

## **DETAIL OF WORK FOR STAND PIPE I AND II**

STD.MFG.QP.NO.HYQA/HE/SQP/500/01

1. Vendor to be qualified to IBR by Director of Boilers of concerned state
2. IBR certificate in form -III/IV shall be submitted by the supplier along with equipment.
3. If the job is loaded outside of the Telangana state, vendor shall get drawings approved by DOB of concerned state prior to manufacture of assembly.
4. The complete equipment shall be manufactured as per IBR CHAPTER - XII (CLASS - 1 BOILER) and ASME Sec.VIII,Div.1-2013,HE-2011
- 5.Stages of Inspection by IBR shall be as per Q.P.No.HYQA/SQP/500/01 additional stages of inspection as desired by IBR authorities shall also be offered.
6. All materials of the equipment shall be supplied as per bill of materials with attestation by BHEL QC, IBR and review of records as per quality plan.
7. Welders qualified to IBR code, shall be employed on the job.
8. Welding procedure to be qualified by BHEL QC as per ASME Sec.IX .
- 9.Check for the identification of all welds(weld No. punched for correlation with welder)inspection by BHEL QC/TPIA.
- 10.Qualified painters shall only be used on the job.
11. Adhere strictly to the notes/remarks/instruction's mentioned on the individual, sub-assy. and main drgs.
12. Assemble parts as Stand pipe -I and Stand pipe - II separately. Inspection by QC/TPIA and IBR.
13. Follow drg. nos. 2-16310-00014/Rev.02 for weld details and WPS nos.
14. Assemble plugs to couplings and blind all openings.
15. Hydraulic test is to be conducted for Stand pipes I & II separately, to pressure as indicated in the drg. in presence of QC/TPIA and IBR as per Std.HY0852061 and IBR regulation 601.
16. Drain the water completely from Stand pipes I & II and send hot air to dry the internal surfaces.
17. Shot/grit blast outside surfaces of Stand pipes I & II.

18. Clean thoroughly the outer surfaces of stand pipes I & II.
19. Paint the external surface of Stand pipes I & II with one coat of zinc silicate primer and Two coats of Heat Resistant Aluminum paint as per AA56134.
20. Stage and final inspection as per QP.