P We) TORISHIMA												
	INSPECTION AND TEST PLAN							D: LNH3-HEI-ITP-QC-001						
					Rev. No. ()		Page 1 of 7						
		OWNER PROJECT TITLE PO NO VENDOR LOCATION	: TORISHIMA : LNH3 TEST : 3100099788 : PT. HANAZ : TORISHIMA	ING FAC & 31000 ONO ENG A PUMP N	ILITY 99789 GINEER IFG. CC	Approve Approve Commen Not appr ate : by :	JAPAN PROV	YAL tes						
			BRid	April		$\lambda \mathbb{A}$	miX							
0	February 08, 2024	For Approval	BENRIDHO	RUSN	ANDI	MURA	ASATO	CLIENT						
REV	DATE ISSUED	ISSUE PURPOSE	PREPARED	CHEC	KED	APPR	OVED	AUTHOLIZED						
	(R	PT. HANAZON	O ENGINE	ERING	INDO	ONES	A							



LNH3 TESTING FACILITY



INSPECTION AND TEST PLAN

Vendor Doc. No. : LNH3-HEI-ITP-QC-001
Rev. No. 0 Page 2 of 7

Revision History

Revision No.	Date	Description of Revision
0	February 08, 2024	For Approval



	PT. HANAZONO Engineering Indonesia We are always partner with you	PT. HANAZONO Engineering Indonesia Inspection and Test Plan We are always partner with you Inspection and Test Plan								TORISHIMA								
		: LNH3 TESTING FACILITY : 3100099788 & 3100099789 : AMMONIA TEST PLANT (STORAGE TANK, : TORISHIMA PUMP MFG. CO., LTD.	TEST TANK, SCRUBBER)	Inspection Item ITP No. Revision No. Vendor Name	L : AMMONIA TEST PLANT FACILITY (STORAGE TANK, TEST TANK, SCRUBE : LNH3-HEI-ITP-QC-001 : 0 : PT. HANAZONO ENGINEERING INDONESIA													
Step	Inspection Activitry	Reference Procedure	Acceptance Criteria				Involve	ed Party										
No. (1)	(2)	(3) (4) Verification Document (5)	PT HEI	Sign	CLIENT	Sign	THIRD PARTY	Sign	Rem	ark								
Α	Kick of Meeting	KOM Agenda	Purchase order	KOM/MOM	Н		Н		Н									
1.	Project Specification																	
	a. Purchase Order with Material Requesition	Client Specification																
	b. Engineering Drawing and Data Sheet	ASME Standard																
	c. Specification	JIS Standard																
	d Application Code and Standart	ASME Sec. VIII. Div. 1																
2.	Vendor Documents and Approval Procedure																	
	a. Assembly and Detail Drawing	PO Spec. Code and Standards																
	b. Fabrication Sequence Diagram	Approval Shop Drawing																
	c. Faabrication and Inspection Procedure	Client Specification																
	d. WPS/PQR, Welder and Welding Operator Qualification	ASME Sec. IX																
	e. Inspection Records	JIS Standard																
3.	After PO Requirements																	
	a. Expediting Inspection																	
	b. Monthly Progress Report																	
	c. Shipping and Packing List																	
В	Pre-Inspection Meeting		Purchase order	KOM/MOM	Н		Н		Н									
1.	Preparation installation Drawing/Procedure for assmbly/Inspection Test and NDE Test	PO Spec. Code and Standards																
	Notification for Inspection																	
2.	a. Ensure that Vendor is aware of all Inspection requirements and agree the notification Process	PO Spec. Code and Standards																
	Schedule																	
3.	a. As certain Material Procurement Ststus and assembky Program																	
	Design Freeze	Approval Status of Vendor				1		İ										
4.	a. As certain Documents Approval Status Including Shop Drawing	Drawing/Documents																
	Witness Point	Approval ITP				1		1										
5.	a. Establish the Required Inspection Point	ASME Sec. VIII. Div. 1					1		1									
	Job Specific Requirements	Related Job Specification					1		1									
6.	a. Highlight Job Specific Requirements	PO Spec. Code and Standards					1	1	1									

