



CHEMDIST PROCESS SOLUTIONS PVT. LTD.

QUALITY ASSURANCE PLAN (REACTOR/PRESSURE VESSEL)

PURCHASE ORDER No.		2223004158 DATE: 27/05/2022			QAP Document No	CDPS-QAP-SO-650, REV-00 Date- 03.06.2022				
VENDOR NAME		CHEMDIST PROCESS SOLUTIONS PVT. LTD.			PROJECT	DAHEJ-2, JOLVA UNIT				
EQUIPMENT DESCRIPTION		MONOMER MIXING TANK - 40.2M3			INSPECTION BY	ELECTROMECH ENGINEERING ENTERPRISES				
EQUIPMENT DRG NO. & REV.		-			CDPS SO NO.	650				
Sr. No.	INSPECTION ACTIVITY & DESCRIPTION	CHARACTERISTICS	TYPE/METHOD OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE CRETERIA/STANDARD	FORMAT OF RECORD	INSPECTION BY			REMARK
							VENDOR	TPI	GFL	
1	DOCUMENT CONTROL & APPROVALS									
1.1	REVIEW & APPROVAL OF G.A. DRAWING	ASSEMBLY AND DETAILED ENGINEERING DRAWING	REVIEW & APPROVED	P.O./DATASHEET/APPLICABLE ASME CODE		APPROVED DRAWING	P	R	A	APPROVED BY CLIENT
1.2	REVIEW OF INSPECTION & TEST PLAN	APPROVED DRAWING & SPECIFICATION	REVIEW & APPROVED	P.O./DATASHEET/APPLICABLE ASME CODE/DRAWING/TECHNICAL DATA SHEET		QUALITY ASSURANCE PLAN	P	R	A	
2	MATERIAL CONTROL & IDENTIFICATION (PRESSURE & NON PRESSURE PARTS)									
2.1	INSPECTION FOR MAIN SHELL & DISH END PLATES.	VISUAL AND DIMENSION CHECK	TEST CERTIFICATE VERIFICATION & IDENTIFICATION	APPROVED DRAWING & APPLICABLE CODE	APPLICABLE ASME STANDARD	MILL TEST CERTIFICATES / LAB TEST REPORTS & INSPECTION REPORTS	P	R	R	1. EN 10204 3.1 CERTIFICATION REQUIRED 2. IF MTC IS NOT AVAILABLE, THEN SAMPLES TO BE DRAWN FROM MATERIAL FOR CHEMICAL & MECHANICAL TEST AT NABL ACCREDITED LAB.
		CO-RELATION OF MARKINGS WITH MILL TEST CERTIFICATES. MECHANICAL & CHEMICAL PROPERTIES, ETC.	100% EDDY CURRENT & HYDRO TESTED TUBES				P	W	R	
2.2	INSPECTION FOR NOZZLE PIPES & STANDARD FLANGES	VISUAL AND DIMENSION CHECK	TEST CERTIFICATE VERIFICATION & IDENTIFICATION	APPROVED DRAWING & APPLICABLE CODE	APPLICABLE ASME STANDARD	MILL TEST CERTIFICATES / LAB TEST REPORTS & INSPECTION REPORTS	P	R	R	
		CO-RELATION OF MARKINGS WITH MATERIAL TEST CERTIFICATES. MECHANICAL & CHEMICAL PROPERTIES, ETC.					P	W	R	
2.3	POSITIVE MATERIAL IDENTIFICATION	PMI OF ALL STAINLESS STEEL AND SPECIAL MATELLURGY MATERIALS COMPONENTS	RANDOM	APPROVED DRAWING	APPLICABLE ASME STANDARD	INSPECTION REPORT	P	R	R	NOT REQUIRED FOR SS304
2.4	OTHER BOUGHT OUT ITEMS	MOTOR, GEAR BOX, MECHANICAL SEAL, FLUSH BOTTOM VALVE ETC.	ROUTINE TEST	APPROVED DRAWING	AS PER APPLICABLE PARAMETER AND TECHNICAL DATA SHEET	ITEM TEST CERTIFICATE	P	R	R	
3	MANUFACTURING STAGES AND PROCESS CONTROL									
3.1	DISH END INSPECTION AFTER FORMING	VISUAL AND DIMENSION CHECK	VISUAL, MEASUREMENT, PROFILE CHECKING	APPROVED DRAWING & NDT PROCEDURE	APPLICABLE ASME STANDARDS	INSPECTION REPORT	P	R	R	IF REQUIRED STRESS RELEVING TO BE DONE.
		DPT ON DISHED ENDS- SF & KNUCKLE PORTION	INSIDE & OUTSIDE SURFACE OF KNUCKLE PORTION & EDGES				P	W	R	
3.2	FIT-UP OF L/S, C/S JOINTS (SHELL, DISHED ENDS, ETC.)	VISUAL, DIMENSION, WELD EDGE PREPARATION, ROOT GAP, OFFSET, ALIGNMENT ETC.	VISUAL, MEASUREMENT, PROFILE CHECKING	APPROVED DRG.	APPLICABLE DRAWING & ASME STANDARD	INSPECTION REPORT	P	R	R	

