



# **BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL**

## **QUALITY ASSURANCE PLAN FOR RESISTANCE RING TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO**

QUALITY PLAN NO. - QAP/QTM/VENDOR QAP/2021-22/ RESISTANCE RING DTD 07.09.2021 REV 01 DTD 12/03/2021  
 Reference Document- PO DRAWING/SPECIFICATION

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SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTITY OF CHECK		REFEREN-CE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TP/A					
1)	Raw material	a) Chemical properties b) Specific gravity c) Temper condition d) Oxygen content	TC verification	100% (VR)	100% (VR)	As per specification	As per specification	MTC	BHEL/TP/A	SOURCES MENTIONED IN SPECIFICATION RAW MATERIAL TC to be co-related to finished material and to be verified by TP/A
2)	Dimension	Dimension	Measurement	100%	20% (w)	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	100 % TC verified by TP/A and 20 % TC Witnessed by TP/A to be submitted
3)	Visual check	Free from any piping, crow feet, indentations, foreign particles or inclusion, surface defect, twists & entanglements	Visual	100%	5% (w)	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TP/A	

Prepared By

*(Signature)*

Approved By

*(Signature)*

741493/2022/HEP-TAM21300



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4)	Testing on finished bar	Testing	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPA	NABL LAB tested TC to be verified and co-related by TPA and submitted to BHEL
		Chemical properties a) Cu + Ag <sup>-</sup> b) Zr c) oxygen content	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPA	NABL LAB tested TC to be verified and co-related by TPA and submitted to BHEL
		Mechanical properties a) Tensile strength b) Yield strength c) Elongation d) Hardness	one sample per lot At NABL lab	RR	As per specification	As per specification	Supplier record	BHEL/TPA	NABL LAB tested TC to be verified and co-related by TPA and submitted to BHEL
		Electrical properties a) Electrical Conductivity	One sample per lot at NABL LAB & 100 % by supplier	100 % RR & 1% witness	As per specification	As per specification	Supplier record	BHEL/TPA	NABL LAB tested TC to be verified and co-related by TPA and submitted to BHEL
		5)DT testing 2) ultrasonic testing/Eddy current testing	10 % per lot at NABL lab OR Government approved LEVEL II operator at vendor works	1% witness	As per specification	As per specification	Supplier record	BHEL/TPA	NABL LAB tested TC to be verified and co-related by TPA and submitted to BHEL

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	Visual	Visual	100%	10% witness	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TPJA	Witness
4) Identification vendor name, PO & job serial no. Hardware fitment	Visual	Visual	100%	10%	As per drawing & specification	As per drawing & specification	Supplier record	BHEL/TPJA	Packing to be such that no damages should occur during transit. 1 kit items should be placed in on 1 box
5) Packing to avoid transit damage	Visual	Visual	100%	20%	As per drawing & specification	As per drawing & specification	Packing list for each kit box	BHEL/TPJA	

Approved By

Prepared By