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Project P.O. No. Order Item Name Client Name	: LNH3 TESTING FACILITY : 3100099788 & 3100099789 : AMMONIA TEST PLANT (STORAGE TANK, : TORISHIMA PUMP MFG. CO., LTD.	TEST TANK, SCRUBBER)	TTP No. : LNH3-F Revision No. : 0			L DNIA TEST PLANT FACILITY (STORAGE TANK, TEST HEI-ITP-QC-001 .NAZONO ENGINEERING INDONESIA							
Step Inspection Activitry	Reference Procedure	Acceptance Criteria				Involve	ed Party			D			
No. (1)	(3)	(4)	Verification Document (5)	PT HEI	Sign	CLIENT		THIRD PARTY	Sign	Remark			
C DOCUMENT													
1. Approval of Drawing & Strength calculation	Drawing	Design Data	Drawing	Р		R		R					
2. Inspection Test Plan (ITP)	PO and Specification	Project Specification	Procedure	Р		R		R					
3. Approval / WPS & PQR	WPS & PQR Approval	ASME Section IX	Procedure	Р		R		R					
4. Welding & NDE Map	Drawing Approval and Welding Map	ASME Section VIII Div. 1	Procedure	Р		R		R					
5. Welder List & Certifcate	Welder List Approval	ASME Section IX	Procedure	Р		R		R					
6. NDE Procedure & Personnel Certificates	Procedure	ASME Section V (ASNT-TC 1A)	Procedure	Р		R		R					
7. Surface Preparation & Painting Procedure	Procedure	Specification Protective Coating	Procedure	Р		R		R					
8. Hydrotest Procedure	Procedure	Specification General Equipment Requirements	Procedure	Р		R		R					
9. Others Are As Per Doc, List	-		-	Р		R		R					
D MATERIALS													
1. Receiving Material Inspection Report			Mill Test Certificate (MTC)	р		R							
2. Review of Mill Certificate and Conformance to Code	 Drawing Approval /Documents Receiving Report 	ASME Section II Part A, JIS Standard	Receiving Report	— Р		K		R					
E WELDING CONSUMABLE													
1. Electrode Storage and Drying	Manufacturer Standard	Specification Equipment Welding Carbon Steel	Certificate	Р		R		R					
F FABRICATION													
F-1 Marking and Cutting													
1. Check Marking and Cutting ,Shell , Head, Pipe	Drawing Approval	Instantian Desire dura	Material Traceability Report	р		R		R					
2. Check Transfer Heat Number etc.	Drawing Approva	Inspection Procedure	Material Traceability Report	P		к		ĸ					
F.2 Rolling Shell and Spinning Ellipsiodal Head 2:1													
1. Visual and Dimensional	Drawing Approval	Inspection Procedure	Dimensional Check Report	р		w		R					
2. Check of Wall Thickness Shell and Ellipsiodal Head 2:1	Diawing Approva	Inspection Procedure	Dimensional Check Report	г		vv		ĸ					
F.3 Fit-up Inspection													
F3-1 STORAGE TANK													
1. Check Nozzle orientation and Hole opening													
2. Fit-up Nozzle	Derwing Americal	In an estima Desce dura	Dimensional Check Dana	р		R		р					
3. Fit-up Shell to Head,	Drawing Approval	Inspection Procedure	Dimensional Check Report	Р		ĸ		R					
4. Other accessories													

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Project P.O. No. Order Item Name Client Name		E LNH3 TESTING FACILITY : 100099788 & 3100099789 : AMMONIA TEST PLANT (STORAGE TANK, TE : TORISHIMA PUMP MFG. CO., LTD.		Inspection Item ITP No. Revision No. Vendor Name	: LNH3-H : 0	EI-ITP-QC	EST PLANT FACILITY (STORAGE TANK, TEST TANI P-QC-001 NO ENGINEERING INDONESIA					
Step	Inspection Activitry	Reference Procedure	Acceptance Criteria				Involve	d Party			D I	
No. (1)	(2)	(3)	(4)	Verification Document (5)	PT HEI	Sign	CLIENT	Sign	THIRD PARTY	Sign	Remark	
F3-2	TEST TANK											
1.	Check Nozzle orientation and Hole opening											
2.	Fit-up Nozzle, Pipe Colomn, Pipe Coil	Drawing Approval	Inspection Procedure	Dimensional Check Report	р		R		R			
3.	Fit-up Shell to Head,		inspection Procedure	Dimensional Check Report	r		ĸ		K			
4.	Other accessories											
F3-3	SCRUBBER TANK											
1.	Check Nozzle orientation and Hole opening											
2.	Fit-up Nozzle	Drawing Approval	Inspection Procedure	Dimensional Check Report	р		R		R			
3.	Fit-up Shell to Cover		Impection Procedure	Differsional Circle Report	1							
4.	Other accessories											
G	WELDING INSPECTION											
G-1	STORAGE TANK											
1.	Welder Performance Qualification Test	ASME Sect. IX Part C	Specification Equipment Welding Austenitic Stainless Steel	Welder List & Certificate	Р		R		R			
2.	Check Weld. Consumables being used for each process of welding	JIS Standard	Welding Procedure/ITP	Mill Test Certificate (MTC)	Р		R		R			
3.	Welding Inpection and Visual	Procedure	NDE Map	Welding Record	Р		w		R			
G-2	TEST TANK											
1.	Welder Performance Qualification Test	ASME Sect. IX Part C	Specification Equipment Welding Austenitic Stainless Steel	Welder List & Certificate	Р		R		R			
2.	Check Weld. Consumables being used for each process of welding	JIS Standard	Welding Procedure/ITP	Mill Test Certificate (MTC)	Р		R		R			
3.	Welding Inpection and Visual	Procedure	NDE Map	Welding Record	Р		W		R			
G-3	SCRUBBER TANK											
1.	Welder Performance Qualification Test	ASME Sect. IX Part C	Specification Equipment Welding Austenitic Stainless Steel	Welder List & Certificate	Р		R		R			
2.	Check Weld. Consumables being used for each process of welding	JIS Standard	Welding Procedure/ITP	Mill Test Certificate (MTC)	Р		R		R			
3.	Welding Inpection and Visual	Procedure	NDE Map	Welding Record	Р		w		R			

