





Plant MRPL Mangalore	Client MRPL	Contract Code WSS for PFCC Flue Gas	Document ID 6723-IEX-G00-EC-0001	Contract No. 66-6723
	Project Inspection and Test Plan for Shop Inspection			
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1 Purpose

This document describes the procedures to be followed for Quality Assurance, Inspection, Expediting and monitoring by LSTK contractor for all equipment and items supplied by them for MRPL Project, Mangalore, to ensure compliance to quality standards during execution of the contracted services.

2 Scope

This procedure is applicable to LSTK Contractors, Vendors / Sub-Vendors for Engineering, Procurement, Manufacturing and supply of Equipment, Package units and Bulk material like Pipes, Fittings, Flanges, Valves etc., Shop inspection requirements for Rotary Equipments, Electrical & Instrumentation items are attached elsewhere in the Tender.

3 Definitions

OWNER/ MRPL means Mangalore Refinery Pvt Limited, Mangalore.

Consultant/ PMC means Project Management Consultant i.e. thyssenKrupp Industrial Solutions India Private Limited. (tkIS India).

LSTK Contractor - Any Third Party whose services are obtained for supply execution and /or erection of Units/facilities covered under consultant's scope of work.

Vendor means any third party supplying any of the equipment/materials/Items for setting up Plant covered under Consultant's scope of work.

Supplier, Seller, Manufacturer, agents are considered synonymous to Vendor

Equipment/Package/ Material/Item means any mechanical item, Static Equipment, Rotary Equipment, Piping Items, Structural etc.,

Surveillance means "Monitoring of LSTK Contractor's/Vendor's design, Inspection and Test activities to ensure compliance to Project and Statutory requirements"

TPIA – Third party inspection agency

PITP - means Project Inspection and Test Plan for Shop Inspection

IITP - Indicative Inspection and test plans for package and static equipments and standard Bulk items



4 General Inspection Requirements

4.1 Approved Vendors

All items / equipments shall have to be procured from Owner/PMC approved vendors for this Project. Any deviation to the approved vendor list needs owner's prior approval. List of owner / PMC approved vendors is attached elsewhere in this Tender. In this regard, no difference is made between the equipments and materials purchased by the LSTK contractor directly or through his vendors / sub-vendors.

If the items are ordered on OWNER Approved Traders, Traders shall supply the items manufactured by the OWNER approved Vendors.



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4.2 LSTK Contractor's Inspection

All items shall be inspected by LSTK Contractor, irrespective of criticality. LSTK contractor shall depute their inspection engineers during the fabrication / manufacture to ensure that the proper quality is maintained.

4.3 Third Party Inspection

In addition to their own inspection, LSTK contractor shall appoint OWNER approved Third Party Inspection Agency (TPIA) for Material Identification, stage wise, final and pre despatch inspection of all the materials. Equipments within the Package shall also be inspected by TPIA. Name of the agencies appointed shall be mentioned in the detailed Project Inspection and Test Plan to be submitted by LSTK contractor to PMC / Owner for review & approval. The list of TPIA Agencies are as below.

4.4 OWNER Approved Third Party Inspection Agencies

1. M/s. ABS Industrial Verification (India) Pvt Limited
2. M/s. Projects and Development India Ltd.
3. M/s.TUV SUD South Asia Pvt Ltd
4. M/s. IR Class Systems and Solutions Private Limited
5. M/s. Certification Engineers International Limited
6. M/s. Bureau Veritas (India) Pvt. Ltd.
7. M/s. International Certification Services Pvt Ltd.
8. M/s. SGS India Pvt. Ltd.
9. M/s. Tata Projects Ltd.
10. M/s. VCS Quality Services Pvt. Ltd.

In case of any Equipment is manufactured partly at shop and partly at Site, Inspection by same TPIA is required at Shop as well as at Site. This is in addition to inspection by Manufacturer and LSTK Contractor.

4.5 OWNER/PMC Inspection



Inspection for Identified critical equipments, OWNER's / PMC inspection may also be involved. Critical Equipment List is attached elsewhere in the Tender. Contractor shall give minimum two weeks' notice to OWNER/ PMC to arrange for participation in such inspection.

PMC / Owner reserves the right to inspect any item at any stage during Fabrication / Manufacturing, even if the items are under third party inspection. Inspection by Owner / PMC / Third Party inspection agency does not absolve the LSTK contractor's responsibility for ensuring the contractual quality requirements and overall performance of items, equipment and Machinery.

Owner's/PMC's approval of documents does not absolve the LSTK contractor's responsibility for overall performance of equipment's and machinery.

