



STANDARD QUALITY PLAN

ITEM : Plate Heat Exchanger

SQP NO: ADANI/QA/SQP/M/04
 Rev. No.: 00
 Date: 01.07.2012
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PROJECT: M/S MEL 2X800 MW (PHASE-II) MAHAN THERMAL POWER PROJECT, SINGRAULI, M.P.
 2X800 MW ULTRA SUPER CRITICAL THERMAL POWER PROJECT, MAHAN (PHASE-II), SINGRAULI, M.P.
 PACKAGE: MAIN PLANT PACKAGE
 CONTRACTOR: BHEL, Haridwar

SL No.	COMPONENT/ OPERATION	CHARACTERISTICS	CATEGORY OF CHECK	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		INSPECTION AGENCY			REMARKS
					M	C/A				*D	M	C	A	
1	2	3	4	5	6		7	8	9		**10			11
2.3	Fit up & Welding of Parts	Visual & Size	Major	Visual	100%	100%/-	Mfr.Drg	Mfr.Drg	IR /Log Book	√	P	V	-	
2.4	NDT	RT on Butt welds	Major	NDT	100%	100%/100%	ASME Sec.V	ASME Sec.VIII, Div.1,	RT Film	√	P	V	V	
2.5	Drilling/Machining of Parts	Visual & Dimension	Major	Visual & Measure	100%	100%/-	Mfr.Drg	Mfr.Drg	IR /Log Book		P	V	-	
2.6	Heat Transfer Plate (stainless steel)	Light Box Test	Major	Visual	100%	100%/10%	Appd Procedure	No Light indication	Test Report	√	P	H	H	
		DPT	Major	Test	10%	10%/10%	Appd Procedure	ASME Sec.VIII, Div.1,App-08	Test Report	√	P	V	V	
3	Assembly													
3.1	Laying of Gaskets in HT Plates	Size, Fitment & Finish	Major	Visual	100%	100%/-	Mfr.Drg	Mfr.Drg	IR /Log Book	√	P	V	-	
3.2	PHE Structure	Visual & Dimension	Major	Visual & Measure	100%	100%/100%	Appd. Drg, Data sheet/ Mfr std	Appd. Drg, Data sheet/ Mfr std	IR /Log Book	√	P	V	V	
		Surface Cleaning & Painting for CS Parts	Major	Visual & Measure	100%	100%/100%	Appd.Drg, Data sheet	Appd.Drg, Data sheet	IR	√	P	V	V	
3.3	Laying Of HT in PHE Structure	Size & NO of HT Plates	Major	Visual & Measure	100%	100%/100%	Appd.Drg, Data sheet	Appd.Drg, Data sheet	IR	√	P	V	V	
3.4	Tightening of Bolts	Size & Visual	Major	Visual	100%	100%/100%	Mfr.Drg	Mfr.Drg	IR /Log Book	√	P	V	-	
4	Final Inspection													

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BHEL

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28/8/2012

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adani™	STANDARD QUALITY PLAN													
	ITEM : Plate Heat Exchanger					SQP NO: ADANI/QA/SQP/M/041		PROJECT: MS MEL 2X800 MW (PHASE-II) MAHAN THERMAL POWER PROJECT, SINGRAULI, M.P.						
						Rev. No.: 00		2X800 MW ULTRA SUPER CRITICAL THERMAL POWER PROJECT, MAHAN (PHASE-II), SINGRAULI, M.P.						
					Date: 01.07.2012		PACKAGE: MAIN PLANT PACKAGE			CONTRACTOR: BHEL, Haridwar				
					Page: 3 of 3									
SL No.	COMPONENT/ OPERATION	CHARACTERISTICS	CATEGORY OF CHECK	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY			REMARKS	
					M	C/A				M	C	A		
1	2	3	4	5	6		7	8	9	*D	**10			11
4.1	Assembly	Visual & Dimension, No of HT Plate, Tightness of Bolts	Major	Visual & Measure	100%	100%/100%	Appd.Drg	Appd.Drg	IR	√	P	H	H	
4.2	Hydrostatic Test (Primary & Secondary side)	Test Pressure & Visual	Major	Visual	100%	100%/100%	Appd.Drg	No Leakage	IR	√	P	H	H	
4.3	Surface Preparation & Painting	Finish, Colour, Adhesion, Shade, DFT	Minor	Visual & Measure	Random	Random	Appd. Painting Schedule	Appd. Painting Schedule	IR	√	P	V	V	
4.4	Identification Marking	Marking	Minor	Visual	100%	100%/100%	Mfg. Std, Appd. Drg.	Mfg. Std, Appd. Drg.	IR	√	P	V	V	
Notes : 1.For UT these are not acceptable: (1) Cracks, flaps, seams, laps (2) Defect giving indication larger than from 2 mm diameter equivalent flaw (3) Group of defect with maximum indication less than that of from 2 mm diameter equivalent flaw which can not be separated at testing sensitivity if back echo is reduced to less than 70% (4) Defect giving indication of 1 to 2 mm diameter equivalent flow separated by a distance less than 4 times the size of larger of the adjacent flaw,														
2. In case of difference in requirement specified in col. 7 & 8 of the QP from Appd. Drawing, Datasheet, the requirement mentioned in Appd. Drawing, Datasheet shall prevail.														
LEGEND:- D* Records identified with tick (p) shall be essentially included by supplier & manufacturer in Quality Documentation package.														
** M: Manufacturer / Sub-Supplier, C: Main Supplier, A: ADANI or their authorized representative.														
Use the following term as appropriate in columns 10. P: Perform, V: verification and H: Customer Hold Point to be witnessed and work shall not proceed till it is witnessed and cleared in writing.														

