



BHARAT HEAVY ELECTRICALS LIMITED – BHOPAL


QUALITY ASSURANCE – HYDRO


QUALITY ASSURANCE PLAN


PROJECT: KALESHWARAM LINK-IV Pkg-II (6 X 125 MW) LIS, TELANGANA	QA PLAN NO: QA/HT/2111	REV 00	DATE: 05.04.2021	SHEET- 1 OF 2
EQUIPMENT: DISCHARGE VALVE	CUSTOMER: GOVT. OF TELANGANA, IRRIGATION & CAD DEPT			

ABBREVIATIONS:

B	BHEL QUALITY DEPT / BHEL APPOINTED THIRD PARTY AGENCY	MECH	MECHANICAL TEST
CHP	CUSTOMER HOLD POINT	P	PERFORM
CoC	CERTIFICATE OF COMPLIANCE	QCR	QC REPORT
CHEM	CHEMICAL TEST	SAMPLE	ONE SAMPLE PER HEAT/PER LOT AS PER SPEC.
D	DOCUMENT SUBMISSION TO CUSTOMER	SPEC	BHEL SPECIFICATION
DOC	BHEL INTERNAL DOCUMENT	TC	TEST CERTIFICATES
DRG	DRAWING	R	RECORD REVIEW
M	MANUFACTURER (BHEL / BHEL APPROVED VENDOR)	VIS	VISUAL EXAMINATION
MEAS	MEASUREMENT	W	WITNESS


 Advisor
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 Deputy Executive Engineer
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CUSTOMER

BHEL



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SL NO	COMPONENT/ASSY/ OPERATION	CHARACTERISTICS	TYPE OF CHECK	QUANTUM OF CHECK	REF. DOC. /ACCEPTANCE NORMS	RECORD FORMAT	AGENCY			REMARKS
							M	B	C	
1.0	IN-COMING MATERIAL/PLATE MATERIAL									
1.1	Butterfly Valve Body, Door, Lever, Inlet & Outlet Pipe	Chemical composition Mechanical Properties NDT as per spec (for plates 40 mm thk and above)	CHEM MECH NDT	Sample Sample Sample	SPEC. SPEC. SPEC.	TC TC TC	P P P	R R R	R R R	
2.0	INPROCESS INSPECTION									
2.1	Dimensional Check Of Valve Body, Valve Door And Lever	Measurement	MEAS	100%	DRG	QCR	P	R	-	
3.0	FINAL INSPECTION									
3.1	Shop Assembly & Testing of BF Valve Without Servomotor	Free movement of door Hydrostatic pressure test of valve assembly Leakage test on door seal	VIS Test / MEAS Test / MEAS	100% 100% 100%	DRG DRG DRG	QCR QCR QCR	P P P	W W W	R R R	
3.2	Servomotor Assembly	Operational test	Test / MEAS	100%	DRG	QCR	P	W	R	
3.3	Bypass Valve	Operational test	Test	100%	DRG	QCR	P	W	R	
3.4	Pressure Oil Supply Unit (P.P. Set)	Operational test	Test	100%	DRG	QCR	P	W	R	
3.5	Pressure receiver	Hydraulic pressure test	Test	100%	DRG	QCR	P	W	R	
3.6	Hydraulic control panel	Operational test	Test	100%	DRG	QCR	P	W	R	

Author
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 श्री आचार्य (एग्रेजेट) / श्री आचार्य (एग्रेजेट)
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