



<b>MAIN SUPPLIER</b> <b>BHEL-PIPING CENTRE</b> 	<b>MANUFACTURER'S NAME AND ADDRESS</b>	<b>MANUFACTURING QUALITY PLAN</b>		<b>PROJECT : NABINAGAR (3X660 MW) &amp; DARLIPALLI (2X800 MW)</b>	
		<b>ITEM : AUX. PRDS DESUPERHEATER</b>	<b>QP NO. PC-ND-DSH-QP</b> <b>REV.NO.:00</b>	<b>CUSTOMER : NTPC</b>	
		<b>SUB-SYSTEM:</b>	<b>DATE: 30/05/2016</b>	<b>PAGE: 1 OF 2</b>	

SL No	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT #	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY			REMARKS
1	2	3	4	5	6	7	8	9	*	**			
									D	M	C	N	
1.0 MATERIAL													
1.1	PIPE	CHEMICAL &MECHANICAL PROPERTIES SOUNDNESS – UT DIMENSION & VISUAL	B	REVIEW OF MTC & DIMENSIONAL REPORT	100 %	APPROVED DRAWING / DATASHEET / MATERIAL SPECIFICATION AND ASME B 16.34		MTC, IBR FORM III D / III A, AS APPLICABLE	√	P	V	V	@10% DURING FINAL INSPECTION
		PMI FOR ALLOY STEEL	A	PMI	100 %	MATERIAL SPECIFICATION		IR	√	P	W @	V	
1.2	NOZZLE (FORGING)	CHEMICAL &MECHANICAL PROPERTIES -HARDNESS	B	REVIEW OF MTC	100 %	APPROVED DRAWING / DATASHEET / MATERIAL SPECIFICATION		MTC	√	P	V	V	
		SOUNDNESS	B	UT	100 %	ASME B 16.34		IR	√	P	V	V	
2.0 INPROCESS INSPECTION													
2.1	MACHINING OF BODY INTERNALS	DIMENSION	B	MEASUREMENT	100 %	APPROVED DRAWING		IR	√	P	-	-	
		SURFACE DEFECTS	B	LPI ON MACHINED SURFACES	100%	ASME SEC V	ASME SEC VIII – DIV 1	IR	√	P	-	-	
2.2	WELDING	a) WPS, PQR,WPQ	A	REVIEW OF RECORDS	100 %	ASME SEC IX	ASME SEC IX	WPS, PQR	√	P	V	V	
		b) WELDER PERFORMANCE - WPQ	A	REVIEW OF RECORDS	100 %	IBR	IBR	WPQ	√	P	V	V	
		c) RT ON BUTT WELD	B	RT	100 %	ASME SEC V	ASME SEC VIII – DIV 1	IR	√	P	V	V	
		d) LPI ON FILLET WELD	B	LPI	100 %	ASME SEC V	ASME SEC VIII – DIV 1	IR	√	P	V	V	
2.3	PWHT	TIME & TEMP CONTROL	B	REVIEW OF HT CHART	100 %	HT PROCEDURE		RECORD	√	P	V	V	
		MPI, UT, HARDNESS AFTER PWHT	B	NDE	100 %	ASME SEC V / VIII	ASME SEC VIII – DIV 1	IR	√	P	V	V	
3.0 FINAL INSPECTION													
3.1	ASSEMBLY LEAK TIGHTNESS TEST	HYDRO PRESSURE TEST	A	LEAKAGE TEST	100 %	ASME B 16.34 / APPROVED DATA SHEET		IR	√	P	W	W	
3.2	FINAL INSPECTION	COMPLETENESS	B	VISUAL	100 %	APPROVED DRAWING / DATASHEET		IR	√	P	W	W	
		DIMENSION	B	MEASUREMENT	100 %	APPROVED DRAWING / DATASHEET							
4.0 PAINTING													
	PAINTING	SURFACE PREPARATION, APPEARANCE , DFT , SHADE & ADHESION	B	VISUAL & MEASUREMENT	100 %	NTPC APPROVED PAINTING SCHEME		IR	√	P	V	V	

		<b>LEGEND:</b> * RECORDS, IDENTIFIED WITH “TICK” (√) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION. CLASS : A-CRITICAL B-MAJOR C-MINOR ** M: MANUFACTURER/SUB-SUPPLIER C: MAIN SUPPLIER(BHEL/BHEL AIA) N:NTPC  P: PERFORM W: WITNESS V: VERIFICATION. AS APPROPRIATE CHP : CUSTOMER HOLD POINT	<b>DOC. NO.:</b>		<b>REV..... CAT.....</b>	
<b>MANUFACTURER/ SUB-SUPPLIER</b>			<b>MAIN-SUPPLIER</b>			
<b>SIGNATURE</b>					<b>REVIEWED BY</b>	<b>APPROVED BY</b>

<b>MAIN SUPPLIER</b> <b>BHEL-PIPING CENTRE</b> 	<b>MANUFACTURER'S NAME AND ADDRESS</b>	<b>MANUFACTURING QUALITY PLAN</b>		<b>PROJECT : NABINAGAR (3X660 MW) &amp; DARLIPALLI (2X800 MW)</b>		
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					M C / N			D*	M C N	

<b>5.0</b>	<b>PACKING &amp; PRESERVATION</b>									
	PACKING & MARKING	SURFACE CONDITION, CLEANLINESS, MARKING, END CAP	B	VISUAL	100 %	MANUFACTURER'S STANDARD / PURCHASE SPECIFICATION / PURCHASE ORDER	IR	-	P	V -
<b>6.0</b>	<b>DOCUMENTATION</b>									
	QUALITY DOCUMENTATION	COMPLETENESS OF RECORDS	B	REVIEW OF DOCUMENTS	100 %	TECH. SPEC / APPD. DRG / IBR FORM	DOC. PACKAGE, IBR FORM III C, TEST REPORTS	√	P	V V IBR FORM III C SHALL BE PROVIDED

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<b>MANUFACTURER/ SUB-SUPPLIER</b>	<b>MAIN-SUPPLIER</b>					
<b>SIGNATURE</b>			<b>REVIEWED BY</b>	<b>APPROVED BY</b>	<b>APPROVAL SEAL</b>	