

	POBOYA 2000 TPD EXPANSION PROJECT	
(CPM Work No.) 14898	Project Document No.: E2601-4400-PRO-013	Revision No. : B
(Vendor Work No.) E2601	Client Document No. : HNZ-V-PT0061.08-4400-STR-PRO-013	Page 1 of 16

ERECTION STEEL STRUCTURE PROCEDURE (STRUCTURE OF CIL TANK AREA)

CLIENT : PT. CITRA PALU MINERALS (CPM)
PROJECT NAME : POBOYA 2000 TPD EXPANSION PROJECT
LOCATION : PALU, SULAWESI
CONSULTANT : PT. COMO ENGINEERS (PT. CE)
VENDOR : PT. HANAZONO ENGINEERING INDONESIA
DOCUMENT NO. : E2601-4400-PRO-013

FOR APPROVAL

☐ AP	APPROVED
☐ AN	APPROVED AS NOTED
☐ RE	NOT APPROVED (Re-Submit)
☐ RV	REVIEWED
☐ RN	REVIEWED WITH NOTES
☐ NR	NOT BE RETURNED
RETURN DATE	
	

						
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1. Purpose

This Procedure covers the requirements a minimum guideline for Erection of steel structure of Poboya 2000TPD Expansion Project and to be use for Structure for CIL Tank area, the owned by PT Citra Palu Minerals. The project is located at Palu, Sulawesi Tengah, Indonesia.

2. Scope

This procedure will cover the erection of all Structure for CIL Tank area, of Poboya 2000TPD Expansion Project.

This is item to be erection as below :

1. Fabrication and Installation Structure for CIL Tank at Vessel Loaded Carbon
2. Fabrication and Installation Structure for CIL Tank for Trash Screen
3. Fabrication and Installation Structure for CIL Tank for Loaded Carbon Screen
4. Fabrication and Installation Structure for CIL Tank for Baren Carbon Screen
5. Fabrication and Installation Structure for CIL Tank for Carbon Safety Screen
6. Fabrication and Installation Structure for CIL Tank for Leach Feed Sampler
7. Fabrication and Installation Structure for CIL Tank for Tailing Sampler

3. Reference

This procedure prepared in accordance with following reference:

- JIS Standards
- ASTM Standards
- ANSI
- AWS D1.1
- SSPC Steel Structure Painting Council"
- Fabrication Drawing (AFC)
- Request for Quotation (RFQ) Steel Structure and Plate works Supply and Install Document No. 2000-4000-STR-RFQ-002
- General Specification for Painting Document No. : ADIP-3655-2100-018-SFP-0003
- Specification for General Mechanical Requirement Document No. : 2000-4000-MER-SPE-001
- Specification for Supply & Fabrication of Plateworks Document No. : 2000-4000-MER-SPE-002
- Specification for Installation of Mechanical Equipment Document No. : 2000-4000-MER-SPE-004
- Specification for Structural Steel Work Supply, Fabrication and Erection Document No. : 2000-4000-STR-SPE-001

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4. Erection Drawing

Erection process shall be refer to latest revision and approval drawing.

- a All drawing before start of erection will approved by Client.
- b The document related to erection process will prepare and submit to site erection like as : diagram erection, drawing, procedure etc.
- c All drawings and documents shall be stamp For Construction before use to Site erection.

5. Responsibility

- 5.1 Construction Manager is Responsibility for overall implementation of HSE, and shall study, analyze and schedule all construction activities with his departement to include manpower and equipment line up as well as other possible resources required for the successful implementation od the construction work activities. Study all aspect of work procedure as pertechnical scope of work.
- 5.2 Structure Supervisor is resposible for all HSE mater of the works and shall study and review all necessary documents for the erection works, in his area to include, technical scope of work, specification, bill of quantities, planned milestone dates and construction procedure in support to his structure foreman. He shall monitor the availability reporting to theConstruction Manager. He shall be coordinate with other discipline to visualize possible conflicts in the drawins as well as in the schedules to provideothers options in preventing unnecessary delays obstructions.
- 5.3 Structure Foreman shall be responsible for all HSE maters and for thedirect work supervision at site and ensure that the work is performed in accordance with technical scope of work and latest approved forconstruction drawings. He shall monito the availability of materials in line with his required schedule.
- 5.4 Surveyor shall study and analyze if the location where the structure should be installed satisfies the condition 01' restrictionof erection workson site. He shall coordinate with other discipline to visualize possible conflicts in the drawings as well as in the schedules to provide other options in preventing unnecessary delays obstructions.
- 5.5 QC Inspector shall be responsible in monitoring and inspection of the work and ensure that the work is performed in accordance with tehcnical scope of work and Standards.