4.6 Statutory Approval

If any item requires Statutory Approval, it is LSTK Contractor's responsibility to arrange for approval of all relevant documents by Statutory Authorities and inspection by Statutory Authorities or Statutory Authority Authorised Inspection Agencies.

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4.7 Material Certification

All Raw materials and bought out components shall be with minimum EN 10204 3.1 Certification unless otherwise specified.

4.8 Language of Communication

The language of communication shall be English. All reports, certificates and documents must be in English only.

5 Document Approval Codes

All documents shall be marked with following Approval Code

5.1 Following are the Acceptance Code for PITP/ITP/QAP

Acceptance Code 1 = Approved
Acceptance Code 2 = Approved with Comments
Acceptance Code 3 = Not Approved / Resubmit

5.2 Welding Procedures, Inspection and Test Procedures

All WPS/PQR, Weld Map and Inspection related NDT Procedures, PWHT, Surface Preparation & Painting Procedures and other test Procedures shall also be reviewed / approved by LSTK Contractor and TPIA.

Acceptance Code 4 = Retained for information/ Records
Acceptance Code 5 = Reviewed
Acceptance Code 6 = Reviewed with Comments

6 Inspection Stages

Inspection stages are categorized as follows :

▪ Hold Stage (H)



An activity which requires inspection / verification and acceptance by Inspecting Authorities.

Vendor shall not process activity / item beyond a hold point without written approval from Inspecting Authority except where prior written permission for further processing is obtained.

▪ Witness Stage (W)

An activity which requires witnessing by Inspecting Authority. After proper notification has been provided, the Vendor is not obliged to hold further processing if Inspecting Authority is not available to witness the activity or does not provide the comments before the date notified.



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▪ Review Stage (R)

An activity carried out by Vendor and documents reviewed by Inspecting Authority. Documents for review stage shall be offered to Inspecting Authority for review during the immediate subsequent visit.

7 LSTK Contractor's Overall Project Inspection and Test Plan for Shop inspection (PITP)

The management of "Quality System" is the responsibility of LSTK Contractor.

LSTK Contractor shall prepare Overall Project Inspection and Test Plan for Shop Inspection in line with this document and attached Quality Assurance Plans and Indicative Inspection and Test Plans (Indicative Inspection and Test Plans for Major items and standard bulk items are attached in Annexure 1) and submit to OWNER/PMC for Review and Approval.

LSTK Contractor shall prepare Inspection and Test Plan for all items, including the items for which Indicative Inspection Test Plan / Quality Assurance Plans are not attached with this document. The same shall be part of LSTK Contractor's PITP.

LSTK Contractor shall take care of all Project requirements, code requirements and other Statutory Requirements as applicable.

LSTK Contractor's Overall Project Inspection and Test Plan shall cover all activities to be performed by Vendors and their suppliers, LSTK Contractor, TPIA, and PMC/OWNER. LSTK contractor shall ensure that all the requirements of Equipment data sheets, Applicable General Engineering Specifications, Project specific requirements, Contract Requirements, Applicable Statutory Requirements and code requirements are taken care of while preparing the Project Inspection and Test Plan.

Owner's/PMC's approval of documents does not absolve the LSTK contractor's responsibility for overall performance of equipment's and machinery.



7.1 The PITP shall cover the following as minimum

Details of Documents which are to be reviewed/approved, Inspection stages such as, material identification, Weld Edge Preparation, Fit ups, examination of root welds / back chip welds, completed welding, pre/post weld heat treatments, Non Destructive Tests, Positive Material Identification of materials and welds, balancing test, MRT / Performance tests, Functional tests, Hydro tests, Surface preparation and Painting, lining etc., covering all requirements of project specifications, Licensor, Codes, Statutory Requirements and applicable standards.

The stages / tests not listed in the attached Quality Assurance Plans, but required as per equipment design data sheet, project specification and applicable codes shall also be listed out in detail, in the PITP.

7.2 PITP shall also include below points

- Name of third party inspection agency
- Contact Details for performing the inspection
- Bio-data of Inspection Team leader and inspection engineers, including NDT Qualifications
- Quality Assurance Manual including organogram, standard quality assurance plan

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- Equipment / item final clearance procedure
- Reporting procedure for monitoring, Pre order, Post order manufacturing status, inspection and frequency of reporting and distribution
- Standard formats for above activities
- Non conformity control & approval system

8 Vendor's Quality Assurance Plan/Inspection & Test plan

LSTK Contractor shall get Equipment/ Package/ Item specific Quality Assurance Plan from their Vendors/ Suppliers. Vendor QAP/ITP shall be prepared taking care of all Contractual Technical requirements and shall be in line with LSTK Contractor's Project Inspection and Test Plan & IITP, which is approved by PMC/OWNER.

