

MAIN SUPPLIER BHEL-PIPING CENTRE 	MANUFACTURER'S NAME AND ADDRESS	TENDER QUALITY PLAN			
		ITEM : 1) HC/LC SPRAY CONTROL VALVE 2) LC PRESSURE CONTROL VALVE 3)COMMON SPRAY BLOCK VALVE	QP NO. PC-ND-SPCV-QP-01 REV.NO.:00 DATE: 18/12/2017	PROJECT : NABINAGAR (3X660 MW) & DARLIPALLI (2X800 MW)	
				CUSTOMER : NTPC	
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SL No	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTITY OF CHECK	REFERENCE DOCUMENT #	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY			REMARKS
1	2	3	4	5	6	7	8	9	* D	**			
										M	C	N	
1.0 MATERIAL (All material of Construction shall be as per approved drawing/ datasheet and Acceptance norms shall be as per relevant standards)													
1.1	BODY, BONNET – CASTING / FORGING, STEM, DISC, SEAT	CHEMICAL &MECHANICAL PROPERTIES	B	REVIEW OF MTC	100 %	NTPC APPROVED DRAWING / DATASHEET / MATERIAL SPECIFICATION		MTC	√	P	V	V	ONLY FOR RATING 900 & ABOVE
		SOUNDNESS		RT/UT FOR BODY, UT FOR BONNET	100 %	ASME B 16.34		IR	√	P	V	V	
				UT FOR DIA ≥ 50 mm	100 %	ASME B 16.34			√	P	V	V	Relevant IBR Forms shall be furnished.
		DIMENSION	B	MEASUREMENT	100 %	APPROVED DRAWING / DATASHEET		IR			V	V	
1.2	FASTENERS	CHEMICAL &MECHANICAL PROPERTIES	B	CHEMICAL & MECHANICAL		APPROVED DRAWING / DATASHEET / MATERIAL SPECIFICATION		MTC	√	P	V	-	
1.3	ACCESSORIES	VERIFICATION OF TC	B	TC REVIEW	100 %	APPROVED DRAWING / DATASHEET		TC	√	P	V	V	
	2.0 INPROCESS INSPECTION												
2.1	MACHINING OF BODY INTERNALS	DIMENSION	B	MEASUREMENT	100 %	APPROVED DRAWING		IR	-	P	-	-	@ ALL ACCESSIBLE AREAS
		SURFACE DEFECTS	B	MT/PT ON MACHINED SURFACES	100% @	ASME SEC V	ASME SEC VIII – DIVISION 1	IR	√	P	V	V	
2.2	WELDING	a) WELDING PARAMETER - WPS, PQR	B	REVIEW OF RECORDS	100 %	ASME SEC IX	ASME SEC IX	WPS, PQR	√	P	V	V	
		b) WELDER PERFROMANCE - WPQ	B	REVIEW OF RECORDS	100 %	IBR	IBR	WPQ	√	P	V	V	
		c) NDT – RT ON BUTT WELD	B	NDE	100 %	ASME SEC V / VIII	ASME SEC VIII – DIVISION 1	IR	√	P	V	V	
		d) LPI ON FILLET/ BRANCH/ ATTACHMENT WELD	B	NDE	100 %	ASME SEC V / VIII	ASME SEC VIII – DIVISION 1	IR	√	P	V	V	
2.3	PWHT	TIME & TEMP CONTROL	B	REVIEW OF HT CHART	100 %	HT PROCEDURE		RECORD	√	P	V	V	
	3.0 FINAL INSPECTION												
3.1	BODY MOUNT LEAKAGE TEST	LEAKAGE TEST	A	HYDRO TEST	100 %	ASME B 16.34 / NTPC APPROVED DATA SHEET		TC	√	P	W	W	IBR FORM III C TO BE PROVIDED

		LEGEND: * RECORDS, INDENTIFIED WITH “TICK” (√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. CLASS : A – CRITICAL, B - MAJOR, C -MINOR ** M: MANUFACTURER/SUB-SUPPLIER C: MAIN SUPPLIER(BHEL/BHEL AIA) N: NTPC P: PERFORM W: WITNESS V: VERIFICATION. AS APPROPRIATE	DOC. NO.:		REV..... CAT.....	
MANUFACTURER/ SUB-SUPPLIER	MAIN-SUPPLIER					
SIGNATURE			REVIEWED BY	APPROVED BY	APPROVAL SEAL	

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									D	M	C	N	
3.2	SEAT LEAKAGE TEST	LEAKAGE TEST	A	HYDRO TEST	100 %	FCI 70.2 / NTPC APPROVED DATA SHEET		TC	√	P	W	W	
3.3	FUNCTIONAL / PERFORMANCE TEST	STROKE TIME (OPEN / CLOSE), VALVE TRAVEL, HYSTERESIS, LINEARITY, REPEATABILITY, FAIL SAFE OPERATION	A	MEASUREMENT	100 %	NTPC APPROVED DRAWING / DATASHEET, MANUFACTURER STANDARD		TC	√	P	W	W	
3.4	CV TEST@	VALVE CHARACTERISTICS	A	TYPE TEST	ONE / TYPE	NTPC APPROVED DRAWING / DATASHEET / ISA 75.02		TC	√	P	W/V	W/V	@CHP. NOTE 1
3.5	ACTUATOR	MAKE, MODEL, TAG	A	VISUAL, PNEUMATIC TEST	100 %	APPROVED DATASHEET / MANUFACTURER STANDARD		TC	√	P	W	W	
3.6	FINAL INSPECTION	AIR LEAKAGE TEST											
		COMPLETENESS	B	VISUAL	100 %	APPROVED DRAWING / DATASHEET		IR	√	P	W	W	
		OVERALL DIMENSION	A	MEASUREMENT	100 %	NTPC APPROVED DRAWING / DATASHEET		IR					
		PMI CHECK	A	VERIFICATION	100% Alloy steel	RELEVANT MATERIAL STANDARD		IR	√	P	W	W	
4.0	PAINTING												
	PAINTING	SURFACE PREPARATION, APPEARANCE, DFT, SHADE & ADHESION	B	VISUAL & MEASUREMENT	100 %	NTPC APPROVED PAINTING SCHEME		IR	√	P	V	V	
5.0	PACKING & PRESERVATION												
	PACKING & MARKING	SURFACE CONDITION, CLEANLINESS, MARKING, END CAP	B	VISUAL	100 %	MANUFACTURER'S STANDARD / PURCHASE SPECIFICATION/ PURCHASE ORDER		IR	-	P	V	V	

NOTE :

1. REVIEW OF CV TYPE TEST CLEARANCE FROM NTPC ENGG. CV TYPE TEST REPORTS WILL BE SUBJECTED TO NTPC REVIEW. INCASE, TYPE TEST CERTIFICATE NOT FOUND VALID, SAME SHALL BE CONDUCTED IN FCRI/NABL ACCREDITED LAB/ANY GOVT APPVD LAB/SUPPLIER'S OWN LAB.

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