

 <p>شرکت توسعه صنایع لوان Lavan Industry Development Company</p>	<p>LIDCO, Pars SEE Zone, Assaluyeh, Integrated Methanol and Ammonia Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT</p>																				
	<p>Hydrotest procedure</p>																				
<p>Document No. 17735-17</p>		<p>Page</p>																			
<table border="1"> <tr> <th>Project No.</th> <td>N278</td> </tr> </table>	Project No.	N278	<table border="1"> <tr> <th>Vendor Doc.</th> <td>VD</td> </tr> </table>	Vendor Doc.	VD	<table border="1"> <tr> <th>P.O. No.</th> <td>6019</td> </tr> </table>	P.O. No.	6019	<table border="1"> <tr> <th>Department</th> <td>GN</td> </tr> </table>	Department	GN	<table border="1"> <tr> <th>Document Type</th> <td>PRC</td> </tr> </table>	Document Type	PRC	<table border="1"> <tr> <th>Serial No</th> <td>0018</td> </tr> </table>	Serial No	0018	<table border="1"> <tr> <th>Revision</th> <td>06</td> </tr> </table>	Revision	06	<p>Page 1 of 6</p>
Project No.	N278																				
Vendor Doc.	VD																				
P.O. No.	6019																				
Department	GN																				
Document Type	PRC																				
Serial No	0018																				
Revision	06																				

**Airpack B.V. - Air Compressor –
Integrated Methanol and Ammonia Plant
17735-COM Hydrotest procedure (K020)**

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Hydrotest procedure




Document No. 17735-17

Page

Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision	Page
N278	VD	6019	GN	PRC	0018	06	Page 2 of 6

LIST OF REVISED PAGES

Rev. Page	01	02	03	04	05	Rev. Page	01	02	03	04	05	Rev. Page	01	02	03	04	05	Rev. Page	01	02	03	04	05
1	X	X	X	X	X	26						51						76					
2	X	X	X	X	X	27						52						77					
3	X	X	X	X	X	28						53						78					
4	X	X	X	X	X	29						54						79					
5	X	X	X	X	X	30						55						80					
6	X	X	X	X	X	31						56						81					
7						32						57						82					
8						33						58						83					
9						34						59						84					
10						35						60						85					
11						36						61						86					
12						37						62						87					
13						38						63						88					
14						39						64						89					
15						40						65						90					
16						41						66						91					
17						42						67						92					
18						43						68						ATTACHMENT					
19						44						69						1					
20						45						70						2					
21						46						71						3					
22						47						72						4					
23						48						73						5					
24						49						74						6					
25						50						75						7					

	LIDCO, Pars SEE Zone, Assaluyeh, Integrated Methanol and Ammonia Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT						
	HYDROTEST PROCEDURE						
Document No. 17735-17			Page				
Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision	
N278	VD	6019	GN	PRC	0018	06	3 of 6

Hydrostatic test

This procedure is applicable to all items subject to a hydrostatic test. Refer to project Inspection & Test Plan for the items subject to a hydrostatic test.

Following procedures will be maintained before and during testing:

- Before test, tested equipment will be inspected properly by the Airpack quality manager.
- Two calibrated pressure gauges will be installed on the highest and lowest position clearly readable.
- Test pressure will be between 50% and 75% of range of used pressure gauges (where possible)
- Used gauges are direct reading type and pressure should be stable during testing.
- Duration of test will be 1 hour as required per authorities code (ASME B31.3 for piping and ASME VIII latest edition for vessels)
- Prior to carrying out the hydrostatic test, weld of reinforcing pad will be leak tested (max 1 bar(g)) by air via tell tail hole and inspected with soap and water (if applicable).
- All oil, grease, dirt and foreign material will be removed.
- Start and end pressure will be recorded by hand during hydro test.




Below Items are tested separately, no complete hydrostatic test of package is done.

Cooling water piping (carbon steel)

This test is executed by sup-supplier or Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 50 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure: 1.3x design pressure for the following items (as per P&ID drawing 17735-03)

- Piping cooling water inlet / inter- aftercooler : 9,1 bar(g)
- Piping inter- aftercooler / cooling water outlet : 9,1 bar(g)

 <p>شرکت توسعه صنایع لوان Lavan Industry Development Company</p>	<p>LIDCO, Pars SEE Zone, Assaluyeh, Integrated Methanol and Ammonia Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT</p>						
	<p>HYDROTEST PROCEDURE</p>						
<p>Document No. 17735-17</p>			<p>Page</p>				
<p>Project No.</p>	<p>Vendor Doc.</p>	<p>P.O. No.</p>	<p>Department</p>	<p>Document Type</p>	<p>Serial No</p>	<p>Revision</p>	<p>Page</p>
<p>N278</p>	<p>VD</p>	<p>6019</p>	<p>GN</p>	<p>PRC</p>	<p>0018</p>	<p>06</p>	<p>4 of 6</p>

