PART RI
INSPECTION REQUIREMENTS

ARTICLE RI-1
GENERAL

RI-100 SCOPE
The inspection and examination of all pressure vessels and vessel parts shall comply with the general requirements set forth in this Article. The special requirements for vessels made by the bag molding, centrifugal casting, filament winding, and contact-molding processes are provided in Articles RI-2, RI-3, RI-4, and RI-5.

RI-101 FABRICATOR’S RESPONSIBILITY
The Fabricator who completes any vessel to be stamped with the Certification Mark (see RS-110) has the responsibility of complying with all the requirements of this Code and, through proper certification, of assuring that any work performed by others also complies with all requirements of this Code including the required inspections by an Authorized Inspector.

RI-110 QUALIFICATION OF INSPECTORS
All references throughout this Section to Inspector mean Authorized Inspector as defined in this paragraph. The inspection required by this Article shall be carried out by an Inspector employed by an ASME accredited Authorized Inspection Agency, as defined in QAI-1. The Inspector shall not be in the employ of the Fabricator.

RI-120 ACCESS FOR INSPECTOR
The Fabricator of the vessel shall arrange for the Inspector to have free access to such parts of all plants as are concerned with the manufacture of materials for the vessel, when so requested. The Inspector shall be permitted free access, at all times while work on the vessel is being performed, to all parts of the Fabricator’s shop that concern the fabrication of the vessel, during the period of assembly and testing of the vessel. The Fabricator shall keep the Inspector informed of the progress of the work and shall notify the Inspector, reasonably in advance, when vessels will be ready for any required tests or inspections.

RI-130 INSPECTOR’S DUTIES
RI-131 INSPECTOR’S DUTY RELATIVE TO QUALIFICATION TESTS OF PROTOTYPE VESSELS
The Inspector shall verify the cyclic pressure tests and witness the hydrostatic qualification pressure tests (see RT-223) of the prototype vessels by means of which the vessel design and the fabrication procedure are qualified.

RI-132 INSPECTOR’S DUTY RELATIVE TO THE FABRICATOR’S DESIGN REPORT
The Inspector shall determine that the Fabricator’s Design Report is on file and shall examine it to verify that:
(a) the vessel conforms to the Design Drawings in all respects;
(b) the materials being used and the fabrication procedures being employed are in strict compliance with the requirements of the Procedure Specification;
(c) the Quality Control Program which was accepted by ASME prior to issuance of the Certificate of Authorization is being followed routinely and that the tests required by it confirm that the Procedure Specification requirements are being met;
(d) the vessel design, as demonstrated by the Test Report for Class I vessels or by Design Calculations and Acceptance Test for Class II vessels, meets the requirements of this Code.