



BHARAT HEAVY ELECTRICALS LIMITED
R.C.PURAM, HYDERABAD

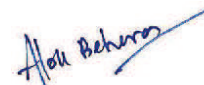
ADDENDA TO VENDOR STANDARD QUALITY PLAN

ITME DESCRIPTION	NAVAL BRASS TUBE PLATE		
PO/PR NO :DATE	8000092891, 17.02.2020		
BHEL SPEC/DRAWING:	BHEL SPEC: HE51516 REV 00.		
PROJECT :	HRRL TOYO TWIN OIL COOLER.		
APPLICABLE SVQP:	HY/QA/VSQP/TCMO/012 REV 01 (Validity of the SQP is extended till the PO delivery Date)		
PROJECT SPECIFIC REQUIREMENTS	1. MATERIAL SHALL CONFORM TO SB171 C46400 OF ASME SEC II PART-B 2019 EDITION. 2. SHALL BE PROCURED FROM CUSTOMER APPROVED VENDOR LIST. 3. CLADDED MATERIALS SHALL BE WITH EN10204 TYPE 3.2 CERTIFICATION & OTHER MATERIAL SHALL BE IN EN10204 TYPE 3.1		
QA REMARK :	 CH. B. V. SIRISHA SR. ENGR/ QA	01.06.2020	STANDARD QAP TO BE FOLLOWED ALONG WITH PROJECT SPECIFIC REQUIREMENT

		BHARAT HEAVY ELECTRICALS LIMITED R.C.PURAM, HYDERABAD		STANDARD QUALITY PLAN FOR VENDOR ITEMS				QP. NO: HY/QA/VSQP/TCMO/012 Rev. No. : 01 DATE: 05.06.2018 VALID UPTO: 04.06.2020 PAGE 1 OF 2					
SI No	Component & Operations	Characteristics	Class	Type Of Check	Quantum Of Check	Ref Document	Acceptance Norms	Format Of Record	* D	Agency			Remarks
										P	W	V	
1.0	AT SUPPLIERS WORKS												
1.1	PLATES	CHEMICAL COMPOSITION	MAJOR	CHEMICAL	AS PER SPEC.	SB 171M & BHEL SPECIFICATION	SB 171M & BHEL SPECIFICATION	SUPPLIERS TC	✓	2		1	
1.2		REVIEW OF HEAT TREATMENT CHART	MAJOR	REVIEW	100%	SB 171M & BHEL SPECIFICATION	SB 171M & BHEL SPECIFICATION	HT CHART	✓	2		1	
1.3		MECHANICAL PROPERTIES	MAJOR	MECH.	AS PER SPEC.	SB 171M & BHEL SPECIFICATION	SB 171M & BHEL SPECIFICATION	SUPPLIERS TC	✓	2	1		
1.4		UT EXAM. OF PLATES AFTER MACHINING	MAJOR	NDE	100%	SA 578	LEVEL B OF SA 578M	SUPPLIERS TC	✓	2	1		NOTE 1
1.5		VISUAL EXAM AND DIMENSIONS	MAJOR	VISUAL & MEASURT.	100%	DRAWING, BHEL SPEC. & SB-171M	DRAWING, BHEL SPEC. & SB-171M	SUPPLIERS TC	✓	2	1		CHP
1.6		FLATNESS	MAJOR	MEASURT.	100%	DRAWING, BHEL SPEC. & SB-171M	DRAWING, BHEL SPEC. & SB-171M	SUPPLIERS TC	✓	2	1		
1.7		VERIFICATION OF TCS, IDENTIFICATION OF MATERIAL FOR COMPLETION AS PER SPEC. & QP	MAJOR	VISUAL	100%	SB 171M, BHEL SPECIFICATION & QP	SB 171M, BHEL SPECIFICATION & QP	SUPPLIERS TC		2		1	
1.8		PACKING AND MARKING	MAJOR	VISUAL	100%	P.O., DRG. & BHEL SPEC.	P.O., DRG. & BHEL SPEC.	SUPPLIERS TC	✓	2		1	NOTE 4
2.0	AT BHEL												
		VERIFICATION & CORRELATION OF MATERIAL WITH TC	MAJOR	VISUAL	100%	P.O., DRG. & BHEL SPEC.	P.O., DRG. & BHEL SPEC.	INSPN. RECORD		2		1	

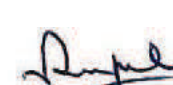
LEGEND:
P: - PERFORM, W: - WITNESS, V: - VERIFICATION,
INDICATING 1: - BHEL / BHEL NOMINATED INSPECTION AGENCY, 2: - VENDOR / SUB VENDOR AS
APPROPRIATE AGAINST EACH COMPONENT / CHARACTERISTICS UNDER THE COLUMNS P, W & V.
* D: RECORDS IDENTIFIED WITH TICK (✓) SHALL BE ESSENTIALLY INCLUDED IN QA DOCUMENTATION.

PREPARED BY:



ALOK BEHERA
SR.ENGR/ QA

REVIEWED BY:



D S SATPUTE
AGM /QA

APPROVED BY:



D S SATPUTE
AGM /QA

		BHARAT HEAVY ELECTRICALS LIMITED R.C.PURAM, HYDERABAD		STANDARD QUALITY PLAN FOR VENDOR ITEMS ITEM: NAVAL BRASS TUBE PLATE BHEL SPEC: HE 51516 Rev.00				QP. NO: HY/QA/VSQP/TCMO/012 Rev. No. : 01 DATE: 05.06.2018 VALID UPTO: 04.06.2020					
								PAGE 2 OF 2					
SI No	Component & Operations	Characteristics	Class	Type Of Check	Quantum Of Check	Ref Document	Acceptance Norms	Format Of Record	* D	Agency P W V			Remarks

Notes:

1. UT has to be performed on plates of all thicknesses.
2. All machined surfaces to be protected by applying rust preventive coating to protect from rust for a minimum period of 6 months.
3. All requirements as per BHEL approved specification & drawing/datasheet are to be complied with.
4. Pre Despatch Photographs shall be included in QC Documentation.

GENERAL NOTES:

1. This QP should be read along with BHEL Spec, BHEL drawings / approved drawings, data sheet, BOM and PO.
2. Latest revisions of specification / drawings as per P.O., approved drawings & bill of materials are applicable.
3. Any other tests/ checks indicated in specification, P.O., or drawing & any additional checks envisaged by BHEL/TPI to ensure workmanship, finish, aesthetics, etc. shall also be conducted and witnessed/verified by BHEL /TPI / customer as required.
4. All test certificates/ reports reviewed and certified by BHEL/TPI shall be submitted to BHEL as documentation package.
5. Drawing / Data Sheet shall prevail over Quality Plan in case of any contradiction between Quality Plan and Drawing / Data Sheet.
6. Any project / customer specific requirement, like QP approval & Customer/Consultant Inspection, which shall be notified have to be fulfilled by the vendor at the time of execution of order.
7. This QP shall not be applicable to the orders for which QP approval & Inspection by customer/consultant is required.
8. This SQP is not applicable for vendors supplying this item for the first time to BHEL.

MTC – Mill Test Certificate

TC – Test Certificate

IR – Inspection Report

COC – Certificate of Conformity

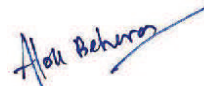
TPIA – Third Party Inspection Agency appointed by BHEL.

PO – Purchase Order

LEGEND:

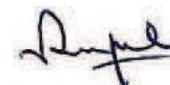
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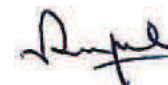
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