



# BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

## QUALITY PLAN FOR –RETAINING RING TO SPEC. BP19381

QUALITY PLAN NO. QA/MT/BOI/099 REV 01

DATE: 02/04/2021

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### ABBREVIATION:

<b>V</b>	Visual,
<b>M</b>	Measurement
<b>T</b>	Testing
<b>PV</b>	Process Verification

SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANT AM OF CHECK	REFERENCE DOCUMENT	ACCEPTANC E NORMS	FORMA T OF RECORD	REMARKS
1.0		<b>Chemical Analysis</b>	T	Sample/ melt	BP19381	BP19381	TC	Record Review
2.0		<b>Heat Treatment</b>	PV	100%	BP19381	BP19381	Temp. chart	Record Review
3.0		<b>Mechanical properties</b> -Tensile Strength -Impact Value (0.2% Proof Stress, % elongation, % Reduction in Area, Charpy Impact	T	Sample/h eat/heat treatment batch	BP19381	BP19381	TC	Record Review Record Review
4.0		<b>Surface Finish</b> Free from cracks, flakes, seams, segregation, harmful non-metallic inclusion	V	100%	BP19381	BP19381	TC	Record Review
5.0		<b>UT</b>	T	100%	AA0850118	Cat-I-AA0850118/BP 19381	TR	Record Review
6.0		<b>LP</b>	T	100%	BP19381	BP19381	TR	Record Review
7.0		<b>Dimensional inspection</b>	M	100%	Drg./spec/PO	Drg./spec/PO	IR	Record Review




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8.0		<b>Packing &amp; Marking</b>  <b>Machined surface protection by Anti corrosive compound</b>  <b>Marking - Drg.no (on inner surface), supplier name, batch, weight &amp; PO no.</b>	V	100%	Drg./spec/PO	Drg./spec/PO	TC	Record Review
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