
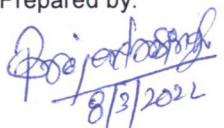

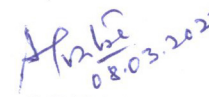



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 <div>Heat Exchanger Group BHEL BHOPAL</div>		STANDARD QUALITY PLAN - SQP						QA PLAN No. : CDE-22-3528 Revision No. : 00 Date of issue : 08.03.2022 PAGE : 1 of 2					
		Item : STAINLESS STEEL PLATE											
S. No.	Operations	Characteristics	Class	Type of Check	Quantum-of Check	Reference Document	Acceptance Norms	Format of Record	*D	Agency for action			Remarks
										S	B	C	
1	2	3	4	5	6	7	8	9	10			11	
1	STAINLESS STEEL PLATE	Chemical composition	Major	Chemical	1/Heat	ASTM standard	ASTM A240 TP304 or S41500 as applicable	MILL TC / NABL.ACCR.LA B.TC & IR	✓	P	W*	V	* Co-related mill TC to be furnished, if not then the material is to be tested in NABL ACCR. Lab & mechanical tests are to be witnessed by BHEL TPIA.
		Mechanical Properties	Major	Mechanical	1/Heat	ASTM standard	ASTM A240 TP304 or S41500 as applicable	MILL TC / NABL.ACCR.LA B.TC & IR	✓	P	W*	V	
		Ultrasonic test (UT) (For thickness 12 mm and over)	Major	Mechanical	100%	ASTM standard	ASTM A578 (Acceptance Std. level is LEVEL-B)	MILL TC / TC & IR	✓	P	W*	V	* Co-related mill TC to be furnished, if not then the material is to be Ultrasonically tested as per ASTM std. Test is to be witnessed by BHEL TPIA. Also Ref. note-5.
		Charpy V-notch impact test on longitudinal specimen at (-) 20 deg. C. (For ASTM A240 S41500 only)	Major	Mechanical	1/Heat	ASTM standard	ASTM A480	MILL TC / NABL.ACCR.LA B.TC & IR	✓	P	W*	V	* Co-related mill TC to be furnished, if not then the material is to be impact tested in NABL ACCR. Lab and same to be witnessed by the inspector appointed by BHEL TPIA.
		Bend Test (For ASTM A240 S41500 only)	Major	Mechanical	1/Heat	ASTM standard	ASTM A480	MILL TC / NABL.ACCR.LA B.TC & IR	✓	P	W*	V	* Co-related mill TC to be furnished, if not then the material is to be bend tested in NABL ACCR. Lab and same to be witnessed by the inspector appointed by BHEL TPIA.

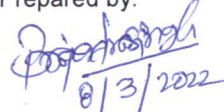
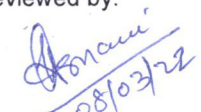
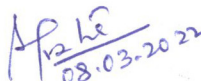
BHEL Drg No. : As mentioned in P.O.	BHEL Spec. No.: As mentioned in P.O.	Prepared by:  8/3/2022 Brajendra Yadav Dy. Manager - CDE	Reviewed by:  08/03/2022 Lalit Asnani Sr. DGM(Design) - CDE	Approved by:  08.03.2022 S P Vatsa AGM - CDE
Legend: *D- Documents marked (✓) to be included by Supplier in Doc. Package. S - Trader / Manufacturer P - Perform IR : Inspection Record B - BHEL TPIA W - Witness Measurt.: Measurement C - Customer (if any) V - Verify I - Instrument used to check TC - Test Certificate				

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 Heat Exchanger Group BHEL BHOPAL		STANDARD QUALITY PLAN - SQP						QA PLAN No. : CDE-22-3528 Revision No. : 00 Date of issue : 08.03.2022 PAGE : 2 of 2					
		Item : STAINLESS STEEL PLATE											
S. No.	Operations	Characteristics	Class	Type of Check	Quantum of Check	Reference Document	Acceptance Norms	Format of Record	*D	Agency for action			Remarks
										S	B	C	
1	2	3	4	5	6	7	8	9	10			11	
		Dimensional check (Measurt. of Thickness, Length, Width & Flatness)	Critical	I + Visual	100%	Annexure-A to PI-241111093	Annexure-A to PI-241111093	IR	✓	P	W	V	
		Condition, Surface check, appearance	Critical	Visual	100%	ASTM standard	As per Clause 10 & 13.1.2 of ASTM A480	TC / IR	✓	P	W	V	
		Packing & Marking	Critical	Visual	100%	ASTM standard	ASTM A480	IR	✓	P	V	V	

Notes:

1. All testing shall be carried out at NABL/BHEL approved laboratories only.
2. Two (02) sets of all the above documents (i.e. MTC, TC & Inspection Record - IR) duly signed and stamped by the BHEL-IA shall be provided along with the supply.
3. Sharp edges/burrs if any to be removed.
4. Repair of plates by welding (for any surface defects) is not permitted.
5. UT to be carried out by ISNT / ASNT NDT Level-I person under the supervision by Level-II/III person only.

BHEL Drg No. : As mentioned in P.O.	BHEL Spec. No.: As mentioned in P.O.	Prepared by:  08/03/2022 Brajendra Yadav Dy. Manager - CDE	Reviewed by:  08/03/2022 Lalit Asnani Sr. DGM(Design) - CDE	Approved by:  08.03.2022 S P Vatsa AGM - CDE
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