Based on LSTK Contractor approved Vendor drawings and OWNER/PMC approved LSTK Contractor's PITP, LSTK Contractor shall approve their supplier's/ vendor's Quality Assurance Plan. After approval, the same is to be submitted for TPIA approval.

LSTK Contractor shall submit Equipment Specific / Item specific QAP/ITP, prepared by the Vendor duly reviewed and Approved by LSTK Contractor's Quality Assurance Manager and TPIA to the Owner/PMC for review and approval. This must be done prior to commencement of manufacturing activities.

WPS/PQR, Weld Map, NDT Procedures, Production Test Coupon Plate requirement Plan, PWHT Procedure, NDT & Test Procedures, Surface Preparation & Painting Procedures etc., of Vendors shall be reviewed and approved by LSTK Contractor and TPIA.

Vendor QAP duly approved by LSTK Contractor and TPIA shall be submitted to OWNER/PMC for approval/Review. Welding Procedures & Inspection related procedures duly approved by LSTK Contractor and TPIA shall be submitted to OWNER/PMC for Information.

TPIA's/Owner's/PMC's approval / review / information, of documents does not absolve the LSTK contractor's responsibility for overall Quality, performance of equipments, Items and machinery.



Approved QAP shall be revisited by LSTK Contractor, whenever there is a revision in drawing and shall be updated, if necessary. In such cases, the QAP shall be stamped as revisited.

In case of discrepancies between the Quality Assurance Plan, the workshop documents approved / reviewed by OWNER/PMC, Purchase Specification, Contract documents, more stringent conditions shall be applicable. The Vendor / Contractor shall be responsible for the required Tests to be performed.

The Quality Assurance Plan (QAP) / Inspection and test plan (ITP) shall identify and include the following.

- Item Name, Item No., Classification Group, Drawing No. with Rev. No.
- A documented sequence of inspection and test activities related to the product or service provided, specific procedures, methods and work instructions to be applied to each activity shall be defined. This shall include but not limited to material identification, qualification of welding & NDT procedures and personnel, Weld Edge Preparation and fitups NDT of root / back chip and final welds, NDT after PWHT / hydrotest, post weld heat treatment procedures, positive material identification of materials and welds, pressure tests, performance tests, strip tests and pre-shipment clearing procedures, etc. as the case may be.



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- Method of verification of sub-vendors conformance to requirement.
- Incoming, in process and final inspection requirements.
- Calibration of measuring and test instruments and maintenance of calibration records.
- Statistical techniques, if employed, to be identified.
- The specific allocation of responsibilities for each activity, including identification of inspection authority responsible for the release of confirming product.

9 Pre Inspection Meeting

After placement of purchase orders and Initial approval of Drawings and QAP, LSTK contractor shall organize pre-inspection meetings with their vendor / manufacturers along with TPIA to confirm all Contract Requirements (owner's / PMC's / Licensors requirements) and to ensure that these requirements are fully understood by all parties including third party inspection agency/agencies and a minutes of the meeting shall be prepared. LSTK contractor shall submit signed copy of MOM to PMC / Owner for information. Information about all such PIMs shall be provided to PMC / Owner with 15 days' notice. PMC / Owner have right to participate in PIM.

LSTK contractor shall submit Copies of Purchase orders, approved technical specifications (order specifications) along with approved / commented drawings, agreed deviations / variations, if any to PMC/ OWNER.

10 Inspection

All items shall be inspected by Vendor, LSTK Contractor and TPIA as per approved QAP.

Identified Critical items may be inspected by OWNER/PMC, in addition to inspection by Vendor, LSTK Contractor and TPIA.



Inspection shall be carried out as per approved Quality Assurance Plan/Quality Control Plan/Inspection and Test Plan. Atleast, Code 2 approved drawings, Approved Quality Assurance Plan and reviewed in code 4 procedures are minimum requirement for carrying out inspection.

For Final inspection, Code 1/4 approved drawings, QAP and other Procedures are required.

Inspection stage meeting Code / Specification / Drawing requirements shall be released for further processing. Inspection activity is concluded with the Inspection Report.

In case of discrepancies between the Quality Assurance Plan, the workshop documents Approved / Reviewed by OWNER/PMC, Purchase Specification, Contract documents, more stringent conditions shall be applicable. The Supplier/ Contractor shall be responsible for the required Tests to be performed.

