


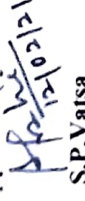


| <div>Condenser and Heat Exchanger Engineering BHEL Bhopal</div> | | QUALITY ASSURANCE PLAN | | | | Doc. No. CDE-20-3483 | | | | |
|---|------------------------------------|---|-------|---------------|------------------|---|------------------------------|---|--------|--|
| ITEM | | | | | | Revision 03 | | | | |
| | | | | | | Date 12.02.2021 | | | | |
| | | | | | | Page 1 of 1 | | | | |
| S.No. | Components & Operations | Characteristics | Class | Type of Check | Quantum of check | Reference Document | Acceptance Norms | Format of Records | Agency | Remarks |
| | | | | | | | | | | |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 |
| 1.0 FINISHED PRODUCT INSPECTION | | | | | | | | | | |
| 1.1 | Mechanical and chemical properties | Chemical composition (Ladle Analysis) | Major | Record Review | 1 no. per lot | IS-1285-(2002) Gr.-63400, T4 | IS-1285 (2002) Gr.-63400, T4 | MTC & TCR | P R | - |
| | | Mechanical Properties | Major | Record Review | 1 no. per lot | IS-1285 (2002) Gr.-63400, T4 | IS-1285 (2002) Gr.-63400, T4 | MTC & TCR | P R | - |
| 1.2 | Dimensional check | Dimensions as per indent (OD x Thickness, Length) | Major | Visual + I | 100% | As per indent | As per indent | IR | P W * | *10% at random (Selected by IA) subject to min.-50 nos. and max. - 500 nos., of each size witnessed by IA. |
| 1.3 | Visual check | Corners to be free from burrs | Major | Visual | 100% | - | No cutting burrs | IR | P W | - |
| 1.3 | Packing & Dispatch | To be packed in sturdy wooden / cardboard box to avoid damage during transit and storage. | --- | Visual | 100% | -- | -- | IR | P | - |
| LEGEND : 1: Tube Supplier, 2: Inspection Agency, 3: Customer / Customer's IA; P-Perform, W-Witness, R-Review MTC: Mill test Certificates, TCR: Test Certificate Report, IR: Inspection report, IA: Inspection Agency, I: Instrument to be used for check, HP: Hold point. | | | | | | | | | | |
| Note: 1. All mechanical & chemical testing to be done in-house by NABL calibrated instrument or by NABL approved lab. 2. All IR/ MTC & TCR duly verified/Witnessed by IA to be provided with dispatch. | | | | | | | | | | |
| Approval does not relieve supplier from meeting contract requirements as per the drawing / Tech. specification. | | | | | | | | | | |
| Prepared by :  Arun Kumar Singh (Dy. Mgr.- CDE) | | | | | | Reviewed by :  Lalit Asnani (DGM - CDE) | | Approved by :  S.P. Vatsa (AGM-CDE) | | |