

Inspection and Test Plan for Process Piping

No.	Inspection and Test Plan	Reference Document	Acceptance Criteria	Verifying Document	Activity By			Remark
					Contract	TPI	Client	
1	Pre-Inspection Meeting	Spec.	Spec.	MOM	H	H	H	-
Documentation Control								
2	Receiving Material Check	ASME B31.3, Spec.	ASME B31.3, Spec	Related Forms	H	W	A	-
3	Material Certificate Control	ASME SEC II, Spec.	ASME SEC II	Certificates	H	W	A	-
4	WPS	ASME IX, Spec.	ASME IX	WPS	H	H	-	-
5	PQR	ASME IX, Spec.	ASME IX	PQR	H	H	A	-
6	WPQ	ASME IX, Spec.	ASME IX	WPQ Records	H	H	-	-
7	NDT Operator Certificate	ASME B31.3, Spec	ASME B31.3	Certificates	H	H	A	-
8	Calibration Certificate Control	ASME B31.3, Spec	Spec.	Records	H	H	A	-
SPOOL MAKING (SHOP)								
9	Cutting and Beveling of each parts & Check of identification	WPS/Spec.	ASME B31.3	-	H	SW	R	-
10	Fit up of spools	WPS/Spec.	ASME B31.3	Dialy Fit-Up Report	H	W	R	-
11	Monitoring of Welding	WPS/Spec.	ASME B31.3	Dialy Welding Report	H	W	R	-

12	PWHT (If Any)	WPS/Spec.	ASME B31.3	PWHT Report	H	W	R	-
13	Final Inspection	WPS/Spec.	ASME B31.3	-	H	H	R	-
14	Identification of Spools Control	Spec.	Spec.	-	H	W	R	-
Painting of Spools (Primer)								
15	Surface Preparation	SSPC, Spec.	SSPC	Daily Surface Preparation Report	H	W	R	-
16	DFT Measurement	SSPC, Spec.	SSPC	Daily Painting Inspection Report	H	W	R	-
Field Assembly								
17	Inspection of internal cleanliness prior of installation	Spec.	ASME B31.3, Spec	-	H	SW	R	-
18	Fit up	WPS/Spec.	ASME B31.3	Daily Fit-Up Report	H	W	R	-
19	Check that no significant stresses on line	Spec.	ASME B31.3	-	H	W	R	-
20	Surveying	Spec.	ASME B31.3, Spec	Surveying Report	H	W	R	-
21	Monitoring of welding	WPS/Spec.	ASME B31.3	Daily Welding Report	H	W	R	-
22	PWHT (If Any)	WPS/Spec.	ASME B31.3	PWHT Report	H	W	R	-

23	NDT	ASME B31.3, Spec	ASME B31.3	NDT Request Report RT Test Report PT Test Report UT Test Report	H	W	R	-
24	Pipe Support	DWG/WPS	DWG	Pipe Support Report	H	W	R	-
25	Line Check (Punch List acc. to Isometric DWG)	WPS/DWG	WPS/DWG	Punch List Report	H	W	R	-
26	Pressure Test	ASME/NDT map/NDT Procedure	ASME VIII	Pressure Test Report		H	R	-
27	Test Package	Spec./DWG	Spec./DWG	Pipes History Report Test Package Line List NDT Test Reports Hydrostatic Test Report		H	R	-
28	Valve Installation	Spec./DWG	Spec./DWG	Valve Installation Report		W	R	-
29	Final Inspection (Reinstatement)	Spec./DWG	Spec./DWG	Reinstatement Certificate	H	H	R	-
Final Field Coat								
30	Surface Preparation	SSPC, Spec.	SSPC	Daily Surface Preparation Report	H	W	R	-
31	Wrapping for UG Piping	SSPC, Spec.	SSPC	Wrapping Report	H	W	R	
32	DFT Measurement	SSPC, Spec.	SSPC	Daily Painting Inspection Report	H	H	R	-

Abbreviations:

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.

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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/piping-inspection.html>

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