

QUALITY ASSURANCE PLAN (SRCG IM PHASE)									Issue No : 01
									Rev No:
									Date of Issue 10/06/ 2021
Drg . No.	Y17592A-00								
Nomenclature	BLOCK STORAGE WELDED								
Material	As per Assembly Part List.								
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks
Block Storage Welded (Raw material)	General appearance	Non Critical	Visual	100%	As per Assembly Part List.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R	
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R	
In process - Milling,Drilling, Reaming, Threading, Bending, Forming etc.,	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17592A-00	As per Approved Drg No. Y17592A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted
A dry film lubrication in a fluoropolymer organic resin Solvent Color black Class-2.	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17592A-00	TYPE I, 30-40 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).	Firm Inspection report	W	
Welding	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17592A-00	WELDING PER AWS D1.1 GTAW OR GMAW USING ELECTRODE ER308L PER AWS A5.9 OR EQUIVALENT	Firm Inspection report	W	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17592A-00	As per Approved Drg No. Y17592A-00	Firm Inspection report	W	
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Process audit on Dry film lubrication, Welding and Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>									

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Drg . No.	Y17593A-00									OFT/QAP/SRCG/Y17593A-00
Nomenclature	BASE BLOCK STORAGE : REQD FOR BLOCK STORAGE WELDED (Y17592A-00)									
Material	CRES SHEET 5 MM THICK 316L PER ASTM-A-240.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
Base Block Storage (Raw material)	General appearance	Non Critical	Visual	100%	CRES SHEET 5 MM THICK 316L PER ASTM-A-240.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency	
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R		
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R		
In process - As per approved Drg.No. Y17593A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17593A-00	As per Approved Drg No. Y17593A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y17593A-00	As per Approved Drg No. Y17593A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	Y18697A-00									OFT/QAP/SRCG/Y18697A-00
Nomenclature	RIB 1, BLOCK STORAGE : REQD FOR BLOCK STORAGE WELDED (Y17592A-00)									
Material	CRES PLATE 4 MM THICK 316L PER ASTM-A-240.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
RIB 1,Block Storage (Raw material)	General appearance	Non Critical	Visual	100%	CRES PLATE 4 MM THICK 316L PER ASTM-A-240.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency	
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R		
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R		
In process - As per approved Drg.No. Y18697A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18697A-00	As per Approved Drg No. Y18697A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18697A-00	As per Approved Drg No. Y18697A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										

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Drg . No.	Y18698A-00									OFT/QAP/SRCG/Y18698A-00
Nomenclature	RIB 2, BLOCK STORAGE : REQD FOR BLOCK STORAGE WELDED (Y17592A-00)									
Material	CRES PLATE 4 MM THICK 316L PER ASTM-A-240.									
Component Nomenclature/ operations	Characteristics	Class	Type of check	Quantum of check	Reference document	Acceptance norms	Format of record	Inspection by GM/OFT (Review/Witness)	Remarks	
RIB 2,Block Storage (Raw material)	General appearance	Non Critical	Visual	100%	CRES PLATE 4 MM THICK 316L PER ASTM-A-240.		Firm Inspection report	R	Sample will be drawn and sealed by Inspection Agency	
	Chemical properties	Non Critical	Chemical Lab analysis	100%			Test report from NABL lab	R		
	Mechanical properties	Non Critical	Mechanical Lab analysis	100%			Test report from NABL lab	R		
In process - As per approved Drg.No. Y18698A-00	Dimensions Specified in the Inspection report of the component	Non Critical	Dimensional measurement	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18698A-00	As per Approved Drg No. Y18698A-00	Firm Inspection report	W	Firm will be undertaking 100 % Checks and Pre inspection Report for the same be submitted	
Final Inspection	General appearance	Non Critical	Visual and Dimensional Checks	IS 2500 Level II AQL 2.5%	Approved Drg No. Y18698A-00	As per Approved Drg No. Y18698A-00	Firm Inspection report	W		
<p>* Note: 1. Clause indicated in the drawing to be followed 2. Traceability of Raw materials to Final Product (Man,Material,Machine and Methods)</p>										