








OWNER:  شرکت سست و سویی تو مو ایرانیا (سهامی خاص)	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT						EPC CONTRACTOR:  Chagalesh-Enerchimi-Steam Joint Venture BUPC-MEG PLANT PROJECT		
	Inspection and Test Plan (ITP) for Reciprocating Compressor-MEG-303						Vendor: 		
MC:   شرکت سست و سویی تو مو ایرانیا (سهامی خاص)	Project	Area	Phase	Unit	Dis.	Doc.	Seq.	Contract No : 52-98/445	
Owner Document Number: 17811-08	BU	20	VD	303	QC	ITP	0005	Rev.:	Page
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Inspection and Test Plan for reciprocating compressor MEG-303

 شرکت سست و سویی تو مو ایرانیا	 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		
Approval or review hereunder shall not be construed to relieve Vendor / Subcontractor of his responsibilities and liability under the contract.		

02	27/08/2021	For approval;	JB	JR	PW	
01	17/06/2021	For approval	KP	JR	PW	
00	30/10/2020	For approval	KP	JR	PW	
Rev.	Date	Purpose of Issue	Prepared	Checked	Approved	AC Code
					Class: 1	Phase: P

OWNER:



MC :



**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

**Inspection and Test Plan (ITP) for
Reciprocating Compressor-MEG-303**

EPC CONTRACTOR:



Owner Document Number: 17811-08	Project	Area	Phase	Unit	Dis.	Doc.	Seq.	Contract No : 52-98/445	
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1. GENERAL

1.1. Scope

This Inspection Test Plan (ITP) covers the minimum requirements for inspection, testing and fabricating of reciprocating compressor used in the MEG plant of Bushehr Petrochemical Project.

The EPCC/Supplier shall in any case conduct all the tests required by contractual documents, specifications, codes and standards and keep the relevant documentation.

Where required, Inspection Test Plan (ITP) will be finalized during the pre-inspection meeting.

The EPCC/Supplier is responsible for the adequacy and compliance of inspection and tests of equipment with the applicable code and standards requirements, the process conditions and/or other conditions as specified in this ITP.

The OWNER`s Inspection and Test Plan for equipment is an engineering document, which defines:






- The type and extent of OWNER`s Representative Involvement in each phase of fabrication, control and testing requiring an inspection.
- The resulting EPCC/VENDOR`s contractual obligations in accordance with general purchase condition.

During the course of project execution, if an activity is found to be necessary but not covered in the ITP table, any party`s proposal shall be prepared describing the items in ITP format for activity and issued to OWNER/MC for approval prior to commencement of the referred activity.

Compliance with this document and the accompanying data does not relieve the EPCC/VENDOR from his own responsibilities and guarantees nor from any further contractual obligations.






1.2. Definition of Terms

The following defines the meaning of specific words used in this document:

OWNER:  شرکت ست و توی توند ایرانیان (سامی تانگ)	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT							EPC CONTRACTOR:  Chagalesh-Enershimi-Steam Joint Venture BUPC-MEG PLANT PROJECT	
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MC :   شرکت ست و توی توند ایرانیان (سامی تانگ)	Project	Area	Phase	Unit	Dis.	Doc.	Seq.	Contract No : 52-98/445	
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Owner	Bushehr Petrochemical Company (BUPC)
MC	Samt-O-Sou-Ye Tose-Eye Iranian (SSTI) Company & Namvaran Delvar Engineering & Construction Company (NDEC).
EPCC	Joint Venture of Chagalesh, Enershimi and Steam (CES)
Supplier / Vendor	Means the company who will supply and/or manufacture equipment(s) and/or materials under Purchase Order issued by the EPCC , which is FGS Global AB Company for this Contract.
Project	Phase 2 Bushehr Petrochemical Project, MEG Plant
Location	South of IRAN, Bushehr Province, Assaluyeh city
Third Party Inspection Agency (TPA)	The Company that is responsible for Inspecting of all tests and documents review as Client's representative and checking of fabricated equipment/commodities conformity with Approved procedures and documents before, during and end of manufacturing.
Shall	Refer to a mandatory requirement.
ITP	Inspection and Test Plan
MR	Material Requisition
P.O	Purchase Order
PIM	Pre-Inspection Meeting
IRN	Inspection Release Note
MTC	Material test certificate

OWNER/MC shall be consulted in writing in every case of conflict, for approval.

