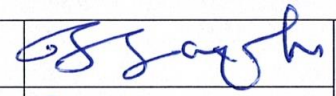
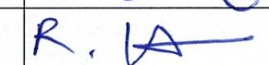
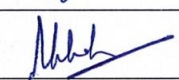
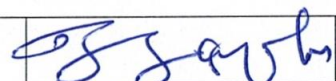


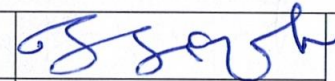
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		ITEM: STRUCTURES SUB SYSTEM: STRUCTURES- COLUMNS (BOX, PLUS & I TYPE) AND BUILT UP BEAMS								QP NO		STR: 751	
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										DATE:		22.11.2018	
								PAGE NO:		Page 1 of 9			
SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY		REMARKS
					M	B				D *	M	B	
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.	11.	
1.0	RAW MATERIALS												
1.1	PLATES & ROLLED SECTIONS	Chem & Mech Properties	A	Verification of Tc	100%	@@	Respective Mateial Specification As Per Drawing & Note-1	TC	√	P	V	Raw materials are taken to stock on verification of TC/ Random testing UT for plates>40mm thk	
		Soundness Of Plates > 40mm	A	UT	100%	@@	As per customer specification	TC	√	P	V		
2.0	QUALIFICATION												
2.1	Welding Control	Procedure Qualification	A	Review of Documents	100%	100%	AWS D 1.1	WPS/ PQR	√	P	W		
		Personnel Qualification	A	Review of Documents	100%	100%	AWS D1.1	WPQ	√	P	W		
2.2	NDE Personnel	Personnel Qualification	A	Review of Documents	100%	100%	SNT- TC- !A, or Equiv	Certifi cates	√	P	V		
3.0	IN PROCESS												
3.1	Cutting, Punching & Drilling	Dimension	C	Visual, Measurement	100%	Rand om	Drawing	Dim. Rec.	√	P	V		

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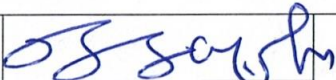
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						M	B					M	B
1.		2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.	11.
3.2	Preheating for Gas cutting	Preheating Temperature	B	Visual	100%	100%		Note 2		✓	P	V	Gas cut edges shall be free from slag and ground smooth
3.3	Gas cut edges	NDE	B	MPI	100%*	10%#	Random	BHE:NDT:RP:MT 01 LATEST	R	✓	P	W	*t≥38mm #20≤t<38mm
3.4	EDGE PREPARATION (SHOP& SITE WELDS)	NDE	B	LPI/ MPI	100%	-		BHE: NDT:RP:PT 01 LATEST BHE:NDT:RP:MT 01 LATEST	R	✓	P	V	
4.0 WELDING													
4.1	Welding consumables*	TC	B	Verification	100%	Batch / Lot		WPS		✓	P	W	*For 450BR
4.2	Fit up	Root gap, Groove angle, Mismatch	B	Visual & Measurement	100%	Random		Drawing / WPS		✓	P	V	
4.3	Welding Control	Preheating, Consumables, Welding	B	Measurement, Verification	100%	Random		WPS, Drawing, Preheating		✓	P	V	
4.4	Visual Welds	Surface quality, Profile	B	Visual	100%	100%		Drawing		✓	P	V	

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					M	B				D *	M	B	
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.		11.
5.0 NDE ON BUTT WELDS													
5.1	After Back gouging	Weld soundness	C	LPI	100%	Random	BHE: NDT:RP:PT01 LATEST	R	✓	P	V		
5.2	Finished welds (Full penetration- Complete Joint penetration Butt welds)- On columns flanges and Web	Weld soundness Plate thk ≥ 32 mm	B	RT/ UT	100%	100%	BHE: NDT:RP: RT01 LATEST BHE: NDT:RP: MT01 LATEST BHE: NDT:RP: PT01 LATEST BHE: NDT:SS: UT31 LATEST Note 9	R	✓	P	W		
		25 ≤ Plate thk < 32 mm		RT/ UT & MPI	10% & 100% for all joints	10% #		R	✓	P	W	# 10% of each joint/ PGMA/ Vendor	
		Plate thk < 25 mm		MT	10%	10%		R	✓	P	W		
5.3	Partial joint penetration/ Complete joint penetration joints other than specified in CL.5.2	To check Edge preparation and Weld penetration	B	Macro-Etch	100%	100%	AWS D1.1 Note 9	R	✓	P	W		
6.0 NDE ON FILLET WELDS													
6.1	Finished Welds	Weld soundness	B	LPI/MPI	100% \$ 10% #	100%	BHE: NDT:RP: MT01 LATEST BHE: NDT:RP: PT01 LATEST	R	✓	P	W	\$- When thk in both plate is 25mm and above #- Other fillet welds	

