



LIDCO, Pars SEE Zone, Assaluyeh,
Integrated Methanol and Ammonia
Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT



Hydrotest procedure

Document No. 17735-03

Page

Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision
N278	VD	6019	GN	PRC	0018	02

Page 1 of 6

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

REV.	DATE	DESCRIPTION	DRAWN	CHECKED	APPROVED
02	06-11-2023	Issued for Approval	S.K.	K.P.	
01	14-09-2023	Issued for Approval	S.K.	J.J.	

INSPECTION

1- APPROVED

2- APPROVED AND NOTED

3- NOT APPROVED

BY: M. REZAEI DATE: 07 Nov 2023

Signature: *M. Rezaei*

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Document No. 17735-03




Page

Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision	Page
N278	VD	6019	GN	PRC	0018	02	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				26						51						76					
2	X	X				27						52						77					
3	X	X				28						53						78					
4	X	X				29						54						79					
5	X	X				30						55						80					
6	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					

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BY: M. REZAEI	DATE: 07 Nov 2023
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	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	02	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 positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. **150** ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Usually maximum allowable content for hydrotest in standards is 50ppm (e.g. API 618). So you are kindly requested to consider 50ppm. Sorry for our previous comment in this regard.

Hydrostatic test pressure: 1.5x design pressure for the following items (as per P&ID drawing 17735-03)

- Piping cooling water inlet / inter- aftercooler : **10,5 bar(g)**
- Piping inter- aftercooler / cooling water outlet : **10,5 bar(g)**

	
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	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	02	4 of 6

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. 10 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure: 1.5x design pressure for the following items (as per P&ID drawing 17735-03)

- Piping 1st stage suction / inlet
- Piping 1st stage discharge / 2nd stage suction
- Piping 2nd stage discharge

: 18,75 bar(g)
 : 45,75 bar(g)
 : 58,5 bar(g)

Inter- Aftercooler

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. 150 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)

- Intercooler E-001 shell (CS)
- Intercooler E-001 Tubes (SS316)
- Intercooler E-002 shell (CS)
- Intercooler E-002 Tubes (SS316)

: 39,65 bar(g)
 : 9,1 bar(g)
 : 51 bar(g)
 : 9,1 bar(g)

since we have comments on design pressures, this document will be checked after finalizing related docs (e.g. drawings, datasheets, P&ID, etc.)

please refer to comment on page 3



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. 150 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure: 1.5x design pressure for the following items (as per P&ID drawing 17735-03)

- Pulsation dampener V-001
- Pulsation dampener V-002
- Pulsation dampener V-003
- Pulsation dampener V-004

: 18,75 bar(g)
 : 45,75 bar(g)
 : 43,5 bar(g)
 : 58,5 bar(g)

	
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	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	02	5 of 6

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. 150 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per TTP.



Hydrostatic test pressure will be 1.5x design pressure. (37,5 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 dep

since we have comments on design pressures, this document will be checked after finalizing related docs (e.g. drawings, datasheets, P&ID, etc.)

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

	
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	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	02	6 of 6

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 : 30 min.
 Test pressure :


RECORDED PRESSURES

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

In presence of :

Airpack Approval:

Customer Approval:

	
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BY: M.REZAEI DATE: 07 Nov 2023	
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