

# TUV INDIA PRIVATE LIMITED

## INSPECTION VISIT REPORT

Number: 8115855766/1001127318 - IVR - 05.12.2018 - A C Ramana - Revision - 0



<b>General:</b>			
<b>TUV SAP &amp; Control Number:</b>	8115855766/1001127318	<b>Branch:</b>	Hyderabad
<b>Notification Name / Number with Date:</b>	Email Dated 03.12.2018	<b>Date(s) of Inspection:</b>	04.12.2018 & 05.12.2018
<b>Project Name &amp; Location:</b>	BS IV Project, IOCL Barauni	<b>Place / Address of Inspection:</b>	Anakapalli
<b>TUVIPL Client Name:</b>	M/s. Heurtey Petrochem	<b>End User Name:</b>	Not Applicable
<b>DEC / PMC / EPC Name:</b> (If applicable)	M/s. Technip	<b>DEC / PMC / EPC Assignment Number:</b> (If applicable)	Not Applicable
<b>Vendor Name &amp; Location:</b>	M/s. Heurtey Petrochem	<b>P.O. Number:</b> (Client on Vendor)	305045 Amd. 1, dated 14.08.2018
<b>Sub Vendor Name &amp; Location:</b> (If applicable)	M/s. Hastalloy India Limited - Anakapalli	<b>P.O. Number:</b> (If applicable - Vendor on Sub Vendor)	Not Applicable
<b>Stages Of Inspection:</b>			
<input type="checkbox"/> Kick Off / Pre Inspection Meeting	<input checked="" type="checkbox"/> Material Identification	<input type="checkbox"/> Interim Stages	
<input type="checkbox"/> Document Review	<input checked="" type="checkbox"/> Final Inspection	<input type="checkbox"/> Re-Inspection	
<b>Item Description:</b>			
P.O. Item Number	Item Code & Item Description	P.O. Quantity	Offered Quantity
		Unit: Nos	
2	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 609.1	36	36
3	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 609.2	3	3
4	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 609.3	5	5
5	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 609.4	3	3
6	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 610.1	68	68
7	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 610.2	7	7
8	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 610.3	13	13
9	Tube Spacer Drawing No: 0903-FD-601 R.2 ITEM NO: 610.4	7	7
10	U Bolt + 2 Nut + 5Thick Washer Drawing No: 0903-FD-601 R.1 ITEM NO: 609.9	248	248
11	U Bolt + 2 Nut + 5Thick Washer Drawing No: 0903-FD-601 R.1 ITEM NO: 609.1	526	526
12	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.1	7	7
13	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.2	7	7
14	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.3	204	204
15	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.4	7	7
16	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.5	7	7
17	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.6	3	3
18	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.7	3	3
19	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.8	97	97
22	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.9	3	3
23	Seal Plate 10 THK Drawing No: 0903-FD-604 Rev 1, Item No: 611.10	3	3
24	0903-FD-405 Rev 1, Item No: 612.1	6	6
25	0903-FD-405 Rev 1, Item No: 612.2	6	6
26	0903-FD-405 Rev 1, Item No: 612.3	4	4

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**Form No. :** F / INSP / VR / 11 - R8; Revision Date: 28/09/2018