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- HOLD POINT (H):** Hold point is a designate point during or following specific activity which are defined in ITP and which inspection or examination shall not proceed unless the designate parties have witnessed the inspection or examination or test.
 - WITNESS POINT (W):** A designated point during or following an important activity at which inspection or examination is required in accordance with the relative procedure. Work may proceed through the designated point if the required party is not present for the previously established activity, provided that inspection and test records are made available to OWNER/MC/TPI for review.
 - SPOT WITNESS POINT (10% W):** A designated point during or following an activity at which spot inspection or spot examination is required in accordance with the relative procedure. Work may proceed through the designated spot witness point if the required party is not present for the previously established activity.
- This may include a wide variety of actions taken by in charge person to inspect, check, control of activities and their sequence by means of observation, information collection, and verbal instruction, verify the routing and supporting documents for the purpose of proper expedition. Any non-conformity found during above mentioned inspection by TPI shall be reported to OWNER/MC immediately.
- REVIEW POINT (R):** It is processed through reviewing any results of inspection or test as a method of ensuring that the inspection or test is performed in accordance with any approved drawing, procedure, specifications or acceptance criteria.
- Inspection result shall review, but presence of involved party at inspection time is not mandatory, all documents shall be sign and stamp as reviewed and results all activates shall be specified clearly by term Accepted/Rejected.

this has been commented before to 20%.

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- REVIEW & APPROVAL (RA):** RA means that the document reviewed by involved parties shall be signed and stamped as reviewed & approved. Where a document is specified to be subjected to a party`s approval, work shall not be proceeding until this approval to be obtained.

1.3. Applicable codes and standards

ASME VIII Div. 1

ASME XI

ASME B31.3

AWS D1.1






API 618 (latest edition) with deviations and clarifications as per PO

1.4. Abbreviations






E.P.M = engineering and production manual, can be supplied on request

2. INSPECTION REQUIREMENTS

- OWNER/MC could have witness during and on any of the manufacturing steps.
- EPCC/Supplier shall inform other parties for 7 calendar days prior to subjected action for H/W/SW inspection points for LOCAL inspection.

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- EPCC/Supplier shall inform OWNER/MC for 14 calendar days prior to subjected action for H/W/SW inspection points for OVERSEAS inspection.
- All items and their materials shall be inspected according to OWNER/MC's requirements. However, the acceptance of any work and/or release of the material/equipment by the OWNER /MC shall in no way relieve the supplier of any responsibility for carrying out all the provisions of the applicable codes, standards and the specification.
- Inspectors or representatives shall have free access to all shops of the supplier or sub-supplier.

OWNER:  شرکت پتروشیمی بوشهر	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT						EPC CONTRACTOR:  Chagafesh-Enerchimi-Steam Joint Venture BUPC-MEG PLANT PROJECT		
	Inspection and Test Plan (ITP) for Reciprocating Compressor-MEG-303								
MC :   شرکت مهندسی و پیمانکاری اندیمیا	Project	Area	Phase	Unit	Dis.	Doc.	Seq.	Contract No : 52-98/445	
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3. INSPECTION AND TEST PLAN TABLE

Row	Activities	Reference Documents	Acceptance Criteria	Verifying Document	Action			
					Manufacturer/Vendor	CES Contractor	TPA	BUPC/MC
A.1	Kick of Meeting (KOM)	Contract/PO	Contract/PO	MOM	H	H	R	H
B.1	Pre-Inspection Meeting (PIM)	Project Specification	---	MOM and ITP	H	H	R	H
B.2	Engineering documents	According to VPIS	Project Spec, Standards	Eng Docs	H	RA	R	R
B.3	Procure documents	According to VPIS		Approved Procedures	H	RA	R	R

OWNER:



شرکت پتروشیمی بوشهر
BUPC

**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:




Chagalesh-Enerchimi-Steam
Joint Venture
BUPC MEG PLANT PROJECT

MC :




**Inspection and Test Plan (ITP) for Reciprocating
Compressor-MEG-303**

add EN10204 type 3.1 / Lab test report (Note 1)
Note 1: If there is any doubt about the authenticity of the material test certificate, sampling and laboratory tests shall be done under supervision of TPI.



