

BHARAT HEAVY ELECTRICALS LIMITED, CFP RUDRAPUR											
CUSTOMER:		QUALITY ASSURANCE PLAN(QAP) For Raw Material of Transformer Tank		MATERIAL INSPECTION/INPROCESS INSPECTION/FINAL INSPECTION		SUB VENDORS/ VENDUORS/ CONTRACTORS WORKS		DOC NO : QLY/TT/RM/00 REV NO: 02 DATE: 09.01.2021 PAGE : 1 OF 1			
SL. No.	COMPONENT	CHARACTERISTICS	CATEGORY	METHOD OF CHECK	EXTENT OF CHECK	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY			REMARKS(if any)
								P	R	W	
1.0	Raw Material (Al. Plate, Angle, Tube, Bar etc)	a) Visual	Major	Visual	100 %	Should be free from any surface defects, voids / BHEL Spec	IR	2		1	
		b) Dimension	Major	Measurement	10 %	BHEL PO / BHEL Spec.	IR	2		1	Supplier/Manufacturer TC will be reviewed for 100% lot.
		c) Chemical Composition	Major	TC	100%	Grade as per BHEL PO / BHEL Spec.	TC	2	1		Supplier/Manufacturer TC will be reviewed for 100% lot.
			Major	TEST	1 Sample/Lot	Grade as per BHEL PO / BHEL Spec.	TC	3		1	1 Sample of each type of material will be offered to BHEL/BHEL TPIA for witness.
		d) Mechanical Properties - Tensile Strength Test - Yield Stress Test - Elongation Test	Major	TC	100%	Grade as per BHEL PO / BHEL Spec.	TC	2	1		Supplier/Manufacturer TC will be reviewed for 100% lot.
			Major	TEST	1 Sample/Lot	Grade as per BHEL PO / BHEL Spec.	TC	3		1	1 Sample of each type of material will be offered to BHEL/BHEL TPIA for witness.

Ref: A) Engineering mail dated 07.02.2020 regarding material specification.
B) Aluminium specification of 7775 KVA /6531 KVA Locomotive Transformer Tank Dated : 01.02.2020 Rev.00.
C) Engineering mail dated 04.03.2020 & 05.06.2020 regarding mechanical testing.

NOTE: For all the Raw Materials which will be procured from outside India, Third party inspection witness from BV/TUV/Lloyd shall be in Manufacturer's scope.

ABBREVIATIONS:

R= REVIEWED BY
P= PERFORMED BY
W= WITNESSED BY

SPEC= SPECIFICATION
TC= TEST CERTIFICATE
IR= INSPECTION REPORT
PO = PURCHASE ORDER

3= AI NABL LAB (for Material procured within India) / CERTIFIED LAB(for material procured outside India).
2= MANUFACTURER /SUPPLIER
1= BHEL/BHEL INSPECTION AGENCY

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