

Inspection & Test Plan		
Client:	Job No.:	Plan number : 01-07-2011
Project:	Contract :	Rev. : 01
Specifications : DNV OS F 101 Oct.2007 / LAT-L-SP-90133 LTM-L-SP-90183 / GS-EP-PLR-420-EN		Sheet : 1 of 5

PREFABRICATION; ERECTION AND TESTING

Act .No	Description	Procedure	Acceptance Criteria	Document	Cofely	Allseas	DNV	TEP
01	Approval of WPS / PQR	W11.03.01	DNV OS-F101 Oct.2007 LAT-L-SP-90133	Approved WPS/PQR	H	H	H	H/R
02	Approval of Welders Qualifications	W11.03.01	DNV OS-F101 O LAT-L-SP-90133ct.2007	Approved welders list	H	R/H	H	H/R
03	Approval NDT Operators / NDT Procedures.	Rt ,UT,MT,PT	DNV OS-F101 Oct.2007	RT 11207 Rev0 UT11210 Rev0 MT11208 Rev1 PT 11209 Rev0	H	H	H	H/R
04	Check calibration of all welding / inspection equipment / NDT Equipment	Internal procedure		Calibration Certificate Register	H	M/R	R	R
05	Pre-Inspection Meeting				H	H	H	H
06	Drawings "Approved for Construction"		DNV OS-F101 Oct.2007	AFC Drawings	R	H	R	R
07	Receiving Inspection of materials including identification	W08.05.01 W10.02.01	DNV OS-F101 Oct.2007	Mat. Cert.	H	R	M	M

Inspection points: H = Hold; W = Witness; R = Review; M = Monitor			Manufacturer	Client	Cert. Auth DNV	TEP
Rev.	Date	Prepared	Sign. and Date	Sign. and Date	Sign. and Date	Sign. and Date
00	26-06-2011					
01	06-07-2011					

Inspection & Test Plan		
Client:	Job No.:	Plan number : 01-07-2011
Project:	Contract :	Rev. : 01
Specifications : DNV OS F 101 Oct.2007 / LAT-L-SP-90133 LTM-L-SP-90183 / GS-EP-PLR-420-EN		Sheet : 2 of 5

PREFABRICATION; ERECTION AND TESTING

Act .No	Description	Procedure	Acceptance Criteria	Document	Cofely	Allseas	DNV	TEP
---------	-------------	-----------	---------------------	----------	--------	---------	-----	-----

08	Compiling material certificates of all materials Certificates conforming to DNV Rules	W08.05.02 W08.05.01	DNV OS-F101 Oct.2007	Mat. Cert. 3.2 Certificate	R	H	H	R
09	Remark pipe materials with heat number (by means of hard stamps) and identification (by means of a paint marker) before cutting .	W10.02.03	W10.02.03	Cert. Index	H	M/R	H	M
10	Bevel preparation by machining or grinding	WPS	WPS	WPS	H	M	M	M
11	Bevel Check (Visual)	WPS	DNV OS-F101 Oct.2007		H	M	M	M
12	All bevelled ends to be UT tested for laminations to 100 mm back from pipe ends prior to welding All prepared weld bevels to be 100% MPI examined by wet MPI prior to welding	UT 11210 rev.0 MT11208 rev. 1	DNV OS-F101 Oct.2007	NDT reports	H	M/R	R	M
13	Fit –Up spools including dimensional control	W10.02.02 PW11.05.22.E	WPS	F11.03.01.07 E	M	M	M	M
14	Handling of welding consumables	W11.03.02	DNV OS-F101 Oct.2007	F11.03.02.01	H	M/R	M	M
15	Welding by qualified welders. Welding parameter check	W10.02.02	DNV OS-F101 Oct.2007	Weld Log sh.(LISL)F11.	H	M/R	M	M/R

Inspection points: H = Hold; W = Witness; R = Review; M = Monitor			Manufacturer	Client	Cert. Auth DNV	TEP
Rev.	Date	Prepared	Sign. and Date	Sign. and Date	Sign. and Date	Sign. and Date
00	26-06-2011					
01	06-07-2011					

Inspection & Test Plan		
Client:	Job No.:	Plan number : 01-07-2011
Project:	Contract :	Rev. : 01
Specifications : DNV OS F 101 Oct.2007 / LAT-L-SP-90133 LTM-L-SP-90183 / GS-EP-PLR-420-EN		Sheet : 3 of 5

