




CLIENT : POLYPLAST CHEMI-PLANTS PVT. LTD. PO No. : P2200283 DATE : 12.05.2022 QRN NO. : 7025/R0 SO No. : 643			CHEMDIST PROCESS SOLUTIONS PVT. LTD. QUALITY ASSURANCE PLAN QAP NO: CDPS-QAP-SO-643, REV-02 DT. -29/06/2022			ITEM DESC. : 1. COOLING COIL (25NB - DUPLEX 2507)			
SR No.	COMPONENT / OPERATION	CHARACT. CHECKED	TYPE/METHOD OF CHECK	EXTENT	REF. DOCUMENT / ACCEPTANCE NORM	FORMAT OF RECORD	INSPECTION BY		REMARKS
1	Raw Material						CDPS	CLIENT/TPI	
1.A	Pipe, Flanges (Forged/Plate) & Bend	Visual, Dimensional, Mechanical & Chemical Test / Properties	Correlation with Lab T.C. Mill T.C.	One per heat/Lot	ASME Sec. II & Approved G.A. Drg. / Specifications	Material Test Certificate & Lab Test Report	H	W	1. EN 10204 - 3.1 Certification Required for all material. 2. Additional lab check testing chemical, Mechanical & IGC Pr. C test at NABL accredited lab to be done for pipe & plate flanges.
2	In Process								
2.A	Coil Set-up	Dimension, Visual & Weld Edge Preperation	Dimensional & Visual	100%	As per approved G.A. Drg.	Inspection report	H	W	
2.B	Radiography of Butt Welds	Soundness of Weld Joint	RT & Visual	As per approved G.A. Drg./ 10%	As per ASME SEC VIII & Sev V	RT Report	H	R	Film Review
2.C	DP test for Butt weld Joints	Soundness of Weld Joint	DPT & Visual	As per approved G.A. Drg./ 100%	As per ASME SEC VIII & Sev V	DPT Report	H	W	
2.D	Heat Treatment of Cooling Coil - Bend (If applicable)	Visual & heat treatment	Heat Treatment Cycle	As per approved G.A. Drg.	As per ASME SEC VIII Div. 1	Heat Treatment Report	H	W	
3	Final Inspection								
3.A	Dimensional, Visual Inspection	Overall Dimension & Visual	Dimensional & Visual Check	100%	As per approved G.A. Drg. / Specifications	Inspection report	H	W	
3.B	PMI test	Chemical Composition	Portable XRF alloy analyzer	100%	As per approved G.A. Drg. / ASME Sec II Part A/B. /ASTM E 1476 / E1916	PMI Report	H	W	
3.C	Ferrite Test for butt weld joints	Ferrite Content	Ferrite Content	100%	ASME Sec. II & Approved G.A. Drg. / Specifications /ASTM A800	Test Certificate	H	W	
3.D	Hydro Test	Pressure Test (Leak Tightness)	Water	100%	As per scope/Drg.	Inspection report	H	W	

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3.E	Outside Surface Preparation (Pickling & Passivation)	As per requirement	Finish	100%	As per Scope/ Drg./ Specifications	Inspection report	H	R	
4	Document Verification								
4.A	Final Document Review	Major	Review of documents	100%	As per scope/Drg.	Inspection Reports	P	R	
CDPS : CHEMDIST PROCESS SOLUTIONS, R: REVIEW, W: WITNESS, P: PERFORM H: HOLD									
For, CHEMDIST PROCESS SOLUTIONS PVT. LTD. 			Prepared by: RAHUL CHAVAN  				Approved By:		

Add- IGC Practice C test and shall be witnessed