

ARAT HEAVY ELECTRICALS LIMITED, BHOJAL
QUALITY CONTROL TRANSPORTATION
QUALITY ASSURANCE PLAN (QAP)

QA Plan for Steel Bar H&T to BP10590
QAP No : QTM/QAP/VENDOR/21-22/09 REV.00 Dt:12.01.2022

Sl. No.	Name of the process	Parameters for inspection	Quantum of Check*		Mode of inspection/ equipment used	Drawing No./Spec./ Std.	Acceptance norms***	Requirement from supplier (See note 1)
			TP/Supplier	TP/AQC**				
1	Melt analysis	Chemical Composition	One sample/ heat / Lot	100% TC Verification	Spectrometer / Wet analysis method	As per BHEL drawing/ specification	As per BHEL drawing/ specification	a) TC (as per specification) to be supplied in supplier's format with all parameters (specification format) from NABL accredited Lab. b) Three shafts with diameter length per heat / per heat to be marked on be punched marked on extended portion by supplier. Same to be correlated by TPA (for heat & heat) to be marked on extended portion by supplier. Supplier reports, provided against clause 1(a). Extended portion of 3 nos. shaft per heat per heat treatment batch (correlated with TPA) to be marked by TPA before parting from shaft. Extended portion of shaft (Duty seal marked by TPA) to be supplied along with commitment.
2	Mechanical Testing	Mechanical properties mentioned in the BHEL specification/ drawing	One sample/ Heat treatment batch / Lot	100% TC Verification	Mechanical testing equipment	As per BHEL drawing/ specification	As per BHEL drawing/ specification	

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Notes:

- 1) All test records checked by TP, TP/IA/QC (duly signed & sealed) as per above QAP requirement shall be submitted along with consignment.
- 2) Final acceptance will be based on inspection at BHEL, Bhopal.
- 3) (*) Quantum of inspection shall be in line with QAP unless otherwise mentioned in the drawing.
- 4) (**) Job shall be randomly selected from offered lot, the quantum of check (min. 1 no.) from the offered lot to be checked by TP/IA or QC (e.g. if lot size is 2 then minimum one no. is to be checked).
- 5) (***) Sample inspection of component does not mean that the supplier will not meet drawing & specification requirements in remaining components. In case any defect / non-conformance is observed at any stage (during processing or before and after filament in any job), the same is liable to be rejected and same shall be replaced immediately by the supplier at BHEL or BHEL Customer site (wherever deficiency is observed) and necessary practical action will be taken as per BHEL norms.

Meaning of Legends: '+' - Supplier to submit test certificates & reports of above mentioned parameters.

Abbreviation: TPIA –BHEL appointed third Party Inspecting Agency, T P – Task Performer (vendor), QC-QIX.

Prepared by:

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