



## ANNEXURE - VIII

<b>QUALITY ASSURANCE PLAN</b>					 CE/PED/204		<b>SAWAN ENGINEERS</b> (AN ISO 9001-2000 COMPANY)	
<i>Client</i>	:	<i>QAP NO. &amp; Dt.</i>	:	QAP/SE/F.000 Rev.00				
<i>Contractor</i>	:	<i>PO NO. &amp; Dt.</i>	:					
<i>Consultant</i>	:	<i>Ref.Doc.</i>	:					
<i>Project</i>	:	<i>Moc</i>	:					
<i>Item</i>	:		:					
OPERATION	CHARACTERISTICS	REF. DOC.	FORMAT OF RECORD	TYPE OF CHECK	SE	IA		
<b>RAW MATERIAL INSPECTION</b>								
Pipes / Plates	1.Chemical	Verification of size marking & correlation with Mill test certificate & Check Test Certificate	Applicable codes	Mill T.C. Or Check TC.	Visual, dimensions, verification of marking with MTC & check test if any.	R	R	
<b>IN PROCESS CONTROL</b>								
	FORMING, FORM CORRECTION	Verification of form shape, size & thk.	ANSI MFR. STD	Internal Inspection	Visual, Dimensions, verification of profile & dimension	H	R	
	HEAT TREATMENT	Quenching, Normalising and Tempering	MOC	HT Records	Visual & Review Certification	P	R	
	MACHINING	Verification of size	ANSI MFR. STD	Internal Inspection	Visual & Dimension	P	R	
	CLEANING & FINISHING	Mechanical descaling	---	Internal Inspection	Visual	P	R	
	MARKING	Logo, Matl. Specn., Size, Sch/ Rating, Lot No.	P.O Spec.	SPECIFIED IN T.C.	Visual	P	W	
<b>DESTRUCTIVE TESTING</b>								
	Mechanical Test/Hardness Test	Testing- per heat	MOC	LR	Witness/Scrutiny of the report	H	R / W	
	NDT (whichever applicable)	R.T OF WELDS 100%	ASME Sec V	LR	Witness/Scrutiny of the report	H	R	
		UT of Adjacent For Laminar Defect Welds 100%	ASME Sec V	LR	Witness/Scrutiny of the report	H	R / W	
		M.P.I AT BEVEL ENDS THK≥6MM, D.P. at Bevel if t ≤6MM,100%	ASME Sec V	LR	Witness/Scrutiny of the report	H	R / W	
<b>FINAL</b>								
	Overall Dimension	FFD-100%	ANSI MFR. STD	IIR		W	W	
	Visual Check	FFD-100%		IIR		W	W	
	Marking & final stamping as per standard code requirement					H	R	
	Review of Manufacture's Test Certificate	Correlation of TC			LR	H	R	
	Preparation of documentation and issue of Release Note			Standard	LR	-	H	
ABBREVIATION :		CTC/MTC : CHECK/MIL TEST CERTIFICATE	W : WITNESS	H : HOLD				
		P : PERFORM	FFD : FREE FROM DEFECTS	SE : SAWAN ENGINEERS				
		IIR : INTERNAL INSPECTION REPORT	LR : LAB REPORTS	IA : INSPECTION AGENCY				
NOTE-1 :								
NOTE-2 :								
PREPARED BY		APPROVED BY		APPROVED BY		APPROVED BY		
SAWAN ENGINEERS		[CONTRACTOR]		[CONSULTANT]		[CLIENT/END USER]		