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5.6 Safety Engineer/Supervisor shall be responsible in monitoring safety aspects and ensuring that the work is done in accordance with Safety standards procedure. He shall be discuss to the workers of the characteristics of related materials and status of work area givinf reminders as an additional point to work safely.

6. Safety Precaution

6.1 Approved work permit should be obtained prior to the start any structure works.

6.2 Work execution shall be carried out in accordance with this method of statement.

6.3 Erection crew must carry out a safety risk assessment prior to the start of any new activities.

6.4 During any lifting works, signalman must be assigned full-time.

6.5 The necessary manpower inclusive of supervisory staff, tools, equipment, materials, and other resources required must be made available and ready to use.

6.6 Workers should be provided with and wear their PPE's needed for work.

6.7 Fire watcher with fire Extinguisher shall assign for any hot work.

6,8 Certified permit receiver, fire watcher, traffic flag man and work in charge should be at work site during the execution of the work.

6.9 Use of special man basket (engineered lifts), is subjected for inspection prior to be utilized on steel erection works. (Rigger I Required to sign man basket permit).

6.10 Personnel who will be working form a suspended work basket should start work. And have dedicated.

6.11 Man basket shall be inspected and tagged with PCM Certification.

6.12 Main Lift equipment shall be tested and certification by the CPM Equipment Inspection Division.

6.13 Only certified man lift operators shall be allowed to operate the man lift equipment.

6.14 Sufficient lighting shall be provided if work is done at night time. Work at night shall be approved by Client (PT CPM).

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7. Manpower

7.1 Manpower will consist of the following, but not limited to as listed below :

- ~ Supervisor
- ~ Foremen
- ~ Crane Operator
- ~ Surveyor
- ~ Man Lift Operator
- ~ Truck Drivers
- ~ Structure Fitters
- ~ Riggers
- ~ Plate Welders
- ~ Scaffolders
- ~ Semi-skilled workers
- ~ Safety

8. Tools s and Equipment.

8.1 Tools and equipment will consist but not limited as below :

- ~ Hydro Crane 150/70/60 tons
- ~ Crawler Crane 180 tons
- ~ Man lift
- ~ Trailer
- ~ Boom truck
- ~ Welding Machine
- ~ Air Compressor
- ~ Towel lights
- ~ Man basket
- ~ impact tools

9. Methods / Procedure

9.1 General Preparatory Work.

9.1.1 Confirm the turnover of civil works foundation / pedestals form civil for the installation of Column structure.

9.1.2 Secure necessary work permit representative prior to start of work activity.

9.1.3 Check foundations and others connection points to confirm locations, orientation elevation and condition.

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9.1.4 Identify the structure members for leave-out (if any) due to installation of equipment and other prerequisite.

9.1.5 Mobilize all manpower, tools and equipment needed for the job.

9.1.6 Prior to turnover, insure that the completed foundation with anchor bolts was already checked and is dimension, levelness, alignment top of concrete elevation, surface finish, and other as per the latest revision drawing and within acceptable tolerance.

9.2 Anchor Bolt Setting

9.2.1 Anchor bolt shall be installed as shown on the design drawing.

9.2.2 Contractor to coordinate with other trades when inserts placed by others are required.

9.2.3 Contractor to fill voids in sleeves with readily removable material to prevent the entry of concrete, dirt, etc.

9.3 Installation and Grouting of Packer Plates

9.3.1 Clean of the top of bearing surface and bottom of surface plates, Set and shim column base plate to correct positions, elevations, and locations as shown on the latest approved erection drawings. Shim and wedges to be used shall be provided by contractor, setting nuts shall be loosened before grouting.

9.3.2 Ensure that the top fo foundations have been properly roughened for bonding laitance, oil, grease, sand and other foreign matter shall be removed if any.

9.4 Dry Pack Grouting

9.4.1 Contractor shall be conduct one (1) time sampling/testing for dry pack grouting during setting of packer plates to ensure compressive strength of grout materials conforms to requirements.

9.4.2 Mixture of grout to be used for installation of packer plates shall be dry pack “non-shrink packer plates shall be dry pack “non shrink cementitious grout” in accordance with manufacturer’s recommendations.

