

CUSTOMER: HSE Group  
 REQUISITION:  
 MAYEKAWA NO.: PR200  
 PROJECT: Refrigeration  
 LOCATION: unit TBA  
 REF. NO.: SQ22000787  
 ITEM NO.: RU0001A/B

# INSPECTION & TEST PLAN (ITP)

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		
9.1	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	---	
9.2	Welding Procedure Selection & Welder Performance Qualifications & Records	AWS & MFR Engineering Standard	AWS, Approved MFR Engineering Standard	WPS, PQR & Welder Qualification Records	H		R&A	---	
9.3	Physical & Chemical Analysis	ASME, MFR Engineering Standard	ASME, Approved MFR Engineering Standard	Material Test Reports	H		R	MTR	
9.4	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	---	
9.5	Final Visual & Dimensional Inspection - Shop Assembly & Fabrication Tolerances	AISC, MFR Engineering Standard	Approved MFR Engineering Standard	Skid Base Drawing PR200 (Internal Drawing)	H		H	---	MT REPORT DIMENSION REPORT
9.6	Surface Preparation / Painting	MFR Engineering Standard	Approved MFR Engineering Standard	Painting Procedure PR200	H		R	---	PAINT REPORT
9.7	Preparation for Shipment	MFR Engineering Standard	Approved MFR Engineering Standard	MFR Standard Certificate (Packing List)	H/R		W	T/C	