
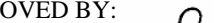
		BHEL HYDERABAD-32		STANDARD QUALITY PLAN					QP No. : HY/ HE/ 009/ HH				
				ITEM: 500MW H.P.HEATER (U TUBE TYPE) HEMI HEAD					Rev. No.: 01 DATE : 12.08.2003 PAGE : 1 OF 1				
SL NO	COMPONENTS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	* D	S	AGENCY M C		REMARKS
1.0	AT SUPPLIERS WORKS												
1.1	Hemihead	Verification of mill TC for identification marks, Chem. & Mech. Properties	Critical	Visual	100%	SA 516 Gr.70	SA 516 Gr.70	Mfgr. TC	✓		P	V	Note 1
1.2		UT exam. after forming	Major	NDE	100%	SA 435	SA 435	Suppliers TC	✓		P	W	
1.3		MT on outer surface after forming	Major	NDE	100%	ASME Sec.V Art.7	ASME Sec.VIII Div.I, Appx.6	Suppliers TC	✓		P	W	
1.4		Verification of HT Chart after normalising	Major	Review	100%	SA 516 Gr.70	SA 516 Gr.70	HT Chart	✓		P	V	
1.5		Mech. properties on test coupon	Major	Mech.	As per spn.	SA 516 Gr.70	SA 516 Gr.70	Suppliers TC	✓		P	W	
1.6		Dim. Conformity including thickness measurt. & ovality by UT method.	Major	Measurt.	100%	Drg.	Drg. & ASME Sec.VIII Div.I	Suppliers TC	✓		P	W	
1.7		Verification of TCs, identification of material & test coupon for completion as per Specn. & QP	Major	Visual	100%	Drg. & QP	Drg. & QP	Suppliers TC	✓		P	V	
1.8		Preservation, packing & identification of forging	Major	Visual	100%	P.O., Drg. & Spn.	P.O., Drg. & Spn.	Suppliers TC	✓		P	V	
2.0	AT BHEL												
2.1		Verification & Correlation of material with TC	Major	Visual	100%	P.O., Drg. & Spn.	P.O., Drg. & Spn.	Inspn. Record	✓			P	

Note :

1) With Supplementary requirements S1, S5, & S8.

2) Project specific requirements, if any as per P.O., shall also be complied with.

BHEL Drg No. : As per P.O.		BHEL Spec. No.: SA 516 Gr.70		PREPARED BY:		APPROVED BY:	
Legend: * D- Documents marked (✓) to be included by Supplier in Documentation Package. S - Sub Vendor M -Vendor / Manufacturer C - BHEL / Inspection Agency (For NTPC projects, Inspection Agency shall be LRS.) P - Perform W - Witness V - Verify				 CH.SRINIVASULU SR.MANAGER/ QA		 M.S.S.RAO DGM/ QA	