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SKID (S355)

C.1	Raw material	E.P.M. 11.1.1	EN 10204	EN10204 type 3.1	H	H/H/R		
C.2	Welding	E.P.M. 11.1.2 - 11.1.7 WPS/PQR	AWS D1.1 WPS/PQR	PQR / WPS	H	W		
C.2	NDT (100% MT on lifting lugs)	E.P.M. 11.4 NDT procedure	NDT procedure and NDT map	MT report including NDT qualification certificate	H	R		
C.3	Dimensions	E.P.M. 11.3 General Arrangement Drawing	General Arrangement Drawing	General Arrangement Drawing as built	H	W		
C.4	Painting ((RAL check and DFT	E.P.M. 14.2.1 Surface preparation and Painting procedure	Surface preparation and Painting procedure	Painting report	H	W	W	R

Project Spec, Data Sheet, DWG

Project Spec, Data Sheet, DWG

change to VT report

add visual and move this step before step of welding

OWNER:



شرکت پتروشیمی بوشهر

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Chagalesh-Enerchimi-Steam
Joint Venture
BUPC-MEG PLANT PROJECT



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As per Item c.1 comments.

add PT for fillet weld such as branch and socket welds (if any)

and UT for all joints except for pipes less than 8 mm thick

Piping (CS)

D.	Description	Project Spec and Drawing	Standard	Requirement	Frequency	Witness	Review	Acceptance
D.1	Materials	Project Spec and Drawing	EN 10204	3.1 Material certificate	H	R	R	R
D.2	Visual & dimensional (fit up)	Project Spec and Drawing	Drawing	As built Drawing	H	SW	SW	R
D.3	Welding	E.P.M. 7.2.4 - 7.2.5 WPS/PQR	ASME section IX WPS/PQR	PQR / WPS	H	SW	SW	R
D.4	NDT (5% RT as per ASME B31.3) W= Review of film	E.P.M. 7.3.2 ASME B31.3 NDT procedure and	NDT procedure and NDT map	NDT Report, Certificates	H	SW		R
D.5	Hydrostatic Test	E.P.M. 7.3.1 ASME B31.3 Hydrostatic Test Procedure	Hydrostatic Test Procedure	Hydrostatic Test Report	H	H	H	R

OWNER:



**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:



**Inspection and Test Plan (ITP) for Reciprocating
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D.6

Painting (~~RAL check~~
~~and DFT~~)

E.P.M. 14.2.3
Surface preparation
and Painting
procedure

Surface preparation
and Painting
procedure

Painting report

H

W

W

R

OWNER:



شرکت پتروشیمی بوشهر

**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:

Chagalesh-Enerchimi-Steam
Joint Venture
BUPC-MEG PLANT PROJECTAirpack
Netherlands

MC :



شرکت پتروشیمی بوشهر

As per C.1 comments

**Inspection and Test Plan (ITP) for Reciprocating
Compressor-MEG-303**

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Pulsation damper (CS, ASME VIII Div 1)

E.1	Materials	Project Spec and Drawing	EN 10204	3.1 Material certificate	H	R	R	R
E.2	Visual & dimensional (fit up)	Project Spec and Drawing	Drawing	As built Drawing	H	SW	SW	R
E.3	Welding	E.P.M. 7.2.4 - 7.2.5 WPS/PQR	ASME section IX WPS/PQR	PQR / WPS	H	SW	SW	R
E.4	NDT (5% RT as per ASME B31.3) W= Review of film	E.P.M. 7.3.2 ASME B31.3 NDT procedure and	NDT procedure and NDT map	NDT Report	H	W	W	R
E.5	Hydrostatic Test	E.P.M. 6.7.2 ASME VIII div.1	Hydrostatic Test Procedure	Hydrostatic Test Report	H	H		R

