



SAKTHI INDUSTRIES

AMBATTUR, CHENNAI 600 098

(EXCEL Brand Industrial Valves)

QUALITY ASSURANCE PLAN CAST CARBON STEEL GLOBE, GATE, CHECK VALVE

Q.A.P. NO. : QAP-GGC

DATE : 11-02-22

REV. NO. : 0

PO NO.:		OPC NO.:			CUSTOMER:							
Sr, No.	Component / Description	Characteristic	Type of Check by SI	Quantum of Check	Reference Documents	Acceptance Criteria	Format of Records	V	SI	TPIA	Re.	
1.0	<u>RAW MATERIAL</u>											
1.1	1.1 Casting: Body, Bonnet/Cover	Chemical, Heat Treatment, Mechanical Properties	Review of Vendor TC	All Lots	Relevant ASTM Std.	Relevant ASTM Std.	Foundry test certificate	P	R	R		
		Surface Examination & Dimension Inspection	Visual & Measurement	Random	Relevant MSS Std	Relevant MSS Std & SI Drawing	Casting Inspection Report	-	P	-		
1.2	1.2 Forging: Body, Bonnet/Cover, Seat Ring	Chemical, Heat Treatment, Mechanical Properties	Review of Vendor TC	All Lots	Relevant ASTM Std.	Relevant ASTM Std.	Foundry test certificate	P	R	R		
		Surface Examination & Dimension Inspection	Visual & Measurement	Random	Relevant MSS Std	Relevant MSS Std & SI Drawing	Casting Inspection Report	-	P	-		
2.0	<u>TRIMS, PACKINGS, FASTENERS & OTHERS</u>											
2.1	2.1 Spindle	Chemical Properties	Review of Lab TR	Random	Relevant ASTM Std	Relevant ASTM Std	Lab Test Report		P	-		
		Dimension Inspection	Visual & Measurement	100%	SI Drawing	SI Drawing	ShopFloor Inspection Report	-	P	-		
2.2	2.2 Disc/Seat	Chemical	Review of Lab TR	Random	Relevant ASTM Std	Relevant ASTM Std	Lab Test Report		P	-		
		Surface Examination & Dimension Inspection,	Visual & Measurement,	100%	SI Drawing	SI Drawing	ShopFloor Inspection Report	-	P	-		
		Weld Overlay: Stelling hardness measurement	Hardness Check	Random	Approved SI Std	Approved SI Std	Test Report	-	P	-		
2.3	2.3 Bellow#	Chemical, Physical, Leakage Test	Review of Vendor TC	All Lots	Relevant ASTM Std/ Manufacturer Spec	Relevant ASTM Std/ Manufacturer Spec	Vendor TC	P	R	R		
		Visual & Dimension Check	Visual & Measurement	100%	SI Drawing	SI Drawing	Inspection report & GRIN	-	P	-		

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CAST CARBON STEEL GLOBE, GATE, CHECK VALVEQ.A.P. NO : QAP-GGO
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2.4	Gaskets and Gland Packings*	Chemical & Physical Properties	Review of Vendor TC	All Lots	Approved SI Std	Approved SI Std	Vendor TC	P	R	-	
		Visual & Dimension Check	Visual & Measurement	Random	SI Drawing	SI Drawing	GRIN	-	R	-	
2.5	Fasteners	Chemical	Review of Lab TC	Random	Relevant ASTM Std/ Manufacturer Spec	Relevant ASTM Std/ Manufacturer Spec	Lab TR	-	P	-	
		Visual & Dimension Check	Visual & Measurement	Random	SI Drawing	SI Drawing	GRIN	-	P	-	
3.0	EVALUATION & TESTING										
3.1	Testing	Seat Test	Hydro	Random	API 598/BS 6755	API 598/BS 6755	Testing Record	-	P	W	
		Back Seat Test*	Hydro								
		Seat Test*	Pneumatic								
		Function	Operational Check								
4.0	FINAL INSPECTION										
4.1	Valves	Tag No. & SI No.	Visual & Measurement	100%	Approved SI Std	Approved SI Std	SI No. Record	-	P	R	
		Final Inspection	Visual & Dimension	100%	Approved SI Std	Approved SI Std	Final Inspection report	-	P	R	
		Surface Preparation & Painting	Visual & Measurement	100%	Approved SI Std	Approved SI Std	-	-	P	-	
5.0	DOCUMENTATION	Documents	Check & verify	100%	Approved SI Std	Approved SI Std	MTC	-	P	R	

Note:
P-Perform, R- Review, W-Witness, TC-Test Certificate, TR-Test Report, GRIN-Goods inward Receipt Note, MTC-Material Cum test Certificate,
TPIA-Third Party Inspection Agency, V-Vendor/Supplier, SI-Sakthi Industries
*Only for Globe & Gate #Bellow Seal Only
IBR Valves Inspection Will be as per IBR satutory requirements. No TPIA Involved

Prepared By: _____ Approved By: _____