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					M	B				D *	M	B	
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.		11.
6.2	Lifting hook	Weld soundness	B	MPI	100%	100%	BHE: NDT:RP: MT01 LATEST	R	✓	P	W		
7.0 PRODUCTION TEST COUPONS													
7.1	For Butt welds	Weld soundness	B	RT & Mechanical (Tensile, Bend)	100%@	100%	BHE: NDT:RP: RT01 LATEST Note-9	R	✓	P	W	@- One test plate per PGMA per Work order	
7.2	For Fillet welds	Weld Soundness	B	Macro- Etch	100%	100%	AWS D1.1	R	✓	P	W	Note 9	
8.0 POST WELD HEAT TREATMENT													
8.1	Post weld Heat treatment	Time and Temperature ROH, ROC	B	Verification of HT chart	100%	100%	Note 4	R	✓	P	V		
9.0 END PLATE/ SPLICE JOINT PLATES FOR BOLTED CONNECTIONS													
9.1	Machining/ End milling	Surface Finish, Squareness, Flatness	B	Measurement	100%	Random	Drawing	R	✓	P	V	0.30 feeler gauge max. during assembly. Note 5 & 7	
9.2	Match Drilling	Dimension, Size and Pitch Distance	B	Measurement	100%	Random	Drawing	R	✓	P	W		

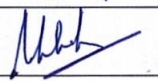
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					M	B				D *	M	B	
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.	11.	
10.0 FINAL INSPECTION													
10.1	Individual Piece	Dimensions, Straightness (Camber & Sweep), Twist, Squareness and Orientation	B	Visual & Measurement	100%	100%	Note-7	R	✓	P	W		
10.2	Marking, Identification of Parts	WO/ DU Number Designation & S/C code	B	Visual	100%	100%	Drawing	R	✓	P	V		
10.3	Trial assembly of columns, beams (including roof girders)	Overall dimensions, Alignment, Elevation, Squareness and Match Marking	A	Visual & Measurement	100%	100%	Trial assembly procedure/ Drawing Note-8	R	✓	P	W		
10.4	Surface preparation & painting	Surface Finish, Shade, Dry Film Thickness	B	Visual & Measurement	100%	Random	Approved Painting Scheme	R	✓	P	W		
10.5	Verification of completion	Overall dimensions, Compilations, Marking, Stenciling, Punching & Dispatch clearance	B	Verification	100%	100%	All documents identified as 'R' in the D column			P	V		

NOTES:

1)

MATERIAL	SPECIFICATION	TDC No.
Plates and Rolled Section	ASTM A36, IS 2062/ E250A, E250 BR, E350BR, E350B0, E350C. E450BR	Refer to TDCs for specific projects
Separate colour code to be maintained for BHEL material with separate storage area		

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					M	B				D *	M	B			
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.	11.			

2) Pre heating for Gas cutting

MATERIAL	THICKNESS	PRE HEAT TEMPERATURE (MIN)
E350C	>50mm	100°C
E450BR	>25mm	150°C

3) Preheating before welding (Unless specified otherwise in the WPS)

MATERIAL	WALL THICKNESS	PRE HEATING TEMPERATURE
E350C	< 20 mm	NIL
	>20 mm	150°C
E450BR	All thickness	220°C

4) Post heating after welding: (Unless specified otherwise in the WPS)

MATERIAL	WALL THICKNESS	PRE HEATING TEMPERATURE
E350C	< 20 mm	NIL
	>20 mm	150°C
E450BR	All thickness	220°C- 250°C

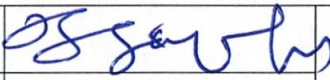
5) Post weld heat treatment (Stress relieving) shall be performed for:

a. All welds when t>50mm- Applicable for E250BR, E350C

b. All welds when t>35mm- Applicable for E450BR

Where t= plate thickness in case of butt welds and weld thickness in case of groove/ fillet welds.

The actual PWHT requirements shall be as per the BHEL approved WPS.

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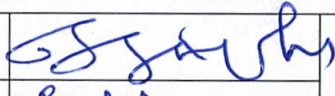
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					M	B				D *	M	B	
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.		11.

6) The machined/ bolted surface shall be applied with rust preventive oil coating and the painting of that surface shall not be done. All the machined and bolted surfaces should be suitably masked to avoid handling damages.

