 	PROJECT		Standby SRU & Additional Tanks IOCL Paradip Refinery	
	CLIENT		INDIAN OIL CORPORATION LIMITED	
QCP-PIPING WELDING ACTIVITIES MANAGEMENT	Project No. 080557C001	Document No. 080557C-000-QCP-1399-002	Rev. No. A	Page 1 of 3

QUALITY CONTROL PLAN
PIPING WELDING ACTIVITIES MANAGEMENT
(NDE / PWHT / HT / PMI INCLUDED)

TYPE OF QUALITY CONTROL REPORT	CERTIFICATION EXTENT
W 11	SUMMARY
W 25	MONTHLY REPORT


REFERENCE DOCUMENTS:

- 080557C-000-PP-805 Site Coordination & Communication Procedure.
- 080557C-000-PP-814 Welding Specification for Fabrication of Piping
- 080557C-000-PP-807 Material Receiving Handling & Storage procedure
- 080557C-000-PP-804 Specification for Positive Material Identification at Construction Sites
- 080557C-000-JSC-1300-001 Standard Specification for Fabrication and Erection of Piping
- QCP 1399.01 Welders Management
- DRAWINGS

LEGENDA

H	=	HOLD (RFI required - Work stop for inspection)
W	=	WITNESS (RFI required)
WC	=	100 % SUPERVISION AND EXAMINATION BY CONTRACTOR.
S	=	SURVEILLANCE (No RFI)
R	=	REVIEW OF REPORTS
N.A.	=	NOT APPLICABLE
A	=	AUTHORIZATION / APPROVAL
IFA	=	ISSUED FOR AUTHORIZATION/APPROVAL
INFO	=	FOR INFORMATION
RFI	=	REQUEST FOR INSPECTION
!	=	WARNING (control of document revision status)

A	19/10/2019	ISSUED FOR INFORMATION	SMP	PKP	LA/ANJ	JMC
REV.	DATE	DESCRIPTION	PREPARED	CHECKED	APPROVED	AUTHORIZED

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S.No	CHECK AND INSPECTION ITEM	QUALITY CONTROL REPORT	ACTION		NOTES
			CONTR.	TECHNIP	
A) PRELIMINARY ACTIVITIES					
A.1	CONTRACTOR DRAWINGS CHECK REVISION STATUS	N.A.	!	!	
A.2	CONTRACTOR / COMPANY TECHNICAL SPECIFICATIONS AND PROCEDURES	N.A.	!	!	
B) WELDING					
B.1	REVIEW OF PROPOSED (WPS) WELDING PROCEDURE SPECIFICATION.		A / R	A / R	
B.2	WELDING OF TEST COUPONS & SUBSEQUENT TESTING IF APPLICABLE		WC	H	
B.3	APPROVAL OF WPS & PQR		WC	H	
B.4	WELDING BOOK (PIPING WELDING KEY FORM)	W11	A	R	
B.5	LOG OF WELDING EQUIPMENT CALIBRATION VERIFICATION	Subc. Log	A	R	
C) WELDING CONSUMABLES					
C.1	PROCEDURE OF FILLER MATERIAL MANAGEMENT	Subc. Log	A	R	
C.2	STORAGE / HANDLING	Subc. Log	S	S	
C.3	MATERIAL CERTIFICATES	Subc. Log	R	S	
D) ISOMETRICS					
D.1	PIPE SPOOLS IDENTIFICATION	N.A.	S	S	
D.2	WELDS IDENTIFICATION	N.A.	S	S	
E) POSITIVE MATERIAL IDENTIFICATION (PMI)					
E.1	PMI PROCEDURE	N.A.	A	R	
E.2	PMI OPERATORS QUALIFICATION	N.A.	A	R	
F) NON DESTRUCTIVE EXAMINATION (NDE)					
F.1	VISUAL EXAMINATION (VT) PROCEDURE	N.A.	A	A	
F.2	LIQUID PENETRANT (PT) EXAM. PROCEDURE	N.A.	A	A	
F.3	MAGNETIC PARTICLE (MT) EXAM. PROCEDURE	N.A.	A	A	
F.4	RADIOGRAPHIC EXAM. (RT) PROCEDURE	N.A.	A	A	
F.5	ULTRASONIC EXAMINATION (UT) PROCEDURE	N.A.	A	A	
F.6	NDE MONTHLY STATUS	W 25	R	R	(1)
F.7	NDE PERSONNEL	N.A.	H	R	(2)
G) POST WELD HEAT TREATMENT (PWHT) & HARDNESS TEST (HT)					
G.1	PWHT PROCEDURE	N.A.	A	R	
G.2	LIST OF JOINTS REQUIRING PWHT	N.A.	R	R	
G.3	HT PROCEDURE	N.A.	A	R	
H) REPAIRS PROCEDURE		N.A.	A	R	

