

**QUALITY ASSURANCE/INSPECTION TEST PLAN-STRUCTURAL FABRICATION**

**CONCEPT PROJECT & CONSULTANCY SERVICES**

Contract Agreement :

Job Code:

Employer:

Reference PO Nos.:

S.NO	Component/ Operations	Characteristics Check	Type of Check	Reference Documents	Fabrication/q uality control	Inspection Detail		Format of record	Accepted Norms	Remarks
						Inspection Agency	Extent of Inspection			
A) Raw Material										
1	PLATES & Structural Steel	Identification & Correlation with mill T.C.from suppliers	Manufacturer's Mill T.C./Third party test as required	Challan ,Mill T.C.,etc	Verification of Documents	CLIENT/TPIA	One Plate of Each Batch no/per consignment	Inspection Report/Fabri cators record	IS:2062-2011 ,E250 (Fe 410 WA)/E 250 (FE 410 WB)	
2	Bolts,Nuts & Studs	Identification and corelation with Mill T.C. from suppliers	Visual	Challan,Man ufacturer,s TC/Batch Certificates	Verification of reference documents	, -do-	As required	Fabricators Record	As per Codal requirements	
B) Manufacturing Process										
1	Cutting ,Straightening, Fit-up & Edge Preparation	Dimensional & Visual	Visual/ Measurements	, -do-	Visual Inspection & Measurement of Dimensions	, -do-	, -do-	Fabricators Record	, -do-	
c) Welding Operations										
(i)	Submission of WPSS	Review of WPSS	Visual	AWS D 1.1, ASME SEC IX	Verification of reference documents	, -do-	, -do-	Fabricator's Record	, -do-	
(ii)	WPQR	Witness of established WPSS	Visual,NDT,DT,at appr.Lab/ fabricator's site	Approved WPSS	Verification of reference documents & test reports	, -do-	As required	WPQR witness sheet to be recorded	, -do-	
(iii)	WQR	Witness of Welder's test	Visual,NDT,DT,at appr.Lab	As per Codal Requirement	Verification of reference documents & test reports	, -do-	As required	WQR record for each welder	, -do-	

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D) Inspection of Welding after completion										
(i)		Visual,Weld size	Visual ,Gauge	Approved Drawing & WPSS	Visual Inspection & Verification of dimension by gauge	, -do-	Random	Fabricator's Record	As per Codal Requirement	
(ii)		NDT of Fillet & Butt welds	Radiography/Ultrasonic Test & DPT	As per Codal Requirement	Verification of film review.	, -do-	3% of total weld	As per Codal Requirement	As per Codal Requirement	
E) Final inspection										
(i)	Individual Piece	Dimensions, Straightness,Camber, Orientation,Squareness,	Visual/ Dimensions	Approved drawings	Complete checking of Dimensions & Fairness of holes	, -do-	100%	Inspection Report	As per Codal requirement within tolerable limits	
(ii)	Trial Assembly	Overall dimension, Alignment, Elevation, Match Marking	Visual/ Dimensions	Approved drawings		, -do-	10%	Inspection Report	As per Codal requirement within tolerable limits	
F) Painting										
(i)	Clearance for surface & painting	Component completeness/DFT	Visual /Dimensions by Elcometer	Approved drawings & Specifications	Verification of stage clearance records	, -do-	Random	Inspection Report/Fabricator inspection report	As per Codal requirement	

Prepared by

ENGINEER QC

Reviewed by

SR. ENGINEER QC

Approved by

MANAGER QC

