



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



INSPECTION AND TEST PLAN (ITP)



Document No. 17735-08

Page

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N278	VD	6019	GN	ITP	0008	02

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Inspection and Test Plan for Air Compressor Package (K-020)

 NARGAN COMPANY	
INSPECTION	
1- APPROVED	<input type="checkbox"/>
2- APPROVED AS NOTED	<input checked="" type="checkbox"/>
3- NOT APPROVED	<input type="checkbox"/>
BY: M. REZAEI DATE: 22 Nov 2023	
SIGN: 	

REV.	DATE	DESCRIPTION	DRAWN	CHECKED	APPROVED
02	13-11-2023	Issued for Approval	SK	LvG	
01	14-09-2023	Issued for Approval	SK	LvG	JJ

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5	X	X				30						55						80						
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7	X	X				32						57						82						
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PROJECT : Integrated Methanol and Ammonia Plant				VENDOR: Airpack Netherlands B.V.		EQUIPMENT/PKG: K-020		
COMPANY: Lavan Industry Development Company of Iran			MR. NO.: N278-000-ME-MR-1020-001-02		SUBVENDOR: According to N-278-VD-6019-GN-EQL-0038		COMMODITY / ITEM NAME: Instrument air	
PURCHASER: Nargan Company			P.O.NO.: LIDCO-PO-NEC-278-6019		ISSUE DATE: 10-8-2023		QTY: 01 Page: 01	
ACTIVITY NO.	INSPECTION STAGE / ACTIVITY	APPLICABLE DOCUMENTS (Note-1)	VERIFYING DOCUMENT	PARTICIPATION BY:				REMARKS
				VENDOR	Nargan	LIDCO	TPA	
Before manufacturing								
1	Pre- Inspection	GAD approval P&ID approval Painting procedure approval Welding documents approval Inspection and test plan approval Datasheets approval	PIM MOM As per PO / MR / Project Specifications	HP	HP	HP	R	

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INSPECTION AND TEST PLAN (ITP)

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ACTIVITY NO.	INSPECTION STAGE / ACTIVITY	APPLICABLE DOCUMENTS (Note-1)	VERIFYING DOCUMENT	PARTICIPATION BY:				REMARKS	
				VENDOR	Nargan	LIDCO	TPA		
COMPRESSOR									
2.1	Component check Complete compressor	Approved mechanical datasheet	Drawing of compressor	HP	R	R	SW		
2.2	Materials inspection Visual and certificate check for cylinders and cylinder heads of the compressor	EN 10204 Approved mechanical datasheet	3.1 material certificate	HP	R	R	W	Review of material certificates	
2.3	Hydrostatic test Compressor cylinders	Approved hydrotest procedure	Hydrostatic test certificate	HP	R	R	W		
SKID base and lifting frame									
3.1	Materials inspection Visual check Certificate check	EN 10204 ASME Sec II, 2019	EN 10204 / 2.1 material certificate Lifting lugs: 3.1 material certificate	HP	R	R	SW	Review of material certificates	
3.2	Welding Visual Inspection / dimension check Base frame / lifting lugs skid	AWS D1.1	PQR / WPS	W	R	R			
3.3	NDT Lifting lugs 100% MT	NDT procedure	MT certificate	W	R	R			
3.4	Painting Random Paint thickness check Color check	Approved painting procedure	Painting report	W	R	R			
Piping									
4.1	Materials inspection Visual check Certificate check	EN 10204 ASME Sec II, 2019	EN 10204 / 3.1 material certificate	HP	R	R	W	Review of material certificates	
4.2	Welding Visual check Certificate check	ASME section IX	Approved PQR / WPS	W	R	R	SW		
4.3	NDT Welds check 10% spot RT	NDT procedure	RT certificate	W	R	R			
4.4	Hydrostatic test Piping	Hydrostatic test procedure	Hydrostatic test certificate	W	R	R			
4.4	Painting Random Paint thickness check Color check	Approved painting procedure	Painting report	W	R	R			

