



STANDARD INSPECTION AND TEST PLAN FOR API6D VALVES				Page 1 of 4			Reference No.: P160-001			
P.O.Number :			Customer :							
Description :			Location :							
Project :										
ITEM NO.	MANUFACTURING OR INSPECTION DESCRIPTION	PROCEDURE No. SPECIFICATION REQUIREMENTS	ACTION			SUPPLIER'S RECORD/ CERTIFICATE	ACTIONED BY/ WITNESSED			REPORT, DOCUMENT REF.
			1	2	3		1	2	3	
1	INSPECTION AND TEST PLAN	API6D	R							
2	Casting surface inspection	MSS SP55	R							WPS/PQR
3	Material (Body, Body Cap, Ball, Stem, Bonnet, Bolts)									
	Mill Certificates	ASTM STD	R							MATERIAL CERTIFICATE TYPE 3.1
	Chemical Composition	ASTM STD API6D	R							MATERIAL CERTIFICATE
	Mechanical Test (Tensile, Bend, Hardness)	ASTM STD NACE MR0175	R							MATERIAL CERTIFICATE
	Impact Test	ASTM STD API6D	R							MATERIAL CERTIFICATE
	Heat Treatment	ASTM STD	R							HEAT TREATMENT RECORD
	Marking Check		FW							TEST CERTIFICATE

Key

- 1.Manufacturer FW : Full witness inspection/test R : Verify by reviewing documentation
 2.Purchaser SW : Spot witness inspection/test SP :Specified by the purchaser
 3.Other H : Hold Point



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4	NDE (If specified by client)		SP							
	RT for pressure retaining casting	API6D ASME B16.34 SEC 8	SP							TEST CERTIFICATE
	RT for pressure retaining casting (Apply to Body, Cap, Bonnet)	API6D ASME B16.34 ANNEX D	SP							TEST CERTIFICATE
	'AFTER ASSEMBLY'									
5	Pressure Testing (Ambient)		FW			Req'd				
	Hydrostatic shell testing	API6D	FW							TEST CERTIFICATE
	Hydrostatic seat testing	API6D	FW							TEST CERTIFICATE
	Low pressure gas seat	API598	FW							TEST CERTIFICATE
6	Torque Test (If specified by the client)	API6D	SP							TEST CERTIFICATE

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			1	2	3		1	2	3	
			7	Visual Check	MSS-SP-55		FW			
8	Dimensional Check					Req'd				
	Face to Face Dimension	API6D Approved Drawings	FW							TEST CERTIFICATE
	End Flange Dimension	ASME B16.5	FW							TEST CERTIFICATE
9	Marking/Tagging Check	API6D	FW							TEST CERTIFICATE
10	Painting Inspection		FW							TEST CERTIFICATE

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11	Fugitive Emission Leak Test (if specified)									
	Prototype Fugitive Emission Leak Test	SPE 77/312-2002	FW	FW		Req'd				TEST CERTIFICATE
	Production Fugitive Emission Leak Test	SPE 77/312-2002	SW 3%	SW 3%		Req'd				TEST CERTIFICATE
12	Low Temp./Cryogenic Test (Acceptance Test)	MESC77/306	SW 10%	SW		Req'd				TEST CERTIFICATE
	(if specified)									
13	Positive Alloy Material Identification (Apply to the valve of alloy body, Body, Body Cap, Bonnet, Stem: 100%, Bolt & Nut: 5%) (if specified)		FW	SW		Req'd				TEST CERTIFICATE

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