



QUALITY
MANAGEMENT

STANDARD QUALITY PLAN

FOR GATE VALVES UPTO WEDGE MATCHING

QP NO. : SQP-IVP-01 REV.:00
Date : 30/10/2008
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IVP, GOINDWAL

S. NO.	Component/ Operations	Characteristics	Check		Reference Doc. / Acceptance Norms	Format of Record	AGENCY			REMARKS
			Cl	Type			M	S	C	
1.0	Machining of components Body, Wedge, Seat Ring	Dimensions	A	Measurement	100%	Drawings, QCP-003	R	P	W	Note-2
1.1	Welding	Procedure qualification Welder qualification	A	Review of document	100%	ASME Sec. IX, IBR	WPS WQR	P	V	
1.2	Weld Inspection Body, Wedge, Seat Ring	Hard faced surface soundness	B	LPI	100%	BHE:NDT:VV:PT:02	R	P	V	(Body, Wedge, Seat ring)
1.3	PWHT of welded/Hard faced components	Time & temp. control	B	Review of HT Charts / Log book	100%	WPS, QCP 003	R	P	V	
1.4	Heat treated hard faced components	Hardness	B	Measurement	1 Sample per lot	SIP:VS:04/Drawing	R	P	W	On sample piece per heat treatment batch
1.5	End Machining	Overall dimension, ID, OD EP style EP surface finish NDE	A B B	Measurement Visual LPI	100%	Drawing BHE:NDT:VV:PT:02	R R R	P P P	W W W	100% LPI at IVP Goindwal Sanib

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30/10/08

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			cl	Type	Quantum		Record	M	S	C	REMARKS	
1.6	Blue Matching	Proper impression	A	Visual	100%	SIP:VS:21 Impression as per Annexure I	R	P	W			
1.7	Preservation of machined surfaces	Surface protection	B	Visual	100%	SIP:PP:22	R	P	V			
<p>LEGEND: C: Class (A: Critical, B: Major, C: Minor) ** TPI: Third Party Inspection V: Verification of test/Dimension/Insp. Reports R: Test / Dimensional / Inspection Reports M: Sub-Contractor, C: Customer P: Perform, W: Witness, V: Verification S: BHEL/ Nominated Inspection Agency</p>												
<p>Prepared by <i>Sumeet</i> <i>30/10/08</i> <i>(SAHEET BANSAL)</i> <i>Engineer - Quality</i></p>												
<p>Approved by <i>[Signature]</i> <i>30/10/08</i> <i>(R.K. PAUL)</i> <i>MANAGER-QM</i></p>												

NOTES

NOTE: 1

Wherever special contract requirements are envisaged a separate TDC/CQP may be issued, special instructions may be provided through P.O or stock material may be upgraded to special requirement.

NOTE: 2 The following dimensions of valves components shall be verified by task performer

SL NO.	Characteristic
1	a. Body Gasket locating bore dimension & depth b. Seat gap & L/2 with respect to guide center for all gate valves. c. End dimension, (Flange thickness, Hole dia, PCD, RF, finish, overall length) BW ends ID d. Top Flange distance from body center. e. Perpendicularity of seat thread w.r.t seat face & top flange face. f. Four hole tapping concentricity with respect to gasket locating bore. g. Seat angle & finish h. Butt weld edge ID/OD concentricity w/r.t seat bore
2	a. Top thickness b. L/2 distance with respect to guide slot.
3	Seat angle & finish, ID & OD

NOTE: 3 - Butt weld end of bodies to be protected suitably.