

Nash Engineering FZCO


DOCUMENT COVER SHEET

DOCUMENT TITLE

INSPECTION & TEST PLAN

ITP NO : NASH -ITP-S -N-8366-001

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
				
00	FOR APPROVAL	11.03.2025		

INSPECTION & TEST PLAN

CLIENT	ENERPROCESS	ITP NO : NASH -ITP-S -N-8356-001	Rev. 00	DATE : 11.03.2025
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				

Client

SL NO	QUALITY RELATED ACTIVITY	REFERENCE	CHARACTERISTICS TO	ACCEPTANCE	VERIFYING	AGENCY										REMARKS
		DOCUMENTS	BE VERIFIED	STANDARD	DOCUMENTS	NASH	MUSCAT NATIONAL									
INSPECTION & TEST PLAN (FOR SUPPORTS)																
1.0	Review fabrication drawing Review Vendor procedure documents :	AWS D1.1	Drawings	AWS D1.1	Project Documents.	H									R&A	
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		

Nash ENGINEERING FZCO										
JEBEL ALI FREE ZONE WEST - DUBAI - U.A.E.										
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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			
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										
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										