9.4.3 Sampling, curing and testing grout specimen shall follow procedure as

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specified in method statements for Non-shrink Grout Installation.

- 9.4.4 Setting of packer plates or other adjusting devices shall be in a manner that will ensure structural members are located in correct positions and elevations.
- 9.4.5 Install packer plates in locations as applicable in between anchor bolts of concrete pedestal. Packer plates will be coated as per applicable coating system schedule. Grade of packer plate is shall be ASTM A36 as Client Specification.
- 9.4.6 Conduct inspection for elevation and location of installation packer plates.
- 9.4.7 Upon acceptance and curing of dry pack grout installation and packer plates setting, erection of column structure shall commence.

9.5 Non-shrink grout requirement

- 9.5.1 The grouting requirement and specification is SikaGrout-215 with compressive strength of approximately 65 MPa to 67 MPa (or N/mm²) at 28 days. And the thickness of grouting is 20-100 mm.
- 9.5.2 Surface preparation . : The most common cause of grout failure is improper surface preparation. The concrete substrate must be clean, sound, and rough (CSP 5-9) to ensure a mechanical bond. Crucially, the concrete must be brought to a Saturated Surface Dry (SSD) condition.
- 9.5.3 Formwork Construction: Forms must be watertight and rigid. Non-shrink grout, especially in fluid consistency, will leak through the smallest pinhole. Forms should be coated with a release agent (form oil) to prevent adhesion. Critical to success is the construction of a headbox on one side of the form. A headbox is a slanted hopper that allows the grout to be poured from a height, creating pressure (head) that helps flow the material under the plate. Vent holes should be drilled in the base plate or formwork on the opposite side to allow trapped air to escape.
- 9.5.4 Mixing and water control : Precision is non-negotiable. You must use potable water and adhere strictly to the manufacturer's specified water ratios. Adding too much water—even a pint—to make it “flow better” is a cardinal sin in grouting. Excess water causes segregation (sand settling to the bottom) and bleeding (water rising to the top), which destroys the non-shrink properties and strength. Mix for the recommended time (typically 3–5 minutes) using a mechanical mixer; hand mixing is rarely sufficient for achieving a uniform consistency.



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9.5.5 Placement and Curing : Pour the grout continuously from one side only to prevent trapping air pockets under the plate. If you pour from two sides, the flows will meet in the middle and trap a large air bubble, creating a void. Use a rod or strap to assist flow if necessary, but do not over-vibrate. Once placed, immediate curing is vital. For cementitious grouts, wet curing (covering with wet burlap) is standard practice for the first 48 hours to prevent the water from evaporating too quickly, which would cause shrinkage cracks.

9.5.6 Sampling Frequency ; Frequency per Volume: Collect one set of samples for every 5 to 10 m³ of grout placed, or for every 200 to 300 bags utilized on-site.

9.5.7 Acceptance Criteria : Compressive strength is the final metric for structural acceptance. The tested cubes must meet or exceed the performance thresholds published in the product's technical data sheet:

Compressive Strength (Example: SikaGrout-214 / 215 at +30°C):

- 1 Day: ≥ 20 to 25 N/mm^2 (MPa)
- 3 Days: $\geq 35 \text{ N/mm}^2$ (MPa)
- 7 Days: ≥ 40 to 45 N/mm^2 (MPa)
- 28 Days: $\geq 65 \text{ N/mm}^2$ (MPa) (*Final Structural Acceptance*)

9.6 Preassembly and Erection

9.6.1 All material shall be place on designated area near the location for assembly and erection.

9.6.2 Surface of steel structural member shall be clean by air blowing on ground prior for lifting work.

9.6.3 Provide dunnage under neath to a void materials on direct contact with soil and protect from dirt.

9.6.4 After pre-assembly check if bolt for main frame is already installed all part and fully tight conditions by using impact wrench or pas wrench. Marked the bolt as applicable.

9.6.5 Lifting of painted structural shall be done with non abrasive choker.

9.6.6 The crane responsible for loading or unloading structural members shall be assigned separately prior for erection works.



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9.6.7 Position the cranes on designated area. Crane #1 (1 SOT minimum) shall be responsible for the pre assembly of column and girder in ground level and assisting crane #2 for erecting frame assembly. Crane #2 (70T minimum) shall be responsible for the erection of frame assembly from ground level to its designated location and assisting erection of girder connecting frame. Crane #3 (60T minimum) shall be responsible for the erection of girders connection to erected frames, tie beam and bracings.