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Reference Documents:					
Sr. No.	Document Name	Document Number	Approval Status		
1)	PR / MR / ARM	Not Applicable	Not Applicable		
2)	QAP / ITP / QCP	916 Rev 01, Date 17.05.2018	Approved by Client		
3)	Drawing(s)	0903-FD-601 R.1, 0903-FD-604 Rev 0 & 0903-FD-405 Rev 1	Approved		
4)	Procedure(s)	Not Applicable	Not Applicable		
5)	Datasheet(s)	Not Applicable	Not Applicable		
6)	Others (Specify)	Not Applicable	Not Applicable		
Inspection Activities Carried Out :					
Stages Witnessed:					
1)	Verified pouring report of heat numbers 3186A, 3187A, 3188A, 3189A, 3190A, 3191A & 3193A integral test bars identified and hard punched for physical testing				
2)	Witnessed Mechanical test duly attested Test Bar with Heat Number 3186A, 3187A, 3188A, 3189A, 3190A, 3191A & 3193A and found satisfactory as per QAP/ITP				
3)	Visual check for surface finish on all offered material – following defects were observed. Sand inclusions, Sharp edges at Cored holes areas, rough surface finish, dent marks observed in all offered material on surface area except U Bolts. Bend observed 5 to 12mm in Tube spacers. Machined burrs not cleaned in Nuts.				
4)	Witnessed Dimensional Inspection 100% on pilot Castings and 10% on production castings and found to meet the drawing/specification requirements.				
5)	Witnessed PMI for offered material and meet the specification requirements.				
6)	Witnessed Dye Penetrant test 100% on pilot Castings and 10% on production castings - Recordable indications observed. After rework material to be re offer.				
Documents Reviewed:					
1)	Reviewed Pouring report and identified as Heat Nos: 3186A, 3187A, 3188A, 3189A, 3190A, 3191A & 3193A				
2)	Reviewed RT films for offer material - Seal Plates having defects, those defects are not acceptable and same are reported. Remaining material acceptable.				
3)	Reviewed chemical test reports and found meet the specification requirements				
Details of Equipment(s) / Instrument(s) used for measuring / testing During Inspection:					
Sr. No.	Name of Equipment(s) / Instrument(s)	Range	ID	Calibration Valid till Date	Certificate Number with Date
1	Vernier Calliper	0-300mm	HAIL/QC/VC/01	13.05.2019	2018/030 Dt: 14.05.18
2	Measuring Tape	0-5000mm	HAIL/QC/MT/01	13.05.2019	2018/033 Dt: 14.05.18
3	FIE-UTN40-UTM	40KN	1/88-1039	02.08.2019	18-19/31746/01 Date: 04.08.2018
4	PMI	--	XL2-800, SI No: 95206	16.12.2019	262-2017 Date: 17.12.2017
<input checked="" type="checkbox"/>	All Measuring instrument(s) / Equipment (s) mentioned above were verified for suitability for intended use, proper identification and calibration status as per NABCB Document BCB 110 (IB)/Mar 2017, Clause No: 5.0(i) to 5(v) OR WI/INSP/63/00 – Found acceptable.				
Discrepancies observed during inspection :					
Visual, DPT, RT & Dimensional.					
Non Conformity Raised (If Any, Mention TUVIPL NCR Number):					
Nil					
Conclusion (Acceptable / Provisionally Acceptable / Not Acceptable / Acceptance subject to) & Pending Activities:					
Kept on Hold"					
Identification of inspected Item(s):					

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<b>Attachments:</b>			
<input type="checkbox"/>	Inspection records – Total Page Nos.	None	<input type="checkbox"/> NCR Number: None
<input type="checkbox"/>	Inspection Photos – Refer Page Nos.	4 & 5	<input type="checkbox"/> Others (Specify) : None
<b>Authorised Signatures:</b>			
<b>TUVIPL Inspector:</b>		<b>Vendor / Sub Vendor Representative (If Applicable):</b>	
<b>Name: A C Ramana &amp; Date: 05.12.2018</b>		<b>Name &amp; Date:</b>	
<b>Distribution List:</b>	<input checked="" type="checkbox"/> TUV Client / End User <input checked="" type="checkbox"/> TUV Executing Branch / TUV Originating Branch <input checked="" type="checkbox"/> Vendor / Sub Vendor		
<b>Revision – 0 (If Applicable) – type Justification. This Document Supersedes IVR No. type Number Dated 00.00.0000</b>			







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Inspection Pictures:	
Test bar Identification	Mechanical Test Bar
	
PMI	Dimensional Inspection
	
Dimensional Inspection	Dimensional Inspection
	
Dimensional Inspection	Dimensional Inspection

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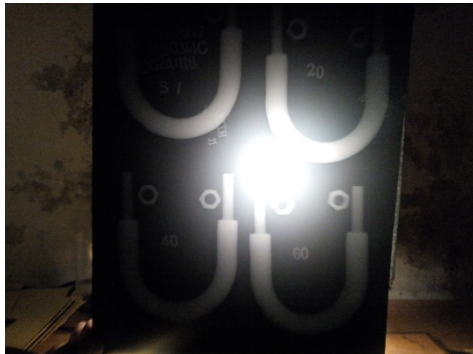
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DPT	DPT
	
RT Films Review	RT Films Review
	

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