FORMAT NO.:AII/CQA/F-18 R1

BB
BHEL

Deepak VIT
DEEPAK VIT
25/8/2023

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K Chauhan
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STANDARD QUALITY PLAN

ITEM : Plate Heat Exchanger

SQP NO: ADANI/QA/SQP/W/041
 Rev. No.: 00
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 Page: 1 of 3

PROJECT: MS MEL 2X800 MW (PHASE-II) MAHAN THERMAL-
 POWER PROJECT, SINGRAULI, M.P.
 2X800 MW ULTRA SUPER CRITICAL THERMAL POWER
 PROJECT, MAHAN (PHASE-II), SINGRAULI, M.P.
 PACKAGE: MAIN PLANT PACKAGE
 CONTRACTOR: BHEL, Haridwar

SL No.	COMPONENT/ OPERATION	CHARACTERISTICS	CATE- GORY OF CHECK	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		INSPECTION AGENCY			REMARKS
					M	C/A			9	*D	M	C	A	
					**10									
1.1	Plate/ Pipe/ Flange/ Bolts/ Fittings	Visual, Chemical & Mech. Property	Critical	Verify	1/Heat	1/Heat	Relevant Std/ Appd. Drg. ,Data Sheet	Relevant Std/ Appd. Drg. ,Data Sheet	TC/ IR	√	P	V	V	11
		Dimension	Major	Measure	100%	100%/Random			TC/ IR	√	P	V	V	
		UT on plate thickness > 40mm	Major	Test	100%	100%/100%	ASTM A 435	ASTM A 435	TC/ IR	√	P	V	V	
1.2	Heat Transfer Plate (stainless steel)	Visual	Major	Surface check	100%	100%/100%	Appd. Drg. ,Data Sheet	Relevant Std /Appd Drg. , Data Sheet	TC/ IR	√	P	V	V	
		Dimension	Major	Verify	100%	100%/Random			TC/ IR	√	P	V	V	
		Chemical & Mech. Property	Critical	Verify	1/Heat	1/Heat	Appd. Drg. ,Data Sheet	Relevant Std /Appd Drg. , Data Sheet	TC	√	P	V	V	
1.3	Gaskets	Visual	Major	Surface check	100%	100%/100%	Appd. Drg. ,Data Sheet	Relevant Std /Appd Drg. , Data Sheet	TC/ IR	√	P	V	V	
		Dimension	Major	Measure	100%	100%/Random	Appd. Drg. ,Data Sheet	Relevant Std /Appd Drg /Data Sheet	TC/ IR	√	P	V	V	
		Test certificate	Major	Verify	Random	Random	Appd. Drg. ,Data Sheet	Relevant Std /Appd Drg. , Data Sheet	TC	√	P	V	V	
2.1	Welding Control	WPS, PQR	Major	Verify	100%	100%/100%	ASME Sec.IX	ASME Sec.IX	Records	√	P	V	V	
2.2	Marking/ Cutting/ Grinding for parts	Visual & Dimension	Major	Visual & Measure	100%	100%/-	Mfr.Drg	Mfr.Drg	IR /Log Book		P	V	-	

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P.R. Bansal
 28/8/23
 (P.R. Bansal)
 BHEL, Haridwar

Om/Amj
 DEEPAK VJ
 28/8/2023

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