The language of communication shall be English. All Supplier reports, certificates and documents shall be in English.

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11 Inspection Reports

Inspection report shall give the following details.

- Supplier Name, Job No. / Project Title / Purchase Order Number / Date of report / Item Tag Number / Name of item, Stage of Inspection.
- Date & Place of inspection, Name of inspection agency and Inspection engineer and Details of inspection carried out.
- Result of inspection. In case of non-conformity, the points where the rectification is required shall be clearly spelt.
- Signature of Supplier and Inspection Engineer.

The Report generated by Supplier or by Contractor shall be supplemented with necessary annexure.

Records of Calibration of measuring and test instruments shall be reviewed by Contractor & TPIA and recorded in Inspection reports.

The Inspection report shall clearly indicate the material inspected is meeting with Purchase Order/Purchase Requisition requirements and inspected as per the approved QAP.

LSTK contractor shall issue regular summary of Final Inspection reports to PMC/ OWNER on a monthly basis (as a minimum) The reports shall include the following as minimum.

- Job no. / Project title / P.O. No. / Purchase Specification No, Date of report and
- Item tag no. / Name / Total Qty ordered and Despatched.
- Manufacturer's name.
- Date & place of inspection, name of inspection agency and inspection engineer.
- Reference of documents with revision status
- Details of inspection carried out.
- Calibration status of measuring and monitoring equipments reviewed and accepted
- Results of inspection
- Deviations, if any
- Constraints, if any



12 Non-Conformance

If LSTK contractor /TPIA and/ or manufacturer finds any deviation or non-conformity with respect to the requirement, it shall be reported to PMC with a copy to owner and seek prior approval before Rectification/acceptance at his end. Contractor shall also indicate and justify (with complete break up) cost benefits, if any, and same shall have to be reimbursed to owner.

13 Inspection Release Note by TPIA

After satisfactory inspection, Third Party Inspection Agency shall issue Inspection Release Note. TPIA shall ensure and declare compliance to approved QAP by endorsing the approved QAP and making it part of Inspection certificate / Inspection Release Note. TPIA shall also sign as built drawings .



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14 Despatch Clearance

After the completion of the final inspection and issuance of Inspection Release Note by TPIA, LSTK contractor shall submit these documents along with back up inspection documents to PMC / Owner for achieving despatch clearance. After clearance from PMC / Owner for despatch, LSTK contractor shall issue despatch clearance to vendor. LSTK contractor shall ensure that the code 1/4 approved QAP number, procedure and Approved Drawing number are incorporated in the TPIA Inspection release Note.

15 Final Documents

Final Documents, as mentioned in Contract, duly signed by LSTK Contractor and TPIA shall be submitted to OWNER/PMC for information.

16 Traceability requirements

Identification of the item from applicable drawings, specifications or other documents during all stages of manufacturing, Inspection, delivery and installation to ensure that each item which is in the process of fabrication / manufacture / Inspection / construction / erection has proper identification throughout the process including final output.

Inspection & test status of the item shall be identified by using markings, authorized stamps, tags, route cards, inspection records etc., during the course of manufacture to clearly indicate acceptance / rejection of tests / stages of inspection performed during its manufacturing cycle. The identification of inspection and test status shall be maintained

LSTK contractor shall ensure that vendors follow the above for the production and supply of material / equipment & other services

17 Implementation of QAP / Inspection requirements

Implementation of QAP / Inspection requirements is LSTK contractor's responsibility.



However, PMC/ Owner shall have the right to verify / audit any approved Quality related functions at vendor shop / independent test house and LSTK contractor shall be bound to take necessary corrective actions as desired by PMC / owner.

Third party inspection agency shall ensure and declare compliance to approved QAP by endorsing the approved QAP and making it part of inspection certificate / inspection release order.

Materials received at site without inspection / without TPIA agency Inspection Release Note and LSTK Contractor's Despatch Clearance or found not meeting the desired quality shall be rejected. LSTK contractor shall be liable to replace these materials at their own risk & cost and within their contractual period. Till such replacements are made, owner at his discretion may use such deficient / defective materials without any payments or any other liability to the LSTK contractor.

18 Manufacturing & Inspection schedules

The LSTK contractor shall submit detailed manufacturing & inspection schedules for the coming

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next two months at the beginning of each month to PMC and owner. LSTK contractor should attach the same in the monthly progress reports.

19 Monitoring

Contractor shall submit to PMC / owner, fortnightly status of the various activities highlighting areas of concern. Vendors shall be closely monitored as per the progress on the job. If required, progress shall be monitored on daily basis.

