

BHARAT HEAVY ELECTRICALS LIMITED, CFP RUDRAPUR												
CUSTOMER:		QUALITY ASSURANCE PLAN(QAP) For Raw Material of Transformer Tank				MATERIAL INSPECTION/INPROCESS INSPECTION/FINAL INSPECTION		SUB VENDORS/ VENDORS/ CONTRACTORS WORKS		DOC NO : QLY/TT/RM/00 REV NO: 00 DATE: 05.06.2020 PAGE : 1 OF 1		
SL. No.	COMPONENT	CHARACTERISTICS	CATEGORY	METHOD OF CHECK	EXTENT OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORDS	AGENCY			REMARKS(If any)
									P	R	W	
1.0	Raw Material (Al. Plate, Angle, Tube, Bar etc)	a) Visual	Major	Visual	100 %	Should be free from any surface defects, voids / BHEL Spec	Should be free from any surface defects, voids / BHEL Spec	IR	2		1	
		b) Dimension	Major	Measurement	100 %	BHEL PO / BHEL Spec.	BHEL PO / BHEL Spec.	IR	2		1	
		c) Chemical Composition	Major	TC	100%	Grade as per BHEL PO / BHEL Spec.	BHEL Spec: Aluminium specification of 7775 KVA /6531 KVA Locomotive Transformer Tank Dated : 01.02.2020 Rev.00	TC/IR	2	1		Supplier/Manufacturer TC will be reviewed for 100% lot.
			Major	TEST	1 Sample/Lot	Grade as per BHEL PO / BHEL Spec.	BHEL Spec: Aluminium specification of 7775 KVA /6531 KVA Locomotive Transformer Tank Dated : 01.02.2020 Rev.00	TC	3		1	1 Sample of each type of material will be witnessed for Chemical composition at any NABL accredited LAB
		d) Mechanical Properties - Tensile Strength Test. - Yield Stress Test - Elongation Test	Major	TC	100%	Grade as per BHEL PO / BHEL Spec.	BHEL Spec: Aluminium specification of 7775 KVA /6531 KVA Locomotive Transformer Tank Dated : 01.02.2020 Rev.00	TC/IR	2	1		Supplier/Manufacturer TC will be reviewed for 100% lot.
			Major	TEST	1 Sample/Lot	Grade as per BHEL PO / BHEL Spec.	BHEL Spec: Aluminium specification of 7775 KVA /6531 KVA Locomotive Transformer Tank Dated : 01.02.2020 Rev.00	TC	3		1	1 Sample of each type of material will be witnessed for mentioned Mechanical tests at any NABL accredited LAB

REF: A) Engineering mail dated 07.02.2020 regarding material specification.
B) Aluminium specification of 7775 KVA /6531 KVA Locomotive Transformer Tank Dated : 01.02.2020 Rev.00.
C) Engineering mail dated 04.03.2020 & 05.06.2020 regarding mechanical testing.

ABBREVIATIONS:

R= REVIEWED BY
P= PERFORMED BY
W= WITNESSED BY

SPEC= SPECIFICATION
TC= TEST CERTIFICATE
IR= INSPECTION REPORT
PO = PURCHASE ORDER

3= EXTERNAL NABL LAB.
2= MANUFACTURER /SUPPLIER
1= BHEL/BHEL INSPECTION AGENCY

Rawindar
05/06/2020
QUALITY

Q. S. A.
05/06/2020

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05/06/2020
ENGINEERING

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05/06/2020