7) Tolerance:

Table 1: Individual columns/ Girders/ Box beams

SL NO	STRUCTURAL PARTS/ PARAMETERS	TOLERANCE IN mm		
01	Section Depth/ Width upto and including 1.0 metre	+3 / -2 (± 1 at the joints)		
02	Section Depth/ Width over 1.0 metre	+3 / -2 (± 2 at the joints)		
03	Web shift	± 2		
SL NO	STRUCTURAL PARTS/ PARAMETERS	TOLERANCE IN mm		
04	Tolerance depending on length dimensions of structural items	Length dimensions in mm		
		≤ 6000	Above 6000 ≤ 12000	> 12000
a.	Columns	± 1	± 2	± 2
b.	Built up beams	+0/ -2	+0/ -3	+0/ -4
c.	Diagonal Bracings	+0/ -2	+0/ -2	+0/ -4
05	Bow in column base plate	1mm per metre of diagonal or 3mm whichever is greater		
06	Camber			
a.	Column/ Girder/ Built up beam	± L/2000 = 0.50mm/m where 'L' is overall length of Column/ Beam subject to maximum of 5mm.		

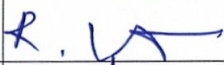
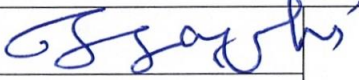
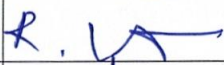
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					M	B					M	B		
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.	11.		

07	Sweep											
a.	Column/ Girder/ Built up beam							$\pm L/2000 = 0.50\text{mm/m}$ where 'L' is overall length of Column/ Beam subject to maximum of 5mm.				
08	Twist							$\pm a/3000 = \pm 0.33\text{mm/m}$, where 'a' is depth of member				
09	Combined warpage							W/100 or 3mm whichever is greater where 'W' is the width of flange other than joint area				
10	Drilled Holes for Bolts											
a.	Hole dimension							+0.6/-0 for others, +0.16/-0 for fit bolts of TMG (Reaming required)				
b.	Pitch distance of holes and distance between rows of holes							± 1				

Table 2: Fabrication Tolerances- Individual Beams & Bracings- Rolled Sections

SL NO	STRUCTURAL PARTS/ PARAMETERS	TOLERANCE IN mm
01	Length	
a.	For members where ends are free	$\pm 1\text{mm/m}$ subject to 5mm max
b.	For members connecting between two structural members	+0/ -3
SL NO	STRUCTURAL PARTS/ PARAMETERS	TOLERANCE IN mm
02	Deviation in straightness	
a.	Sweep	1mm/m upto 15m subject to max of 10mm and for length over 15m: 10mm+1mm/m for the length in excess of 15m
b.	Camber	5mm max.
03	Twist	$\pm 1\text{mm/ metre}$ or 6mm whichever is greater, where 'h' is depth of member
04	Drilled holes for Bolts	

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					M	B					M	B			
1.	2.	3.	4.	5.	6.		7.	8.	9.	D *	** 10.	11.			
	a.	Hole dimension						+0.6, -0							
	b.	Pitch distance of holes and distance between rows of holes						± 1							

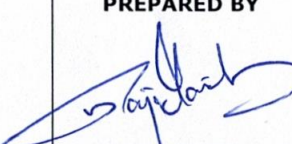
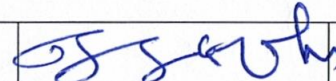
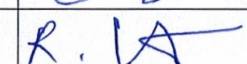
8) TRIAL ASSEMBLY

8.1 Trial assembly shall be performed by butting of ends (contact joints) without providing any gap. Variation in gap shall not be more than 0.30mm for 80% of nominal contact area. Ensured by feeler gauge.

8.2 Alignment of center line of all the pieces of flanges and webs water level deviation shall be within 2mm.

8.3 As per Trial Assembly procedure applicable PRQA:766

9) BHEL/ BHEL'S AIA to necessarily ensure the results recorded in DR for the clause nos: 5.2, 5.3, 7.1& 7.2 before issuing IR.

PREPARED BY  RAJAMANICKAM.M DY.MGR/ QA	REVIEWED BY	QC-SHOPS		APPROVED BY  K.C. GANDHI PARIMALAM DGM/ QA	LEGEND: * RECORDS , IDENTIFIED WITH "TICK" (✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. ** M: MANUFACTURER/SUB-SUPPLIER B: BHEL/ BHEL AUTHORIZED INSPECTION AGENCY P: PERFORM W: WITNESS AND V: VERIFICATION. AS APPROPRIATE, TC – TEST CERTIFICATE, R – REPORT, A- CRITICAL, B- MAJOR, C- MINOR
		QC-OLI			
		ENGG	