





OWNER:  شرکت سست و سویی تو سوا ایرانیاان (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 سوا ایرانیاان (سهامی خاص)	Project	Area	Phase	Unit	Dis.	Doc.	Seq.	Contract No : 52-98/445	
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Inspection and Test Plan for reciprocating compressor MEG-303

05	06/01/2022	Approved for Construction	JB	JR	PW	
04	26/11/2021	For approval;	JB	JR	PW	
03	29/10/2021	For approval;	JB	JR	PW	
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









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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 سوبی توسته ایرانیان (صنای نفت)	BUSHEHR PETROCHEMICAL COMPANY MEG PLANT							EPC CONTRACTOR:  Chagalesh-Enershimi-Steam Joint Venture BUPEC-MEG PLANT PROJECT	
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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 witness 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 (20% 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.

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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.

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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

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B.1	Pre-Inspection Meeting (PIM)	Project Specification	Project Specification	MOM and ITP	H	H	R	H
B.2	Engineering documents	According to VPIS	Contract/PO	Approved Docs	H	RA	R	R
B.3	Procedures	According to VPIS, Project Spec	According to VPIS, Project Spec	Approved Procedures	H	RA	R	R
B.4	Welder Qualifications ¹	ASME Sec IX	ASME Sec IX	Welder Qualification Certificates	H	RA	RA	R
B.5	WPS & PQR	Project Spec, Related Standards, ASME Sec IX	Project Spec, Related Standards, ASME Sec IX	Approved WPS-PQR	H	RA	RA	R
B.6	NDT Personnel Qualification ¹	SNT-TC-1A	SNT-TC-1A	NDT Personnel Qualification Certificate	H	RA	RA	R
B.7	IECEX, IP, ATEX and SIL Certificate (as per Data Sheet)	API 618, Related Standards, Project Spec	API 618, Related Standards, Project Spec	Certificates	H	RA	RA	R

Notes:

- Welder qualification and NDT personnel qualification will be presented during inspection if requested by the inspector, no prior approval required.**




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SKID (S355)								
C.1	Raw Materials Inspection	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	MTC EN10204 type 3.1	H	RA	RA	R
C.2	Welding	WPS/PQR	AWS D1.1 WPS/PQR	VT Report	H	SW	SW	R
C.3	NDT 100% MT on lifting lugs	NDT Procedure and NDT Map, AWS D1.1	NDT Procedure and NDT Map, AWS D1.1	NDT Report	H	SW	SW	R
C.4	Visual and Dimensions Inspection	GA, DWG, Data Sheet	GA, DWG, Data Sheet	Inspection Report	H	W	W	R
C.5	Painting Inspection (Check Visual, RAL and DFT) During FAT	Surface Preparation and Painting procedure, SSPC	Surface Preparation and Painting procedure, SSPC	Painting report	H	W	W	R

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Piping (CS)									
D.1	Raw Materials Inspection	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	MTC EN10204 type 3.1	H	RA	RA	R	
D.2	Visual & Dimensional (Fit-up)	Project Spec, GA, DWG, Data Sheet, WPS	Project Spec, GA, DWG, Data Sheet, WPS	QC Report	H	SW	SW	R	
D.3	Welding Inspection	WPS/PQR	ASME IX, WPS/PQR	VT Report	H	SW	SW	R	
D.4	NDT ¹ 5% RT according ASME B31.3	NDT Procedure and NDT Map, ASME B31.3	NDT Procedure and NDT Map, ASME B31.3	NDT Report	H	SW	SW	R	
D.5	Hydrostatic Test	ASME 31.3, Hydrostatic Test Procedure	ASME B31.3, Hydrostatic Test Procedure	Hydrostatic Test Report, Inspection Report	H	W	W	R	
D.6	Painting Inspection (Check Visual, RAL and DFT) During FAT	Surface Preparation Painting procedure, SSPC	Surface Preparation and Painting procedure, SSPC	Painting report	H	W	W	R	





¹ Action point for RT in NDT is RA for TPA and CES representative.

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Pulsation damper (CS, ASME VIII Div 1)

E.1	Raw Materials Inspection	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	MTC EN10204 type 3.1	H	RA	RA	R
E.2	Visual & Dimensional	Project Spec and Drawing	Drawing	QC Report	H	SW	SW	R
E.3	Welding Inspection	WPS/PQR	ASME IX, WPS/PQR	VT Report	H	SW	SW	R
E.4	NDT ² As per ASME VIII (if any)	NDT Procedure and NDT Map, ASME VIII	NDT Procedure and NDT Map, ASME VIII	NDT Report	H	RA	RA	R
E.5	Hydrostatic Test	ASME VIII, Hydrostatic Test Procedure	ASME VIII, Hydrostatic Test Procedure	Hydrostatic Test Report, Inspection Report	H	W	W	R
E.6	Painting Inspection (Check Visual, RAL and DFT) During FAT	Surface Preparation and Painting procedure, SSPC	Surface Preparation and Painting procedure, SSPC	Painting report	H	W	W	R





² Action point for RT in NDT is RA for TPA and CES representative. If there are other types of NDT, action points for those tests shall be SW for TPA and CES representative.