Frequency of expediting visits to vendor shops or meetings with vendors shall be done on fortnightly basis by LSTK contractor and expediting reports shall be submitted to PMC/OWNER.

Any delay in the supply from any vendor, is however, the responsibility of the contractor. Contractual delivery dates shall be closely monitored and contractor shall ensure adherence to expediting functions & implement plans for remedial actions.

Format of monthly progress report to be finalized during kick off meeting.

OWNER /PMC have the right to visit LSTK Contractor's office, works, their Vendor's office/works, any time for expediting.

20 Quality Assurance

All work / services to be performed by the LSTK contractor shall be of specified / approved quality and the contractor shall have a QUALITY ASSURANCE / CONTROL (QA/QC) system during the performance of various activities.

LSTK contractor shall evolve a comprehensive system of planned and documented audit to verify whether various performed activities comply with detailed procedures, specifications, guidelines etc. and to establish the effectiveness of Quality System.

Audits shall be carried out by Independent Engineers, not responsible for execution of the activity to be audited.

21 Quality Surveillance



Quality Surveillance is Monitoring and making observations to verify whether or not material / items or services conform to specified requirements. Surveillance activity may include audit, inspections, witness of testing, review of quality documentation, Inspection Records, personnel qualification etc. LSTK contractor shall carry out the same.

PMC/OWNER may carry out Quality Surveillance Audit at LSTK Contractor's Office/ works, their supplier's office/works, at any time during the execution of the Project.

22 Inspection Records

Documents which demonstrate achievement of required quality and verify effective operation of quality system are viz.

- Inspection Reports / Test Data
- Approved / reviewed Inspection & Test Plans and procedures.
- Qualification Reports

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- Contract Review Records
- Design Reviews, Verification & Validation records
- Audit Reports
- Material review Reports
- Third Party Inspection Reports / Certifications / Release Notes
- LSTK Contractor's Despatch Clearance
- Calibration Data
- Records of non-conformity.
- Deviations, if any.

23 Quality Audit

A systematic & independent examination of the acts and decisions with respect to quality, in order to verify, evaluate and report degree of compliance to the operational requirement of the quality programme or the specifications or contract requirements of the services.

24 Enclosures

24.1 Annexure 1 – Quality Assurance Plans and Indicative Inspection and Test Plans.

Sr.no	Description	Document No.	Revision No.
1	Project Inspection and Test Plan for Shop Inspection	6723-LEX-G00-EC-0001	00
a	Indicative Inspection and Test Plan for Static equipments - Pressure vessels, heat exchangers, Columns, Tanks, Stack and reactors	6723-LEX-G00-EC-0001-A101	00
b	IITP for Process & Utility Packages	6723-LEX-G00-EC-0001-A102	00
c	Indicative Inspection and Test Plan for Seamless, ERW and Welded Pipes ordered on Manufacturers	6723-LEX-G00-EC-0001-A201	00
d	Indicative Inspection and Test Plan for Seamless, ERW and Welded Pipes ordered on Traders	6723-LEX-G00-EC-0001-A202	00
e	Indicative Inspection and Test Plan for Plate and Forged Flanges	6723-LEX-G00-EC-0001-A203	00
f	Indicative Inspection and Test Plan for Welded, Seamless & Forged Fittings.	6717-LEX-000-EC-0001-A204	00
g	Indicative Inspection and Test Plan for Fasteners	6717-LEX-000-EC-0001-A205	00
h	Indicative Inspection and Test Plan for Gaskets	6717-LEX-000-EC-0001-A206	00
i	Indicative Inspection and Test Plan for Ball Valves – Soft (Resilient) Seated	6723-LEX-G00-EC-0001-A207	00
j	Indicative Inspection and Test Plan for PFA Lined Ball & Plug Valves	6723-LEX-G00-EC-0001-A208	00
k	Indicative Inspection and Test Plan for Rubber or PTFE/PFA lined Butterfly & Diaphragm Valves	6723-LEX-G00-EC-0001-A209	00
l	Indicative Inspection and Test Plan for Butterfly Valves-Soft Seated(Loose Sleeve)	6723-LEX-G00-EC-0001-A210	00
m	Indicative Inspection and Test Plan for Rubber or PFA Lined Check Valves	6723-LEX-G00-EC-0001-A211	00
n	Indicative Inspection and Test Plan for Cast/Forged Gate, Globe and Check Valves	6723-LEX-G00-EC-0001-A212	00
o	Indicative Inspection and Test Plan for Plug Valves-Soft (Resilient) Seated	6723-LEX-G00-EC-0001-A213	00