

## Inspection and Test Plan for Pressure Safety Valve

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	-
<b>Before Manufacturing</b>								
2	DWG, Design, Calculation Document	API 526, Spec.	API 526, 520, 521 ASME	DWG, Calculation book	H	R	A	-
3	NDT procedure	ASME	ASME V,VIII	Procedures	H	R	A	-
4	NDE Personnel Certificates	ASME	ASME V	Certificates	H	R	-	-
5	Heat Treatment Procedure	ASME	ASME VIII / Spec.	Procedure	H	R	A	
6	Hydro Static Test Procedure	Spec.	Spec.	Procedure	H	R	A	-
7	Adjusting and Function Test Procedure	Spec.	ASME SEC VIII	Procedure	H	R	A	
8	Seat Tightness Test Procedure	Spec.	API 527	Procedure	H	R	A	
9	Painting Procedure	Spec.	SSSP/Spec.	Procedure	H	R	A	-
<b>Materials</b>								
10	Control of the material stamping and comparison with material certificate before start of machining for body & internal components	ASME Sec II	ASME Sec II	Original Material Certificates	H	H	-	-

During Manufacturing								
11	Casting Part Visual Inspection	Spec.	SP-55	Report	H	R	-	-
12	Heat Treatment	Procedure	ASME VIII	Report/Graph	H	R	-	-
13	Body Hydrostatic and Leak Test	Procedure	API 598	Report	H	H	-	-
14	Visual Control of all Parts Before Assembly	DWG	DWG	Report	H	R	-	-
15	Adjusting and Function Test	ASME Sec VIII	ASME SEC VIII	Report	H	H	-	-
16	Seat Leak Test	Procedure	API 527	Report	H	H	-	-
17	Control of Main Dimensions	DWG	DWG	Report	H	W	-	-
18	Visual Surface Check Inside and Outside	Spec.	Spec.	Report	H	R	-	-
19	Cleanliness Control	Spec.	Spec.	Report	H	R	-	-
20	Valve Name Plate marking control	DWG/ Datasheet	DWG, PO	-	H	H	-	-
21	Visual Control of Protective Coating	Procedure	SSSP/Spec.	Report	H	W	-	-
Pre-Shipment Inspection								
22	Packing, Marking	PO.	Spec.	Report	H	H	-	-
23	Final Book	Spec.	Spec.	Final Book	H	H	-	-
24	Release Note and Loading	Spec.	Spec.	Release Note	H	H	-	-

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

**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/pressure-safety-valve-inspection.html>

<http://www.inspection-for-industry.com/inspection-and-test-plan-for-pressure-safety-valve.html>