

GP 20-01-01	Inspection of Equipment and Materials	July 2001
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Inspection of Equipment and Materials

GP 20-01-01

Scope

[I] This Global Practice (GP) lists equipment and materials for which ExxonMobil or its Affiliates require inspection by an ExxonMobil Inspector or an appointed Owner's Representative, and defines requirements relating to the inspection activities of this equipment and material.

[I] This practice shall be applied to any direct or indirect purchase orders or sub-orders issued on behalf of, or by ExxonMobil or an ExxonMobil Affiliate.

[I] An asterisk (*) indicates that a decision by the Purchaser is required or that additional information is furnished by the Purchaser.

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1. Required References

* [I] This Section lists Practices and Standards that are generically referenced and shall be used with this GP as specified by the Purchaser. Unless otherwise specified herein, use the latest edition.

1.1. Global Practices–ExxonMobil Engineering Practices

GP 10-14-01	Lube and Seal Oil Systems for Machinery
GP 18-03-04	Pressure Casting Quality and Inspection
GP 20-01-02	Administrative Procedures for Obtaining Inspection
GP 20-01-03	Quality Programs

2. Additional Requirements

- 1) [I] Table 1 lists major equipment and materials requiring inspection by the Inspector, unless waived by the Owner.
- 2) [I] Modifications to the requirements of this GP will be specified in the purchase order for:
 - a) Specific Owner requirements
 - b) Compliance with local rules and regulations
 - c) Additions or deletions to Table 1

Note: This does not preclude the Inspector from inspecting material or equipment component parts that are utilized in fabrication/assembly of equipment and materials in Table 1.

- 3) [I] Inspection and test requirements shall include, but not be limited to, those contained in the purchase order.

3. Definitions

Term	[I] Description
Direct Orders	Purchase orders issued to a supplier on behalf of, or by ExxonMobil or an ExxonMobil Affiliate, for materials or equipment. (These are also known as "main orders" or "prime orders.")
Indirect Orders	Purchase orders issued by a Supplier (who is recipient of a direct order) for mill or foundry materials or component parts or subassemblies for fabrication or assembly. (These are also known as "sub-orders, shop orders, internal work orders, etc.")

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Term	[I] Description
Inspector	Refers to the ExxonMobil Inspector, or the appointed Owner's or Purchaser's Representative.
Owner	ExxonMobil or ExxonMobil affiliate organization that will receive the equipment or materials.
Purchase Order	As used in this GP includes the purchase order (or contract) document, its referenced specifications and practices, attachments, codes, standards, other referenced documents, and all agreed amendments thereto.
Purchaser	May be ExxonMobil, an ExxonMobil affiliate organization, or ExxonMobil designated Representative responsible for procuring equipment, components, materials, systems, or services.
Supplier	Refers to the Manufacturer, Vendor, Sub-Supplier, Contractor or Sub-Contractor, and/or the recipient of the purchase order.

4. Inspection Activities and Data Requirements

- 1) * [C], [R] The scope and extent of inspection may vary depending on the critical purpose and end use of the equipment. The specific inspection activities will be developed by the Inspector and Owner with the Supplier. Unless otherwise specified the equipment and materials in Table 1 may be inspected at the source, or at the Supplier or Sub-Supplier final manufacturing or assembly point as determined by the Inspector and Owner.
- 2) * [O], [R] Unless otherwise authorized by the Owner, the Inspector will not release any equipment and materials which:
 - a) Do not comply with the requirements of the purchase order, or
 - b) Cannot be identified with applicable specifications or insufficient data is available to assure compliance, or
 - c) In the opinion of the Inspector, are of unacceptable workmanship.
- 3) [O], [R] Data requirements shall be per the following:
 - a) The supplier shall provide sufficient documentation to the Inspector at the time of, during, or before the final inspection and prior to shipment, which demonstrates that the requirements of the purchase order or subsequent amendments have been met. This may include: a copy of mill test data or other acceptable chemical and physical material data, code forms, charts, certificates, inspection and test reports, and other information required in the purchase order.
 - b) If in-process inspection, or final inspection has been waived, the specified number of copies of mill test data or other acceptable chemical and physical material data, code forms, charts, certificates, inspection and test reports, and other required information and certificates needed to verify compliance with local rules and regulations and requirements of the purchase order documents shall be forwarded directly to the Purchaser at or prior to shipment.



