

NTPC LIMITED

(SINGRAULI SUPER THERMAL POWER STATION)

REFERANCE QUALITY PLAN FOR BULL RING SEGMENTS
BOWL MIL XRP - 1003

MATERIALCODE: M4761057090
Ref.no-031/ FQA / QP / 2015 /

DATE: 11.07.2015

SL. NO.	COMPONENT / OPERATION	NATURE OF CHECK	CLASS OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	REMARKS
01	Pouring	Process	B	100%	As per NTPC specn / Drg	As per NTPC specn / Drg	Records to be reviewed
02	Heat Treatment	Process	B	100%			
03	Chemical composition	Chemical	A	100%by Vendor&10% by NTPC	As per NTPC specn / Drg	As per NTPC specn / Drg	To be checked by XRF analyzer
04	Dimensional	Measurement / Template	A	100% by vendor & 10% by NTPC	As per NTPC specn / Drg	As per NTPC specn / Drg	All 'A' class checks to be witnessed by NTPC rep.
05	Hardness	Measurement	A	100% by vendor & 10% by NTPC			
06	Micro structure	Micro test	A	Random / Min.2 sample			
07	Fitment	Fitment in test Bowl	A	100% by vendor & 10% by NTPC			
08	Surface Defects	MPI	A	10%	ASME Sec- V	ASME Sec- V	
09	Surface condition	Visual	A	100%	As per NTPC specn/ Drg	Free from heavy surface inclusions and dents smooth as ground.	

Prepared By:

R.B.TIWARI
Manager (BMD)

R.B. Tiwari
11/7/15

Reviewed
Chandrasekhar
11/07/15

Approved By:

Chandrasekhar
11/07/15
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NTPC LIMITED

(SINGRAULI SUPER THERMAL POWER STATION)

REFERANCE QUALITY PLAN FOR GRINDING ROLLS
BOWL MIL XRP - 1003

MATERIALCODE: M4761057091
Ref.no-031/ FQA / QP / 2015 /

DATE: 11.07.2015

SL. NO.	COMPONENT /OPERATION	NATURE OF CHECK	CLASS OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	REMARKS
01	Raw material a) Chemical	Chemical	B	1 Per lot	NTPC Drawing	NTPC Drawing	TC from Govt. approved lab.
02	In process a) Heat treatment	Stress relieving	A	100%	210-235 Deg C- for 4 Hours	210-235 Deg C- for 4 Hours	HT chart will be Reviewed by NTPC
03	Final Inspection a) Hardness	Measurement	A	100%	550 BHN Minimum	550 BHN Minimum	CHP
	b) Dimension	Measurement	A	10%	NTPC Drawing	NTPC Drawing	CHP
	c) Blue match	Visual	A	100%	NTPC Drawing	NTPC Drawing	CHP
	d) Micro structure	Micro Examination	A	1 per heat	Carbide embedded in a matrix of marten site and 30% max. retained austenite	Carbide embedded in a matrix of marten site and 30% max. retained austenite	CHP
	e) Surface crack	MPI	A	10%	ASME Sec-v	ASME Sec-v	CHP
	f) Soundness	UT	A	100%	ASME Sec-v	ASME Sec-v	CHP
	g) Chemical	Chemical composition	A	100% By Vendor & 10% by NTPC	NTPC Drg./ P.O. Spec	ASME Sec-v	To be checked by XRF analyzer

CHP : Customer hold point to be witnessed by NTPC representative during PDI, Lot size = 15 Nos.

Prepared By:

R.B.TIWARI
Manager (BMD)

Reviewed
Champak Kumar
11/07/15

Approved By:

Champak Kumar
11/07/15
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