9.7 Pre-alignment of structure

9.7.1 After completion of steel erection, plumbness checking and alignment of erected structure shall commence from grid lines until the alignment and plumbness of the columns have been checked and corrected. QC Inspection shall follow to verify alignment and plumbness records as per ITP. Plumbness/alignment checking and correction works shall progress continuously after erection of structure until it reaches.

9.7.2 Alignment inspection for completed steel structure shall be done prior to welding and final bolting tightening shall be inspection using calibrated torque wrench ; steel structure shall be totally inspected for accuracy of construction and ensure that all dimensions are as specified.



9.7.3 Inspection records shall be prepared by contractor and shall be submitted to PT. CPM. For approval.

9.8 Bolt Tightening

9.8.1 After QC inspection and acceptance of pre-alignment records, bolt tightening shall done at all grid lines of Steel structure.

9.9 Platform and access ways assembly and installations

9.9.1 Platform and access ways on the Steel structure shall be installed after the structure is fully erected. Refer to drawing Erection of Platform and access way for more detail.

9.10 Detailed procedure on Bolt Tightening

9.10.1 Bolts Connections/General Requirements

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9.10.1.1 ASTM A325M bolt shall not be reused.

9.10.1.2 Where ASTM A307 bolt assemblies are used for connecting miscellaneous items (i.e., handrail assemblies, pipe supports, gates, etc.) to structural members, the bolts shall be tightened to snug tight condition.

9.10.1.3 Workers shall color code the ends of the tightened bolts by placing a yellow paint mark indicating that the bolt have been properly tensioned and are ready for inspection.

9.10.1.4 Workers shall initiate form report for indicate bolt tightening inspection and testing.

9.10.1.5 Enlargement of bolt holes for the correction of misalignment shall be by reaming or drilling only. Flame cutting , burning shall subject to PT. PCM approval.

9.10.1.6 The mill certificates for the faster materials shall meet ASTM Specification.

9.10.1.7 Prior to commence work, impact wrench shall be properly calibrated to desired tension using bolt tension calibrator. Calibration of bolt tension calibrator shall be in every six (6) months.

9.10.2 Bolt Tightening Condition

Tightening condition shall be in accordance with the standards drawings. Bolt applicable for bolt tightening procedure shall be ASTM A325M for M20, M24, and M30.

9.10.2.1 This tightening method should be applicable for the various types of structure connection detail as specified in the drawings. And various structure IFC drawings and various structure IFC Drawing as indicated as the following abbreviation.

9.10.2.2 Table Specification Requirements Bolts/Stud Torque/Tension for Steel Structure connection as below :

Table-1 : Tightening for Bolting Specification.

- ASTM A193-B7/A194-2H HDG

Bolt Dia. (mm)	Tension (lbs)	Tightening Torque (ft-lbs)	Part/Section	Remarks
26 x 110 L	47.738	398	Steel Structure	
26 x 110 L	47.738	398	Steel Structure	
16 x 70 L	17.813	93	Steel Structure	
$\frac{3}{4}$ " UNC x 150L	26.288	164	Steel Structure	

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- ASTM SA193 B7/SA194-2H

Bolt Dia. (in)	Tension (lbs)	Tightening Torque (ft-lbs)	Part/Section	Remarks
18 x 85 L	26.288	164	Steel Structure	

- ASTM A325

Bolt Dia. (in)	Tension (lbs)	Tightening Torque (ft-lbs)	Part/Section	Remarks
22 x 60 L	39.000-47.000	569-685	Steel Structure	

- ASTM A307-A

Bolt Dia. (mm)	Tension (lbs)	Tightening Torque (ft-lbs)	Part/Section	Remarks
16 x 40 L	12.400	73	Platform	
12 x 45 L	7.800	61	Platform	

9.11 Final Alignment

9.11.1 Prior for final grouting, final alignment inspection shall commence to ensure structure plumbness following the tolerance specified in table -2 Erection Tolerances on specs, unless otherwise specified on design drawing and/or erection plans.

