


MANUFACTURER'S NAME AND ADDRESS			STANDARD QUALITY PLAN					TO BE FILLED BY BHEL						
 <b>BHEL</b>	VENDOR'S NAME		ITEM	CALIBRATED FLOW NOZZLE		QP NO.	QA/BE/QP/326							
					REV.	05	Date: 11.09.2025							
	DRG. NO.		As per P.O.		SPEC. & REV.		As per P.O. (ST45008, ST45009, ST45013, ST45015)		Page 1 of 1					
SL. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY			REMARKS		
1	2	3	4	5	6	7	8	9	D	M	B	N	10	11

<b>1.0 RAW MATERIALS / BOUGHT OUT ITEMS</b>													
1.1	Flow nozzle, steel pipes, flanges, fittings etc.	Chem. & mech. properties	Major	Measure	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	MTC	√	P	V	-	
1.2	Stud & nuts (zinc plated)	zinc coating	Major	Measure	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	MTC	√	P	V	-	
<b>2.0 IN PROCESS INSPECTION</b>													
2.1	Machining	Visual	Major	Review	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	Records	√	P	V	-	
2.2	Verification of Welding documents	WPS/PQR/WPQ	Major	Review	100%	ASME SEC IX	ASME SEC IX	Documents.	√	P	V	-	
<b>3.0 FINAL INSPECTION</b>													
3.1	Visual & Dimensional inspection	Dimension, workmanship	Major	Measure	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	I.R.	√	P	W	-	
3.2	Surface finish measurement for nozzles	smoothness	Major	Physical	100%	Drg./ADS/Spec./ ASME PTC-6 & 19.5	Drg./ADS/Spec./ ASME PTC-6 & 19.5	I.R.	√	P	W	-	
3.3	Hydrostatic pressure test	strength	Major	Physical	100%	Drg./ADS/Spec.	No leakage	I.R.	√	P	W	-	
3.4	Welding – visual measurement	Weld quality	Major	Visual	100%	Drg./ADS/Spec.	ASME SEC-V	I.R.	√	P	W	-	
3.5	Welding - MPI or LPI of all welds	Weld quality	Major	Physical	100%	Drg./ADS/Spec.	ASME SEC-V	I.R.	√	P	W	-	
3.6	Welding - R.T. of butt welds	Weld quality	Major	Physical	100%	Drg./ADS/Spec.	ASME SEC-VIII	I.R.	√	P	W	-	
3.7	Calibration	Wet calibration	Major	Physical	100%	ASME PTC-6 2004	ASME PTC-6 2004	Report	√	P	V	-	
3.8	Painting	--	Major	Physical	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	I.R.	√	P	W	-	
3.9	Identification & Marking	--	Major	Review	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	I.R.	√	P	W	-	
3.10	Packing including preservation	soundness	Major	Review	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	I.R.	√	P	V	-	
3.11	Recommended loose spares as per P.O. or specification (root valves, gaskets etc.)	visual	Major	Review	100%	Drg./ADS/Spec.	Drg./ADS/Spec.	I.R.	√	P	V	-	

**NOTES:** 1. Manufacturer to maintain calibrated instruments having better accuracy than the item under test. Inspection engineer shall check the same. 2. Vendor to provide index sheet for co-relation of TC/IR with QP clauses.

MANUFACTURER/ SUBCONTRACTOR	LEGEND: DRG: BHEL APPROVED DRAWING, ADS: APPROVED DATASHEET, SPEC: SPECIFICATION, MTC: MATERIAL TEST CERTIFICATE, T.C.: TEST CERTIFICATE, I.R.: INSPECTION REPORTS, M: MANUFACTURER / SUBCONTRACTOR, B: BHEL / BHEL TPIA, N: CUSTOMER, 'P': PERFORM, 'W': WITNESS, 'V': VERIFICATION, "√" RECORDS IDENTIFIED WITH 'TICK' SHALL BE ESSENTIALLY INCLUDED BY CONTRACTOR IN QA DOCUMENTATION. ALL 'W' INDICATED IN COLUMN 'N' SHALL BE 'CHP' OF CUSTOMER	FOR CUSTOMER USE	APPROVED BY (BHEL HARIDWAR – Q.A.)
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