DOCUMENT #: S11-10279-8-ITP REV 3 DATE: 6/22/12

SCOPE\ ITP \ QUALITY PLAN

TAG No.:	SCOPE INCLUDES OPERATIONS OF SUB CONTRACTOR "J&M WELDING"
HX2065	EQUIPMENT TITLE: AGR FLASH GAS COOLER

LEGEND: V=VERIFY I=INSPECT R=REVIEW W=WITNESS H=HOLD M=MONITOR D=DIMENSIONAL

TASK #	ACTIVITY		FABSCO QC		J&M QC		CUST INSP	ACCEPTANCE CRITERIA	FABSCO OPERATIONS	J&M OPERATIONS
1.00	KICK OFF MEETING			H		H				
	* Review of PO and specifications QC requirements									
	* Review vendor requirements for submittal of engineering									
	documents .									
	* Review and establish Quality Surveillance requirements.									
2.00	FRONT CHANNEL FABRICATION									
2.01	MACHINE & DRILL CHANNEL COVER (Add Stamping)	H						1,2	F	
2.02	MACHINE & DRILL BOTH END FLANGES (Add Stamping)	H						1,2	F	
2.03	VERIFY CHAN CYL MATERIAL, DIMENSIONS	M						1,2	F	
2.04	VERIFY NOZZLE MATERIALS	M						1,2	F	
2.05	VERIFY GIRTH FLG FIT UP & PRE HEAT	M		H				1,2,3		J
2.06	WELD GIRTH FLGS TO CHAN PIPE	M		M				1,2		J
2.07	GSKT FLATNESS OF GIRTH FLGS TO BE BE FLAT WITHIN 1/32"	M		M				1,2		J
2.08	P.T. REQ'D ON GROOVE, PLATE EDGES, & BACK GOUGED SURFACES .	M		M				1,2		J
2.09	WELD CHAN ANSI FLGS TO PIPE	M		V				1,2	F	
2.10	P.T. REQ'D ON GROOVE, PLATE EDGES, & BACK GOUGED SURFACES	M		M				1,2		J
2.11	LAYOUT & CUT NOZZLE HOLES IN CYLINDER	H		H				1,2		J
2.12	VISUAL INSPECT PLATE EDGES @ NOZ OPENING & P.T.	M		M				1,2		J
2.13	VERIFY NOZ FIT UP AND WELD TO CYL	M		H				2	F	J
2.14	NOZ FACE SHALL BE TRUE (VERT & HORIZ) TO 1/2 DEG OR 1/32"	M		H				2	F	J
2.15	UT NOZZLE CATEGORY D TO CYL WELDS	M		M				2		J
2.16	FIT & WELD LIFTING LUGS ON COVER AND CHAN FLGS	M		M				1,2		J
2.17	DYE PENETRANT ALL LIFTING LUG WELDS	M		M				1,2		J
2.18	100% RADIOGRAPH CHAN GIRTH SEAMS AT GIRTH FLGS	MR		H		H		1,2		J
2.19	FIT UP AND WELD PASS PLATES	M		H				1,2		J
2.20	PRECAUTION TO BE TAKEN TO AVOID CONTAMINATION OF	M		M				2,3		J
	STN STL MATERIALS. USE STN STL BRUSHES AND SILICON									
	CARBIDE GRINDING WHEELS	H						2,3		J
2.21	PMI TO BE PERFORMED BY GLOBE SERVICES, IN ACCORDANCE			M						
	WITH KBR SPEC 2-1TS-US-BO-M&U	H						2,3		J
		H						2,3		J
3.00	SHELL FABRICATION									
3.01	MACHINE & DRILL END FLANGE+C22 (Add Stamping)+C22	H						1,2	F	
3.02	VERIFY SHELL SIDE MATERIALS	M		V					F	J
3.03	VERIFY GIRTH FLG FIT UP & PRE HEAT	M		H				1,2,3		J
3.04	WELD GIRTH FLGS TO CHAN PIPE	M		M				1,2	F	J
3.05	GSKT FLATNESS OF GIRTH FLGS TO BE BE FLAT WITHIN 1/32"	M		M				1,2		J
3.06	P.T. REQ'D ON GROOVE, PLATE EDGES, & BACK GOUGED SURFACES	M		M				1,2		J
3.07	WELD 6" & 8" SHELL NOZZLE ASSEMBLIES	M		V				1,2	F	
3.08	P.T. REQ'D ON GROOVE, PLATE EDGES, & BACK GOUGED SURFACES	M		M				1,2		J
3.09	LAYOUT & CUT NOZZLE HOLES IN VAPOR BELT CYLINDER	H		H				1,2		J
3.10	VISUAL INSPECT PLATE EDGES @ NOZ OPENING & P.T.	M		M				1,2		J
3.11	VERIFY NOZ FIT UP AND WELD TO CYL	M		H				2	F	J
3.12	NOZ FACE SHALL BE TRUE (VERT & HORIZ) TO 1/2 DEG OR 1/32"	M		H				2	F	J
3.13	UT NOZZLE CATEGORY D TO CYL WELDS *	M		M				2		J
3.14	LAYOUT AND CUT SLOTS FOR LONG BAFFLE WELDING	M		H						
3.15	FIT AND WELD LONG BAFFLE IN PLACE	M		H						
3.16	P.T. REQ'D ON ROOT PASS OF LG BAFFLE WELDING	M		M				1,2		J
3.17	FIT AND WELD VAPOR BELT END PLATES TO CYL			H						
3.18	LAYOUT & CUT NOZZLE HOLES IN SHELL PER DWG S11-10279-7/8-3A	H		H						
3.19	VISUAL INSPECT PLATE EDGES @ END PLATES & P.T.	M		M				1,2		J
3.20	POSITION AND WELD VAPOR BELT ASSEMBLY ON SHELL			M						
3.21	VERIFY NOZ DIMS FROM REF LINE			M						
3.22	INSTALL SUPT WEAR PADS ON SHELL	M		H				2,3		J
3.23	FIT AND WELD SUPPORT ASSEMBLY (1" RAD)	M		W		W		2,3		J
3.24	FIT & WELD REAR HEAD TO SHELL	H		M				2,3		J