NOTES:

- (1) THESE REPORTS WILL BE ALWAYS AVAILABLE AS HARD COPY DURING PREFABRICATION/ERECTION BUT NOT INCLUDED IN THE FINAL CONSTRUCTION QUALITY DOSSIER.
- (2) NDE PERSONNEL AND RELEVANT PROCEDURES SHALL BE APPROVED BY AN INDEPENDENT RECOGNIZED THIRD PARTY ORGANIZATION.

GENERAL NOTES

- 1 THE ENCLOSED ITP'S ARE INDICATIVE AND SHALL BE FOLLOWED FOR DEVELOPING THEJOB SPECIFIC ITP'S FOR THE WORKS TO BE PERFORMED BY THE CONTRACTOR. THE PROVISIONS INDICATED FOR STAGE WISE INSPECTION BY TECHNIP AND OWNER (FOR SPECIFIC ACTIVITIES) ARE THE MINIMUM AND THE ENGINEER-IN-CHARGE MAY DECIDE TO INCREASE HOLD POINTS/ WITNESS POINTS, WHILE APPROVING THE JOB SPECIFIC

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ITP'S. ACTIVITIES FOR WHICH ITP'S ARE NOT PROVIDED IN THIS SPECIFICATION. CONTRACTOR TO DEVELOP AND GET THE SAME APPROVED BY TECHNIP/OWNER BEFORE START OF THE WORK. IN GENERAL ROLE OF TECHNIP HAS BEEN SPECIFIED IN THE DOCUMENT THE ROLE OF OWNER TO BE SPECIFIED DURING PREPARATION OF SITE SPECIFIC ITP'S.

- 2 CONTRACTOR TO SUBMIT JOB SPECIFIC REPORTING FORMATS AND JOB PROCEDURES FOR THE JOBS FOR EACH ACTIVITY LISTED IN THE ITP'S AND SUBMIT TO TECHNIP/OWNER FOR APPROVAL. BEFORE COMMENCEMENT OF THE ACTIVITY. IF THE CONTRACTOR HAS TO DEVIATE FROM THE GIVEN ITP FOR A VALID REASON, HE SHALL OBTAIN PRIOR WRITTEN APPROVAL OF TECHNIP/OWNER. CONTRACTOR TO CARRY OUT 100% EXAMINATION OF ALL ACTIVITIES.



PROJECT:

COMPANY:

QUALITY CONTROL FORM

W 11

PROJ. No.:

QCF REV.0

SH. 1 OF 2

PIPING WELDING KEY FORM

SUBCONTRACTOR:

W 11 N°

PIPING CLASS (REF TO W 09)	BASE MATERIAL (P-N° OR GRADE)	WPS N°	WELDING DETAIL N° (SEE SH. 2)	WELDING PROCESS			PREHEAT. (Y/N)	HARDNESS (Y/N)	CHARPY IMPACT (Y/N)	PWHT (Y/N)	WALL THK RANGE	PIPE SIZE RANGE	PQR N°	REMARKS
				GTAW	SMAW									

INSPECTORS

CONTRACTOR

PMC

OWNER

NAME

SIGNATURE

DATE

TechnipFMC



PROJECT:

COMPANY:

QUALITY CONTROL FORM

W 11

PROJ.No.:

QCF REV. A

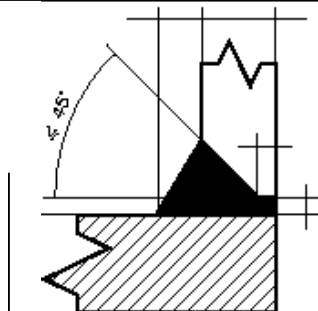
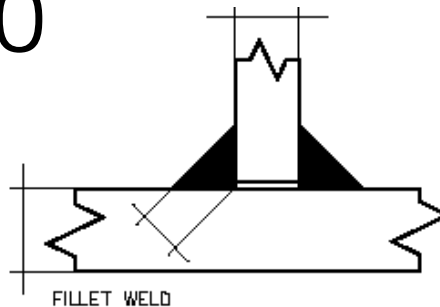
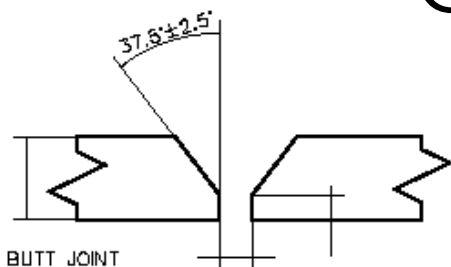
SH. 2 OF 2

PIPING WELDING KEY FORM
ELDING DETAIL

SUBCONTRACTOR:

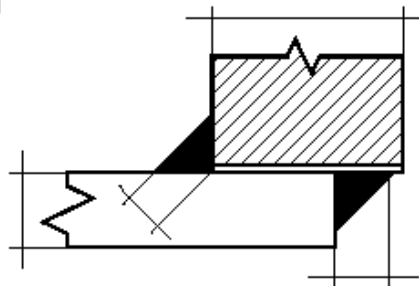
W11W

CD0



3

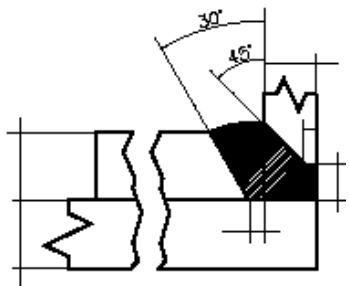
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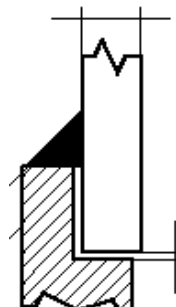
SET ON BRANCH IIIELD

SLIP-ON IIIELD

Ⓡ 0

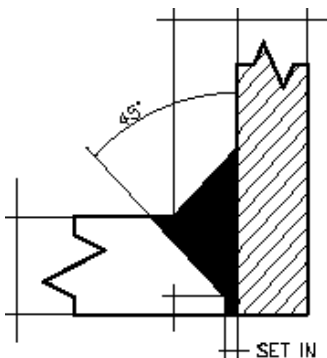


SET ON BRANCH V<ELO WIH REINFORCING PAD

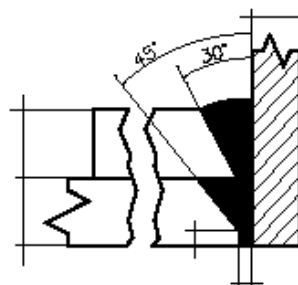


SOCKET V<ELO

0 Ⓡ



SET IN BRANCH WELD



SET IN BRANCH WELD WIH REINFORCING PAD



TechnipFMC



PROJECT:

COMPANY:

QUALITY CONTROL FORM

W 25

PROJ. No.:

QCF REV. 0

SH. ____ OF ____

MONTHLY RADIOGRAPHIC AND REPAIRING STATUS

CONTRACTOR:

W 25 N° ____

UP-TO-DATE TO:

PROGR	ITEM OR DESCRIPTION	MATERIAL	A (1)	B	C = A x B	NDE TYPE	No CHECKS		EXTENSIONS		H = (E+G) / (D+F)	NOTES
			No JOINTS/m	REQUIRED % age	No. CHECKS		D	E	F	G	%	
							PERFORMED	DEFECTIVE	PERFORMED	DEFECTIVE	DEFECTS	
1												
2												
3												
4												
5												
6												
7												
8												
9												
10												
11												
12												
13												

(1) JOINTS NUMBER TO BE CHECKED (PIPING) OR WELDING METERS TO BE CHECKED (TANKS, VESSELS,)

ISSUED By:

CONTRACTOR INSPECTOR

DATE

CHECKED BY:

PMC INSPECTOR DATE