



# FABRICATION QUALITY CONTROL PLAN

QCP Number: <b>13587</b>	Date Created: <b>27 OCT 10</b>	Originator: <b>KRR</b>
MOC Number:	Priority *: <b>2</b>	Plant: <b>67</b>
Equipment Tag: <b>67 LINES</b>	Equip. Name: <b>PLANT 67 LINES &amp; FITTINGS GENERAL</b>	
Additional Tag ID: <b>FLANGED SPOOL</b>	Additional Info <b>PYPLOK TRIAL SPOOL</b>	
QCP Title: <b>INSTAL PYPLOK TRIAL SPOOL ON 50# STEAM LINE.</b>		

\* Priority 1 = immediate; Priority 2 = within 3 months; Priority 3 = within 12 months; Priority 4 = at plant T&I

**BACKGROUND:** ON-STREAM LEAK

THIS REPAIR PROCEDURE IS AUDITABLE PER THE REQUIREMENTS OF **SABS 0227: 2000** (ANNEXURE C). PLEASE ENSURE THAT ALL THE RELEVANT QUALITY CRITERIA ARE ADHERED TO.

QCP Item No	DESCRIPTION OF ACTIVITIES*	Verified by Fabricator/ Contractor	Hold, Monitor, Review **
1.	<b>FABRICATION: (SITE MEASUREMENTS TO BE TAKEN)</b> ASTM A106 1/2" PIPE AND ASTM A 105N 1/2" SOCKET FALNGES STAINLESS STEEL UNIVERSAL CONNECTOR STEAM TRAP INSPECTION TO <b>IDENTIFY</b> MATERIAL PRIOR TO WELDING.	H 28/10/10 	R 28.10.10 58
2.	<b>WELDING: SEAL/SOCKET/FILLET-WELD</b> SOCKET WELDS PER CHEVRON WELD PROCEDURE: # 1-1/T/F/16 (GTAW ER70S-6) # 1-8/M/F/24 (USING ER 309L WIRE) NB: INSPECTION TO <b>REVIEW CONSUMABLE CERTIFICATES</b> PRIOR TO COMMENCING WITH WELDING.	28/10/10  H	R 28.10.10
3.	<b>PYPLOK CRIMPING:</b> FOLLOW PYPLOK CRIMPING PROCEDURE: # <b>SOP604-007</b>	H 28/10/10 	H 28.10.10 58
4.	<b>INSPECTION: CONDUCT 100% VISUAL &amp; 100% DYE PEN EXAMINATION</b> ON COMPLETED WELD SEAMS. ACCEPTANCE CRITERIA PER ANSI B31.3;	H N/A	H 01.11.10
<p>100% VISUAL  ..... 100% PT  ..... 01/11/10</p>			

Issued for  
**CONSTRUCTION**  
 For specific Fixed-Equipment Reliability  
 Inspection Group Repair Instructions Only!  
**ACCREDITED**  
 Inspection Body

APPROVED BY: **K.R. Rooknathan**






RECEIVED BY: **SJS POTKUS**

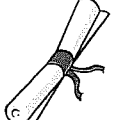

27/10/10  
 Print Name, Sign & Date

\*\* **Hold point:** A hold shall be applied to the production process and the inspection or test shall be conducted with the Inspector in attendance. Work may not proceed until the hold point has been signed off.

**Monitor point:** It is not a requirement that the Inspector monitors each and every one of these activities. The Inspector shall monitor these activities on an ongoing basis and shall only sign the quality control plan for those activities that he/she witnessed.

**Review point:** The Inspector shall review a test report, material certificate etc. to confirm that the detailed inspection requirements are satisfied. Work may proceed pending the Inspector's review.

5.	<b>WELDER CONTROL:</b> WELDING SUPERVISOR TO FURNISH <b>WELDER NAME &amp; STAMP NUMBER</b> IN THE SPACE PROVIDED WELDER NAME: <i>F. SACH</i> STAMP NUMBER: <i>ALM 049</i> NB: INSPECTION TO <b>REVIEW WELDER CERTIFICATES</b> PRIOR TO COMMENCING WITH WELDING.	H <i>28/10/10</i> <i>[Signature]</i>	R  <i>28.10.10</i>
6.	<b>SERVICE TEST:</b> MONITOR PYPLOK CONNECTION EVERY 2 <sup>ND</sup> DAY FOR 1 WEEK.	H <i>26/10/11</i> <i>[Signature]</i>	H  <i>26.10.11</i>
7.	MAINTENANCE SERVICES CO-ORDINATOR TO <b>VERIFY ALL                  WORK COMPLETE, AND RETURN COMPLETED QCP TO                  INSPECTION DEPARTMENT</b> FOR FILING.	H <i>26/10/11</i> <i>[Signature]</i>	R  <i>26 Oct. 11</i>

	<b>CERTIFICATE OF CONTINUANCE:</b> I HEREBY CERTIFY THAT THE ABOVE EQUIPMENT HAS BEEN INSPECTED AND/OR TESTED IN ACCORDANCE WITH THE LEGAL REQUIREMENTS, AND HAS BEEN FOUND FIT FOR CONTINUED SERVICE.	H  59 <i>26. Oct. 11</i>
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**DESCRIPTION OF DEFECT REPORTS & DISPOSITIONS (IF ANY):**



S A N A S



ACCREDITED  
Inspection Body

APPROVED BY: **K.R. Rooknathan**



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RECEIVED BY: *SB POTGIETON*

*27/10/10*  
Print Name, Sign & Date *[Signature]*

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