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**Inspection and Test Plan (ITP) for Reciprocating
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		Hydrostatic Test Procedure						
E.6	Painting ((RAL check and DFT	E.P.M. 14.2.3 Surface preparation and Painting procedure	Surface preparation and Painting procedure	Painting report	H	W	W	R

OWNER:



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BUPC

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MEG PLANT**

CONTRACTOR:



Chagalesh-Enerchimi-Steam
Joint Venture
BUPC-MEG PLANT PROJECT



MC :




سازمان استاندارد و بازرسی
SSTI

**Inspection and Test Plan (ITP) for Reciprocating
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As per C.1 comments

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After cooler (SS, ASME VIII Div 1 and API618)

F.1	Materials	E.P.M. 7.2.1	EN 10204	3.1 Material certificate	H	R	R	R
F.2	Visual & dimensional (fit up)	Project Spec and Drawing			H	W	W	R
F.3	Welding	E.P.M. 7.2.4 - 7.2.5 WPS/PQR	ASME section IX WPS/PQR	PQR / WPS	H	SW	SW	R
F.3	Hydrostatic Test	E.P.M. 6.7.2 ASME VIII div.1 Hydrostatic Test Procedure	Hydrostatic Test Procedure	Hydrostatic Test report	H	H		R
F.5	Painting ((RAL check and DFT)	E.P.M. 14.2.3 Surface preparation and Painting procedure	Surface preparation and Painting procedure	Painting report	H	W	W	R

OWNER:



شرکت پتروشیمی بوشهر
BUPC

**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:



Chagalesh-Enerchimi-Steam
Joint Venture
BUPC-MEG PLANT PROJECT



MC :




شرکت مهندسی و پیمانکاری
SSTI

**Inspection and Test Plan (ITP) for Reciprocating
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Visual and

As per C.1 comments

Compressors

G.1	Materials	E.P.M. 7.2.1	EN 10204	3.1 Material certificate	H	R	R	R
G.2	Components	E.P.M. 2.1 Equipment data sheet	Equipment data sheet	Equipment data sheet approved	H	W		R
G.3	Dimensions	E.P.M 2.2.3 General Arrangement Drawing	General Arrangement Drawing	General Arrangement Drawing as built	H			R
G.4	Hydrostatic Test	E.P.M. 6.7.2 ASME VIII div.1 Hydrostatic Test Procedure	Hydrostatic Test Procedure	Hydrostatic Test Certificate	H	W	W	R

OWNER:



شرکت پتروشیمی بوشهر

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CONTRACTOR:

Chagalesh-Enerchimi-Steam
Joint Venture
BUPC-MEG PLANT PROJECT

**Inspection and Test Plan (ITP) for Reciprocating
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MC :

گروه تست و بازرسی
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G.4	Painting ((RAL check and DFT)	E.P.M. 14.2.3 Surface preparation and Painting procedure	Surface preparation and Painting procedure	Painting report	H	W	W	R
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OWNER:



شرکت پتروشیمی بوشهر

**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:



Chagalesh-Enerchimi-Steam
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MC :




گروه صنعتی پتروشیمی بوشهر

**Inspection and Test Plan (ITP) for Reciprocating
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Add Test Procedure, DWG

Add Test Procedure, DWG

Main motor

H.1	Components	E.P.M. 3.1 Motor data sheet	Motor data sheet	Motor data sheet as built	H	SW	R	
H.2	Dimensions	E.P.M. 3.1.4 Motor drawing	Motor drawing	Motor drawing as built	H		R	
H.3	Performance	E.P.M. 3.1 IEC 60034-1 Motor data sheet	IEC 60034-1	Routine Test Certificate	H	W	R	
H.4	Painting	E.P.M. 14.2.1 Surface preparation and Painting procedure	Surface preparation and Painting procedure	Painting report	H		R	
H.5	Name plate check(during FAT)	DWG, Data Sheet, Project Spec		Signed FAT Procedure; attachment 2: equipment check list	H	W	W	R