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After cooler (SS, ASME VIII Div 1 and TEM C)





F.1	Raw Materials Inspection	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	MTC EN10204 type 3.1	H	RA	RA	R
F.2	Visual & Dimensional	Project Spec and Drawing	Drawing	QC Report	H	SW	SW	R
F.3	Welding Inspection	WPS/PQR	ASME IX, WPS/PQR	VT Report	H	SW	SW	R
F.4	NDT ³ As per ASME VIII (if any)	NDT Procedure and NDT Map, ASME VIII	NDT Procedure and NDT Map, ASME VIII	NDT Report	H	RA	RA	R
F.5	Hydrostatic Test	ASME VIII, Hydrostatic Test Procedure	ASME VIII, Hydrostatics Test Procedure	Hydrostatic Test Report, Inspection Report	H	W	W	R
F.6	Painting Inspection (Check Visual, RAL and DFT) During FAT	Surface Preparation and Painting procedure, SSPC	Surface Preparation and Painting procedure, SSPC	Painting report	H	W	W	R

³ Action point for RT in NDT is RA for TPA and CES representative. If there are other types of NDT, action points for those tests shall be SW for TPA and CES representative.





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Compressors									
G.1	Raw Materials Inspection ⁴	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	MTC EN10204 type 3.1	H	RA	RA	R	
G.2	Components Inspection	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	MCC, COC	H	RA	RA	R	
G.3	Visual and Dimensions Inspection	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	Inspection Report	H	W	W	R	
G.4	Hydrostatic Test	ASME VIII div.1 Hydrostatic Test Procedure	Hydrostatic Test Procedure	Hydrostatic Test Certificate	H	W	W	R	
G.5	Gas Leak Test (during FAT)	Gas Leak Test Procedure, API 618	Gas Leak Test Procedure, API 618	Test Report	H	W	W	R	
G.6	Painting Inspection (Check Visual, RAL and DFT) (During FAT)	Surface Preparation and Painting procedure, SSPC	Surface Preparation and Painting procedure, SSPC	Painting report	H	W	W	R	





⁴ For all pressured and components of compressor EN 10204 3.1 shall be presented.

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Main motor								
H.1	Components Inspection	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	MCC, COC	H	RA	RA	R
H.2	Visual and Dimensions Inspection (During FAT)	GA, DWG, Data Sheet, Project Spec	GA, DWG, Data Sheet, Project Spec	Inspection Report	H	W	W	R
H.3	Type Test	IEC 60034-1, Data Sheet	IEC 60034-1, Data Sheet	Type Test Certificates and Reports	H	RA	RA	R
H.4	Painting Inspection (Check Visual, RAL and DFT) (During FAT)	Surface Preparation and Painting procedure, SSPC	Surface Preparation and Painting procedure, SSPC	Painting report	H	W	W	R
H.5	Name Plate Check (During FAT)	GA, DWG, Data Sheet	GA, DWG, Data Sheet	Approved FAT Procedure; Equipment check list	H	W	W	R

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FAT								
I.1	FAT Test Instrument calibration	FAT procedure	Relevant Standards	Calibration certificate	H	RA	RA	R
I.2	Quality Inspection	General Arrangement Drawing P&ID	FAT Procedure	Approved FAT Procedure; Equipment Check List	H	W	W	R
I.3	P&ID Review	P&ID	FAT Procedure	Approved FAT Procedure; Equipment Check List	H	RA	RA	R
I.4	Visual and Dimensions	General Arrangement Drawing	FAT Procedure	Approved FAT Procedure; Equipment Check List	H	W	W	R
I.5	Painting	Surface preparation and Painting Procedure, SSPC	Surface preparation and Painting Procedure, SSPC, FAT	Approved FAT Procedure; Equipment Check List	H	W	W	R
I.6	Control Panel	Wiring diagram Panel lay-out, FAT Procedure	FAT Procedure	FAT Test Report	H	W	W	R

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I.7	Instruments	Wiring diagram P&ID, FAT Procedure	FAT Procedure	FAT Test Report	H	W	W	R
I.8	Function check control panel	Control Philosophy, Wiring Diagram, FAT Procedure	FAT Procedure	FAT Test Report	H	W	H	R
I.9	Mechanical Run Test, Performance Test	Control Philosophy P&ID	FAT Procedure	FAT Test Report	H	W	H	R
I.10	Noise level test	FAT Procedure	Equipment Data Sheet	FAT Test Report	H	W	H	R
I.11	Vibration level test	FAT Procedure	FAT Procedure	FAT Test Report	H	W	H	R
I.12	Leak test	Leak Test Procedure, FAT Procedure	FAT Procedure	FAT Test Report	H	W	W	R
I.13	Strip Down Test (if Issue appear during Run-Test)	FAT Procedure	FAT Procedure	FAT Test Report	H	R	R	R

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Final inspection								
J.1	Punch Items Inspection	Punch list, Data Sheet,	MTO	Approved Signed Punch List	H	RA	RA	R
J.2	Quantity Inspection	MTO, Data Sheet	MTO, Data Sheet	Inspection Report	H	W	W	R
J.3	Two Years Spare Parts and Commissioning Inspection	Two Years Spare Parts and Commissioning List, MTO	Two Years Spare Parts and Commissioning List, MTO	Approved Two Years Spare Parts and Commissioning Packing List	H	W	W	R
J.4	Packing and Marking Inspection	Packing and Marking Procedure	Packing and Marking Procedure	Signed Packing List	H	W	W	R
J.5	Manufacturer Certificates	Data Sheet, MR, GA, DWG	Data Sheet, MR, GA, DWG	MCC, COC	H	RA	RA	R
J.6	Inspection releaseNote	Signed PL, MTO	Signed PL	Signed InspectionRelease Note	H	R	H	R
J.7	FINAL DATA BOOK	Index Manufacturing Data Book, VPIS	Index Manufacturing Data Book, VPIS	Approved FDB	H	RA	RA	R