of related activities and in case of any failure, at the first case, inspector's supervision increases to 30% of goods and by the second failure, whole activity shall be witnessed by inspectors.

**R:** Review (It is processed through reviewing any results of inspection or test as a method of ensuring that the inspection or test is performed in accordance with any approved drawing, procedure, specifications or acceptance criteria. (Certificates).

**RA:** induces reviewing of all related reports/certificates which vendor shall provide at each step and vendor shall not proceed his fabrication/test unless receiving inspector's approval.





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Row	Activities	Reference Documents	Acceptance Criteria	Inspection Frequency	Verifying Document	Vendor	Contractor	TPI	Client
A	Pre-Inspection Meeting (PIM)	Project Specification	-	-	MOM- ITP	H	H	R	H
<b>1</b>	<b>Document Review (Before Manufacturing)</b>								
1-1	Documentation (DWG, Calculation, Data Sheet, Procedures, ...) Sub Vendor List	Approved VPIS	IGS	-	Approved Doc.	H	RA	R	RA
1-2	WPS&PQR	ASME IX	ASME IX	100%	WPS&PQR	H	RA	R	RA
1-3	Welder Qualification Certificates	ASME IX	ASME IX	100%	Certificate	H	R	R	R
1-4	NDE Personal Certificate	ASNT-TC-1-A	ASNT-TC-1-A	100%	Certificate	H	R	R	R
<b>2</b>	<b>Fabrication (During Manufacturing)</b>								
2-1	Material Certificate(Pipe, Flange & Fitting)	Original / true copy of MTC from AVL	IGS	100%	MTC, Quantity check and VT report	H	H	H	R
2-2	Visual and Material Inspection (Valve's, Regulator, SSOV, SRV) (if Applicable)	Approved sub vendor list	IGS	100%	All mandatory QC record/ certificates such as calibration, function, hazardous are certificate (if required) etc.	H	H	H	R
2-3	Fit-Up	WPS & DWG	WPS & DWG	100%	Fit up report	H	R	R	R
2-4	Visual Check of Welding	WPS	WPS	100%	VT Test Report	H	R	R	R
2-5	NDT(RT) <sup>2</sup>	NDT Map	NDT Procedure	100%	RT Test Report	H	RA	RA	R
2-6	NDT(PT/MT) <sup>2</sup>	NDT Map	NDT Procedure	20%	PT/MT Test Report	H	SW	SW	R
2-7	Hydrostatic Test	Hydrostatic Procedure	Hydrostatic Procedure	100%	Hydrostatic Test Report	H	H	H	W
2-8	Final Painting	Painting Procedure	Painting Procedure	100%	Painting Report	H	W	W	R

Note(s):

- All inspections of raw materials (including bulk components or sub-components) are performed in the THECO shop.
- although the inspection status is RA for Contractor & TPI, Vendor shall submit an inspection notification similar to the hold point for inspector attendance at RT film interpretation.
- According to project specification, all butt weld shall be 100% examined by RT





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Row	Activities	Reference Documents	Acceptance Criteria	Inspection Frequency	Verifying Document	Vendor	Contractor	TPI	Client
<b>3</b>	<b>Final Test / Activities (Final Inspection)</b>								
3-1	Final visual & dimensional check	DWG	DWG	100%	Test Report	H	H	H	R
3-2	Final Inspection, Performance & Pneumatic test (if applicable)	Pneumatic & Performance Test Procedure	Pneumatic & Performance Test Procedure	100%	Test Report	H	H	H	W
3-3	Check of Name Plate	DWG	DWG	100%	-	H	W	SW	R
3-4	Packing and marking	Packing and marking Procedure	(including checking project main and spare parts)	100%	Packing List	H	H	H	W
3-5	Release Note	Project ITP, Packing list & PO	Project ITP, Packing list & PO	100%	IRN/Packing List	R	R	H	R
3-6	Final book	Project Specification	Project Specification	100%	---	H	RA	-	RA