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							VENDOR	TPI	GFL	
3.3	FIT UP OF NOZZLES ON SHELL/DISH	VISUAL, DIMENSION, EDGE PREPARATION, ROOT GAP, PT EXAMINATION ON WEP	VISUAL AND MEASUREMENT	APPROVED DRG. & NDT PROCEDURE	APPLICABLE ASME STANDARD	INSPECTION REPORT	P	R	R	
3.4	INSPECTION OF COMPLETED WELDS	VISUAL INSPECTION FOR UNDERCUTS, REINFORCEMENTS & OTHER SURFACE DEFECTS	VISUAL	APPROVED DRAWING & NDT PROCEDURE	APPLICABLE ASME STANDARDS	INSPECTION REPORT	P	R	R	
		TO CHECK WELDING / FABRICATION QUALITY	APPLICABLE NDT (DPT/RT)			NDT REPORTS/RADIOGRAPHY FILMS	P	R	R	REVIEW OF ALL RT REPORTS WITH FILMS
3.5	OTHER PRESSURE/NON PRESSURE PART ATTACHMENTS TO EQUIPMENT	VISUAL, DIMENSION, WELDING FABRICATION TESTING ETC.	VISUAL AND MEASUREMENT	APPROVED DRAWING & NDT PROCEDURE	APPLICABLE ASME STANDARDS	INSPECTION REPORT	P	R	R	
3.6	PNEUMATIC TEST OF RF PADS	PRESSURE TEST OF LEAK TIGHTNESS BY AIR	VISUAL	APPROVED DRAWING & PROCEDURE	APPLICABLE ASME STANDARDS	INSPECTION REPORT	P	R	R	
4 FINAL INSPECTION/TESTING										
4.1	FINAL DIMENSION AND WELD VISUAL WHEREVER ACCESSIBLE	VISUAL AND DIMENSION CHECK	VISUAL AND MEASUREMENT	APPROVED DRAWING	APPROVED DRAWING AND SPECIFICATION	INSPECTION REPORT	P	W	R	
4.2	HYDROSTATIC TEST (VESSEL & LIMPET COIL)	PRSSSURE TEST OF LEAK TIGHTNESS BY WATER	VISUAL	APPROVED DRAWING & PROCEDURE	APPLICABLE ASME STANDARDS	INSPECTION REPORT	P	W	R	CLEAN PORTABLE WATER SHALL BE USED FOR HYDROTEST AND CHLORINE CONTENT SHALL BE < 25 PPM
4.3	RUNNING TRIAL OF EQUIPMENT	RUNNING TRIAL WITH LOAD	CHECK AS PER PARAMETER (RPM, CURRENT & TEMP.)	APPROVED DRAWING	AS PER APPLICABLE PARAMETER AND APPROVED DRAWING	INSPECTION REPORT	P	W	R	
4.4	DRAINING & DRYING	VISUAL INSPECTION	VISUAL	AS PER PROCEDURE	COMPLETE DRAINING & DRYING	VISUAL VERIFICATION	P	R	R	
4.5	SURFACE PREPARATION & PAINTING	SURFACE ROUGHNESS, FINISH & COATING THICKNESS CHECK	VISUAL AND MEASUREMENT	APPROVED DRAWING & PROCEDURE	APPROVED DRAWING & PROCEDURE	INSPECTION REPORT	P	R	R	
4.6	PICKLING & PASSIVATION OF ALL S.S./SPECIAL MATTELURGY	VISUAL INSPECTION FOR SURFACE CLEANLINESS	VISUAL	APPROVED DRAWING & SPECIFICATION	ASTM A 380/SPECIFICATION	INSPECTION REPORT	P	R	R	
5 DISPATCH/DOCUMENTATION										
5.1	FINAL STAMPING ON NAME PLATE	VERIFYING NAME PLATES DETAILS AND STAMPING	VISUAL	APPROVED DRAWING	APPROVED DRAWING	NAME PLATE/RUB OFF	P	V	R	
5.2	INSPECTION RELEASE NOTE	VERIFICATION OF DOCUMENTS	AS BUILT DRAWING	-	PURCHASE ORDER AND SPECIFICATION	RELEASE NOTE	P	V	H	
5.3	DOCUMENTATION	VERIFICATION & COMPILATION OF INSPECTION & TEST RECORDS	-	-	PURCHASE ORDER AND SPECIFICATION	QUALITY CONTROL DOSSIER	P	R	R	
LEGENDS- P:Perform, V:Verification, R:Review, W:Witness, H:Hold, A:Approval, TPI-Third Party Inspection										
 Rahul Chavan Prepared By Vendor					 Approved By GFL					