







OWNER: 	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT							EPC CONTRACTOR:  Chagalesh-Enerchimi-Steam Joint Venture BUPC-MEG PLANT PROJECT	
	Hydrostatic/ pneumatic test procedure for reciprocating compressor								
MC:  شرکت سفت و سوی توسعه ایرانیان	Project	Area	Phase	Unit	Dis.	Doc.	Seq.	Contract No : 52-98/445	
Owner Document Number: 17811-17	BU	20	VD	303	QC	PRC	0006	Rev.:	Page
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 شرکت سفت و سوی توسعه ایرانیان	 Chagalesh-Enerchimi-Steam Joint Venture BUPC-MEG PLANT PROJECT	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT
Document Review		
Issue Purpose:	IFA	
Result Code: AP,AN,CM,RE,NC	CM	
Next Status : IFC,IFA,IFI,AFC,AB	IFA	
Responsible Department	INSPECTION	
Commented Date	6/19/2021	
Approval or review hereunder shall not be construed to relieve Vendor / Subcontractor of his responsibilities and liability under the contract.		

Hydrostatic/ pneumatic test procedure for reciprocating compressor

Comment:

- Please generate diagram same as attached file.
- Please add some note for personal safety during hydrostatic and pneumatic test.
- Data of pneumatic test shall be added to document.
- Gaskets used during hydrostatic testing of an assembled pressure casing, shall be of the same design as those supplied (for final final assembled) with the pump and shall be installed without sealant.
- During the hydrostatic test TPI shall be done a sample of water for send to approved Lab. For water analyze.
- During the hydrostatic test, one pressure gauge should be installed at the highest point and another at the lowest point of the casing. All installed gauges must not be more than one month old from their calibration date.
- The pressure and pressure relief graph should be considered in this document.
- No pressure drop and leakage should be observed during the test.
- All fittings and pipes related to the compressor must be individually hydro tested

00	16/11/2020	For approval	KP	JR	PW	
Rev.	Date	Purpose of Issue	Prepared	Checked	Approved	AC Code
					Class: 1	Phase: P



**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**







**Hydrostatic/ pneumatic test procedure
for reciprocating compressor**

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OWNER:  شرکت پتروشیمی بوشهر	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT						EPC CONTRACTOR:  LOGO CES		
MC :   شرکت سفت و سوی توسعه ایرانیان	Hydrostatic/ pneumatic test procedure for reciprocating compressor						Contract No : 52-98/445		
Owner Document Number: 17811-17							Project BU	Area	Phase

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 30 minutes 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.

Air piping (carbon steel)

This test is executed by Airpack. For hydrostatic tests a suitable positive displacement pump is available to supply a maximum pressure. Water will be of non-chloride type (max. 200 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure: 1.5x design pressure.

Vessels (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. 200 ppm - Cl₂), temperature approximately 20°C. Tests are non-witnessed by client as per ITP.

Hydrostatic test pressure: 1.5x design pressure.

After test,

- Equipment must be free from any unexpected condition
- Equipment will be dried and cleaned appropriately. Stainless steel will be cleaned by pressurized air.
- 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 : 18377-17

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: