

ITEM- STRAINER ('Y' TYPE AND BASKET TYPE) FOR AUX. PACKAGES, MAXIMUM WORKING PRESSURE UP TO 10 KG/CM ²		STANDARD QUALITY PLAN CONFORMING TO CODE				QP NO.	0000-999-QOM-S -013		REVIEWED BY		APPROVED BY				
SN		COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS		
1.		2.	3.	4.	5.	6.	7.	8.	9.	D*	M	C	N	10.	11.
						M	C/N								
1.0 RAW MATERIAL INSPECTION															
1.1	MS PLATE / ERW PIPE FOR BODY (IF FABRICATED)	CHEMICAL & MECHANICAL PROPERTIES	MAJOR	CHEMICAL ANALYSIS	1 SAMPLE / HEAT	RELEVANT MATERIAL STANDARD AS PER APPROVED DRAWING/ DATA SHEET		TC	√	P	V	V	REFER NOTE-1		
				MECHANICAL PROPERTIES	1 SAMPLE / HEAT										
		VISUAL	MAJOR	VISUAL,	100%	FREE FROM SURFACE DEFECTS		IR		P	-	-			
1.2	CAST BODY	CHEMICAL & MECHANICAL PROPERTIES	MAJOR	CHEMICAL ANALYSIS	1 SAMPLE / HEAT	RELEVANT MATERIAL STANDARD AS PER APPROVED DRAWING/ DATA SHEET		TC	√	P	V	V	REFER NOTE-2		
				MECHANICAL PROPERTIES	1 SAMPLE / HEAT										
		SOUNDNESS OF CASTING	MAJOR	HYDRO TEST	100%	SEE NOTE - 3 NO LEAKAGE		TC	√	P	V	V			
1.3	WIRE MESH (SCREEN)	CHEMICAL	MAJOR	CHEMICAL ANALYSIS	1 SAMPLE / HEAT	RELEVANT MATERIAL STANDARD AS PER APPROVED DRAWING/ DATA SHEET		TC	√	P	V	V			
		MESH SIZE	MAJOR	DIMENSIONAL,	1 SAMPLE / LOT	APPROVED DRAWING/ DATA SHEET		IR	√	P	V	V			
		VISUAL	MAJOR	VISUAL	100%	FREE OF SURFACE DEFECTS		IR		P	-	-			
2.0 IN PROCESS INSPECTION															
2.1	WELDING	WELDING PROCEDURE QUALIFICATION WELDER QUALIFICATION	MAJOR	VISUAL MECHANICAL TESTS, NDT	100% & EACH WELDER	ASME SEC IX, APPROVED WPS	ASME SEC IX, QW-482, 483, 484 OF ASME SEC IX	√	P	V	V	REFER NOTE- 4			
		EDGE PREPARATION & FIT UP CHECK	MAJOR	VISUAL DIMENSIONAL	100%	-	APPROVED WPS / FABRICATION DRAWING	IR		P	V	-			
2.2	WELD QUALITY	SOUNDNESS OF FINAL RUN OF BUTT WELDS AND FILLET WELDS INCLUDING NOZZLE WELDS	MAJOR	DP TEST	100%	RANDOM 10% OF EACH WELD	ASTM E - 165	NO RELAVANT INDICATIONS	IR	√	P	W	V	REFER NOTE- 5	
2.3	MACHINING OF SURFACES, DRILLING OF HOLES ETC	COMPLETENESS, SURFACE FINISH	MAJOR	VISUAL DIMENSIONAL	100%	100%	MANUFACTURING DRAWING		IR		P	V	V		
3.0 FINAL INSPECTION															
3.1	STRAINER ASSEMBLY	COMPLETENESS	MAJOR	VISUAL MEASURE	100%	APPROVED DRAWING / APPROVED DATA SHEET		IR	√	P	W	W			

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"

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							REV. NO	01		H. S. MAURYA				
							DATE	01-05-2014		M.K.ASTHANA				
							PAGE	01 of 02		RAJEEV GARG				
							VALID UPTO	30-04-2017						
SN	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS	
										M	C	N		
1.	2.	3.	4.	5.	6.		7.	8.	9.	D*	** 10.		11.	
					M	C/N								
		HYDRAULIC TEST	MAJOR	VISUAL MEASURE &	100%	10% OF EACH SIZE PER VISIT	APPROVED DRAWING / APPROVED DATA SHEET	IR	√	P	W	W		
		FLOW V/S PRESSURE DROP CHARACTERISTIC	CRITICAL	MEASURE (TYPE TEST)	ONE PER TYPE & SIZE		APPROVED TEST PROCEDURE	APPROVED DRAWING / DATA SHEET	IR	√	P	W	W	REFER NOTE- 6
		PAINTING – COLOR, SHADE, DRY FILM THICKNESS	MAJOR	VISUAL & MEASURE	100%	10% RANDOM	TECHNICAL SPECIFICATION	IR	√	P	V	V		
3.2	REVIEW OF QA DOCUMENTS	COMPLETENESS OF DOCUMENTS/ RECORDS	MAJOR	VERIFICATION	100%		APPROVED DRAWING / DATA SHEET & APPROVED SQP		√	P	V	V		
4.1	MARKING & PACKING	COMPLETENESS	MAJOR	VERIFICATION	100%	100%	MANUFACTURER STANDARAD			P	V	-		
NOTE														
1	IN ABSENCE OF CO-RELATED TCS, CHECK-TESTS SHALL BE CARRIED OUT IN PRESENCE OF MAIN CONTRACTOR.													
2	NO WELD REPAIR ON CI CASTING IS PERMITTED													
3	HYDRO TEST PRESSURE SHALL BE 2TIMES OF WORKING PRESSURE OR 1.5 TIMES OF DESIGN PRESSURE WHICHEVER IS HIGHER FOR 30 MINUTES.													
4	WPS/PQR APPROVED BY NTPC/BHEL/LLOYDS/ BVQI/ DNV/TUV ARE ACCEPTABLE. WELDERS QUALIFIED BY THESE AGENCIES SHALL BE DEPLOYED.													
5	SL.NO.2.1, 2.2 APPLICABLE IN CASE OF WELDED CONSTRUCTION ONLY.													
6	FLOW V/S PRESSURE DROP TEST; ACCEPTANCE OF NTPC ENGINEERING FOR FLOW V/S PRESSURE DROP TEST TO BE REVIEWED DURING FINAL INSPECTION. IF NOT CARRIED OUT EARLIER, THIS TEST SHALL BE OFFERED TO NTPC FOR WITNESS.													

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