**Section 2120.1330 Examination and Inspection Program**

The Owner-User Quality Control System shall describe the repair operations, including examinations, sufficiently to permit the inspector to determine at what stages specific inspections are to be performed. The system shall include a checklist, traveler or process sheet which lists important stages in the repair procedure which will allow the inspector to designate his desired inspections. As a minimum the stages shall permit the inspector to indicate his verification of the following:

a) Calculations are available.

b) Materials used comply with the ASME Code.

c) Welding procedures have been qualified in accordance with Section IX, ASME Code.

d) Welders and welding operators have been qualified in accordance with Section IX, ASME Code.

e) Heat treatment, including post weld heat treatment, as applicable, has been performed.

f) Material imperfections have been acceptably repaired.

g) Weld defects have been acceptably repaired.

h) Nondestructive examinations have been performed and results are acceptable.

i) Material identification markings have been properly transferred.

j) There are no material or dimensional imperfections.

k) Performance of internal and/or external inspections and witnessing hydrostatic or pneumatic test.

(Source: Amended at 17 Ill. Reg. 14917, effective September 1, 1993)