PREFABRICATION; ERECTION AND TESTING

Act .No	Description	Procedure	Acceptance Criteria	Document	Cofely	Allseas	DNV	TEP
			PQR	03.01.07E				
16	Visual inspection of welds	W11.03.07 EN 970:1997	DNV OS-F101 Oct.2007	F11.03.01.07 E	H	W	W	M
17	Pre NDO BPWHT In House	Per Act No 19/20	DNV OS-F101 Oct. 2007	NDT Report	H			
18	PWHT / Procedure 110286-0 rev.00	Heat Treatment proc.Delta Heat	DNV OS-F101 Oct.2007	Report	H	H	W	W
19	Non Destructive Examination of welds – 100% UT + Rt. To be executed no less than 24 hours after welding	UT 11210 rev 0 RT 11207 rev.0	DNV OS-F101 Oct.2007	NDT Report	H	M/R	R	M/R
20	Non Destructive Examination of welds – 100% MT (c/s) 100% PT (Inconel) welds To be executed not less than 24 hours after welding	MT 11208 rev.1 PT 11209 rev.0	DNV OS-F101 Oct.2007	NDT Report	H	M/R	R	M/R
21	Completing of Line Inspection Summary List + As built	W10.02.02	DNV OS-F101 Oct.2007	LISL + As built drawing	H	M/R	R	R
22	Inspection and releasing spools for hydrotest (including verification of main dimensions and cleaning)	W10.02.02 / PW11.05.22E	DNV OS-F101 Oct.2007	LISL+ As built F11.03.01.07	H	H/R	H	H/R

Inspection points: H = Hold; W = Witness; R = Review; M = Monitor			Manufacturer	Client	Cert. Auth DNV	TEP
Rev.	Date	Prepared	Sign. and Date	Sign. and Date	Sign. and Date	Sign. and Date
00	26-06-2011					
01	06-07-2011					

Inspection & Test Plan		
Client:	Job No.:	Plan number : 01-07-2011
Project:	Contract :	Rev. : 01
Specifications : DNV OS F 101 Oct.2007 / LAT-L-SP-90133 LTM-L-SP-90183 / GS-EP-PLR-420-EN		Sheet : 4 of 5

PREFABRICATION; ERECTION AND TESTING

Act .No	Description	Procedure	Acceptance Criteria	Document	Cofely	Allseas	DNV	TEP
---------	-------------	-----------	---------------------	----------	--------	---------	-----	-----

				E				
23	Welding of pressure parts. 100% RT, UT, MT	W10.02.02	DNV OS-F101 Oct.2007	Weld log sht F11.03.01.07E	H	M/R	M	M/R
24	Pressure testing of lines, Test 1 = 529bar Test 2 = 406bar	W11.05.06	DNV OS-F101 Oct.2007	F11.05.05.04	H	H/R	H	H/W
25	Removal of pressure parts				H	M	M	M
26	All prepared weld bevels to be 100% MPI examined by wet MPI , before transport.	UT 11210 rev.0 MT11208 rev. 1	DNV OS-F101 Oct.2007	NDT Reports	H	M/R	R	M
27	Visual inspection after hydro test / verification of main dimensions and cleaning	W11.05.05	Drawings	F11.05.05.02	H	H	M	W/R
28	Release for painting according GS-EP-COR350-system P10	Procedure & ITP Subcontractor	GS-EP-COR350-system P10	Inspection report	H	H/R	M	M/R
29	Final inspection / release	W11.05.09	DNV OS-F101 Oct.2007	Data dossier	H	H	H	H/R

Inspection points: H = Hold; W = Witness; R = Review; M = Monitor			Manufacturer	Client	Cert. Auth DNV	TEP
Rev.	Date	Prepared	Sign. and Date	Sign. and Date	Sign. and Date	Sign. and Date
00	26-06-2011					
01	06-07-2011					

Inspection & Test Plan

Client:	Job No.:	Plan number : 01-07-2011
Project:	Contract :	Rev. : 01
Specifications : DNV OS F 101 Oct.2007 / LAT-L-SP-90133 LTM-L-SP-90183 / GS-EP-PLR-420-EN		Sheet : 5 of 5

PREFABRICATION; ERECTION AND TESTING

Act .No	Description	Procedure	Acceptance Criteria	Document	Cofely	Allseas	DNV	TEP
---------	-------------	-----------	---------------------	----------	--------	---------	-----	-----

				Release note				
30	Compiling final documentation	W11.05.09	DNV OS-F101 Oct.2007	Data dossier Release note	H	H	H	H/R
31	Handover final documentation	W11.05.09	DNV OS-F101 Oct.2007	Data dossier Release note	H	H	H	H/A

Inspection points: H = Hold; W = Witness; R = Review; M = Monitor			Manufacturer	Client	Cert. Auth DNV	TEP
Rev.	Date	Prepared	Sign. and Date	Sign. and Date	Sign. and Date	Sign. and Date
00	26-06-2011					
01	06-07-2011					

Inspection & Test Plan		
Client:	Job No.:	Plan number : 01-07-2011
Project:	Contract :	Rev. : 01
Specifications : DNV OS F 101 Oct.2007 / LAT-L-SP-90133 LTM-L-SP-90183 / GS-EP-PLR-420-EN		Sheet : 6 of 5

PREFABRICATION; ERECTION AND TESTING

Act .No	Description	Procedure	Acceptance Criteria	Document	Cofely	Allseas	DNV	TEP
---------	-------------	-----------	---------------------	----------	--------	---------	-----	-----

Inspection points: H = Hold; W = Witness; R = Review; M = Monitor			Manufacturer	Client	Cert. Auth DNV	TEP
Rev.	Date	Prepared	Sign. and Date	Sign. and Date	Sign. and Date	Sign. and Date
00	26-06-2011					
01	06-07-2011					