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| **INSPECTION TEST AND PLAN EXAMPLE: A1, D1.** | |
| **Contractor/customer:**  ABBC Engineering | **Date of issue: 1st July 2021** |
| **Project title:** Karratha Tank Renew | **Prepared by: Joe Bloggs** |
| **Water Corporation project No.:**  CW 1999999 | **Job/contract number: xxxxxxxxx** |
| **Description and system:**  Clarifier Internal Coatings System A1 D1 | **No. of pages: 3** |
| **Legend of inspection points:**   |  | | --- | | **H = Hold Point.** Work may not proceed without approval or notification, unless approved by the principal or contractor.  **W = Witness Point.** Work may proceed without the presence of the principal.  **S = Surveillance.** Witness at random, no formal notification required.  **V = Verify.**  **R/A = Review.** Review documents & accept.  **(work can proceed if Principal cannot attend hold point inspection within three hours of notified time for attendance)** | | |

| **N0** | **Activity/Operation** | **Specification/Document** | **Acceptable Criteria** | **Verifying Document** | **Person Responsible** | **Inspection & Verification Points** | | | | | |
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| **Sub-**  **Contractor** | **Sign** | **Contractor** | **Sign** | **Principal or Nominee** | **Sign** |
| 1 | Review Client Specifications | * Water Corporation DS95 * Specification A1 * Specification D1 | Read and fully understand the requirements & responsibilities. | Signed and approved ITP | QC Inspector | **R/A** |  | **R/A** |  | **V** |  |
| 2 | Blasting and coating applicators qualification | * Water Corporation DS95 * ASTM D4228 | As per coating contractor’s internal procedure and standards. | Verification of competency record (VOC) | QC Inspector | **H** |  | **V** |  | **V** |  |
| 3 | Certificate of inspection personnel | * Water Corporation DS95 * NACE/ACA | Certified as per specification requirements. | NACE/ACA | QC Inspector | **H** |  | **H** |  | **W** |  |
| 4 | Calibration of all test equipment | * Water Corporation DS 95 * SSPC PA2 * AS3894.3 * ISO 17025 | Equipment manufacturers criteria, qualified person, or NATA registered or equivalent testing facility. | Calibration and testing certificates and records. | QC Inspector | **V** |  | **V** |  | **W** |  |
| 5 | Substrate inspection | * Water Corporation DS 95 * Specification A1 | Surfaces checked for no sharp edges, have a 2mm radius, and weld spatter burrs, etc. are removed. | Daily coating and inspection report | Supervisor/ QC Inspector | **H** |  | **W** |  | **W** |  |
| 6 | Surface cleanliness | * SSPC SP1 * AS3894.6 * AS1627.1 | Oil, grease, dirt, and other foreign matter shall be removed. | Daily inspection report | Supervisor/ QC Inspector | **H** |  | **W** |  | **W** |  |
| 7 | Compressed air supply and clean air inspection | * ASTM D 4285-83 | Compressed air shall be free from water and oil and tested each day. | Daily coating and inspection report | Supervisor/ QC Inspector | **V** |  | **S** |  | **W** |  |
| 8 | Verify abrasive blast and surface profile. | * Water Corporation DS 95 * Specification A1 * AS 1627.4 * AS 3894.5 * AS3894.12 | Class 3 (white metal) finish.  SSPC-SP 5, SA-3.  Surface profile as per coating manufacturers recommendation, typically 75-100µm. | Daily coating and inspection report | QC Inspector | **H** |  | **S** |  | **S** |  |
| 8 | Test for chloride contamination | * Water Corporation DS 95 * Specification A1 * AS 3894.6 | Immersion service -< 3µg/cm².  Ambient service – < 5µg/cm². | Daily coating and inspection report | QC Inspector | **H** |  | **S** |  | **S** |  |
| 9 | Test for particulate surface contamination | * Water Corporation DS 95 * Specification A1 * AS 3894.6 * ISO 8502-3 | Determination of surface dust pressure sensitive tape method.  Dust level shall not exceed rating 2. | Daily coating and inspection report | QC Inspector | **V** |  | **W** |  | **S** |  |
| 10 | Ambient conditions | * Water Corporation DS 95 * Specification A1 * Specification D1 * AS3894.7 * AS3894.13 | Ambient conditions shall be recorded at least 4 times per shift  Max relative humidity 85%  Min/Max substrate Temp 10°C - 55°C  Min Substrate Temp 3oC above dew point. | Daily coating and inspection report | QC Inspector | **H** |  | **W** |  | **W** |  |
| 11 | Stripe coat 1st and 2nd coating. | * Water Corporation DS 95 * Water Corporation D1 | Ensure all welds, edges, crevices, seams, joints, and corners are brush stripe coated on each application. | Daily coating and inspection report | QC Inspector | **V** |  | **W** |  | **W** |  |
| 12 | Apply 1st coat  **Insert the Coating Product Name** | * Water Corporation DS 95 * Water Corporation D1 | Monitor WFT/DFT regularly during and after application. | Daily coating and inspection report | QC Inspector | **V** |  | **W** |  | **W** |  |
| 13 | Apply 2nd coat  **Insert the Coating Product Name** | * Water Corporation DS 95 * Water Corporation D1 | Monitor WFT regularly during application.  500 µm DFT minimum  750 µm DFT maximum | Daily coating and inspection report | QC Inspector | **V** |  | **W** |  | **W** |  |
| 14 | Finish coat inspection | * Water Corporation DS 95 * Specification D1 * AS3894.3 * AS3894.4 * SSPC PA2 | Visual inspection for runs, sags and any inclusions etc.  Coating cured and final DFT recorded. All batch numbers are documented. | Daily coating and inspection report | QC Inspector | **H** |  | **H** |  | **W** |  |
| 15 | Holiday testing for buried, immersion or as defined in the ITP. | * Water Corporation DS 95 * AS 3894.1 | 100% of total coated accessible surface area. | Daily coating and inspection report | Supervisor / Inspector | **H** |  | **H** |  | **H** |  |
| 16 | Adhesion testing on test panel (if applicable) | * Water Corporation DS 95 * Specification D1 * AS3894.9 | Adhesion test of cured coating on test panel. (Pull off test) | Daily coating and inspection report | Supervisor / Inspector | **H** |  | **H** |  | **H** |  |
| 17 | Verifying acceptance  documentation. | * Water Corporation DS 95 * AS3894.12 | Check that all inspection, test documentation and completion reports have been completed and singed. Submit documentation to Contractor/Principal. | Completion report.  IRC and signed ITP. | Inspector / Principal | **H/R** |  | **RA** |  | **RA** |  |
| **COMMENTS AND NOTES:** | | | | | | | | | | | |
| Consider environmental conditions in relation to coastal C4 or C5 location of works.  Water blasting to remove soluble salts prior to abrasive blast cleaning and between coats might be a consideration for adding an inspection line item into the ITP. | | | | | | | | | | | |
| Sub-contractor, contractor then principal to sign ITP at completion of works and ITP close out. | | | | | | | | | | | |
| This example ITP covers the coating system D1 for both liquid immersion and non-immersion. | | | | | | | | | | | |
| ≠For buried application refer D4 specification. | | | | | | | | | | | |

Insert signature box for individual client acceptance for ITP details here