

 <p>شرکت توسعه صنایع گوارا Lavan Industry Development Company</p>	<p>LIDCO, Pars SEE Zone, Assaluyeh, Integrated Methanol and Ammonia Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT</p>						
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**Airpack B.V. - Air Compressor –
Integrated Methanol and Ammonia Plant
17735-COM Hydrotest procedure (K020)**

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Hydrotest procedure




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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)

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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.

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.

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)

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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

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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: