



Toase-ehe Park Sanati Gohar Ofogh
Petrochemical Co.
**CONCEPTUAL, BASIC and DETAIL DESIGN
ENGINEERING OF STYRENE PARK OFFSITE**



Document Title:
Inspection and Test Plan (ITP) for Ru0001A / B-D-02

Document No.: EI027-ASP-VD-ME-ITP-005

Rev. R1

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STYRENE PARK OFFSITE

Inspection and Test Plan (ITP) for Ru0001A / B-D-02

Rev.	Issued Date	DESCRIPTION	PREPARED	CHECKED	APPROVED
R1	24-Nov.-2024	IFA	F.Malekifar	M.Yasini	GH.Azizi
R0	05-Nov.-2024	IFA	F.Malekifar	M.Yasini	GH.Azizi



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ARKAN SANAT PAYDAR
Procurement & Construction

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REVISION RECORD SHEET

Page Page	Revisions							Page	Revisions						
	R0	R1	R2	R3	R4	R5	R6		R0	R1	R2	R3	R4	R5	R6
1	X	X						41							
2	X	X						42							
3	X	X						43							
4	X	X						44							
5	X	X						45							
6	X	X						46							
7	X	X						47							
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1. Purpose

The inspection and test plan is an engineering document, which defines the type and extent of CONTRACTOR and CLIENT involvement in each phase of fabrication, control and testing requirements and inspection.

2. Applicable Documents

ASME Sec. II	Material
ASME Sec. VIII Div. 1	Rules for Construction of Pressure Vessels
ASME Sec. VIII Div. 2	Rules for Construction of Pressure Vessels, Alternative Rules
ASME Sec. V ASME Sec. IX	Non-Destructive Examination
BS EN 10204 (3.1)	Welding and Brazing Qualifications
ASME Sec. V ASME Sec. IX	Material Certificates
All Standards and Specifications listed in the Requisition	

3. Defenitions

Abbr.	Description
PROJECT	Receiver Header/ PR200
Client / TPI	HSE
(C) CONTRACTOR	Toase-ehe Park Sanati Gohar Ofogh
(V) Vendor	Arkan Sanat Paydar Company(ASP)

4. Definition of CONTRACTOR and CLIENT / TPI Involvement





The nature of CONTRACTOR and CLIENT involvement is indicated against each activity of fabrication and testing by means of the letters H, W, SW, R and A with the following definitions:

H: (Hold) Point

The VENDOR cannot carry out the specified controls and tests without CONTRACTOR and CLIENT attendance and witnessing. The VENDOR must notify CONTRACTOR by fax of the dedicated inspection activity at least twenty (20) Calendar days in advance and consequently CLIENT will be informed by CONTRACTOR. The VENDOR cannot deviate from this rule unless written approval has been given by CONTRACTOR.

W:(Witness)

The VENDOR must notify CONTRACTOR of the dedicated inspection activity at least twenty (20) Calendar days in advance and consequently CLIENT will be informed by CONTRACTOR. Although CONTRACTOR and CLIENT witnessing is not mandatory.

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If CONTRACTOR does not elect to be present, the VENDOR may proceed with his own inspection, provided controls and test records are made available to CONTRACTOR for review.

SW: (Spot Witness)

Spot Witness denotes to random attendance of inspector without any invitation from the VENDOR and without advance notification by the CONTRACTOR to the VENDOR.

R: (Review)–Review of Documents

The VENDOR has either to submit to CONTRACTOR for review and comments the documents required prior to the performance of the dedicated activity or to transmit or make available for the review of CONTRACTOR the result of the controls and tests conducted, as the case may be. Consequently CLIENT will be informed by CONTRACTOR.

A: (Approval)–Approval of Documents

The VENDOR has either to submit to CONTRACTOR for comments and approvals the documents required prior to the performance of the dedicated activity or to transmit or make available for the approval of CONTRACTOR the result of the controls and tests conducted, as the case may be. VENDOR is not allowed to proceed the work before receipt of CONTRACTOR approval on the required documents.





