

BEHARAT HEAVY ELECTRICALS LTD	QUALITY CONTROL PLAN FOR	NAME OF CONTRACT PACKAGE	OP.NO.FAN306
BOILER AUXILIARIES PLANT			REV.No.01
RANIPET-632 406 (INDIA)	SEAL AIR FAN	STANDARD	DATE:100694
QUALITY ASSURANCE DEPT.			PAGE 1 of 04

PREPARED BY: gpon REVIEWED BY: B. Srinivasulu APPROVED BY: HA

S.No.	COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE STANDARD	FORMAT OF REC	AGENCY	REMARKS
1	2	3	4	5	6	7	8	9	10	11
1	MATERIAL FOR ROTATING PARTS									
	SHAFT	CHEM & MECH. PROPERTIES	MAJOR	REVIEW OF TEST CERTIFICATES	100%	RESPECTIVE MATERIAL SPECIFICATION		TC	QC-PROCUREMENT	
	FORGINGS									
	BRG. HOUSING	-DO-	MAJOR	-DO-	-DO-	-DO-	-DO-	-DO-	-DO-	
	PLATES FOR IMPELLER	-DO-	MAJOR	-DO-	-DO-	- DO -	-DO-	-DO-	-DO-	
	SUB DELIVERIES									
	MOTOR	ROUTINE/TYPE TEST	MAJOR	-DO-	100%	PURCHASE SPECIFICATION		-DO-	SUPPLIER	
	COUPLINGS	(1) DIMENSIONS	MAJOR	MEASUREMENT	100%	-DO-	-DO-	-DO-	-DO-	
		(2) DYNAMIC BALANCING	MAJOR	BALANCING	100%	-DO-	-DO-	-DO-	-DO-	
	BEARINGS	COMPLIANCE WITH PURCHASE ORDER	MAJOR	REVIEW OF TCS & VISUAL INSPECTION OF BEARINGS	100%	PURCHASE ORDER	-DO-	-DO-	-DO-	

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2.0.	INPROCESS CONTROL									
2.1.	SHAFT	JOURNAL DIA LENGTHS, SIZE OF KEY WAY & OFFSET	MAJOR	MEASURE- MENT	100%	DRAWING	DRAWING	DR	SUBCONT- RACTOR	
2.2.	IMPELLER	BORE DIA & KEY WAY SIZE & OFFSET	MAJOR	-DO-	100%	DRAWING	DRAWING & NOTE 2	-DO-	-DO-	
2.3.	BLADES & IMPELLER RING	SHAPE & PROFILE	MAJOR	CHECK WITH TEMPLATE	100%	DRAWING	DRAWING & NOTE 2	-DO-	-DO-	
2.4.	BRG. HOUSING & COVER	1) BORE 2) LENGTH	MAJOR	-DO-	100%	DRAWING	DRAWING	-DO-	-DO-	
2.5.	WELD QUALITY	EXTERNAL FINISH & SIZE	MAJOR	VISUAL & MEASURE- MENT	100%	DRAWING	DRAWING & NOTE 1 & 2	-	-DO-	
		BUTT WELDS OF IMPELLERS	CRIT- CAL	MT*	100%	BHE: NDT: RP: MT1/ LATEST		NDT REPORT	-DO-	* MT FROM BOTH SIDES OF COVER PLATE
		FILLET WELDS FOR IMPELLERS AFTER STRESS RELIEF	CRIT	PT/MT	100%	BHE: NDT: RP: MT1/ LATEST BHE: NDT: RP: PT1/ LATEST		-DO-	-DO-	
2.6.	STRESS RELIEF OF IMPELLERS	COMPLIANCE TO STRESS RELIEF CYCLE	MAJOR	TIME & TEMP CHART VERIFI- CATION	100%	BAP: HT: 001/ LATEST		HEAT TREATMENT CHART	-DO-	

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2.7.	DYNAMIC BALANCING	RESIDUAL UNBALANCEMENT	CRITI- CAL	UNBALANCE COMPENSAT- ION	100%		DRAWING	BLNG. REPORT	SUBCON- TRACTOR	
2.8.	STATIC PARTS [SPIRAL CASING SUCTION CONE, BEARING PEDESTAL]	DIMENSIONS	CRITI- CAL	MEASURE- MENT	100%		DRAWING	DRAWING	DR	-DO-
	FINAL INSPECTION	a) FINISH PAINTING, PRESERVATION, IDENTIFICATION & PACKING	MAJOR	VISUAL	100%		RP 0674199 AND PACKING DRAWING NOTE 3	—	-DO-	
		DR : DIMENSIONS REPORT								

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- NOTE 1: 1) WELDERS SHALL BE QUALIFIED AS PER AWS D1.1. /ASME SECTION IX /LATEST
 2) LOW HYDROGEN ELECTRODES SHALL BE BAKED FOR 2 Hrs AT 350 DEG C' AND DRIED AT 150 DEG C' BEFORE WELDING.
 3) ELECTRODES OPENED TO ATMOSPHERE MORE THAN 4 Hrs SHALL BE REBAKED
 4) SEQUENCE OF WELDING SHALL BE ADOPTED
 5) FULL PENETRATION WELD SHALL BE ENSURED BY BACK CHIPPING
 6) DEFECTS LIKE CRACKS, POROSITY, UNFUSED METAL, SHALL BE REMOVED WHILE WELDING
 7) WELD SHALL BE FREE FROM OIL GREASE, RUST ETC, & CRATER TO BE REMOVED
 8) THE TOES OF THE FILLET WELDS SHALL BE SMOOTHLY GROUND FOR THE LENGTH AS SHOWN IN THE DRG.
 09) BUTT WELDS SHALL BE GROUND FLUSH.
 10) TACKS AND BRIDGES SHALL BE REMOVED BY CHIPPING
 11) NO JOINT IS ALLOWED ON THE BACK PLATE OR IMPELLER RING'

- NOTE 2: 1) PLATES CUT BY FLAME SHALL BE CLEANED TO REMOVE SLAG & UNEVEN EDGES
 2) GAS CUT NOTCHES SHALL BE FILLED BY WELDING .

- NOTE 3: 1) THE IMPELLERS SHALL BE PAINTED AND PUNCHED WITH FOLLOWING DETAILS
 WORKORDER NO, DU NO, SLNO & SUBCONTRACTOR CODE . DIRECTION OF ROTATION OF IMPELLER SHALL BE
 2) SHAFTS SHALL BE PUNCHED WITH ABOVE DETAILS ON BOTH FACES
