



QUALITY ASSURANCE
BHEL, IVP- GOINDWAL

QUALITY PLAN FOR BALL-SEAT RING ASSEMBLY OF BALL VALVE

QP No: QP:IVP:BV Rev.:00
Date:04-04-2014
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Sl. No.	Component/Operation	Characteristics	Check			Reference Doc./ Acceptance Stnd.	Type of records	Agency		Remarks	
			Cl.	Type	Quantum			M	C		
1.0	RAW MATERIAL SEAT RING(UPSTREAM/DOWN STREAM) & BALL	Mechanical Properties & Soundness		B	TC Verification	100%	Drawing and TDC no:0404 REV 11	TC	P	V	
2.0	IN PROCESS CONTROL				Measurement/ Dimension Report	100%	Drawing	R	P	V	
2.1	Machining of Components	Critical Dimensions		B	Dimension Report	100%	Drawing	R	P	V	
2.2	LPI test on Chromium Carbide surface	No Visible defect		A	Visual	100%	ASME Section V	R	P	W	10% of total lot
2.3	Chromium Carbide surface Hardness	Hardness value		A	TC Verification	100%	Drawing	TC	P	W	10% of total lot
2.4	Chromium Carbide thickness	Coating Thickness Value		A	TC Verification	100%	Drawing	TC	P	W	10% of total lot
2.5	Lapping on Chromium Carbide surface	Surface Roughness Value		A	Surface Roughness measurement	100%	Drawing	R	P	W	10% of total lot
2.6	Stellite 6 surface (As applicable)	No Visible defect		A	Visual	100%	BHE:NDT:W:PT:02/Latest	R	P	W	10% of total lot
3.0	FINAL INSPECTION						Continuous impression for metal to metal contact	R	P	W	100%
3.1	Blue Matching	Matching Impression		A	Matching Impression	100%		R	P	W	100%

LEGEND:C:Class (A:Critical,B:Major)

M: Manufacturer, C: BHEL/ Nominated Inspection Agency

R: Test / Dimension / Inspection Reports

V: Verification of test/Dimension/Insp Reports

P: Perform, W: Witness

Prepared By

PRIKSHIT RAVESH
Sr. ENGINEER (QM)

Reviewed & Approved By:

S.R.KENNY
DGM (QM)



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IVP-GOINDWAL

QUALITY PLAN FOR BALL-SEAT RING ASSEMBLY OF BALL VALVE

QP No: QP-IVP:06 Rev.:00
Date: 08-11-2010
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NOTE:- 1 Wherever special contract requirements are envisaged a separate TDC/CQP may be issued, special instructions may be provided through P. O, or stock material may be upgraded to special requirements.

NOTE:- 2 Machined/ Lapped surfaces should be placed/stacked on rubber sheet and should be protected from any damage. Packing should be secured enough so that the assembly is not damaged during transit.

NOTE:-3 Material to be offered for inspection to BHEL / TPI before final assembly. Records as mentioned in Quality Plan by BHEL to be produced during Final inspection.

Remarks:Raw material to be used is A182-F316

Note: 1. Visible - solvent removable die and Non-aqueous developer to be used for PLI test At CI 202

2. No indication acceptable in LPI test at CI 2.2

3. This QP is with ref.to TDC no TBV:001

LEGEND:C:Class (A:Critical,B:Major)

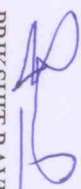
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