

KRØLL CRANES A/S – DENMARK		CLIENT		AFCONS INFRASTRUCTURE LIMITED		ITP No.		01			
END USER		MODEL		K703V		PROJECT		REV. 01			
PREPARED BY: Tor Larsen APPROVED BY: Henrik B. Nielsen		S/No.		W = WITNESS M = MONITOR		R = REVIEW S = SIGNATURE		H = HOLD			
		PO No.									
		Ref.:		PROD.		QA /QC		3 rd party		AFCONS	
		KC JOB		ACCEPTANCE CRITERIA		CERTIFY. / VERIFY. DOCS.		IN ACT		SIGN ACT	
DESCRIPTION OF EVENTS		CONTROL DOCUMENT		MOTOR / MDR		SIGN ACT		SIGN ACT		SIGN ACT	

ENGINEERING PRIOR TO FABRICATION – ALL ELEMENTS

1.	APPROVAL OF DESIGN CALCULATIONS	CALCULATIONS	F.E.M. 3 RD ED. EN 14439+A2	-		R	R	R*
2.	APPROVAL OF DESIGN DRAWINGS	DRAWINGS	F.E.M. 3 RD ED. EN 14439+A2	-		R	R	R*

ELECTRICAL WORKSHOP PRIOR TO, AND DURING FABRICATION

3.	MOTORS & UNITS	MANUFACTURERS DOCUMENTS	SPECIFICATION / APPR. VENDOR	YES	H	R	R	R
4.	ELECTRICAL PARTS	PURCHASE ORDER	SPECIFICATION / APPR. VENDOR	-	H	R	R	R



* Calculations and production drawings are sent to 3rd Party only.




ACT No.	DESCRIPTION OF EVENTS	CONTROL DOCUMENT	ACCEPTANCE CRITERIA	CERTIFY. / VERIFY. DOCS.	DOCS. IN MDR	PROD.		QA / QC		3 rd party		AFCONS		End user		REMARKS
						ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	
<u>STEEL WORKSHOP PRIOR TO, AND DURING FABRICATION – ALL ELEMENTS</u>																
5.	APPROVAL OF WPS, WPQR	WPS'es WPQR's	EN ISO 15609-1 EN ISO 15614-1 OR SIMILAR	WPS'es WPQR's	-	H		H		R		R		R		
6.	APPROVAL OF WELDERS QUALIFICATION	WELDERS CERTIFICATES	EN ISO 9606-1 OR SIMILAR	WELDERS CERTIFICATES	-	H		H		R		R		R		
7.	APPROVAL OF NDT PERSONNEL QUALIFICATIONS	NDT CERTIFICATES	EN 473 / ISO 9712 EWI / IWI OR SIMILAR	NDT CERTIFICATES	-	H		H		R		R		R		
8.	MATERIAL RECEIVING	MATERIAL CERTIFICATES	PRIMARY STEEL: ISO 10204 3.1	LIST OF CERTS. MATERIAL CERTIFICATES	-	H		H		R		R		R		
9.	GEARS	MANUFACTURERS DOCUMENTS	SPECIFICATION / APPR. VENDOR	NAMEPLATES	YES	H		H		R		R		R		
<u>STEEL WORKSHOP DURING FABRICATION</u>																
<u>CRANE BASE / UNDERCARRIAGE</u>																
10.	VISUAL CHECK OF EDGE PREPARATIONS AND DIMENSIONS	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
11.	FIT UP	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
12.	SPOTCHECK OF WELDING PARAMETERS	NDT GENERAL PROCEDURE	ACC. TO WPS	-	-	M		M		R		R		R		
13.	CHECK NAMEPLATES ON SECTIONS	-	-	CHECKLIST	-			H		R		R		R		




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						ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	
STEEL WORKSHOP DURING FABRICATION (CONINUED)																
PORTAL																
14.	VISUAL CHECK OF EDGE PREPARATIONS AND DIMENSIONS	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
15.	FIT UP	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
16.	SPOTCHECK OF WELDING PARAMETERS	NDT GENERAL PROCEDURE	ACC. TO WPS	-	-	M		M		R		R		R		
17.	CHECK NAMEPLATES ON SECTIONS	-	-	CHECKLIST	-			H		R		R		R		
MASTHEAD / SLEWING TOP TOWER																
18.	VISUAL CHECK OF EDGE PREPARATIONS AND DIMENSIONS	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
19.	FIT UP	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
20.	SPOTCHECK OF WELDING PARAMETERS	NDT GENERAL PROCEDURE	ACC. TO WPS	-	-	M		M		R		R		R		
21.	CHECK NAMEPLATES ON SECTIONS	-	-	CHECKLIST	-			H		R		R		R		

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						ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	
STEEL WORKSHOP DURING FABRICATION (CONINUED)																
MACHINERY DECK																
22.	VISUAL CHECK OF EDGE PREPARATIONS AND DIMENSIONS	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
23.	FIT UP	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
24.	SPOTCHECK OF WELDING PARAMETERS	NDT GENERAL PROCEDURE	ACC. TO WPS	-	-	M		M		R		R		R		
25.	CHECK NAMEPLATES ON SECTIONS	-	-	CHECKLIST	-			H		R		R		R		
BOOM UNITS																
26.	VISUAL CHECK OF EDGE PREPARATIONS AND DIMENSIONS	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
27.	FIT UP	WELD PREP. PROCEDURE	ACC. TO DRAWINGS	-	-	H		R		R		R		R		
28.	SPOTCHECK OF WELDING PARAMETERS	NDT GENERAL PROCEDURE	ACC. TO WPS	-	-	M		M		R		R		R		
29.	CHECK NAMEPLATES ON SECTIONS	-	-	CHECKLIST	-			H		R		R		R		





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						ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	ACT	SIGN	
<u>NDT INSPECTION</u>																
CRANE BASE / UNDERCARRIAGE																
30.	100% VT. ALL WELD SEAMS	VT PROCEDURE	EN ISO 5817 LEVEL C	VT REPORTS	MECH. FAT				H		R				R	
31.	20% MT. ALL WELD SEAMS	MT PROCEDURE	EN ISO 23278 LEVEL 2X	MT REPORTS	MECH. FAT				H		R				R	
32.	100% UT. ALL BUTTWELDS IF UT IS REQUIRED IN THE DRAWING. EXTERNAL COMPANY	EXTERNAL PROCEDURE	AS PER DRAWING	UT REPORTS	MECH. FAT				H		R				R	
PORTAL																
33.	100% VT. ALL WELD SEAMS	VT PROCEDURE	EN ISO 5817 LEVEL C	VT REPORTS	MECH. FAT				H		R				R	
34.	20% MT. ALL WELD SEAMS	MT PROCEDURE	EN ISO 23278 LEVEL 2X	MT REPORTS	MECH. FAT				H		R				R	
35.	100% UT. ALL BUTTWELDS IF UT IS REQUIRED IN THE DRAWING. EXTERNAL COMPANY	EXTERNAL PROCEDURE	AS PER DRAWING	UT REPORTS	MECH. FAT				H		R				R	