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Table: Inspection Activities

ROWS	INSPECTION ACTIVITIES	APPLICABLE DOCUMENTS	VENDOR	CONTRACTOR	CLIENT / TPI
1	VENDOR's Quality Control Plan	VENDOR's Document	H	R	R
2	Pre-Inspection Meeting	Agenda	H	H	H
3	Material Test Certificate	BS EN 10204 (3.1)	H	R	R
4	Checking The Material With Requirements of Requisition	Requisition	H	W	W
5	Inspection of Sub Ordered Components	Requisition	H	W	R
6	Material identifications and markings	-	H	W	W
7	Storage of materials and welding consumables	-	H	W	R
8	WPS/PQR	Design Code,ASME Sec IX	H	R/A	R
9	Production Test Coupons (if required)	Design Code,ASME Sec IX	H	R/A	R
10	NDT Personnel's Qualification	Design Code,ASME Sec V,ASNT Lev.II or eqv.	H	R/A	R
11	Material Traceability	-	H	R	R
12	Dimensional check (before forming & rolling)	Approved Drawings	H	W	R
13	Cutting, Forming, Rolling, Punching, Drilling, Tacking and Fit up	Approved Drawings	H	W	R
14	Inspection of Back Gouged portions of edges prepared for welding by MT or PT	Design Code, ASME Sec V	H	W	W
15	Welding	Design Code,ASME Sec IX	H	W	W



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Please add below inspection step for Head to ITP

ROWS	INSPECTION ACTIVITIES	APPLICABLE DOCUMENTS	VENDOR	CONTRACTOR	CLIENT / TPI
16	Confirmation of NDT Results RT, UT, MT, PT (Review of all Radiographs)	Design Code, ASME Sec V	H	W/A	W
17	Stress Relieving on dished head	ASME Sec VIII Div 1, Approved Drawings, Approved PWHT Procedure	H	R	R

5.0 Dish Head Forming						
NO.	ACTIVITY	REFERENCE	DESCRIPTION	APPLICABLE DOCUMENTS	REPORTS	REQUIREMENTS
5.1	MT on Bevel Cut Edges	Approved MT Procedure	Weld visual for defects	App.8 ASME Sec VIII Div 1; Approved MT Procedure	MT Reports	H
5.2	MT/100% on knuckle & crown areas	Approved MT Procedure	Weld visual for defects	App.8 ASME Sec VIII Div 1; Approved MT Procedure	MT Reports	H
5.3	Inspection After dish forming - UT thickness verification, Dimensional & visual Check	UG 79, UCS 79 ASME Sec VIII Div 1	Dimensional check	Approved Drawing	Inspection Reports	H
5.4	Stress Relieving on dished head	ASME Sec VIII Div 1, Approved Drawings, Approved PWHT Procedure	Material thickness, WP requirements, Loading temperature, Rate of heating, Soaking time, Rate of cooling, Unloading temperature & Thermocouple locations	ASME Sec VIII Div 1 - UCS-56, Approved PWHT procedure	Inspection, Heat Treatment Report, Chart, calibration certificates	H

	CHECK	DRAWINGS			
23	Reinforcing Pad air-soap test	Requisition	H	W	W
24	Leakage Test/Hydrotest	Requisition	H	H	H
25	Complete Draining and drying, N2/VPT/desiccant filling, (which applicable)	Requisition	H	W	W
26	Surface Preparation, Anti-Corrosion /Painting	Requisition	H	W	W
27	Name plate, Cleanliness, Tagging and Marking	Requisition	H	W	W
28	Packing/ Preparation for Shipment	Requisition	H	W	W
29	Check Identification and Destination Marking	Requisition	H	W	-
30	Final Inspection Prior to Shipment	Requisition	H	H	W
31	Non Conformities Treatment	Requisition	H	H	W
32	NDT Documents	Design Code, ASME Sec V	H	R/A	R
33	Documentations	Requisition	H	A	W/R



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ROWS	INSPECTION ACTIVITIES	APPLICABLE DOCUMENTS	VENDOR	CONTRACTOR	CLIENT / TPI
34	Control of Packing List	-	H	H	-
35	Deviations	-	H	H	W/R
36	Final Inspection / Data Book	Requisition	H	H/A	W/R
37	Release Note	-	H	H	H