and Test Report

OWNER:  شرکت پتروشیمی بوشهر	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT							CONTRACTOR:  Chagalesh-Enerchimi-Steam Joint Venture BUPC-MEG PLANT PROJECT 	
MC :   شرکت سازه های پتروشیمی	Inspection and Test Plan (ITP) for Reciprocating Compressor-MEG-303							Contract No : 52-98/445	
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FAT									
I.1	Manufacturing data book check	Index Manufacturing Data Book	Inspection Test Plan	Manufacturing Data Book	H	RA		R	
I.2	FAT test instrument calibration	FAT procedure	Inspection Test Plan	Calibration certificate	H			R	
I.3	Quality	General Drawing P&ID	FAT Procedure	Signed FAT Procedure; attachment 2: equipment check list	H	H	H	R	
I.4	P&ID Review	P&ID	FAT Procedure	Signed FAT Procedure; attachment 2: equipment check list	H	H	H	R	
I.5	Dimensions	General Arrangement Drawing	FAT Procedure	Signed FAT Procedure; attachment 2: equipment check list	H	H	H	R	

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Joint Venture
BUPC-MEG PLANT PROJECT



MC :




شرکت مهندسی و پیمانکاری
NDP BPT

**Inspection and Test Plan (ITP) for Reciprocating
Compressor-MEG-303**

API 618, Specification

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I.6	Painting	Surface preparation and Painting procedure	FAT Procedure	Signed FAT Procedure; attachment 2: equipment check list	H	H	H	R
I.7	Control Panel	Wiring diagram Panel lay-out	FAT Procedure	Signed FAT Procedure; attachment 2: equipment check list	H	H	H	R
I.8	Instruments	Wiring diagram P&ID	FAT Procedure	Signed FAT Procedure; attachment 2: equipment check list	H	H	H	R
I.9	Function check control panel	Control Philosophy, Wiring Diagram	FAT Procedure	Signed FAT Procedure; attachment 3: functional check list	H	H	H	R
I.10	Mechanical run test, performance test	Mechanical and performance Procedure	FAT Procedure	Signed FAT Procedure; attachment 4: performance test result	H	H	H	R

OWNER:



**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:

API 618, Specification



**Inspection and Test Plan (ITP) for Reciprocating
Compressor-MEG-303**

MC :



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I.11	Noise level test	Equipment Data Sheet	Equipment Data Sheet	Signed FAT Procedure; attachment 5: noise level sheet list	H	H	H	R
I.12	Vibration level test	Mechanical and performance Procedure	FAT Procedure	Signed FAT Procedure; attachment 4: performance test result	H	H	H	R
I.13	Leak test	Leak test procedure	FAT Procedure	Signed FAT Procedure; attachment 5: leak test result	H	W	W	R
I.14	Strip down test (if issue appear during run test)	Strip down procedure	FAT Procedure	Signed FAT Procedure; attachment 6: strip test result	H	R	R	R

OWNER:



شرکت پتروشیمی بوشهر

**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:



Chagalesh-Enerchimi-Steam
Joint Venture
BUPC-MEG PLANT PROJECT



**Inspection and Test Plan (ITP) for Reciprocating
Compressor-MEG-303**

MC :



گروه مهندسی ماشین‌سازی

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For Main Parts and
2 Years Spare
Parts

*

Clearance of all remained
punches.

Final Inspection

J.1	Punch items	Punch list	-	Signed Punch List	H	W	W	R
J.2	Quantity	Commissioning and Start-up Spare Part List	Packing and Preservation Procedure Commisioning and Start-up Spare Part List	Signed Packing List	H	W	W	R
J.3	Packing and Marking Inspection	Packing and Marking Procedure	Packing and Marking Procedure	Signed Packing List	H	W	W	R

OWNER:



**BUSHEHR PETROCHEMICAL COMPANY
MEG PLANT**

CONTRACTOR:



**Inspection and Test Plan (ITP) for Reciprocating
Compressor-MEG-303**



MC :



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J.4	Marking	Packing and Preservation Procedure	Packing and Preservation Procedure	Signed Packing List	H	R	H	R
J.5	Inspection release Note	-	Signed ITP	Signed Inspection Release Note	H	R	H	R
J.6	FINAL DATA BOOK	Index Manufacturing Data Book	Inspection Test Plan	Manufacturing Data Book	H	RA	RA	R