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				VENDOR	Nargan	LIDCO	TPA	
Inter- / Aftercooler								
5.1	Component check Visual check for coolers	Approved mechanical datasheet	Drawing of coolers	W	R	R	SW	
5.2	Materials inspection Visual and certificate check of Coolers	EN 10204 ASME sec II, 2019 Approved mechanical datasheet	3.1 material certificate	HP	R	R	W	Review of material certificates
5.3	Hydrostatic test Cooler shells Cooler tubes	Approved hydrotest procedure, according ASME Sec VIII div.1	Hydrostatic test certificate	HP	R	R	W	Done with service gaskets and fasteners
5.4	NDT 10% spot RT for all pressure parts	NDT procedure	RT certificate	HP	R	R	R	
5.5	Repair Execution of major repairs	Approved mechanical datasheet	Drawing of coolers	HP	HP	HP	H	If major repairs are needed
Pulsation Dampeners								
6.1	Component check Visual check for pulsation dampeners 1 st and 2 nd stage	Approved mechanical datasheet	Drawing of pulsation dampeners	W	R	R	SW	
6.2	Materials inspection Visual and certificate check for pulsation dampeners 1 st and 2 nd stage pressure parts	EN 10204 ASME Sec II, 2019	3.1 material certificate	HP	R	R	W	Review of material certificates
6.3	Hydrostatic test Certificate check for pulsation dampeners 1 st and 2 nd stage pressure parts	Approved hydrotest procedure, according to ASME Sec VIII div.1	Hydrostatic test certificate	HP	R	R	W	Done with service gaskets and fasteners
6.4	NDT 10% spot RT for all pressure parts	NDT procedure	RT certificate	HP	R	R	R	
LV motor								
7.1	Routine test Certification check for low voltage motor	Motor datasheet	Routine test certificate Ref. std. : IS: 12615/IEC60034-1	To be added as per agreed ITP: -Execution of Major Repairs(if any) (H)				

motor type test report to be added

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Pressure / temperature gauges								
8.1	Materials inspection Visual and certificate check for pressure / temperature gauges	Approved instrument datasheet EN 10204	3.1 material certificate	HP	R	R	R	Review of material certificates
8.2	Calibration certificate inspection Certificate check for pressure / temperature gauges	Approved instrument datasheet EN 10204	Calibration certificate	HP	R	R		
Pressure / temperature transmitters								
9.1	Materials inspection Visual and certificate check for pressure / temperature transmitters	Approved instrument datasheet EN 10204	3.1 material certificate	HP	R	R	R	Review of material certificates
9.2	Calibration certificate inspection Certificate check for pressure / temperature transmitters	Approved instrument datasheet EN 10204	Calibration certificate	HP	R	R		
9.3	Ingress Protection Declaration check for pressure / temperature transmitters	Approved instrument datasheet EN / IEC 60529	IP 65 declaration	HP	R	R		
Hand valves and strainers								
10.1	Materials inspection Visual and certificate check for hand valves and strainers	Approved instrument datasheet EN 10204	3.1 material certificate	HP	R	R	W	Review of material certificates
10.2	Hydrostatic test Certificate check for hand valves / strainers / body / seat	ASME B31.3 Approved instrument datasheet	Hydrostatic Test Certificate	HP	R	R	R	
10.3	Painting Random paint thickness test Color check	Approved painting procedure	Painting report	W	R	R		
Check valves								
11.1	Materials inspection Visual and certificate check for check valves	Approved instrument datasheet EN 10204	3.1 material certificate	HP	R	R	W	Review of material certificates
11.2	Hydrostatic test Certificate check for check valves	ASME B31.3	Hydrostatic Test Certificate	HP	R	R	R	
11.3	Painting Random paint thickness test Color check	Approved painting procedure	Painting report	W	R	R		

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Pressure control valves								
12.1	Materials inspection Visual and certificate check for pressure control valves	Approved instrument datasheet EN 10204	3.1 material certificate	HP	R	R	R	Review of material certificates
12.2	Hydrostatic test Certificate check for pressure control valves body / seal	ASME B31.3 ANSI B16.37	Hydrostatic Test Certificate	HP	R	R	W	
12.3	Seat Leakage test Certificate check for pressure control valves	ANSI-B16.104 / FCI-70-2	Leakage test certificate	HP	R	R	W	
12.4	Painting Random paint thickness test Color check	Approved painting procedure	Painting report	W	R	R	R	
Pressure safety valves								
13.1	Materials inspection Visual and certificate check for pressure safety valves	Approved instrument datasheet EN 10204 ASME Sec II, 2019	3.1 material certificate	HP	R	R	R	Review of material certificates
13.2	Hydrostatic test Certificate check for pressure safety valves	ASME B31.3 Spec, N278-000-CI-JSS-1545-004.02	Hydrostatic test certificate	HP	R	R	W	
13.3	Tightness test Certificate check for pressure safety valves	API 527 Spec, N278-000-CI-JSS-1545-004.02	Tightness test declaration	HP	R	R		Part of 3.1 material certificate
13.4	Set Pressure Test Checking of setting pressure for pressure safety valves	Spec, N278-000-CI-JSS-1545-004.02	Set pressure test report	HP	R	R		
13.5	Seat tightness test Certificate check for pressure safety valves	API 527 Spec, N278-000-CI-JSS-1545-004.02	Seat tightness test report	HP	R	R	W	Part of 3.1 material certificate
13.6	Painting Random paint thickness test Color check	Approved painting procedure	Painting report	W	R	R	R	

