

General Inspection plan Title Wet Motors	Document KBE IP – 103.4
	Issue 3
	Date 2024-05-07
	Supersedes 2

Inspection according to codes below					
<u>Inspection Specification</u> (1st letter)	<u>Inspection performed and documented by</u> (2nd letter)	<u>Inspection supervised by</u> (3rd letter)	<u>Documentation</u> (4th letter)		
A: Routine 100% Insp. S: Sample Inspection T: Type Inspection	E: Manufacturer D: Supplier B: Purchaser	B: Purchaser C: Inspector engaged by purchaser D: Supplier	R: Technical Report P: Inspection Record I: Certificate		
Examination Procedures	Codes	Inspection Procedure	Inspection Record	Deviation Report/Remark	
Type Inspection					
T1	Withstand voltage test KBE EP-170 pt. 3.16	TEBR			
T2	Temperature rise KBE EP-170 pt. 3.9	TEBR			
T3	Load losses KBE EP-170 pt. 3.8	TEBR			
T4	No-load test KBE EP-170 pt. 3.7	TEBR			
T5	Short circuit test KBE EP-170 pt. 3.12	TEBR			
T6	Torque curve KBE EP-170 pt. 3.19	TEBR			
T7	Aging (winding wire) KBE EP-135	TE-R			
T8	Test/Inspection of electrical Penetrations Note 1	TEBR			
T9	Noise level KBE EP-170 pt. 3.14	TEBR			
T10	Seismic Qualification Note 2 KBE EP-147	TEBR			
T11	Type Inspection review and certification KBE EP-180	TE-R			
T12					
T13					
T14					
Notes					
(See page 2)					

Examination Procedures		Codes	Inspection Procedure	Inspection Record	Deviation Report/Remark
Routine Inspection					
R1	Inspection of welds Note 3	AE-P			
R2	Airgap measurement KBE EP-170	AE-P			
R3	Winding resistance measurement KBE EP-170	AE-P			
R4	No-load test KBE EP-170	AE-P			
R5	Overspeed and vibration test KBE EP-170	AE-P			
R6	Overvoltage test KBE EP-170	AEBP			
R7	Short-circuit (locked rotor) test KBE EP-170	AEBP			
R8	Voltage withstanding test KBE EP-170	AEBP			
R9	Insulation resistance measurement KBE EP-170	AEBP			
R10	Bearing inspection/testing Note 4	AE-P			
R11	Visual inspection KBE EP-170	AEBP			
R12	Surface finish inspection KBE EP-148	AEBP			
R13	Material quality certificates KBE EP-109	AE-P			
R14	Delivery Release Inspection Note 5	AEBP			
R15	Quality and identity certification KBE EP-180	AE-I			
R16					
R17					
Notes					
<ol style="list-style-type: none"> The test shall be carried out according to Manufacturer's standard procedure, subject to prior review and approval by the Purchaser. As a minimum the test shall include thermal ageing, radiation ageing, cyclic pressure testing and cyclic temperature testing, followed by voltage test, insulation resistance test and leakage test. Verification of seismic requirements given in the Technical Specification. Welder's licenses shall be checked before manufacturing starts. Visual inspection of welds before start of stator winding. SPM (Shock pulse measurement) inspection, where called for in Technical Specification. Inspection witnessed by Purchaser before Delivery (Shipping) Release in accordance with KBE 100-X. 					