

		GENERAL QUALITY ASSURANCE PLAN				QAP NO: QP/BD/Al/FILLER WIRE Rev.01					
		ALUMINIUM FILLER WIRE				CUSTOMER: BHEL RUDRAPUR PROJECT: VARIOUS DATED: 13.10.2023					
SL. NO.	COMPONENT	CHARACTERISTICS	CATEGORY	METHOD OF CHECK	EXTENT OF CHECK	ACCEPTANCE CRITERIA / REFERENCE STANDARD	FORMAT OF RECORDS	AGENCY			REMARKS
								P	R	W	
1.	ALUMINIUM FILLER WIRE	a) Visual Check (Marking)	Major	Visual	Sample check from each Cast/Heat No.	Each Spools should have marking for Batch No/Heat No, Size, Grade, Make & Date of Manufacturing/ IS 5897/AWS A5.10	IR	2		1	Supplier to submit their internal TC/Reports for review to BHEL/BHEL TPIA
		b) Visual Check for Surface Finish	Major	Visual	Sample check from each Cast/ Heat No.	Should be free from surface Imperfections, corrosion products, grease , excess oxide or other foreign matter/IS 5897/AWS A5.10	IR	2		1	
		c) Dimensions (Diameter, Weight)	Major	Measurement	Sample check from each Cast /Heat No.	BHEL PO specifications	IR	2		1	
		d) Chemical composition	Major	Chemical	1 sample/Heat or Cast No.	AWS5.10 ER 4043/PO Specifications	IR/TC	2		1	
		e) Usability Test (Groove Weld Test through Radiographic testing)	Major	Mechanical	1Sample per Heat/ Cast No	AWS 5.10 Cl. No.9.3 , Table-3	IR/TC	2		1	
NOTES: 1. Flanges of Wire spools should be sufficiently Robust to avoid deformation during normal usage. 2. Filler wire spools shall be Heat sealed in Plastic bags and packed suitably to guard against moisture , contamination or deterioration.											

ABBREVIATIONS:

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

IR= INSPECTION REPORT
TC= TEST CERTIFICATE

1= BHEL/BHEL NOMINATED THIRD PARTY AGENCY (TPIA)
2= BHEL'S SUB-VENDOR / NABL ACCREDITED LABORATORY

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