



BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPPALLI - 620014

QA:CI:STD:QP:73

Rev: 00

Page: 1 of 3

CONTROLS AND INSTRUMENTATION/QA/FB

STANDARD QUALITY PLAN FOR

SENSOR, SONIC TUBE ASSEMBLY AND PURGE ACCESSORIES

REV	DATE	PREPARED	REVIEWED	APPROVED	REVISION HISTORY
00	15/06/2013	RM.VAIRAVAN 	N.SRIDHAR 	K.PALANIVEL 	Initial release.



BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPPALLI - 620014

QUALITY PLAN FOR
SENSOR, SONIC TUBE ASSEMBLY AND
PURGE ACCESSORIES

QA:CI:STD:QP:73

Rev: 00

Page: 2 of 3

Sl. No	Component & Operation	Characteristics	Class	Type of Check	Quantum of check		Ref Doc. & Acceptance STD	Format of record	AGENCY			Remarks
					M	B/C			M	B	C	
A	Finished Product Inspection											
1.	Sensor Assembly	a. Material	Major	CHEM	Sample	Sample	IS 2062 & IS 1079	TC	V	V	-	
		b. Over all Dimension	Major	MEAS	100%	20%	BHEL Specification & BHEL Approved Drawings	TR	P	W	-	
		c. Verification of BOM	Major	VISU	100%	100%	-Do-	TR	P	W	-	
2	Sonic Tube Assembly	a. Material	Major	CHEM	Sample	Sample	IS 2062 & IS 1079	TC	V	V	-	
		b. Over all Dimension	Major	MEAS	100%	20%	BHEL Specification & BHEL Approved Drawings	TR	P	W	-	
		c. Verification of BOM	Major	VISU	100%	100%	-Do-	TR	P	W	-	
		d. Straightness of Assembly	Major	VISU	100%	20%	-Do-	TR	P	W	-	
		e. Bend Alignment	Major	VISU	100%	20%	-Do-	TR	P	W	-	
		f. Hydro test on Pipe Line	Major	ENVI	100%	100%	-Do-	TR	P	W	-	1.5 Times of rated pressure
		g. Paint shade & Surface Finish	Major	VISU	100%	20%	-Do-	TR	P	W	-	
3	Purge accessories	a. Material	Major	CHEM	Sample	Sample	IS 2062 & IS 1079	TC	V	V	-	
		b. Over all Dimension	Major	MEAS	100%	20%	BHEL Specification & BHEL Approved Drawings	TR	P	W	-	
		c. Alignment	Major	VISU	100%	20%	-Do-	TR	P	W	-	

M- MANUFACTURER/ SUB-VENDOR; B - BHEL / TPI ; C - CUSTOMER / TPI
P - PERFORM; W - WITNESS V - VERIFICATION;



BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPPALLI - 620014

QUALITY PLAN FOR
SENSOR, SONIC TUBE ASSEMBLY AND
PURGE ACCESSORIES

QA:CI:STD:QP:73
Rev: 00 Page: 3 of 3

B.NOTES:

1.LEGENDS:

TR	:	Test Report	MEAS	:	Measurement
VISU	:	Visual	TC	:	Test Certificate
ENVI	:	Environment	CHEM	:	Chemical

- The vendor shall arrange all testing facilities at their works. Tests for which facilities are not available are to be carried out at recognized National Test Houses like ETDC/CIL/NPL/ERTL etc., at vendor cost.
- Through Log Book / any other documents available at the vendor's works, it shall be possible to correlate the finished products with raw material and in process stage checks / inspection carried out.
- All Measuring and Testing Instruments shall be periodically calibrated from recognized test houses & certificates made available during inspection for verification.

- Test reports for routine test are to be furnished by the vendor.
- Vendor to give tentative inspection program in advance and confirm exact date two weeks in advance for arranging BHEL's inspection.
- Packing shall be as per the "PACKING PROCEDURE" indicated in the specification.

C. REFERENCE STANDARDS:

(For Indicated Standards Refer the Latest Version)

IS 2062	:	Hot Rolled Medium and High Tensile Structural Steel-Specification
IS 1079	:	Hot Rolled Carbon Steel Sheet and Strip Specification

SQP73R0.DOC

M- MANUFACTURER/ SUB-VENDOR; B - BHEL / TPI ; C - CUSTOMER / TPI
P - PERFORM; W - WITNESS V - VERIFICATION;