

BHARAT HEAVY ELECTRICALS LIMITED COMPONENT FABRICATION PLANT (CFP), RUDRAPUR									
CUSTOMER: M/s BHEL PROJECT: VARIOUS		QUALITY ASSURANCE PLAN FOR GALVANIZED STEEL STRUCTURE		MATERIAL INSPECTION/ INPROCESS INSPECTION/ FINAL INSPECTION		SUB VENDORS/ VENDORS WORKS		DOC No: QP/BD/ACC/STR REV NO: 00 DATE: 11.01.2021	
SL. No.	COMPONENT	CHARACTERISTICS	CATEGORY	METHOD OF CHECK	EXTENT OF CHECK	ACCEPTANCE NORVS	FORMA TO RECORD	AGENCY	REMARKS
								P W R	
1.0	Raw Material- Steel Structure (ISMB/ISM/ISA etc)	a) Chemical composition b) Bend Test (as applicable) c) Mechanical (Tensile, Yield, Elongation)	Major	Test	100%	BHEL PO/SPEC	TC	2	1
			Major	Test	100%	BHEL PO/SPEC	TC	2	1
			Major	Test	100%	BHEL PO/SPEC	TC	2	1
2.0	Hot Dip Galvanized Steel Structure	a) Visual check for Surface Finish b) Dimensions c) Galvanizing thickness d) Mass of zinc coating e) Preace test/Uniformity of Thickness f) Adhesion test	Major	Visual	100 %	Structure should be free from flux, ash, gross inclusions, runs, blisters /IS	IR	2	1
			Major	Measurement	10 %	BHEL PO/DWG	IR	2	1
			Major	Measurement	Randomly check	BHEL PO/DWG/IS	IR	2	1
			Major	Chemical Test/ Measurement	1 Sample	BHEL PO/DWG/IS	IR	2	1
			Major	Chemical Test	1 Sample	BHEL PO/DWG/IS	IR	2	1
			Major	Test	Randomly check	BHEL PO/DWG/IS	IR	2	1

ABBREVIATIONS:

P: PERFORMED BY
R: REVIEWED BY
W: WITNESSED BY

2: MANUFACTURER /SUB VENDOR
1: BHEL/BHEL NOMINATED INSPECTION AGENCY
IS: INDIAN STANDARD
SPEC: SPECIFICATIONS

PREPARED BY

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APPROVED BY

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