

Inspection and Test Plan for Line Pipe

No.	Inspection and Test Plan	Reference Document	Acceptance Criteria	Verifying Document	Activity By			Remark
					Manuf.	TPI	Client	
1	Pre-Inspection Meeting	Spec.	Spec.	MOM	H	H	H	-
Before Manufacturing								
2	DWG, Design, Calculation Document	API 5L	API 5L	DWG, Calculation book	H	R	A	-
3	WPS&PQR	ASME IX	ASME IX	Welding Book	H	R	A	-
4	Welder Operators Qualification Certificates	ASME IX	ASME IX	Certificates	H	R	-	-
5	NDT procedures	ASME V	ASME V	Procedures	H	R	A	-
6	NDE Personnel Certificates	API 5L	API 5L	Certificates	H	R	-	-
7	PWHT Procedure (if needed)	API 5L	API 5L	Procedure	H	R	A	-
8	Hydrostatic Testing Procedure	API 5L	API 5L	Procedure				
9	Painting Procedure	SSPC	SSPC	Procedure	H	R	A	-
Materials								
10	Receiving Inspection of Plates	ASME II/ASTM	ASME II/ASTM	Original Material Certificates	H	WS	-	-
During Fabrication								

11	Plate Edge Milling Control	API 5L	API 5L	Report	H	SW	-	
12	Plate Forming Checking	API 5L	API 5L	Report	H	SW	-	
13	Plates Post Bending Checking	API 5L	API 5L	Report	H	W	-	
14	Tack Welding Inspection	WPS/API 5L	WPS/API 5L	Report	H	SW	-	
15	Inside Welding Inspection	WPS/API 5L	WPS/API 5L	Report	H	W	-	
16	Outside Welding Inspection	WPS/API 5L	WPS/API 5L	Report	H	W	-	
17	Bead cutting Inspection	WPS/API 5L	WPS/API 5L	Report	H	SW	-	
18	End Facing checking	API 5L	API 5L	Report	H	SW	-	
19	Hydrostatic Testing	Procedure/API 5L	Procedure/API 5L	Report	H	H	-	
20	Ultrasonic Testing	Procedure/API 5L	Procedure/API 5L	Report	H	W	-	
21	Radiography Inspection	Procedure/API 5L	Procedure/API 5L	Report	H	W	-	
22	Repair Items Inspection	API 5L	API 5L	Report	H	H	-	
23	Dimensional Inspection	API 5L	API 5L	Report	H	W	-	
24	Mechanical Property Testing	API 5L	API 5L	Report	H	R	-	
25	Chemical Testing	API 5L	API 5L	Report	H	R	-	-

26	Impact Testing	API 5L	API 5L	Report	H	R	-	-
27	Visual Inspection	API 5L	API 5L	Report	H	H		
28	Body Marking Check	API 5L	API 5L	Report	H	W	-	
Final Inspection								
29	Final Visual & Dimensional Check	DWG/Spec.	DWG	Report	H	H	-	-
30	Surface Preparation and Painting	Procedure	SSPC	Report	H	W	-	-
31	Check of Final Book	Spec.	Spec.	DWG/ P.O	H	R	-	
Documentation								
32	Inspection Reports	Spec./DWG	Spec./DWG	Report	H	R	-	-
33	NCR	Spec./DWG	Spec./DWG	Report	H	R	-	-
34	Review Final Data Report	Spec./DWG	Spec./DWG	Report	H	R	-	-
Pre-Shipment Inspection								
35	Preservation and Packing	Spec.	Spec.	Report	H	H	-	-
36	Marking	Spec.	Spec.	Report	H	H	-	-
37	Loading Inspection	Spec.	Spec.	Report	H	H	-	-
38	Shipping Document Control	Procedure	Spec.	Packing List	H	H	-	-
auxiliary equipment such as lube oil system, filter, strainer, piping, steel structure and etc. are not included to this ITP								

Abbreviations:

H: Hold Point = Hold on the production till TPI Inspector performs inspection and supervise the required test

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W: Witness Point = Manufacture shall notify client and TPI Inspector but there is no hold on the production;
Client can waive this inspection based on his discretion and informs TPI Inspector accordingly.

R: Document Review = Review means Review document, which includes of material test certificates, WPS, PQR, NDT Procedures and etc.

A: Approval

SW: Spot Witness = for items with spot witness manufacture shall notify TPI inspector as fulfilling the monitoring;
For example one random visit for whole UT tests or one or two visits for whole surface preparation works for painting.

MOM: Minute of Meeting

P.O: Purchase Order

for more information review following articles:

<http://www.inspection-for-industry.com/third-party-inspection-for-Line-Pipe.html>

<http://www.inspection-for-industry.com/inspection-and-test-plan-for-Line-Pipe.html>