

EIL COMMENTS ON SITE QAP

- The category of checking pertaining to BHEL shall be mentioned as "WITNESS".
- The radiography of 180 degree bend after installation as per specification no. 6-17-0003 R5 shall be incorporated.

4.3.8 Radiography of the bottom return bends of the erected radiant coils to detect the presence of any foreign material. In case, any foreign material is detected the return bend to be cut to remove the foreign material and re-welded / inspected / tested.

- The test of filler and electrode as per specification no. 6-17-0003 R5 shall be incorporated.
- Approval of brand of electrode shall be incorporated

3.4 Filler Wire and Electrode Material

3.4.1 Filler metal shall conform to the requirements of ASME Section – II



**STANDARD SPECIFICATION OF
COIL WORK FOR FIRED
HEATERS**

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Preheat the tube around bridging pieces location to approximately 25°C higher than as specified in Appendix – III. Weld bridging pieces using weaving technique with a thin electrode. Wrap the completed joint with insulating blanket and allow gradual cooling. There is no need for PWHT, radiography and hardness check.

- 3.7.7 Brand of electrodes is subject to the approval of the EIC.
 - [SL.NO.](#) 1.5 of the Site activity Quality Plan - The check on sample basis shall be on "Batch wise" instead of "sample wise" and the same to be reviewed by TPI.
 - If skin thermocouple is to be welded at site, then the same shall be incorporated separately in the quality plan in witness category.
 - SL.no 2.3 of the Site activity quality plan - The category for TPI shall be "Hold point"
 - [SL.NO](#) 2.4 of the Site activity quality plan - The category for TPI shall be "Witness"
 - [SL.NO](#) 2.7 of the Site activity quality plan - The category for TPI shall be "Witness". The component shall be specified as PMI including field welds.
 - [SL.NO](#) 3.4 of the Site activity quality plan - The category for TPI shall be "Witness"
 - [SL.NO](#) 3.7 of the Site activity quality plan - The category for TPI shall be "Witness"
 - [SL.NO](#) 3.7 of the Site activity quality plan - The quantum of review of RT films shall be 100%.
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- Site supervision of OEM vendors as per B378-101-80-44-SP-2002 for erection and certification for correct installation shall be incorporated.

2.10.3 Contractor's quoted Lumpsum price to include arranging mandatory site supervision of erection, certification for correct installation for APH, FD/ID Fans, Burners, Dampers/SOBs, Skin TCs and Soot Blowers by the respective OEMs (Original equipment Manufacturers).

- Methodology for procurement of structural steel materials as per Annexure X1 of SCC to be incorporated in the QAP.
- Quality control, Inspection and testing (including sample test at lab) for surface preparation, primer and final paint as per clause no. 14.0 of Job spec B378-000-02-42-PCS-0001 R2 attached in the tender to be incorporated in the QAP.
- Qualification and acceptance criteria for Paint material shall be ensured as per clause no 17 of Job spec B378-000-02-42-PCS-0001 R2 attached in the tender needs to be incorporated in the QAP.