

BHARAT HEAVY ELECTRICALS LIMITED											
COMPONENT FABRICATION PLAN (CFP), RUDRAPUR											
GENERAL		QUALITY ASSURANCE PLAN FOR GALVANIZED STEEL STRUCTURE		MATERIAL INSPECTION/ INPROCESS INSPECTION/ FINAL INSPECTION		SUB VENDOR / VENDORS WORK		DOC No: QP /PVM/STR/GEN REV NO: 00 DATE : 17.05.2022			
Sl. No.	COMOPNENT	CHARACTERISTICS	CATEGORY	METHOD OF CHECK	EXTENT OF CHECK	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY			REMARKS
								P	W	R	
1.0	Raw Material- Cold Rolled Steel (Column Clip & Angles etc)	a) Chamlcal Composition	Major	Test	1 Sample /Heat No.	BHEL PO/SPEC/IS 811	TC	2		1	
		b) Bend Test (as applicable)	Major	Test	1 Sample /Heat No.		TC	2		1	
		c) Mechanical (Tensile, Yeaild, Elongation)	Major	Test	1 Sample /Heat No.		TC	2		1	
2.0	Raw Material- Hot Rolled Steel (Plates etc)	a) Chemical Composition	Major	Test	1 Sample /Heat No.	BHEL PO/SPEC/IS 2062	TC	2		1	
		b) Bend Test (as applicable)	Major	Test	1 Sample /Heat No.		TC	2		1	
		c)Mechanical Tensile, Yield, Elongation)	Major	Test	1 Sample /Heat No.		TC	2		1	
3.0	Hot Dip Galvanized Steel Structure	a) Visual Check for Surface finish	Major	Visual	100%	Structure should be free from flux, ash, dross, inclusions, runs, blisters BHEL PO/DWVG	IR	2	1	Supplier to ensure the proper identification on each structure elements. 100% Internal report of supplier shall be reviewed by BHEL/BHEL TPIA	
		b) Dimensions	Major	Measurement	10%		IR	2	1		
		c) Galvanizing thickness (min 85 micron)	Major	Measurement	Randomly Check	BHEL PO/DWVG/IS 4759/IS 2629/IS 2633	IR	2	1	100% Internal report of supplier shall be reviewed by BHEL/BHEL TPIA	
		d) Mass of zinc coating (min 610 gm/sqm)	Major	Chemical Test / Measurement	1 Sample		IR	2	1		
		e) Preece Test / Uniformity of Thickness	Major	Chemical Test	1 Sample		IR	2	1		
		f) Adhesion test	Major	Test	1 Sample		IR	2	1		

ABBREVIATIONS:

P: PERFORMED BY

R: REVIEWED BY

W: WITNESSED BY

TC: TEST CERTIFICATE

IR: INSPECTION REPORT

PO: PURCHASE ORDER

DWG: DRAWING

2: MANUFACTURER/SUB VENDOR/EXTERNAL NABL LABORATORY

1: BHEL/ BHEL NOMINATE INSPECTION AGENCY

IS: INDIAN STANDARD

SPEC: SPECIFICATIONS

QTY

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