

NIT 2023OSB024		
SECTION I A - [List of Quality Documents/Inspection]		
QP TYPE	QP DESCRIPTION	QP
CONTRACT QUALITY PLAN (CQP)	CONTRACT QUALITY PLAN	CQP6583
	Welding Procedure Qualification	Routine Test During Production
Tests	I) Hammer Test-Fin shall be bent upto 30 deg without Fin to Tube joint Fracture	Hammer tests-10% of fins in every single tube/Double tube
	II) Macro Test (for 5 nos)	
	a) Fin penetration in tube wall 0.3 mm (max)	
	b) Weld Fusion Length(min. 70% of the length of each Fin)	
	III) Visual Inspection	Visual Inspection-100%