

MAIN SUPPLIER BHEL-PIPING CENTRE 	MANUFACTURER'S NAME AND ADDRESS	MANUFACTURING QUALITY PLAN		PROJECT : NEW NEYVELI (1X500 MW)
		ITEM : AUX. PRDS DESUPERHEATER	QP NO. PC--DSH-QP-01	CUSTOMER : NLC
		SUB-SYSTEM:	REV.NO.:00	PAGE: 1 OF 2
			DATE: 18/12/2017	

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	
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	PIPE	CHEMICAL &MECHANICAL PROPERTIES SOUNDNESS – UT DIMENSION & VISUAL	B	REVIEW OF MTC & DIMENSIONAL REPORT	100 %	APPROVED DRAWING / DATASHEET / MATERIAL SPECIFICATION AND ASME B 16.34		MTC, IBR FORM III A	√	P	V	
		PMI FOR ALLOY STEEL	A	PMI	100 %			MATERIAL SPECIFICATION	IR	√	P	
1.2	NOZZLE (FORGING)	CHEMICAL &MECHANICAL PROPERTIES -HARDNESS	B	REVIEW OF MTC	100 %	APPROVED DRAWING / DATASHEET / MATERIAL SPECIFICATION		MTC	√	P	V	
		SOUNDNESS	B	UT	100 %			ASME B 16.34	IR	√	P	
2.0 INPROCESS INSPECTION												
2.1	MACHINING OF BODY INTERNALS	DIMENSION	B	MEASUREMENT	100 %	APPROVED DRAWING		IR	√	P	-	
		SURFACE DEFECTS	B	LPI ON MACHINED SURFACES	100%	ASME SEC V	ASME SEC VIII – DIV 1	IR	√	P	-	
2.2	WELDING	a) WPS, PQR,WPQ	A	REVIEW OF RECORDS	100 %	ASME SEC IX	ASME SEC IX	WPS, PQR	√	P	V	
		b) WELDER PERFORMANCE - WPQ	A	REVIEW OF RECORDS	100 %	IBR	IBR	WPQ	√	P	V	
		c) RT ON BUTT WELD	B	RT	100 %	ASME SEC V	ASME SEC VIII – DIV 1	IR	√	P	V	
		d) LPI ON FILLET/BRANCH /ATTACHMENT WELD	B	LPI	100 %	ASME SEC V	ASME SEC VIII – DIV 1	IR	√	P	V	
2.3	PWHT @	TIME & TEMP CONTROL	B	REVIEW OF HT CHART	100 %	HT PROCEDURE		RECORD	√	P	V	@ as applicable
		MPI, UT, HARDNESS AFTER PWHT	B	NDE	100 %	ASME SEC V / VIII	ASME SEC VIII – DIV 1	IR	√	P	V	
3.0 FINAL INSPECTION												
3.1	ASSEMBLY LEAK TIGHTNESS TEST	HYDRO PRESSURE TEST	A	LEAKAGE TEST	100 %	ASME B 16.34 / APPROVED DATA SHEET		IR	√	P	W	
3.2	FINAL INSPECTION	COMPLETENESS	B	VISUAL	100 %	APPROVED DRAWING / DATASHEET		IR	√	P	W	
		DIMENSION	B	MEASUREMENT	100 %	APPROVED DRAWING / DATASHEET						
4.0 PAINTING												
	PAINTING	SURFACE PREPARATION, APPEARANCE , DFT , SHADE & ADHESION	B	VISUAL & MEASUREMENT	100 %	BHEL APPROVED PAINTING SCHEME		IR	√	P	V	

		LEGEND: * RECORDS, IDENTIFIED 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) P : PERFORM W : WITNESS V : VERIFICATION. AS APPROPRIATE CHP : CUSTOMER HOLD POINT	DOC. NO.:		REV..... CAT.....	
MANUFACTURER/ SUB-SUPPLIER	MAIN-SUPPLIER					
SIGNATURE			REVIEWED BY	APPROVED BY	APPROVAL SEAL	

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					M C / N				D*	M	C	

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		
6.0	DOCUMENTATION											
	QUALITY DOCUMENTATION	COMPLETENESS OF RECORDS	B	REVIEW OF DOCUMENTS	100 %	TECH. SPEC / APPD. DRG / IBR FORM	DOC. PACKAGE, IBR FORM III C, TEST REPORTS	√	P	V		IBR FORM III C SHALL BE PROVIDED

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