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Basic Hydrotest Procedures

- 1) Inspect internally.
- 2) Clean internal of any grinding or other related dust or debris.
- 3) Install hydrotest blinds/plugs with proper gaskets and bolting.
 - a) Note: If unit is to be shop painted, can install all internals (baskets, etc.) at this time and use shipping gaskets on closure flanges.
 - b) Note: If unit is buttweld, then either weld caps/heads or flanges shall be welded to the buttweld ends to accomplish hydrotest. A complete thickness weld may not be necessary to meet this requirement.
- 4) Set the unit in position for hydrostatic testing, with stands, blocking, and any other necessary supports to assure safety of the unit and the personnel.
- 5) Fill the unit with water.
- 6) Hook up gauges(s), pump and valves as necessary to complete the test.
- 7) Slowly pump the unit up to the desired pressure. Close off the block valve.
- 8) Allow unit to sit under pressure for at least 15 minutes.
- 9) Check all welded joints and all bolted joints for leakage or seepage. If no leakage is found the hydrotest shall be acceptable.
- 10) Slowly open block valve and bleed off water in that part of the hydrotest apparatus and pressure down to zero. Open and drain the unit of all water, through the drain, or a hydrotest flange.
- 11) Remove all hydrotest equipment and blinds/plugs.
 - a) If unit is to be buttweld, cut off any flanges, weld caps/heads that are installed only for hydrotest.