



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



ARKAN SANAT PAYDAR  
 Procurement & Construction

Document Title:  
 Inspection and Test Plan (ITP) For Steel Structure





Rev. R0

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## Inspection and Test Plan (ITP) For Steel Structure

Rev.	Date	Status	Description	Prepared	Checked	Approved	AC
00	8-Jan-2025	F1	Issued for Approval	F.M	M.Y	GH.A	



 	<b>Toase-ehe Park Sanati Gohar Ofogh Petrochemical Co.</b> <b>CONCEPTUAL, BASIC and DETAIL DESIGN ENGINEERING OF STYRENE PARK OFFSITE</b>	 
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### 1- Definition of PURCHASER AND OWNER / TPI Involvement:

<b>Project</b>	Structure Fabrication of Chiller Skid
<b>Owner</b>	Polymer Pad Jam Co.
<b>Vendor</b>	Arkan Sanat Paydar Company(ASP)
<b>Contractor</b>	HSE
<b>MC</b>	Toase-ehe Park Sanati Gohar Ofogh

### 2- ABBREVIATION

Abbreviations used in this document are defined as follows:

#### **H: (Hold) Point**

The VENDOR must notify PURCHASER/OWNER by fax of the dedicated inspection activity at least four (4) Calendar days in advance. The VENDOR cannot deviate from this rule unless written approval has been given by PURCHASER/OWNER. The VENDOR cannot carry out the specified controls and tests without PURCHASER/OWNER attendance and witnessing.

The VENDOR must notify PURCHASER by email of the dedicated inspection activity at least four (4) Calendar days in advance. The VENDOR cannot deviate from this rule unless written approval has been given by PURCHASER



#### **W: (Witness)**

The VENDOR must notify PURCHASER of the dedicated inspection activity at least four (4) Calendar days in advance but PURCHASER/OWNER witnessing is not mandatory.

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

#### **SW: (Spot Witness)**

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

 	<p style="text-align: center;"><b>Toase-eh Park Sanati Gohar Ofogh Petrochemical Co.</b></p> <p style="text-align: center;"><b>CONCEPTUAL, BASIC and DETAIL DESIGN ENGINEERING OF STYRENE PARK OFFSITE</b></p>	  
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**R: (Review) - Review of Documents**

The VENDOR has either to submit to PURCHASER 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 PURCHASER the result of the controls and tests conducted, as the case may be.

**A: (Approval) - Approval of Documents**

The VENDOR has either to submit to PURCHASER 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 PURCHASER the result of the controls and tests conducted, as the case may be, VENDOR is not allowed to proceed the work before receipt of PURCHASER approval on the required documents.



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ITEM DESCRIPTION		MANUFACTURER	LEGEND:						
Steel Structures Compressor Skid Bases		NASH, UAE	AR Approval Required	W Witness Point				MFR MANUFACTURER	
			H Hold Point	MTR Material Test Report				CON CONTRACTOR, INC.	
			R Document Review	T/C Test Certificate Required				CL CLIENT	
			V Visual Inspection	HR Hold for Review					
				JIS Japanese Standard					
NO	QUALITY RELATED ACTIVITY	APPLICABLE SPECIFICATION	ACCEPTANCE CRITERIA	VERIFYING DOCUMENT	CONTROL POINTS			T/C	REMARKS
					MFR	CON	CL		
1	Skid Base Design & Material Identification	AISC, ASTM, AWS, MFR Engineering Standard,	AWS & Approved MFR Engineering Standard	Skid Base Drawing PR200 (Internal Drawing) Weld Map	H		R	-	
2	Welding Procedure Selection & Welder Performance Qualifications & Records	AWS & MFR Engineering Standard	AWS, Approved MFR Engineering Standard	WPS, PQR & Welder Qualification Records	H		R & A	-	
3	Physical & Chemical Analysis	ASME, MFR Engineering Standard	ASME, Approved MFR Engineering Standard	Material Test Reports	H		R	MTR	
4	In-Process Fabrication Inspection: - Verify that All Structural Steel Sizes Have Been Properly Received for the Job - Check that the Flame Cut Edges are Ground Smooth & Cleaned During Fit-up - Verify that the Welding Rod to be Used is Suitable for the Structural Materials as per the Welding Procedures - Re-Check Lay-Out Dimensions, Leveling, Squareness, & Workmanship of Fit-Up Before & After Welding - Welding a) Full Penetration b) Verification of Seal Welding Performed c) 100% UT or MT on Lifting Lugs	AWS, MFR Engineering Standard	AWS & Approved MFR Engineering Standard	ITP Sign-Off	H		W	-	MT REPORT
5	Final Visual & Dimensional Inspection - Shop Assembly & Fabrication Tolerances	AISC, MFR Engineering Standard	Approved MFR Engineering Standard	Skid Base Drawing PR200 (Internal Drawing)	H		H	-	DIMENSION REPORT
6	Surface Preparation / Painting	MFR Engineering Standard	Approved MFR Engineering Standard	Painting Procedure PR200	H		R	-	PAINT REPORT
7	Preparation for Shipment	MFR Engineering Standard	Approved MFR Engineering Standard	MFR Standard Certificate (Packing List)	H/R		W	T/C	