

## Inspection Procedures:

Historical Boiler Pre-inspection Criteria  
COLD IRON

**It is recommended to schedule inspections with a minimum of 30-day advance notice.**

PHASE ONE: Have boiler full of water and ready to hydro.

Note: Have test gauge and pump ready.

Safety valve removed and opening blanked/flanged off.

When performing hydrostatic pressure testing for verification of leak tightness or when required by the Jurisdiction, the following requirements shall be met:

a). Hydrostatic pressure test shall be between the calculated maximum allowable working pressure and 1.25 times the calculated maximum allowable working pressure, and held for a minimum of 10 minutes or as required to perform a complete visual examination.

b). The metal and water temperature of the boiler shall be between 60 degrees F to 120 degrees F (16 degrees C to 49 degrees C) anytime a hydrostatic test is being performed.

c). A calibrated gage, acceptable to the inspector, shall be used when hydrostatically pressure testing boiler.

PHASE TWO: Drain and open boiler for internal inspection.

Note: Grates should be removed prior to hydro.

If dry bottom, ash pan should be removed prior to hydro.

Internal surfaces should be cleaned prior to hydro.

1. Open all handholes and manholes.
2. If bolted, remove steam dome cover.
3. Remove fusible plug (Have new ASME plug ready to install).
4. Remove caps/plugs from crosses and tees on pipe connections.
5. Assure all hand valves will open and close properly.
6. Be prepared to remove pipe and fittings as requested.

Have copies of the following information on hand for the inspector.

1. Any technical references related to the boiler.
2. Any current or past inspection documentation.
3. Any documentation concerning past repairs.

CONTACT FOR SCHEDULING INSPECTIONS:

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