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- c) * If specified, a "Certificate of Compliance" stating compliance with the purchase order requirements and the applicable specification or standard shall be issued by the supplier, and shall be provided to the Inspector at the time of, or before final Inspection and prior to shipment.

5. Suppliers Obligations

- 1) [C], [R] Quality Assurance: The Supplier is obligated to assure the quality of the equipment and materials being provided under the purchase order, either directly or indirectly.
 - a) The Supplier shall provide its own quality control and inspection of the materials to ensure that the requirements of the purchase order and its referenced specifications are met.
 - b) The Supplier shall record and maintain records of the quality/inspection activities performed.
 - c) Inspection by the Inspector does not relieve the Supplier of this obligation. Neither does such inspection relieve the Supplier from guarantees as to material; apparatus; workmanship or performance, or both.
- 2) [C], [R] Free Entry: The Supplier shall afford the Inspector the right of access and free entry to any areas of the Supplier or Sub-Supplier premises where storage, work, or test of any material, component, or equipment is being performed to fulfill purchase order requirements. Unrestricted opportunity shall be provided to the Inspector to verify conformance of these materials, components and equipment with the direct purchase order requirements.
- 3) [I] Inspector's Safety: The Supplier shall provide a safe working environment for the Inspector and to alert the Inspector of potential hazards. If in the opinion of the Inspector, the working conditions are unsafe, the Inspector will not perform the work.
- 4) * [I] Quality Program: When [GP 20-01-03](#) is specified, the Supplier shall follow the approved Quality Program to assure the quality of the materials and equipment that is being provided, directly or indirectly. The Quality Program shall also assure that the requirements of the purchase order and its referenced specifications and all attachments and amendments thereto are met.

Table 1: List of Equipment and Materials to be Inspected

(Unless otherwise specified the equipment and materials in this table may be inspected at the originating source, or at the Supplier or Sub-Supplier final manufacturing or assembly points, as determined by the Inspector and Owner.)	
1.	Agitators and mixers: Over 20 hp (15 kW)
2.	Boilers and associated parts: a. Assembled water walls and superheater b. Boiler tubes after bending, or after fin attachment for water walls c. Drums d. Headers e. Installed refractory (shop only) f. Stacks

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(Unless otherwise specified the equipment and materials in this table may be inspected at the originating source, or at the Supplier or Sub-Supplier final manufacturing or assembly points, as determined by the Inspector and Owner.)		
g.	Steam separation equipment	
h.	Tube supports	
3.	Bolting:	
a.	Alloy (e.g., A193, A320, A325, etc.)	
b.	Material involving impact tests for services below - 50°F (- 45°C), including witnessing of impact tests	
c.	Greater than 2 in. (50 mm) diameter	
d.	All coated bolts	
4.	Burners: For process equipment such as boilers, fired heaters, incinerators, sulfur plants, etc.	
5.	Castings other than valve bodies: All ductile iron, carbon steel, and alloy castings (if not part of equipment otherwise listed in this GP) for the following:	
a.	Pressure containing service	
b.	Load bearing, or critical vessel internals such as grid plates cat cracking plants	
c.	High temperature service [above 1000°F (538°C)]	
d.	Foundry for casings for compressors, pumps, turbines and expanders developing or requiring 5000 hp (3750 kW) or more	
e.	Castings when "first-piece" or "pilot castings" are required	
f.	Castings subject to nondestructive examinations (NDE)	
6.	Centrifuges: Over 20 hp (15 kW)	
7.	Circuit breakers: All circuit breakers (with associated relays and panels) rated above 600 volts	
8.	Compressors:	
a.	Centrifugal, axial and rotary screw compressors for special purpose applications	
b.	Packaged, integrally geared compressors	
c.	Reciprocating compressors for process applications	
d.	Other compressors, including axial, centrifugal, rotary screw, reciprocating and liquid ring compressors over 150 hp (112 kW), except laboratory units, or portable commercial units such as for paint sprayers, sandblast machines, or gunite machines	
9.	Control Panels for Instruments, where functional tests or specific name brand components are required	
10.	Cyclones and trickle valves, including installed refractory linings (shop only)	
11.	Dryers	

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