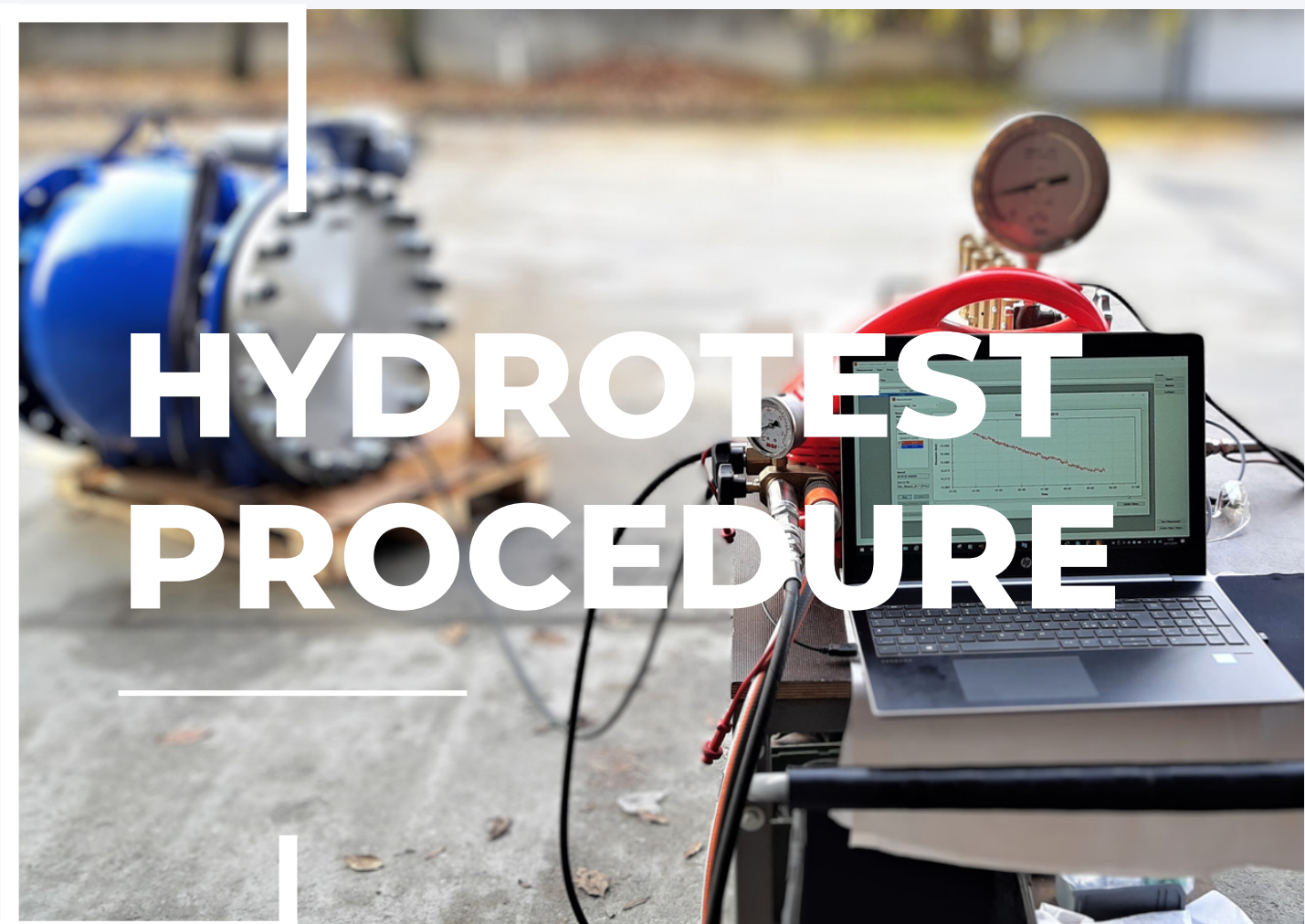




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Via Caduti di Reggio Emilia 27, 40033  
Casalecchio di Reno (BO)  
[www.valveit.com](http://www.valveit.com)  
[info@valveit.com](mailto:info@valveit.com)



## HYDROTEST PROCEDURE

PRO AT FLUID CONTROL



valveIT



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**valveIT** shall carry out the inspection in accordance with the drawings, technical specifications provided, or any requirements otherwise mentioned in the contracts, EN/BS or international standards and as per **valveIT internal procedures**.

**Inspection** will be held at manufacturer's premises to carry out the inspection. All the delivered reports/documents will be validated by internal quality system.

For the mobilization purpose, valveIT is expected to provide to Customer with the testing schedule on **one week advance notice for inspection**.

Deliverables:

- **Inspection reports**
- **NCR [Non -conformity reports], if any**
- **Sign/stamped on valveIT test reports**

Note : All the language used in the report will be in English only.






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**Method statement** as issued by valve manufacturer [valveIT srl] based on customer requirements

- **Material composition:** Review of material test certificates provided by valveIT. Sign/stamp on the certificates, if found OK
- **Valve manufacturing** compliance to the relevant standard and marking of symbols
- **Assembling:** Valve manufacturing / Assembly compliance certificates to be provided by valveIT as per EN/BS or applicable international standards. Marking / nameplates to be verified. Sign /stamp on the certificates, if found OK

**Testing** (Working pressure and test pressure etc)






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**REFERENCE STANDARD:** EN 12266-1

**PRESSURE TESTING:**

- **TESTS REQUIRED:** One valve per size and diameter shall be pressure tested as per below
  - **TEST PRESSURE:** The applicable pressure for various tests shall be as per the appropriate relevant standards referred. Viz., EN 12266, API598, API6D, ASME B16.34, BS5351, BS6755 -I, etc. The **Shell test pressure** shall be **1.5 times**, and the **Seat test** pressure shall be **1.1 times** of the **valve pressure rating** specified.
  - **TEST DURATION:** The test shall be carried out for test duration after the valve is fully pressurized according to EN 12266, API6D, API598, BS6755-I, BS5351 etc, according to the product.
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## TEST PROCEDURE:

- **HYDROSTATIC SHELL TEST:** Complete assembled valve in partial/fully opened condition is clamped on the testing rig/bed and both the ends are closed. Hydrostatic pressure is applied from one end to the rated pressure. This test is carried to detect the leakage / seepage from the boundary of walls of body, bonnet/ cover, body- bonnet joint, gasket joints. Any leakage / seepage from the body, bonnet/ cover will be cause of rejection and no leakages are acceptable.
- **HYDROSTATIC SEAT [CLOSURE] TEST:** This test is conducted to ensure the integrity of mating/ sealing part/component. The valve shall be kept in fully opened condition and is to be evacuated/ purged. After purging valve is fully closed and one end of the valve is blocked from where rated pressure is applied. After pressurizing ensure the body cavity is also pressurized with test fluid. Check for leakage. Repeat the Test from other end in case of bi-directional valves. Leakage is not acceptable in case of soft seated valves and leakage shall not exceed the requirements in case of metal seated valves as per appropriate standards. Test pressure shall be applied for unidirectional valves according to the flow directional marked.

**Note:** Seat leakage/rate is compared with appropriate standards and client requirement for acceptance criteria..

