



**BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL**  
**QUALITY PLAN FOR –RETAINING RING TO SPEC. BP19381**

QUALITY PLAN NO. QA/MT/BOI/099 REV 00

DATE: 03/12/2020

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**ABBREVIATION:**

Traceability with NABL/OEM shall be verified by inspection agency for the equipment/ instrument used for conducting the test and shall be reported in the TCs.	
<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	INSPECTI ON AGENCY	REMARKS
1.0		<b>Chemical Analysis</b>	T	Sample/ melt	BP19381	BP19381	TC	BHEL	Witness
2.0		<b>Heat Treatment</b>	PV	100%	BP19381	BP19381	Temp. chart	BHEL	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	BHEL	Witness
4.0		<b>Surface Finish</b> Free from cracks, flakes, seams, segregation, harmful non-metallic inclusion	V	100%	BP19381	BP19381	TC	BHEL	Witness
5.0		<b>UT</b>	T	100%	AA0850118	Cat-I- AA0850118/BP 19381	TR	BHEL	Witness



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6.0		LP	T	100%	BP19381	BP19381	TR	BHEL	Witness
7.0		Dimensional inspection	M	100%	Drg./spec/PO	Drg./spec/PO	IR	BHEL	Witness
8.0		Packing & Marking	V	100%	Drg./spec/PO	Drg./spec/PO	TC	BHEL	Witness
		Machined surface protection by Anti corrosive compound							
		Marking - Drg.no (on inner surface), supplier name, batch, weight & PO no.							
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