

Supplier Name Inspection & Test Plan (ITP)		
Customer Name:		Document #:
Customer PO #:		Issue Date:
Part/Drawing #:		Issued By:
MLI #:		Approved By (GE):
Description:		Rev #:
Project Name:		Rev Date:

D=Document Review, M=Monitor, W=Witness, H=Hold Point

Inspection Level - Customer Representative

Inspection Level - GE Representative

Inspection Level - Supplier Representative

Step #	Process/ Operation Description	Characteristic	Applicable Procedure	Acceptance Criteria	Verifying Documents/ Reference	Freq	Notes	Inspection Performed By:	Inspection Signoff	Comments	Supplier Name		Customer Name	
											D	GE		
1	Fabricate Skid Base	General Fabrication/ Design	Supplier Procedure	AWS D1.1 GE specs	Drawings			QA Inspector				D	D	D
		Material Traceability	Supplier Procedure	AWS D1.1 GE Specs	BOM/ Material Certs	100%	Verify material complies to PO/BOM upon receipt	Project Manager				D	D	D
		Fit up & Alignment	Supplier Procedure	AWS D1.1 GE Specs	Drawings	100%		Operator				D	M	
		Dimensional Checks	Supplier Procedure	AWS D1.1 GE Specs	Drawings	100%		Operator				W	M	
		Welding Materials Inspection	Supplier Procedure	AWS D1.1 ASME Sec II	Drawings/W PS	100%	Verify markings or certificates	Operator				W		
		Welding Inspection	WPS/ Supplier Procedure	AWS D1.1 GE Specs	Drawings/W PS	100%	All Welds per AWS D1.1	QA Inspector				W	M	M
		Magnetic Particle Testing	NDE-5.3	AWS D1.1 ASTM E-709	Inspection Reports	100%	All Lifting Lugs	QA Inspector				D	D	D
		Skid Base Blasting	Supplier Procedure	Supplier Procedure/ GE Specs	Inspection Reports	100%		QA Inspector				W	D	
		Paint/ Preservation	Supplier Procedure	GE Spec	Inspection Reports	100%	Total DFT 7.0-9.0 mils	QA Inspector				W	D	

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2	Fabricate Piping	General Fabrication & Design	Supplier Procedure	ASME B31.3/ GE Specs	Pipe Spool Drawings									
		Material Traceability	Supplier Procedure	ASME B31.3/ GE Specs	BOM/ Weld Maps	100%	Verify material complies to PO/BOM upon receipt	Project Manager				D	D	D
		Fit Up/ Alignment	Supplier Procedure	ASME B31.3/ GE Specs	Spool Darwings/ Weld Maps	100%		Operator				W	M	M
		Dimensional Checks	Supplier Procedure	ASME B31.3/ GE Specs	Spool Darwings/ Weld Maps	100%		Operator				W	D	D
		Weld Inspection	Supplier Procedure	ASME B31.3/ GE Specs	WPS/Weld Maps/Spool Drawings	100%	All butt welds must have GTAW roots/100% visual	Operator				W	D	D
		Radiographic Testing	NDE-3.5	ASME B31.3/ GE Specs	Test Reports	5%	Must include all welders, weld type, & size	QA Inspector				W	D	D
		Hydrostatic Testing	Supplier Procedure	ASME B31.3/ GE Specs	ANSI B16.5/ Drawings	100%	1 Hr test with chart/ test water includes rust inhibitor VCI-377	QA Inspector				W	D	D
		Blasting	Supplier Procedure	Supplier Procedure/GE Spec	Inspection Reports	100%		QA Inspector				W	D	D
		Paint/ Preservation	Supplier Procedure	GE Spec	Inspection Reports	100%	Total DFT 7.0-9.0 mils	QA Inspector				D	D	D
3	Skid Assembly-Mechanical	P&ID Compliance	Supplier Procedure	GE P&ID	Inspection Reports	100%	Verify components tagged per GE P&ID/BOM	QA Inspector			W	W	W	

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		Flange Connections	Supplier Procedure	B31.3/ GE Specs	Drawings	100%	Flange alignment shall be within 1/16" per foot	QA Inspector				W	M	
		Dimensional	Supplier Procedure	ASME B31.3/ GE Specs	Drawings	100%		QA Inspector				W	W	W
4	Skid Assembly- Instrument & Electrical	Junction Boxes	Supplier Procedure/ GE Spec	NFPA 70 (NEC)/ GE Spec	Drawings/ BOM	100%	Veify Type NEMA 4 or 4X	QA Inspector				W	M	
		Components	Supplier Procedure/ GE Spec	NFPA 70 (NEC)/ GE Spec	Drawings/ BOM	100%	All components per GE BOM & Drawings, including gauge scales	QA Inspector				W	M	
		Wire	Supplier Procedure/ GE Spec	NFPA 70 (NEC)/ GE Spec	Drawings/ BOM	100%	Verify proper wire labels and confirm no splices	QA Inspector				W	w	w
5	Functional Testing	Component Testing	Supplier Procedure/ GE Spec	GE Spec	Inspection Reports	100%	Test all instruments for continuity, short circuit, and "Megger"	QA Inspector				H	W	W
		System Leak Test	ASME VIII/ GE Specs	ASME VIII/ GE Specs/ ASME B31.3	Inspection Reports	100%	25 psi sensitive leak/soap bubble test for 15 min	QA Inspector				H	W	W
6	Final Inspection	System Cleanliness	GE Spec	GE Spec	Witness	100%		QA Inspector				H	W	W
		Nameplate	ASME VIII	GE Spec	Drawings	100%		QA Inspector				W	W	W
		Visual Inspection of Paint	Supplier Procedure	GE Spec	Inspection Reports	100%		QA Inspector				H	W	D

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		Visual Inspection of Preservation & Prep for shipment	Supplier Procedure GE Spec	GE Spec	Witness	100%		QA Inspector	Application of rust inhibitor with shipping covers and gaskets installed		W	D	D