



ITEM (MATERIAL, CLASS, GRADE, RATING, RANGE, SIZE ETC)
MS PIPES (BLACK & GALVANIZED)

STANDARD QUALITY PLAN

CONFORMING TO CODE:
IS: 1239 (PART-I) / IS: 3589

QP NO : 0000-999-QOM-S-001
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APPROVED BY:
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SL NO	COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK M C/N	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY M C N	REMARKS
1.	2.	3.	4.	5.	6.	7.	8.	9.	D* ** 10	11

1.0	Raw Material Inspection									
1.1	Steel Strip/Sheet	Mechanical & Chemical Properties Thickness Visual	Major Major Major	Mechanical & Chemical Measure Visual	1 Sample/ Heat 100% 100%	IS: 1239 (Part-I) / IS:3589 IS: 1239 (Part-I) / IS:3589 IS: 1239 (Part-I) / IS:3589	TC IR IR	✓ P P	V - -	V
2.0	Final Inspection	Surface Defects & Finish, End Conn. Dimensions, Straightness, Ovality, Bead Removal Tensile, Elongation, Bend, Flattening Leakage Finish/Surface Defects Uniformity of Zinc Coating Thickness, Mass and Adhesion of Zinc Coating & Free Bore Test	Major Major Major Major Major Major Major	Visual Measure Physical Hydro Visual Dip Test Mechanical & Verification	Sampling as per IS 100% 100%	IS: 1239 (Part-I) / IS:3589 / NTPC Technical Specifications IS: 1239 (Part-I) / IS:3589 IS: 1239 (Part-I) / IS:3589 IS: 4736 IS: 2633 IS: 4736	IR IR IR IR IR IR IR	✓ P P P P P P	W W W W W W W	W
2.1	Pipe (Black)									
2.2	Galvanizing (if applicable)									
2.3	Finished Pipe	Identification & Marking	Major	Visual				-	✓	P W W W

Note 1: Minimum thickness of Pipe/ Zinc Coating (for Galvanized Pipes) shall be as per NTPC Technical Specifications/ Approved Drawing/ Datasheet.

Note 2: In case of Pipes for Rubber Lining application, internal Bead shall be removed.

Note 3: For Pipe sizes up to and including 150NB, witness Of Mech. Tests, Hydro Test & Galvanizing Checks shall be done on 1 randomly selected size only, where order quantity of particular sizes is less than 100 Meters. If such sizes, where order quantity is less than 100 Meters, are more than 5, then 2 sizes shall be randomly selected for witness tests.

Note 4: Surface protection (Outside & Inside) shall be as per NTPC Technical Specs/ Approved Drawing/ Datasheet.

Note 5: Skelp Joint (in case of Spiral Welded Pipes to IS: 3589), shall be at least 12" away from the Pipe end.

LEGEND: * RECORDS, IDENTIFIED WITH "TICK" (✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION.

** M: MANUFACTURER / SUB-SUPPLIER C: MAIN SUPPLIER, N: NTPC P: PERFORM W: WITNESS AND V: VERIFICATION, AS APPROPRIATE.
CHP: NTPC SHALL IDENTIFY IN COLUMN "N" AS 'W'.

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ENGG. DIV./QA&I