

QUALITY ASSURANCE PLAN (QAP)

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ITEM	GATE, GLOBE AND CHECK VALVES								
MATERIALS	CAST & FORGED STEEL								
PROJECT	THERMAL POWER PROJECT								
SL. NO	COMPONENT / OPERATION	CONTROL ITEMS	RELEVANT DOCUMENT AND PROCEDURE	FREQUENCY	VENDOR	SII	END CUSTOMER	QUALITY RECORD	REMARKS
RAW MATERIAL									
1	STEEL BODY/BONNET/	CHEMICAL, MECHANICAL, HEAT TREATMENT DETAILS	AS PER APPLICABLE ASTM STANDARDS	FOR EACH HEAT	P	R	R	MATERIAL TEST CERTIFICATE	REF. NOTE 1
2	STEM/ DISC/WEDGE/SEAT RINGS/ HING PIN/COVER/ SEAT RING	CHEMICAL, MECHANICAL, HEAT TREATMENT DETAILS	AS PER APPLICABLE ASTM STANDARDS	FOR EACH HEAT	P	R	R	MATERIAL TEST CERTIFICATE	REF. NOTE 2
3	FASTNERS	CHEMICAL, MECHANICAL, HEAT TREATMENT DETAILS	AS PER APPLICABLE ASTM STANDARDS	FOR EACH HEAT	P	R	R	MATERIAL TEST CERTIFICATE	-
IN PROCESS INSPECTION									
4	MACHINING DIMENSION OF BODY/BONNET/ WEDGE/SEAT RING	VISUAL & DIMENSION CHECK	AS PER MFG. DRAWING	100%	-	P	R	INSPECTION REPORT	-
		PT (ONLY OVERLAY & BUTT WELD END, IF APPLICABLE)	ASME SEC-VIII DIV.1/ASME B16.34	100%	-	P	R	PT REPORT	REF. NOTE 3 & 4
FINAL INSPECTION									
5	TESTING	HYDRO SHELL	AS PER APPROVED GA DRAWING	100%	-	P	10% - W	INSPECTION REPORT	-
		HYDRO SEAT						INSPECTION REPORT	-
		PNEUMATIC (AIR)						INSPECTION REPORT	-
		BACK PRESSURE TEST						INSPECTION REPORT	FOR GATE & GLOBE VALVE 80mm AND ABOVE
6	VISUAL, DIMENSION CHECK	DIMENSIONS	AS PER APPROVED GA DRAWING	100%	-	P	10% - W	DIMENSION INSPECTION REPORT	-
		NAME PLATE VERIFICATION & FLOW DIRECTION INDICATION	MFG. STANDARD	100%		P	W	PDI CHECK LIST	-
7	FUNCTIONAL CHECK	SMOOTH OPENING & CLOSING	AS PER APPROVED GA DRAWING	100%	-	P	10% - W	INSPECTION REPORT	REF. NOTE 5
8	SURFACE PREPERATION & PAINTING	FINISH, COLOUR	MFG. STANDARD	100%	-	P	R	PAINTING REPORT	NOT APPLICABLE FOR S.S. VALVES
9	FINAL DOCUMENTS	QUALITY DOCUMENTS		100%	-	P	R	-	-
ABBREVIATION: P-PERFORM, W-WITNESSED, R-REVIEW									
NOTE 1: FOR FORGING UT & MPI; FOR CASTING RT & MPI.									
NOTE 2: FOR FORGING SIZE >Ø 40MM UT & MPI TO BE CARRIED OUT.									
NOTE 3. FOR DISC/PLATE WITH SEAT BLUE MATCHING TO BE CARRIED OUT. NOTE 4: FOR STELLITING HARDNESS REPORT.									
NOTE 5: FUNCTIONAL CHECK WITH ACTUATOR AND REVIEW OF ACTUATOR TC.									