



INSPECTION AND TEST PLAN

Client Doc No: PO 5203254350

PROJECT:Crane access platform **CLIENT:**BHP B-Nickle West KNSC Kalgoorlie **DOC No:** **Revision: 0**

Job No: 12004899 **Prepared By:** Mick Wells **Approved:** Roy Mc Kernan

SCOPE: Supply and Fabrication of Structural Steel

CONTROL CATEGORIES: **H** = Inspection Hold Point (Work must not proceed to the next step until this activity is completed **and a signature obtained** from the column placing the HOLD; i.e.. QA or Client);

W=Witness Point (Notify to permit witness, work can proceed if witness does not attend at agreed time);**S**= urveillance Point (Monitor operations);**R**=Review Documentation (Sign or Stamp to record review).

ACT No.	ACTIVITY	PROCEDURE or SPECIFICATION REFERENCE	ACCEPTANCE CRITERIA	VERIFYING DOCUMENTATION	CONTROL POINT			REMARKS
					T/S	BHP B		
1.1	Submission/Approval of Documentation	SES 105 5.2, 5.4, 5.6 SES 286 -3, 3.1		ITP	H	H		
1.2	Weld Procedure Specifications (WPS) and & Weld Procedure Qualification Records (WPQR)	SES 105- 5.1 SES 286- 4.62	AS1554.1.SP	WPS & WPQR	H	H		
1.3	Welder Qualifications - Original test records available for review @ Kalgoorlie Office. Qualify unqualified welders in accordance with WPS (STOS discretion to witness)	SES 105-4.1-6, 4.2-12 SES 2864.6.2	AS1554.1.SP	WQR	H	H		
2	Materials							
2.1	Inspect materials including welding consumables for damage or contamination and verify are correct in accordance with Purchase Order, Delivery Docket and Material Certificates.	SES 105- 3.1, 3.2, 3.3, 3.4,3.5. SES 286 - 4.6.1, 4..6.2	AS4100	Material Certificates & Consumable Batch Certificates	R	R		In MDR and forward to KNSC
2.3	Store material and welding consumables to eliminate damage and contamination.	SES 105 - 3,6			S	S		
3	Pre Processing & Assembly							
3.1	Material allocation, preparation, cutting, drilling.	SES 105-4		Cutting List	R			
3.2	Assembly of components prior to welding. Fit-up & alignment Root Gap & Landing Dimensions	SES 105 4 5.2	AS4100 Clause 14.4	Drwings	H	R		Yellow ribbon - ready for Dimensional Check
3.3	Dimensional check prior to welding.	SES 105 - 4, 5.2	AS4100 Clause 14.4	Drawing	H	R		Blue ribbon - Dimensionally checked ready to weld.



INSPECTION AND TEST PLAN

Client Doc No: PO 5203254350

PROJECT:Crane access platform **CLIENT:**BHP B-Nickle West KNSC Kalgoorlie **DOC No:** **Revision: 0**

Job No: 12004899 **Prepared By:** Mick Wells **Approved:** Roy Mc Kernan

SCOPE: Supply and Fabrication of Structural Steel

CONTROL CATEGORIES: **H** = Inspection Hold Point (Work must not proceed to the next step until this activity is completed **and a signature obtained** from the column placing the HOLD; i.e.. QA or Client);

W=Witness Point (Notify to permit witness, work can proceed if witness does not attend at agreed time);**S**= urveillance Point (Monitor operations);**R**=Review Documentation (Sign or Stamp to record review).

ACT No.	ACTIVITY	PROCEDURE or SPECIFICATION REFERENCE	ACCEPTANCE CRITERIA	VERIFYING DOCUMENTATION	CONTROL POINT			REMARKS
					T/S	BHP B		
4	Welding							
4.1	Welding to be performed by qualified welder in accordance with approved Welding Procedure Specification.	SES 105 - 4.1. 6, 5.1	AS1554.1.SP	Welding Verification Sheet, WPS	S	S		
4.2	Welding visual Inspection, Check: Root pass/weld size/profile & finish Closing weld size/profile & finish	SES 105 - 4.1.6, 5.2, 5.6	AS1554.1.SP	Sign Drawing	S	S		
4.4	Weld repairs (if any) remove defect in accordance with repair procedure.	SES 105 - 5.6, SES 286-4.5	AS1554.1.SP		H	H		
5	Inspection & Testing							
5.1	Final visual inspection of all welds.	SES 105 - 5.6	AS1554.1.SP	Inspection Release	H	S		
5.2	Non Destructive Examination	SES 105 - 5.6	AS1554.1.SP	Weld Traceability Sheet (NDT only), Weld maps and NATA endorsed Non Destructive	W/R	S		White ribbon - identifies welds requiring NDE. Butt weld root run to be dye Checked & photographed
5.2.1	100% Visual Examination of all welds.				H			
5.2.2	10% MT of all Welds				H			
6	Surface Treatment							
6.1	Protective Coatings BHPB Spec	SES 106 - PCS06 grey for structural steel 7.4 SES 106-5.9	Coating Contractor to supply : Coating procedure and final Paint report		S	R		Check abrasive blast cleaning,Review and file paint procedure and final report . Coating
6.3	Final Inspection of Surface Treatment			H	H			



INSPECTION AND TEST PLAN

Client Doc No: PO 5203254350

PROJECT:Crane access platform **CLIENT:**BHP B-Nickle West KNSC Kalgoorlie **DOC No:** **Revision: 0**

Job No: 12004899 **Prepared By:** Mick Wells **Approved:** Roy Mc Kernan

SCOPE: Supply and Fabrication of Structural Steel

CONTROL CATEGORIES: **H** = Inspection Hold Point (Work must not proceed to the next step until this activity is completed **and a signature obtained** from the column placing the HOLD; i.e.. QA or Client);

W=Witness Point (Notify to permit witness, work can proceed if witness does not attend at agreed time);**S**= urveillance Point (Monitor operations);**R**=Review Documentation (Sign or Stamp to record review).

ACT No.	ACTIVITY	PROCEDURE or SPECIFICATION REFERENCE	ACCEPTANCE CRITERIA	VERIFYING DOCUMENTATION	CONTROL POINT			REMARKS
					T/S	BHP B		
8	Final Inspection & Dispatch							
8.1	Final inspection to also ensure: all necessary inspection & testing has been conducted with all necessary contract requirements completed.	SES 286 4.6.3 4.8.1 4.8.2		Inspection Release certificate, Delivery Docket	H	H		Notify client well in advance to conduct final inspection & issue release to site.
8.2	Protect and secure components for transport	SES 207 - 4.1		Delivery Docket	H	S		
9	Finalise Documentation							
9.1	Sign off Inspection & Test Plan	SES 286 - 4.2.3.4.4.1		ITP	S	S		
9.2	Progressively check all test reports are correct	SES 286 - 4.2.3 4.4.1		Test Reports	S			
9.3	MDR to be progressively compiled and submitted to client for final approval	SES - 286 - 3, 4.1.1, 4.7		MDR	H	R		