

Nash Engineering FZCO


DOCUMENT COVER SHEET

DOCUMENT TITLE

INSPECTION & TEST PLAN

ITP NO : NASH -ITP-S -N-8356-001

CLIENT ENERPROCESS
PROJECT NAME TBA
MANUFACTURER NASH ENGINEERING FZCO
ADDRESS JEBEL ALI FREE ZONE , DUBAI, U.A.E.
NASH W.O.NO N-8356
DESCRIPTION STRUCTURAL SUPPORTS
P.O.NO. ENER-NASH-2025-PO-200

REV	COMMENTS	DATE	NASH	ODS MIDDLE EAST
				
01	FOR APPROVAL	22.03.2025		
00	FOR APPROVAL	11.03.2025		

INSPECTION & TEST PLAN

CLIENT	ENERPROCESS	ITP NO : NASH -ITP-S -N-8356-001	Rev. 01	DATE : 22.03.2025
PROJECT	TBA	JOB TITLE	STRUCTURAL SUPPORTS	
P.O.No & Date	ENER-NASH-2025-PO-200	DRG. NO.	TBA	
W.O.NO	N-8356			
NASH	R.ANANTHAKRISHNAN			
CLIENT				

SL NO	QUALITY RELATED ACTIVITY	REFERENCE	CHARACTERISTICS TO	ACCEPTANCE	VERIFYING	AGENCY										REMARKS
		DOCUMENTS	BE VERIFIED	STANDARD	DOCUMENTS	NASH	MUSCAT NATIONAL	CLIENT								
INSPECTION & TEST PLAN (FOR SUPPORTS)																
1.0	Review fabrication drawing	AWS D1.1	Drawings	AWS D1.1	Project Documents.	H				R&A						
	Review Vendor procedure documents :															
2.0	Welding Procedures & Procedure Qualification Records	AWS D1.1	Approved WPS / PQR	AWS D1.1	WPS / PQR	H				R&A						
3.0	Welder's list & Welder's Performance Qualification Records	AWS D1.1	Approved WPQR	AWS D1.1	WPQR	H				R&A						
4.0	NDE Procedure (MT)	Approved procedure	Approved Procedures	ASME SEC V	NDE Procedure	H				R&A						
5.0	NDE Personnel and Certificates	ASNT-SNT-TC-1A	Qualification & Renewal of operators.	ASNT-SNT-TC-1A	Certificates	H				R&A						
6.0	Surface Preparation & Painting	Approved procedure	Surface Preparation & Painting of filters.	Approved Drg / Data Sheets , □	Painting Procedure	H				R&A						
7.0 MATERIAL PREPARATION & PRE FABRICATION																
7.1	Material Test Certificate	ASME Sec II Part - A	Chemical & Mechanical Properties , Markings, Minimum Thk and Surface Conditions.	As per Approved Drawing in accordance with ASME Sec II Part - A	MTC & Inspection Report.	H				R&A						
7.2	Visual & dimensional of raw material	As per material specification	Visual & dimensional inspection	As per Approved Drawing in accordance with ASME Sec II Part - A.	MTC & Inspection Report.	H				R&A						

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8.0	FABRICATION												
8.1	Fit-up check	AWS D1.1	Drawings	As per Approved Drawing	Inspection Report	H				R			
9.0	Visual Inspection of weld												
9.1	Visual inspection of weld attachment	AWS D1.1 ; Approved weld visual procedure	Approved Drawing , Length , Profile Cutting of plates dimensions and marking.	Approved Drawing & ASME Sec V, Project Specification. , AWS D1.1 Table 8.1	H				W			
10.0	Non Destructive Examination												
10.1	10% MPI on All welds	Approved NDE procedures	Weld Soundness & Quality	Approved Drawing, NDE Procedure & AWS D1.1 Table 8.1	MPI REPORTS	H				W			
11.0	Visual & Dimensional Check												
11.1	Final visual & Dimension	Approved drawing	Parellality, Perpendicularity Orientation, Dimensions& Alignment	Approved Drawing & AWS D1.1	H				H			
12.0	Coating												
12.1	Blasting	As per approved procedure	Surface profile Measurement	Approved drawing & As per approved procedure	Inspection Report.	H				W			
12.2	Final paint , Visual & DFT	As per approved procedure	DFT Measurement	Approved drawing & As per approved procedure	Inspection Report.	H				W			
13.0	Packing & Preservation	Drawing	Visual inspection	Packing procedure & Project Specification	Packing List	H				H			
14.0	MRB Review	MRB	Project Specification/ PO.	MRB	H				R&A			
15.0	Issue of Release Note		Project Specification / PO.	IRN	H				H			

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LEGEND:

- H - HOLD POINT: Verification of Compliance with the applicable Specification is required prior to proceeding (Activity shall not proceed with out approval)
- R - REVIEW of Document and/ or verify the activity
- SW - SPOT WITNESS
- W - WITNESS :Verification of compliance with the specification is required in the form of a documented record of Inspection (Activity may proceed after notifying to witness)
- IW - INTIAL WITNESS ; Witness of First of its type of activity
- S- SURVEILLANCE : Surveillance Inspection during fabrication activity Inspection notification not required
- M - MONITOR: random check by direct or indirect inspection to ensure that the conformance of the item or activity

REFERENCE DOCUMENTS - CODES & STANDARDS

- ASME B31.3 ED 2022
- AWS D1.1 ED.2020
- ASME SEC II PART A,B,C & D-ED 2023
- ASME SEC V - ED 2023
- ASME SEC IX-ED 2023

ABBREVIATIONS

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|--------------------------------|--|
| ITP : Inspection & Test Plan | PIM : Pre-Inspection Meeting |
| DFT : Dry Film Thickness | PMI : Positive Material Identification |
| WFT : Wet Film Thickness | WPS : Welding Procedure Specification |
| MT : Magnetic Particle Testing | PQR : Procedure Qualification Record |
| RT : Radiographic Testing | MTC : Material Test Certificate |
| PT : Penetrant Testing | NA : Not Applicable |
| UT : Ultrasonic Testing | |
| PO : Purchase Order | |
| IRN : Inspection Release Note | |