Main Process Air Piping (SS316)

This test is executed by sup-supplier or Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 50 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure: 1.3x design pressure for the following items (as per P&ID drawing 17735-03)

- Piping Package inlet / 1st stage suction : 16,25 bar(g)
- Piping 1st stage discharge / 2nd stage suction : 39,65 bar(g)
- Piping 2nd stage discharge / package outlet : 50,7 bar(g)

Inter- Aftercooler (SS316)

This test is executed by sup-supplier or Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 50 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Minimum hydrostatic test pressure: 1.3x design pressure for the following items (as per P&ID drawing 17735-03)




- Intercooler KE-020-001 shell (SS316) : 39,65 bar(g)
- Intercooler KE-020-001 Tubes (SS316) : 9,1 bar(g)
- Aftercooler KE-020-002 shell (SS316) : 50,7 bar(g)
- Aftercooler KE-020-002 Tubes (SS316) : 9,1 bar(g)

Pulsation Dampeners (carbon steel)

This test is executed by sup-supplier or Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 50 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Minimum hydrostatic test pressure: 1.3x design pressure for the following items (as per P&ID drawing 17735-03)

- Pulsation dampener KV-020-001 : 16,25 bar(g)
- Pulsation dampener KV-020-002 : 39,65 bar(g)
- Pulsation dampener KV-020-003 : 50,7 bar(g)
- Pulsation dampener KV-020-004 : 50,7 bar(g)

 <p>شرکت توسعه صنایع لوان Lavan Industry Development Company</p>	<p>LIDCO, Pars SEE Zone, Assaluyeh, Integrated Methanol and Ammonia Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT</p>						
	<p>HYDROTEST PROCEDURE</p>						
<p>Document No. 17735-17</p>			<p>Page</p>				
<p>Project No.</p>	<p>Vendor Doc.</p>	<p>P.O. No.</p>	<p>Department</p>	<p>Document Type</p>	<p>Serial No</p>	<p>Revision</p>	<p>Page</p>
<p>N278</p>	<p>VD</p>	<p>6019</p>	<p>GN</p>	<p>PRC</p>	<p>0018</p>	<p>06</p>	<p>5 of 6</p>

Compressor pressure parts




This test is executed by sup-supplier or Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 50 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure will be 1.5x design pressure. (45,75 bar(g) / 58,5 bar(g)) and as per approved datasheet.

After test,

- o Equipment must be free from any unexpected condition
- o Equipment will be dried and cleaned appropriately. Stainless steel will be cleaned by pressurized air.
- o Witnessed test report shall be issued by QA department.

Hydrostatic test will be done after completion of all welding and before any painting activities

	LIDCO, Pars SEE Zone, Assaluyeh, Integrated Methanol and Ammonia Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT																				
	HYDROTEST PROCEDURE																				
Document No. 17735-17			Page																		
<table border="1"> <thead> <tr> <th>Project No.</th> <th>Vendor Doc.</th> <th>P.O. No.</th> <th>Department</th> <th>Document Type</th> <th>Serial No</th> <th>Revision</th> </tr> </thead> <tbody> <tr> <td>N278</td> <td>VD</td> <td>6019</td> <td>GN</td> <td>PRC</td> <td>0018</td> <td>06</td> </tr> </tbody> </table>	Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision	N278	VD	6019	GN	PRC	0018	06							6 of 6
Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision															
N278	VD	6019	GN	PRC	0018	06															

AIRPACK NEDERLAND B.V.
GROENEWEEGJE 25
4301 RN ZIERIKZEE
THE NETHERLANDS

HYDROSTATIC TEST CERTIFICATE

Customer :
Purchase Order number :
Equipment :
Airpack reference :
Serial number :
Date :

We certify that the here under mentioned test data is true and correct.
The test procedure is in accordance with ASME B31.3 & Hydrostatic Test Procedure doc number : 17735-17

Subject name :
Subject number :
Drawing no. :
Test no. : 01 of 0X

HYDROSTATIC TEST:

Fluid :
Test date :
Constant during : 1 hour.
Test pressure :

RECORDED PRESSURES

Start pressure :
End pressure :
Test pressure gauge number :
Remarks (If any) :

In presence of :

Airpack Approval:

Customer Approval: