

Wolf GmbH & Co.KG
57234 Wilnsdorf

Air Liquide Purchase-no.:
4500023998

Project: ASU Kosice No.9

Kom.Nr. 37106

Dokument No. :

Document: Inspection and Testing Plan

Description: Molsieve Filter

Tag No.: F15031

Drawing No.: 11441- 0

0	first issue	07.12.2004		Strake	TB		
Status	Ausgabe	Datum	geänd.Seiten	erstellt	Abtlg.	geprüft	genehmigt

WOLF	Fabrication- and Testingplan MOLSIEVE FILTER F 15031	Wolf-Dokument Nr: 11441-4-ITP Air Liquide-Dokument Nr:	Issue: 0 07.12.04	Sheet 2 of 6
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1 Scope

This Inspection and Test plan covers relevant inspections and tests of 1 Molsieve Filter in an ASU-Unit.

2 Definitions/Abbreviations

SUPPLIER	=	WOLF GmbH & Co. KG, Behälter- und Apparatebau, 57234 Wilnsdorf
CLIENT	=	Client (Erection Place Kosice, Slowakia).
PURCHASER	=	Air Liquide AGS GmbH, Füttingsweg 34,D-57234 Krefeld, Germany.
NB	=	Notified Body = Kenn-Nr.: 0044, (RWTÜV Systems GmbH, Dienststelle Siegen, Leimbachstrasse 227, D-57074 Siegen).
PED	=	Pressure Equipment Directive 97/23/EC.
WPS	=	Welding procedure specification
WPAR	=	Procedure qualification approval record
PWHT	=	Postweld Heat Treatment
NDE	=	Non-Destructive Examination
WPTC	=	Weld Production Test Coupon
MDR	=	Manufacturing Data Report (Final Documentation)
MTR	=	Mill Test Report
LW	=	Longitudinal welding seam
CW	=	Circumferential welding seam
NW, NCW	=	Nozzle welding seam
n.a.	=	Not applicable

3 Key to Type of Inspection

A	=	Approve
I	=	Prepare / Compile and Issue
O	=	Organize
P	=	Participate
R	=	Review of Documents / Evaluation of Radiographs
X	=	Perform
H	=	Full Witness (Hold Point)
		Advance notice for inspection: 5 working days. Supplier shall not proceed with the fabrication unless the concerned party waives their participation in writing
C	=	Certificate / document required for MDR.
W	=	Spot Witness
		Advance notice for inspection: 5 working days. Supplier may proceed with the fabrication or inspection activity even in the absence of concerned parties.

4 Signing-Off

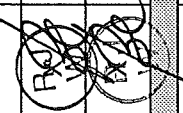
When one operation has been completed to their satisfaction the various representatives shall sign and date their acceptance in the respective columns against the individual operations.

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SL. No.	Operation (Inspection / Test Activity)	Reference Document (Spec's, Drg's etc.)	Verification Document	Inspection / Test Mark-Up / Sign-off				Cert's Doc's for MDR		Remarks	
				SUPPLIER	CLIENT	PURCHASE R	NB				

1	Pre-Fabrication Meeting		Minutes of meeting	P			O + P			
2	Fabrication Documents									
2.1	- Fabrication drawings - List of materials - Design calculation	Tag F15031	Approved documents				R / A			C
2.2	- NDE procedures - Pressure test procedure - Painting procedure - Material traceability procedure	Supplier's documents	Approved documents				R			
2.3	- WPS / WPAR - Welding and testing plan - Inspection and test plan	11441-4-WTP Supplier's documents	Approved documents				R / A			C
2.4	- Welder's list - Welder's qualification records	Supplier's documents	Approved documents				R			
2.5	- Material specifications or suborders for material	n.A.	Approved documents	I						
3	Materials									
3.1	Inspection of in-coming materials (visual checks; identification, dimensional checks etc.)	Material specifications or suborders for material								
3.2	Mill Test Reports	part list	MTR's				R			C
3.3	Filler Metal Certificates	11441-4-WTP	Filler Metal Certificates				R			
4	Templates & Anchor Bolts									
4.1	Dimensional & visual checks on templates	Fabrication drawings	Supplier's inspection report							

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SL. No.	Operation (Inspection / Test Activity)	Reference Document (Spec's, Drg's etc.)	Verification Document	Supplier's inspection report, MTR	Inspection / Test Mark-Up / Sign-off				Cert's Doc's for MDR	Remarks	
					SUPPLIER	CLIENT	PURCHASE R	NB			
4.2	Dimensional & visual checks on anchor bolts	Fabrication drawings		Supplier's inspection report, MTR	X			R			.
5	Fabrication										
5.1	Material identification and transfer of markings	Material traceability procedure									

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SL. No.	Operation (Inspection / Test Activity)	Reference Document (Spec's, Drg's etc.)	Verification Document	Inspection / Test Mark-Up / Sign-off			NB	Cert's Doc's for MDR	Remarks	
		SUPPLIER	CLIENT	PURCHASE R						
5.13	MT of arc strikes on inside wall after grinding	Welding and testing plan,					R			
5.14	n.a.									
6	Inspection & Pressure Test									
6.1	Visual inspection	Fabrication drawings	Supplier's inspection report				H		C	
6.2	Dimensional inspection	Fabrication drawings DIN 28005	Supplier's inspection report				H		C	
6.3	Approval of concession requests & non-conformance reports	n.A.	Approved concession requests & non-conformance reports				R / A			
6.4	Verification of MDR and release for pressure test	Fabrication drawings	See column Cert's, Doc's for MDR				H		C	
6.5	Verification of pressure gauge calibration	Fabrication drawings	Calibration certificate				R			
6.6	Pressure test	Fabrication drawings	Pressure test certificate				H		C	
6.7	Leak test on reinforcing pad welds	Fabrication drawings	Supplier's leak test report				R		C	
7	Painting									
7.1	Surface preparation	Fabrication drawing	Painting certificate				R		C	
7.2	Paint application	Fabrication drawing	Painting certificate				R		C	
7.3	Check of dry film thickness	Fabrication drawing	Painting certificate				W		C	
7.4	Adherence test, if any	Fabrication drawing	Painting certificate				R		C	

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SL. No.	Operation (Inspection / Test Activity)	Reference Document (Spec's, Drg's etc.)	Verification Document	Inspection / Test Mark-Up / Sign-off				Cert's Doc's for MDR	Remarks
				SUPPLIER	CLIENT	PURCHASE R	NB		
8	Final Inspection								
8.1	Marking	Fabrication drawing,		X			W		
8.2	Packing (wooden saddles, desiccant, etc.)	Fabrication drawing,		X			W		
8.3	Cleanliness	Fabrication drawing,		X			W		
8.4	Assembly of internal stand pipes (orientation, spacing & size of bore holes)	Fabrication drawing							
8.5	Assembly of external attachments (e. g. lifting tunnions, davit for manhole cover, platform clips)	Fabrication drawing		X			H		
8.6	Check of name plate	Fabrication drawing	Name plate rubbing or photograph					H	
8.7	Review and approval of MDR		See column Cert's, Doc's for MDR						
9	Release								
9.1	Inspection release		Inspection release certificate				I		
9.2	Shipping Release		Shipping release note				I		