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Junction box								
14.1	Dimensions Visual check for junction boxes	Approved panel layout drawing	Panel layout drawing as built	HP	R	R	R	
14.2	Ingress protection Declaration check for junction boxes	EN / IEC 60529	IP 65 Declaration	HP	R	R		
14.3	Painting Random paint thickness test Color check	Approved painting procedure	Painting report	HP	R	R		
Documentation								
15.1	Content check Review of certification dossier	Index manufacturing data book Inspection test plan	Certification dossier / manufacturing data book	HP	R	R	R	Checked during final Inspection by assigned inspector
15.2	Test instrument Calibration check	N/A	Calibration certificate	HP	R	R		
Factory Acceptance Test (FAT)								
16.1	Equipment inspection Visual check P&ID, Dimensions, Painting, Junction boxes, Instruments and tagging of the complete package	Approved FAT procedure Approved General arrangement drawing Approved P&ID	Signed FAT Procedure; attachment 2: Equipment check list	H	R	R	H	
16.2	Functional test Functional check	Approved FAT procedure Approved control philosophy Approved wiring diagram	Signed FAT Procedure; attachment 3: functional check list		R			
16.3	Performance test Performance check	Approved FAT procedure Approved control philosophy Approved P&ID	Signed FAT Procedure; attachment 4: performance test result		R			
16.4	Noise level test Noise check	Approved FAT procedure Approved equipment data sheet	Signed FAT Procedure; attachment 5: noise level sheet list		R			
Punch list								
17.1	Punch list check Punch items check	As per PO / MR / Drawings / Datasheets	Signed Punch List		R	R	H	

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Packing & marking								
18.1	Packing and marking Quantity inspection	Approved packing and preservation procedure Commissioning and Start-up Spare Part List	Signed packing list	H	R	R	H	
18.2	Packing inspection Preservation check	Approved packing and preservation procedure	Signed packing list	H	R	R	H	
18.3	Marking inspection Equipment Package nameplate	Approved packing and preservation procedure	Signed packing list	H	R	R	H	
Release of package								
19.1	Inspection release note	Signed ITP	Signed inspection release note	HP	R	R	H	
Documents								
20.1	Manufacturing Data Book	-	MRB	HP	R	R	R	
20.2	Non conformity / repairs	-	NCR document	HP	HP	HP	H	If any
20.3	Deviation / concession request	-	Deviations list	HP	HP	HP	H	If any

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ABBREVIATIONS

HP: Hold Point – Vendor/ manufacturer is to notify INSPECTOR 10 days prior to performing the designated feature. Activities may not proceed (Hold) until the continuation of work is permitted by PURCHASER /COMPANY or waived in writing by PURCHASER/OWNER (Inspection waiver).

W: Full Witness Inspection/ Test. Witness-Application for inspection are required. PURCHASER/COMPANY inspector will be arranged to be present at least part of ongoing process. Vendor will proceed to the next step if he is not present; provided controls and tests records are made available to Inspector for review.

SW: Spot Witness Inspection/ Test on Spot / Random Basis. Witness by spot checks refer to an inspection performed at random, between the scheduled inspection points. The frequency and the depth of the inspection will be at least 10% of the items for bulk items, and at least one (1) item per type and category. But controls and tests records are made available to Inspector for review.

R: Verify by review of Manufacturer’s Inspection/ Test Reports & Certificates

A: Approval of Manufacturer’s Drawings and Documents

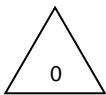
C: COMPANY (Lavan Industry Development Company of Iran)

LIDCO: Lavan Industry Development Company of Iran

TPA: Third Party Agency

P: PURCHASER

MFR: Manufacture



Note-1 All Standards and Codes’ Edition shall be mentioned.

Note-2 Before Manufacturing includes: (1) Procedure Review and Approval, (2) Certificate Records Review and (3) Raw Material Inspection.

	
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