ACCEPTANCE STANDARDS: 1.) ASME CODE 2.) FABSCO DWGS 3.) CUSTOMER SPEC'S

LEGEND: H= HOLD POINT W=WITNESS POINT SW= SPOT WITNESS R= REVIEW

SCS APPROVAL 7-26-2012

_X_ Accepted
___ Accepted w/Comments
___ Not Accepted
___ Not Reviewed

VQ Rep: Clay Smitherman

Southern Company Generation Kemper County
MM82914 C Unit 1

FABSCO SHELL & TUBE PO: MPC17901-0001
S11-10279-8-ITP Rev: 3
IGCC - GASIFIER - MULTIPAGE - AGR FLASH GAS COOLER - ITP - QUALIT

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TASK #	ACTIVITY		FABSCO QC		J&M QC		CUST INSP	ACCEPTANCE CRITERIA		
4.00	**BUNDLE FABRICATION**									
4.01	MACHINE & DRILL BAFFLES(1/2" DRAIN NOTCH)	D						1,2	F	
4.02	MACHINE, DRILL & REAM TUBESHEETS (DBL RING GROOVE)	D						1,2	F	
4.03	BUILD BUNDLE SKELETON ON TUBESHEET.	M						2,3	F	
5.00	**FINAL ASSEMBLY & TESTING**									
5.01	PLUG SHELL	H						1,2,3	F	
5.02	INSERT BUNDLE IN SHELL	H				H		2,3	F	
5.03	STRG WELD TUBE TO TUBESHEET	M						1,2,3	F	
5.04	ROLL & EXPAND TUBE/TUBESHEETS	M						1,2,3	F	
5.05	INSTALL ALL GASKETS AND BOLTING	M						2	F	
5.06	PERFORM SHELL SIDE HYDRO TEST	H				H		1,2,3	F	
5.07	FULL HYDRO-TEST W/CHART	H				H		1,2,3	F	
5.08	VERIFY NOZZLE FINISHG 125 RMS	H				H		1,2,3	F	
5.09	ATTACH NAME PLATE(INCLUDE BUN WT)	H						1,2	F	
5.10	RADIOGRAPHY (REVIEW ALL RADIOGRAPHS)	R				R		1,2,3	F	
5.11	PNEUMATIC TEST	I/H				H		1,2,3	F	
6.00	**PAINTING,MARKING & SHIPPING INSPECTION**									
6.01	CLEANING, DRY-OUT & SURFACE PREPARATION	M				H		2,3	F	
6.02	PAINTING, PRESERVATION & MARKING	I				H		2,3	F	
6.03	PAINT AND INSPECT PAINTING(STENCILING)	H				H		2,3	F	
6.04	NITROGEN PURGE(IF REQUIRED)	M				H		2,3	F	
6.05	DATA PACKAGE REVIEW	H				H		1,2,3	F	

The Purchaser's quality representative shall have notification from the Supplier in sufficient time(minimum of 5 working days for domestic facilities, 10 working days for facilities outside North America) to ensure witness or hold points may be observed.

The supplier shall notify the Purchaser via e-mail to, but not limited to, the following address