9.11.2 Conduct final alignment inspection using ITP.

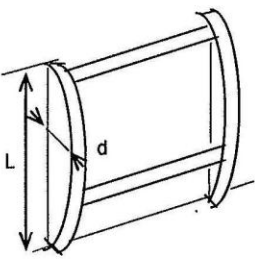
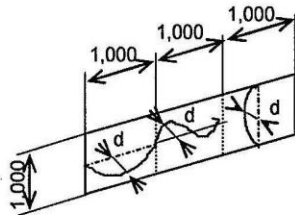
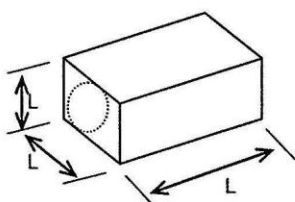
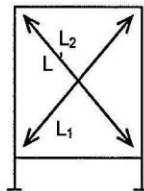
Table - 2 : Erection Tolerances

No	ITEM	TOLERANCE
01	Misalignment between column section central line to foundation central line	± 3 mm
02	Deviation between column section actual elevation and design elevation	± 5 mm
03	Elevation deviation of adjacent column	3 mm
05	Verticality column	and ≤ 15 mm
07	Horizontal section elevation	± 5 mm
08	Horizontal base plate levelness	5 mm

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Table – 3 Erection Tolerances

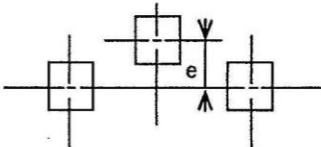
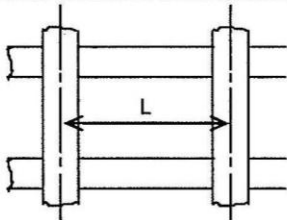
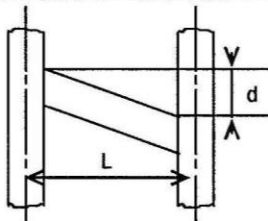
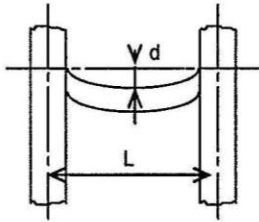
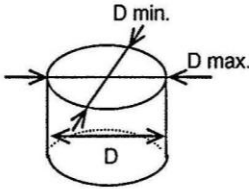
Table-3 : Erection Tolerance Page : 1/2

Item	Figure	Tolerance	
Distortion of Assembled Panel (Column) (d/L)		1/500 and $d \leq 15 \text{ mm}$	
Local warp of panel (d in 1000 mm)		$d \leq 15 \text{ mm}$	
Length after assembly for heater, duct and stack (L)		Heater $L \leq 2\text{m}$ $\pm 2 \text{ mm}$ $L > 2\text{m}$ 1/500 Max. 15mm	Duct/Stack $\pm 3 \text{ mm}$ 1/300 Max. 20mm
Diagonal lengths of panel and duct ($L_1 - L_2$) and $(L_1 - L_2) / L$		Heater $L \leq 2\text{m}$ 2 mm $L > 2\text{m}$ 1/500 Max. 15mm	Duct 4 mm 1/300 Max. 20mm

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Table-4 Erection Tolerances

Erection Tolerance Table-4 Page : 2/2

Item	Figure	Tolerance
Eccentricity of column (e)		$\pm 5 \text{ mm}$
Span of column (L)		$\pm 10 \text{ mm}$
Level of beam (d/L)		$1/500$ and $d < 10\text{mm}$
Sweep of beam and girder (d/L)		$1/500$
Deviation of inside dia. of cylindrical chamber (Dmax.-Dmin.)/D		Heater 1/100 Duct & Stack 1/50

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9.10. Final Grouting

9.10.1 Subsequently the erection and final erection alignment of structure is done, final grouting of packer plates shall commence to complete the erection works.

9.11 Welding Works

9.11.1 Whenever that field welding is required, the welding for main steel members and important joint of steel structures shall be performed in accordance AWS D1.1.

9.11.2 Welder shall be qualifications

9.11.3 Welding equipment machine to be use properly.

9.11.4 Welding equipment shall always be electrically grounded when in use.

9.12 Touch-up Application

9.12.1 As mentioned in specs., when damage painting or galvanized surface on surface on steel structure is observed, and the unpainted area by masking at connection is exposed, surface shall be touch-up.

9.12.2 All repaired, reworked, damage galvanized steel supports and gratings will be coated as per applicable coating system schedule.

10.0 Quality Control

10.1 QC Inspector will be assigned to attend to the quality control and assurance of this work.

10.2 QC Inspector shall be responsible to conduct all required inspection to ensure that all applicable requirements, codes and standards are complied with.

10.3 QC Inspector will be produce all the documents attesting to the acceptability of the works and submits to PT. CPM.

10.4 QC Inspector has to utilize the applicable ITP for every activity.