

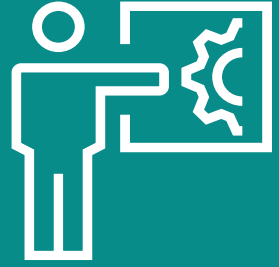
# The 5 stages of an IBR inspection

IBR inspection involves five key stages, all of which are covered by LRQA as Inspecting Authority and by our Competent Persons, both inside and outside India.

LRQA is able to provide a range of services that extend beyond simple certification and inspection. With the expertise at our disposal, we are able to help identify and resolve the most common bottlenecks in IBR certification.

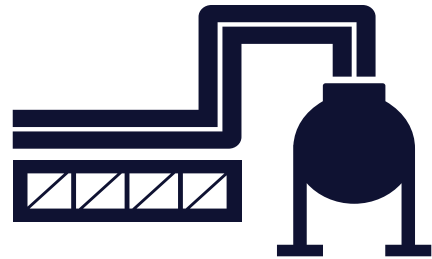
## 1. Design Review

After the manufacturer engages LRQA as Inspecting Authority, we will review and approve all boiler and component calculations and fabrication drawings. Our expert technical teams provide extensive feedback and guidance on the design, calculations and drawings, identifying any possible concerns in relation to IBR certification.



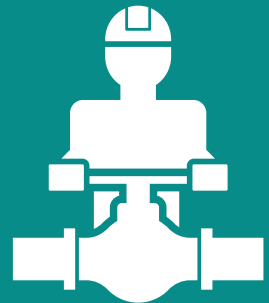
## 2. Material inspection

LRQA will inspect and issue IBR Forms for materials intended for boiler manufacture. This includes plates, pipes, tubes, castings, forgings, and fittings, in addition to electrodes and welding consumables. If an overseas material manufacturer does not have “well-known” status from the CBB, LRQA can be engaged as an Inspecting Authority. The competent person authorized by LRQA for the country will visit the site and inspect the materials at different stages as prescribed in IBR 1950. Following a satisfactory inspection and test, the materials can be certified in the applicable IBR form.



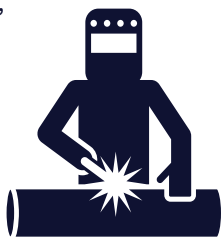
## 3. Stage Testing

LRQA as Inspecting Authority will arrange stage inspections by a Competent Person as per Appendix J of IBR regulation. This inspection will cover fabrication and welding, NDE, heat treatment records, production test coupons testing, pressure testing, and a visual and dimensional examination of the boiler and components. LRQA can provide the inspection services at field site during assembly of a boiler. If satisfied, the Competent Person will issue Inspection Authority certification and endorse manufacturer certification using relevant IBR Forms.



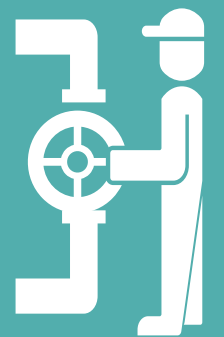
## 4. Welder Certification

As Inspecting Authority, LRQA can also take up the role of Competent Authority for in house certification of welders involved in the erection, fabrication or repair of boilers as per IBR.



## 5. In-service inspection and certificate renewal

LRQA Competent Persons in India can offer value added services for inservice inspection and renewal of certificate for continued operation of boiler.



### Get in touch

Visit [www.lrqa.com/us](http://www.lrqa.com/us) for more information, email [info-usa@lrqa.com](mailto:info-usa@lrqa.com) or call +1 866 971 LRQA



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