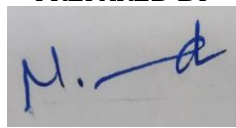


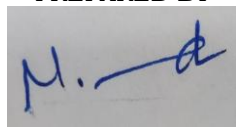
		MANUFACTURER'S NAME AND ADDRESS BHEL: TIRUCHIRAPPALLI / APPD. SUB-CONTRACTORS		STANDARD QUALITY PLAN FOR LP PIPING FABRICATION					QP NO: QPG:75 REV. NO: 01 DATE : 23.02.2026 PAGE 1 OF 4		
S. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY		REMARKS
									M	B	
1	2	3	4	5	6	7	8	9	10		11

1.0 RAW MATERIAL										
1.1	Seamless Pipe or Welded Pipe -IS3589 (longitudinal /Spiral), IS1239 (Black/Galvanized) or as per drawing.	Correctness of Material Spec	Minor	Verification of Specification	100%	Material Specification as per BHEL Drawing.	HC	P	V	
1.2	FITTINGS									
a)	IS1239 Fittings (Black/Galvanized) Screwed & Socketed or as per drawing.	Correctness of Material Spec.	Minor	Verification of Specification	100%	Material Specification as per BHEL Drawing.	HC	P	V	
b)	Forged/BW Fitting/ Flanges as per IS1239 Part II, SA234, SA105, SA182 or as per drawing.	Correctness of Material Spec.	Minor	Verification of Specification	100%	Material Specification as per BHEL Drawing.	HC	P	V	
1.3	Plates: IS2062 or as per drawing.	Correctness of Material Spec.	Minor	Verification of Specification	100%	Material Specification as per BHEL Drawing.	HC	P	V	
1.4	Rods & Rounds CS, AS, SS (Material spec as per BHEL Document)	Correctness of Material Spec.	Minor	Verification of Specification	100%	Material Specification as per BHEL Drawing.	HC	P	V	

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LEGEND:	M Manoj Pandi Manager/QA (Piping)	K Saranya Manager/ QA (Piping)

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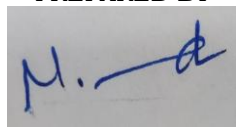
1.5	All Raw materials (If supplied by BHEL)	Correctness of Material Spec.	Minor	Verification	100%	Material Specification as per BHEL Drawing.	HC & BHEL Gate Pass	P	V	
2.0	INPROCESS CONTROL									
2.1	Material receiving inspection	Marking & transfer of identification	Major	Visual	100%	As per drg.	HC	P	W	Note 1
2.2	Marking, Cutting & Edge Preparation	Dimension	Minor	Measurement	100%	As per drg.	HC / Approved Cuttin	P	V	
2.1	Welding	Procedure, Performance Qualification (only Qualified welder's & WPS shall be employed)	Major	Verification @	Each Welder	ASME SEC - IX	WPS/PQR	P	V	@ Review of WPS /PQR by BHEL.
2.3	Rolled and Welded Pipes/fittings using IS2062 plates	a) Circumferential Seam welds	Major	RT	10%*	-do--	HC	P	R @	*- 10% weld + 100% T-joints. ** - 10% weld + 100mm at both ends.
		b) Long Seam welds	Major	RT	10%**	-do--	HC	P	R @	
2.4	Miter bends, Branch Reducer, Tees, Flange	Fit-up	Major	Dimension & Root-gap	100%	BHEL Drawing	HC	P	V	
2.5	NDE: for Weld	a) Weld fusion	Major	Root back Chip & LPI	100%	No linear indication	HC	P	V	@ - Review of 100% of RT film

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LEGEND:

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		b) Weld Profile & Surface defects	Major	Visual	-do-	ASME Sec V/ ASME B 31.1 Cl.136.4.2	HC	P	W	*- 10% weld + 100% T-joints. @ - Review of 100% of RT film
		c) Butt, mitre joints	Major	RT	10%*	ASME Sec V/ ASME B 31.1 Cl.136.4.5.	HC	P	R @	
2.6	Piping Fabrication	a) Butt Joints	Major	RT	10%*	-do--	HC	P	R @	
		b) Fillet Welds	Major	LPT/MPT	100%	ASME B 31.1 Cl.136.4.4/ ASME B 31.1 Cl.136.4.3	HC	P	R	
2.7	NDE for Edge Preparation	Surface Defect	Major	LPT	100%	ASME B 31.1 Cl.136.4.4	HC	P	W	
3.0	FINAL INSPECTION									
3.1	Dimension	Measurement (including Ovality)	Major	Visual & Measurement	100%	BHEL Drawing	HC	P	W	
3.2	Surface preparation and painting	Painting DFT	Major	Visual & Measurement	100%	As per Customer specific approved Painting Scheme	HC	P	W	
3.3	Marking & Identification	Work order, DU Number. Maker's Identification	Major	Visual	100%	Paint stenciling & Hard Stamping as per BHEL drawing/GMS	HC	P	W	
4.0	DOCUMENTATION									
4.1	Documentation Review	Verification of Reports	Major	Visual	100%	All reports as required in this QP	IR, Reports, HC*	P	V	

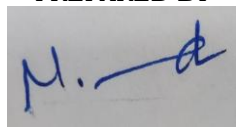
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4.2	Despatch Clearance	Despatch Clearance	Critical	Verification	100%			MDCC	P	V	

Notes:

- 1) All Instruments to be used for Testing/ Inspection shall have Valid 'Calibration Certificates' to be verified by Agencies, Manufacturer and the Contractor.
- 2) All pages of the inspection documents shall be numbered in chronology with the QAP clauses, duly mentioning the corresponding QAP clause no at the top of each page.
- 3) Testing shall be from NABL accredited lab only, if in-house calibrated measuring instruments are not available.
- 4) For any 'HEAT TREATED' component (as applicable), the corresponding 'GRAPH' to be submitted for review.
- 5) Painting can be done only after inspection clearance, as per customer's approved paint specification/schedule, if mentioned. Otherwise manufacturer's standard shall be followed.
- 6) Original Manufacturer's TCs (Duly endorsed by Agencies/Manufacturer & Supplier) shall be submitted for all bought-out Items and sourced from customer's approved 'Make List' Mentioned in approved drg/data sheet for review by customer/ consultant, otherwise manufacturer's standard make shall be followed.
- 7) All TCs / IRs shall be endorsed by agencies manufacturer & supplier, before submitting to agency 'Contractor/Client/Consultant' for review.

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