

Document Name:

- **Contractor Quality Control Plan for Storage Tank Erection**

		Responsibility		
No.	Item description	CC	TPI	Owner
3.6	Atmospheric storage tanks			
3.6.1	Pre-installation check 1) Foundation - Dimensional check before tank erection - Level lcheck under tank shell - Diameter, direction and slope - Location and dimension of drain sump pit	H		
	- Visual 2) Welding test - Welding prodecure test - Procedure qualification test - Welder performance qualification tests	H		
3.6.2	Erection 1) Welding inspection - Visual inspection (Welding & PWHT) 2) Bottom plates - Vacuum test - Radiographic examination of butt joints for annular under shell plates 3) Shell plates - Hydrostatic test - Radiographic examination - Liquid penetrant examination of welding seams, if specified - MagneTPI parTPIlle examination, if specified - Level and out of plumbness 4) Roof plates - Vacuum test - Air test for roof plate & pontoon compartments	H		

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	<ul style="list-style-type: none"> - Oil penetration or vacuum test for deck plate and pontoon 5) Appurtenance - Orientation and dimensional check - Liquid penetrant examination of shell nozzle and reinforcing plate - Air test of shell nozzle reinforcing plate - Hydrotest for heating unit - Air test of roof drain pipe for floating roof tank - Visual check 			
3.6.3	<p>Final check after erection</p> <ol style="list-style-type: none"> 1) Hydrostatic test (Tank fill & held for 24 hours) 2) Final inspection 3) Visual check <ul style="list-style-type: none"> - Plumbness checks - Roundness checks - Peaking checks - Banding checks 	H		

CC: Construction Contractor

TPI: Third Party Inspection

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