

## Inspection and Test Plan for Seel Structure

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	AISC	AISC	DWG, Calculation book	H	R	A	-
3	WPS&PQR	AWS D1.1	AWS D1.1	Welding Book	H	R	A	-
4	Welder Qualification Certificates	AWS D1.1	AWS D1.1	Certificates	H	R	-	-
5	NDT procedures	AWS D1.1	AWS D1.1	Procedures	H	R	A	-
6	NDE Personnel Certificates	AWS D1.1	AWS D1.1	Certificates	H	R	-	-
7	Painting Procedure	SSPC	SSPC	Procedure	H	R	A	-
<b>Materials</b>								
8	Visual Inspection of Materials for General Appearance, Corrosion and Dimension	ASTM	ASTM	Original Material Certificates	H	H	-	-
9	Welding Material Control	ASME II/AWS	ASMEII/AWS	Report	H	W	-	-
10	Review of Certificates	ASTM	ASTM	Certificates	H	H	-	-

11	Inspection of Bolt , Nut and Washers (General Appearance, Corrosion and Dimension, Chemical Composition and Mechanical Properties)	ASTM	ASTM	Report	H	W	-	
12	Material Identification	ASTM	ASTM	Report	H	H	-	
<b>During Fabrication</b>								
13	Fit-Up Inspection	AWS D1.1	AWS D1.1	Report	H	SW	-	
14	Dimensional and Visual Inspection for Correct Location, Orientation, strightness and Dimension	DWG	DWG	Report	H	W	-	
15	Visual Inspection of Welds for Weldment Quality/Defects, Weld Apperance and etc.	AWS D1.1	AWS D1.1	Report	H	W	-	
16	NDE Examination	Procedure	Procedure	Report	H	SW	-	
<b>Final Inspection</b>								
17	Final Visual & Dimensional Check	DWG	DWG	Report	H	H	-	-
18	Surface Preparation and Painting	Procedure	Procedure	Report	H	W	-	-
19	Check of Final Book	Spec.	Spec.	DWG/ P.O	H	R	-	
<b>Documentation</b>								

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20	Inspection Reports	Spec./DWG	Spec./DWG	Report	H	R	-	-
21	NCR	Spec./DWG	Spec./DWG	Report	H	R	-	-
22	Review Final Data Report	Spec./DWG	Spec./DWG	Report	H	R	-	-
<b>Pre-Shipment Inspection</b>								
23	Preservation and Packing	Spec.	Spec.	Report	H	H	-	-
24	Marking	Spec.	Spec.	Report	H	H	-	-
25	Loading Inspection	Spec.	Spec.	Report	H	H	-	-
26	Shipping Document Control	Procedure	Spec.	Packing List	H	H	-	-

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.

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-steel-structure.html>

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