

BHARAT HEAVY ELECTRICALS LIMITED
COMPONENT FABRICATION PLAN FOR
GALVANIZED STEEL STRUCTURE


SL. No.	COMPONENT	CHARACTERISTICS	CATEGORY	METHOD OF CHECK		EXTENT OF CHECK	ACCEPTANCE NORMS	FORMATS RECORDS	AGENCY			REMARKS
				QUALITY ASSURANCE PLAN FOR GALVANIZED STEEL STRUCTURE	MATERIAL INSPECTION/ INPROCESS INSPECTION/ FINAL INSPECTION				P	W	R	
CUSTOMER: M/s BHEL PROJECT: VARIOUS DOC No: QP/BD/ACC/STR REV.No:00 DATE: 11.01.2021												
1.0	Raw Material- Steel Structure (ISMB/ISMC/ISA etc)	a) Chemical composition b) Bend Test(as applicable) c) Mechanical (Tensile, Yield, Elongation)	Major Major Major	Test Test Test	100% 100% 100%	BHEL PO/ SPEC BHEL PO/ SPEC BHEL PO/ SPEC	TC TC TC	2 2 2	1 1 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) Prece test/Uniformity of Thickness f) Adhesion test	Major Major Major Major Major Major	Visual Measurement Measurement Chemical Test/ Measurement Chemical Test	100 % 10 % Randomly check 1 Sample 1 Sample Randomly check	Structure should be free from flux, ash, dross inclusions, runs blisters /IS BHEL PO/ DWG BHEL PO/ DWG/IS BHEL PO/ DWG/IS BHEL PO/ DWG/IS BHEL PO/ DWG/IS	IR IR IR IR IR IR	2 2 2 2 2 2	1 1 1 1 1 1		Supplier to ensure the proper identification on each structure elements. 100% Internal report of supplier shall be reviewed by BHEL/BHEL TPIA 100% Internal report of supplier shall be reviewed by BHEL/BHEL TPIA	

ABBREVIATIONS:

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

TC: TEST CERTIFICATE
 IR: INSPECTION REPORT
 PO: PURCHASE ORDER
 DWG: DRAWING

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


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APPROVED BY

