

INSPECTION & TEST PLAN

DOC.NO : KS-ITP-001

PAGE NO : 1 of 3

P.O NO :

CUSTOMER :

ITEM NAME : FORGED FITTINGS

PROJECT NAME :

				For Approval
REV.NO	PREPARED BY	REVIEWED BY	APPROVED BY	DETAIL OF REV.NO

Project Name :



INSPECTION & TEST PLAN

VENDOR :	Keon Sae High Pressure.co.,Ltd	DOC. No. :	KS-ITP-001
MATERIAL :	FORGED FITTINGS	PAGE :	2 OF 2
P/O No. :		REV No. :	0
		Requisition :	

ACT ION	QUALITY RELATED ACTIVITY	REFERENCE DOCUMENT	CHARACTERISTICS TO BE VERIFIED	Acceptance Criteria	Verifying Document	INTERVENTION POINTS.			Remarks
						Vendor	Custemer	Owner	
1	MATERIAL VERIFY	Specifications and Relevant ASTM STD	CHEMICAL COMPOSITION MECHANICAL PROPERTY SIZE, HEAT NUMBER, GRADE	Conforming to required ASTM standard/specification	RAW MATERIAL CERTIFICATE EN10204 3.1	H	R	R	
2	HEAT TREATMENT	Specifications and Relevant ASTM STD	HEAT TREATMENT METHOD HEATING/COOLING RATE HOLDING TEMP.&TIME	Conforming to required ASTM standard/specification	INSPECTION CERTIFICATE As per EN10204 3.1 Heat Treatment Record and Chart	H	R	R	
3	MECHANICAL TEST	Specifications and Relevant ASTM STD	TENSION TEST HARDNESS TEST	Conforming to required ASTM standard/specification	INSPECTION CERTIFICATE As per EN10204 3.1 Test Report	H	R	R	
4	NDE	SID-10-YME-MIT-IDM-004, ASME BPVC Section V, Articles 6 ASME BPVC Section V, Articles 7 paragraph 136.4.3 or 136.4.4 of ASME B31.1	CRACK, DAMAGE, DEFECT	ASME BPVC Section V, Articles 6 ASME BPVC Section V, Articles 7 paragraph 136.4.3 or 136.4.4 of ASME B31.1	NDE REPORT	H	R	R	- Carbon & Alloy Steel : MT - Austenitic stainless steel : PT
5	POSITIVE MATERIAL IDENTIFICATION	Specifications and Relevant ASTM STD	VERIFICATION OF ALLOY ELEMENT	Conforming to required ASTM standard/specification	PMI REPORT	H	SW	R	
6	MARKING AND COLOUR CODE INSPECTION	SID-10-YME-MIT-IDM-004 ASME BPVC Section V, Articles 6	SURFACE LOGO,SIZE,PRESSURE RATE HEAT NO. , ETC CLEAN AND NO DEFECT DISCIMINATION COLOUR	Conforming to required ASTM standard/specification	INSPECTION CERTIFICATE As per EN10204 3.1	H	SW	R	
7	FINAL DIMENSION INSPECTION VISUAL	Specifications and Relevant ASTM STD	THICKNESS, LENGTH BEVEL ANGLE, ETC.. THREADNES CHECK (By NPT Gauge) OVALITY	ASME CODE ASME B16.11, ASME B16.25, MSS SP-95, MSS SP-97, MAKER STANDARD, DWG...	INSPECTION CERTIFICATE As per EN10204 3.1	H	SW	R	
8	PACKING INSPECTION	-	SHIPPING MARK CARE MARK WATER PROOF BOX	-	PACKING LIST	H	SW	R	
9	INSPECTION RELEASE NOTICE	-	INSPECTION RELEASE NOTICE	MATERIAL REQUISITION AND PURCHASE ORDER	IRN	H	H	R	

Legend : H : Hold Point W : Witness Point SW : Spot Witness R : Document Review M : Monitoring