



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

QUALITY ASSURANCE PLAN FOR ROTOR BAR TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. – QAP/QTM/VENDOR QAP/2021-22/ ROTOR BAR DTD REV 03 DTD 15.11.2022
Reference Document- PO DRAWING/SPECIFICATION

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SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFEREN CE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TPIA					
1)	Raw material	a) Chemical properties b) Specific gravity (for reference) c) Oxygen content	TC verification	100% (VR)	100% (VR)	As per specification	As per specification	MTC	BHEL/TPIA	SOURCES MENTIONED IN SPECIFICATION. RAW MATERIAL TC to be co-related to finished material and to be verified by TP/A
2)	Dimension	Dimension	Measurement	20%	5% (w)	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TPIA	100 % TC verified by TP/A and 20 % TC Witnessed by TP/A to be submitted
3)	Visual check	Free from any piping, crow feet, indentations, foreign particles or inclusion, surface defect. Twists & entanglements	Visual	100%	5% (w)	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TPIA	

Prepared By

Amul Kumar Sen.
Eugene / 10/10/2022

Approved By: *H.G.S. Rathore*
Manager
Quality Control Division
BHEL, Bhopal



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4)	Testing on finished bar	Chemical properties a) Cu + Ag b) ZR c) oxygen content	Testing	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPIA	NABL LAB tested TC to be verified and co-related by TPIA and submitted to BHEL
		Mechanical properties a) Tensile strength b) Elongation c) Hardness	Testing	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPIA	NABL LAB tested TC to be verified and co-related by TPIA and submitted to BHEL
		Electrical properties a) Electrical Conductivity	Testing	One sample per lot at NABL LAB & 100 % by supplier	100 % RR & 1% witness	As per specification	As per specification	Supplier record	BHEL/TPIA	NABL LAB tested TC to be verified and co-related by TPIA and submitted to BHEL
		NDT testing: 2) ultrasonic testing/Eddy current testing	Testing	10 % per lot at NABL lab OR government approved LEVEL II operator at vendor works	1% witness	As per specification	As per specification	Supplier record	BHEL/TPIA	NABL LAB tested TC to be verified and co-related by TPIA and submitted to BHEL

Prepared By

Amit Kumar Sen.
Engineer / QAP

Approved By

G. S. Rathore
Manager / QTM Division
BHEL, Bhopal



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4)	Identification vendor name, PO & job serial no., Hardware fitment	Visual	Visual	100%	10% witness	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TPJA	Witness
5)	Packing to avoid transit damage	Visual	Visual	100%	20%	As per drawing & specification	As per drawing & specification	Packing list for each kit box	BHEL/TPJA	Packing to be such that no damages should occur during transit. 1 kit items should be placed in on 1 box

Prepared By

Approved By

Anand Kumar Sen
 Engineer / QAP
 2022

G. S. Rathore
 Manager
 QTM Division
 BHEL, BHOPAL