

STANDARD QUALITY PLAN

QAP NO:		QAP/TSD/FMS/10721	REV.01	Date: 31/05/2018						
CUSTOMER:		BHEL BHOPAL								
DESCRIPTION		VENDOR NAME:								
MATERIALS:		STAINLESS STEEL BARS (MARTENSITIC) Gr:X20Cr13 -H&T								
SPECIFICATION		AA10721								
P.I./ENQ.NO./P.O. NO.		Rev. No. 07								
		Date:								
Sr. No.	Characteristics	Class	Quantum of check	Reference Document	Acceptance Norm	Type of record	Inspection Agency			Remarks
							P	W	V	
01	Chemical composition	Maj	Each Heat	AA 10721	As per spec	TC	2	1	-	
02	Visual Examination	Maj	100% of each lot/Heat	AA 10721	Free From Internal surface defect bars & shall be free from twists and bends	TC	2	1	-	10% Witness by TPIA
03	Dimensional Inspection	Maj	10% of each lot/Heat	AA 10721	As per Spec	TC	2	1	-	Random Sample to be Witness by TPIA
04	Heat Treatment	Maj	100% of each lot/Heat	AA 10721	As per spec	TC	2	-	1	HT Charts review per batch each melt
05	Identification of test sample	Maj	10% of each lot/Heat	AA 10721	As per spec	TC	2	1	-	As per Sample Requirement
06	Micro Structure	Maj	10% of each lot/Heat	AA 10721	ASM Handbook Vol. 9-2004	TC	2	1	-	Random Sample to be Witness by TPIA
07	Mechanical properties (Tensile strength, Yield, Elongation hardness & Charpy Impact etc.)	Maj	Each Heat	AA 10721	As per spec	TC	2	1	-	Random Sample to be Witness by TPIA
08	Ultrasonic Test	Maj	100% of Bars	AA 19358	As per spec	TC	2	1	-	Test to be performed on above 100 mm dia.
09	Stamping & Marking	Maj	100% of Bars	AA 10721	As per spec	TC	2	-	1	
10	Documentation: TC & Inspection Report	Maj	Verification	AA10721	As per spec	TC	2	-	1	TC & Reports Endorsed by TPIA

Legends: Maj = Major, V= Verification, P=Perform, W=Witness, 1=BHEL/BHEL appointed TPIA, 2= Vendor/Sub-Vendor

Prepared By

Approved By

जी. एस. नेताम / G.S. NETAM
उप प्रबंधक (वि.से.) / Dy. Manager (T.S.)
तकनीकी सेवा विभाग / Tech. Services Deptt.
श्री. एच.ई.एल., भोपाल / BHEL, BHOPAL