


BHARAT HEAVY ELECTRICALS LIMITED, RUDRAPUR										
 BHEL/CFP/QC		QUALITY ASSUARANCE PLAN FOR SUBMISSION TO FABRICATION / ASSEMBLY VENDOR		QUALITY ASSURANCE PLAN FOR FABRICATION & ASSEMBLY OF ISOLATED PHASE BUS DUCT		MATERIAL INSPECTION / IN- PROCESS INSPECTION / FINAL INSPECTION		SUB VENDORS / VENDORS / CONTRACTORS WORKS		Doc No. : QP/BD/IP REV.No.: 00 DATE: 15.05.12 Page 1 of 2
Sl. No.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY	
									M	BHEL/ TPI
1	FABRICATION									
1.1	Enclosure & Conductor Fabrication	a) Visual /Finish b) Dimension c) Welding Quality d) DP Test e) Filler Wire Rod Composition / Grade f) Shielding Gas Purity g) Radiography Test	B B B B B B A	V I V T T T T	100% 100% 100% 100% Sample Sample As required between 2% to 10%	BHEL Appd. Drg. BHEL Appd. WPS AA0850131 GDCCD-198	BHEL Appd. Drg. BHEL Appd. WPS AA0850131 GDCCD-198	OS OS OS TC TC TC	P P P P V P	W W W W V V
2	ASSEMBLY									
2.1	Enclosure & Conductor Assembly	a) Visual b) Dimension c) Distance between Insulator d) Painting thickness & Adhesion Test	B B B B	V I I T	100% 100% 100% 100%	BHEL Appd. Drg. BP56184	BHEL Appd. Drg. BP56184	OS OS OS TC	P P P P	W W W W

LEGEND: -

CLASS
A: CRITICAL
B: MAJOR
C: MINOR

TYPE OF CHECK
V: VISUAL
I: MEASUREMENT
T: TEST

AGENCY
M: MANUFACTURER / SUB CONTRACTOR
TPI: NOMINATED INSPECTION AGENCY

SCOPE
P: PERFORMER
V : VERIFICATION
W: WITNESS

FORMAT OF RECORD
TC: TEST CERTIFICATE
OS : OBSERVATION SHEET
Drg.: DRAWING
Ch.List: CHECK LIST

Note Packing to be as per BHEL Drg.

Prepared by


(FARAAZ ALI)

Engineer (QLY)

Checked & Approved by

(B BANERJEE)

Manager (QC)

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3	Final testing on Bus Duct									
3.1	a) Routine Test	a) HV test for 1 min b) IR	A A	T T	100% 100%	IS-8084 IS-8084	IS-8084 IS-8084	TC TC	P P	W W
3.2	b) Type test	a) Air tightness test b) Water tightness Test c) Mili Volt Drop Test (On Straight but weld joint only)	A A A	T T T	Sample Sample Sample	IS-8084 IS-8084 BS:159	IS-8084 IS-8084 BS:159	TC TC TC	P P P	W W W

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