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		: LNH3 TESTING FACILITY : 3100099788 & 3100099789 : AMMONIA TEST PLANT (STORAGE TANK, : TORISHIMA PUMP MFG. CO., LTD.	TEST TANK, SCRUBBER)	Inspection Item ITP No. Revision No. Vendor Name	: AMMON : LNH3-H : 0 : PT. HAN	Γ TANK, SCRUBBEF					
Step No.	Inspection Activitry	Reference Procedure	Acceptance Criteria	Verification Document (5)			Involve	ed Party			Remark
(1)	(2)	(3)	(4)	Vernication Document (5)	PT HEI	Sign	CLIENT	Sign	THIRD PARTY	Sign	кетагк
н	NDT										
H-1 \$	STORAGE TANK										
1.	Radiographic Test (RT) 100%) for Butt Joint	ASME V, ASME VIII Div. 1									
	Dye Penetrant Test/Magnectic Particle Test: 100% (Weld Seam)	NDE Procedure	NDE Map	NDE Inspection Report	р		R		R		
3. 1	Lifting Lug	ITP		NDE inspection Report	r		K		K		
4. 7	Temaporary Tack weld	Procedure									
п-2	TEST TANK										
1.	Radiographic Test (RT) 100%) for Butt Joint	ASME V, ASME VIII Div. 1		NDE Inspection Report							
	Dye Penetrant Test/Magnectic Particle Test: 100% (Weld Seam)	NDE Procedure	-				R				
3. 1	Lifting Lug	ITP	NDE Map		Р		K		R		
4. 7	Femaporary Tack weld	Procedure									
н-з	SCRUBBER TANK										
1.	Radiographic Test (RT) 10% : for Butt Joint	ASME V, ASME VIII Div. 1									
2.	Dye Penetrant Test/Magnectic Particle Test: 100% (Weld Seam)	NDE Procedure	NDE Map	NDE Inspection Report	Р		R		R		
3. 1	Lifting Lug , Lifting Trunnion	ITP	, i	· · ·							
4.	Femaporary Tack weld	Procedure									
Ι	FINAL INSPECTION										
I-1 8	STORAGE TANK										
1. 1	Final Dimensional assembly Check	Drawing Approval	Vendor Name Vendor Name Acceptance Criteria (4) Veri (1) Image: Image	Dimensional and Visual welding Report	р		w		w		
2.	Visual Welding Check	Welding Procedure	inspection riocedure	2 inclusional and visual working Report							
3.	Hydrotest	ПТР	Hydrostaic Test Procedure	Hydrotest and Leaked Test Report	Р		W		w		
I-2	TEST TANK										
1.	Final Dimensional assembly Check	Drawing Approval	Inspection December	Dimensional and Visual and Jim Day	р	İ	w		w		
2.	Visual Welding Check	Welding Procedure	Inspection Procedure	Dimensional and Visual welding Report	r		w				
3.	Hydrotest	ITP	Hydrostaic Test Procedure	Hydrotest and Leaked Test Report	Р		w		w		

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Project P.O. No. Order Item Name Client Name		: LNH3 TESTING FACILITY : 3100099788 & 3100099789 : AMMONIA TEST PLANT (STORAGE TANK, ' : TORISHIMA PUMP MFG. CO., LTD.	: 3100099788 & 3100099789 : AMMONIA TEST PLANT (STORAGE TANK, TEST TANK, SCRUBBER)			ITP No. :LNH3-HEI-ITP-QC- Revision No. :0			TEST PLANT FACILITY (STORAGE TANK, T IP-QC-001 DNO ENGINEERING INDONESIA							
Step Inspection Activitry No. (2)		Reference Procedure (3)	Acceptance Criteria (4)	Verification Document (5)	PT HEI	Sign	Involve CLIENT	d Party Sign	THIRD PARTY	Sign	Remark					
I-3	SCRUBBER TANK															
1.	Dimensional assembly Check	Drawing Approval	Inspection Procedure	Dimensional and Visual welding Report	Р		w		w							
2.	Visual Welding Check	Welding Procedure	F													
3.	Hydrotest	ITP	Hydrostaic Test Procedure	Hydrotest and Leaked Test Report	Р		W		W							
J	PAINTING															
J-1	STORAGE TANK, TEST TANK, SCRUBBER TANK			Painting Inspection Report (PIR)												
1.	Check Surface Preparation	Panting Procedure	Panting Procedure		Р		w		R							
2.	Visual Inspection (RAL colour) / D.F.T Check															
к	COMISIONING AND TESTING															
1.	ITP															
2.	Mechanical Completion Checklist	Procedure Pre-Comisioning	Procedure Pre-Comisioning	Comisioning Report	Р		w		W							
3.	Pre-Comisioning Testing															
L	DOCUMENTATION MDR															
1.	Manufacturers Data Index Manufacturers Data Report (MDR)	ITP Procedure		MDR Pakage	Р		R		R							

PREPARED BY PT.HANAZONO (HEI)

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Legend H : Hold P : Perform

W : Witness

R : Review

S : Surveillance