

TUV INDIA PRIVATE LIMITED

INSPECTION VISIT REPORT

IVR - 8118167190 - 001 - Rev. 00



General:						
TUV India Control Or SAP Number:	8118167190		Branch:	Mumbai		
Notification Name / Number:	email Dtd. 19/08/2021		Date(s) of Inspection:	20 & 21.08.2021		
Project Name & Location:	R&R of the existing Chinese make waste gas ESP(OC no E308157) E308157 -TATA LONG_SINTER ESP		Inspection Location:	AUTODATA, D240, TTC Ind. Area, sion - Panvel Exp., MIDC Industrial Area, Shiravane, Nerul, Navi Mumbai, Maharashtra, India		
TUV India Client Name:	THERMAX LIMITED - ENVIRO DIVISION IC NO 179878		End User Name:	TATA Steel Long Products Limited		
DEC / PMC / EPC Name: <i>(If applicable)</i>	Not Applicable		DEC / PMC / EPC Asgmt. Number: <i>(If applicable)</i>	Not Applicable		
Vendor Name & Location:	AUTODATA D240TTC Ind. Area, sion - Panvel Exp., MIDC Industrial Area, Shiravane, Nerul, Navi Mumbai, Maharashtra, India		P.O. Number: <i>(Client PO on Vendor)</i>	PO. 124780 dated 24.05.2021		
Sub Vendor Name & Location: <i>(If applicable)</i>	Not Applicable		P.O. Number: <i>(If applicable – Vendor PO on Sub Vendor)</i>	Not Applicable		
Stages Of Inspection:						
<input type="checkbox"/> Kick Off / Pre Inspection Meeting		<input type="checkbox"/> Material Identification		<input type="checkbox"/> Interim Stages		
<input checked="" type="checkbox"/> Document Review		<input checked="" type="checkbox"/> Final Inspection		<input type="checkbox"/> Re-Inspection		
Item Description:						
P.O. Item No.	Item Code	Item Description	UOM	P.O. Quantity	Offered Quantity	Acceptable Quantity
1	ELAK0016 26	THREE PHASE TR SET & TRCC 95KV, 1300MA (IC No 179878)	Nos.	02	02	--
2	ELAK0016 25	Manual HT.Earth Switch for 83KV/1205mA HFTR	Nos	02	02	--
Reference Documents:						
Sr. No.	Document Name	Client Document Number	Vendor Document Number	Approval Status		
1)	PR / MR / ARM	Not Applicable	Not Applicable	Not Applicable		
2)	QAP / ITP / QCP	TL/ENV/QAP-FAB/E308157 Rev. No. 01	Not Applicable	Approved by Thermax Ltd Dtd. 22/06/2021		
3)	Drawing(s)	E308157507 Rev 01 E308157506 REV 01	Not Applicable	Approved in Code-A by Thermax Ltd Dtd 18/06/2021 Approved By Thermax Dtd 21.07.2021		
4)	Procedure(s)	Not Applicable	Not Applicable	Not Applicable		
5)	Datasheet(s)	Not Applicable	Not Applicable	Not Applicable		
6)	Others <i>(Specify)</i>	Not Applicable	Not Applicable	Not Applicable		
Inspection Activities Carried Out :						
Stages Witnessed:						

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1)	<p>Inspection carried out as per approved QAP, Design datasheet & result found acceptable. For details refer attached witness report Dtd. 20 & 21/08/2021 (100% Inspection done as per approved QAP).</p> <p>THREE PHASE TR SET & TRCC 95KV, 1300MA Witnessed Serial no. - 3Φ21706 , 3Φ21707.</p> <p>Manual HT.Earth Switch for 83KV/1205mA HFTR - Part CAT No ELAK001625 OC NO E308157 (02 Nos)</p> <p>FABRICATED ITEMS</p> <p>As per QAP Clause no. 3) HV Duct With TR set base frame</p> <p>a) Raw Material: Mech. & Chem. Properties. - Test report review.</p> <p>b) Visual - Found satisfactory w.r.t approved datasheet.</p> <p>c) Dimensional - Found satisfactory w.r.t approved datasheet Drawing.</p> <p>d) Surface Preparation & Painting - Found satisfactory w.r.t approved datasheet Drawing</p> <p>BOUGHTOUT ITEMS</p> <p>As per QAP Clause no. 3) TR Set & TRCC</p> <p>a) Raw Material: Mech. & Chem. Properties. - Test report review.</p> <p>b) Visual - Found satisfactory w.r.t approved datasheet.</p> <p>c) Dimensional - Found satisfactory w.r.t approved datasheet Drawing</p> <p>d) H.V. & Megger Test - Found satisfactory w.r.t approved datasheet Drawing</p> <p>e) Simulation Test - Found satisfactory w.r.t approved datasheet & drawing</p> <p>f) Spark Test - Found satisfactory w.r.t approved datasheet Drawing</p> <p>g) Open Circuit Test - Found satisfactory w.r.t approved datasheet & drawing</p> <p>h) Short Circuit Test at Rated Output current - Found satisfactory w.r.t approved datasheet & drawing</p> <p>i) Load Regulation Test at 100% Rating - Found satisfactory w.r.t approved datasheet & drawing</p> <p>j) Functional Test (Checking Parameter Settings, All Alarms & Faults) - Found satisfactory w.r.t approved datasheet & drawing</p> <p>k) Measurement of Feedback Resistor. - Found satisfactory w.r.t approved datasheet & drawing</p> <p>l) Oil level check for Tank - Found satisfactory w.r.t approved datasheet & drawing</p> <p>m) Oil dielectric strength found more than 60 KV/2.5 mm - Found satisfactory w.r.t approved datasheet & drawing</p> <p>n) Pressure test applied at 0.5 bar for holding time 20 minutes – No Leakage / No pressure drop observed during holding time</p> <p>o) Paint shade verified with paint shade card & found RAL 7032 and Thickness found greater than 50 & 60 microns for Panel & TR set respectively.</p> <p>As per QAP Clause no. 5) Electrical Access., Instruments & Mechanical Miscellaneous items & Instruments</p> <p>- Review of manufacturers TC (Calibration & Type test report As Applicable)</p> <p>Visual Verification of Earthing unit, Operation Panels & TR Set found acceptable as per GAD.</p>
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Documents Reviewed:

1)	<p>Following documents were reviewed as per approved QAP & found in order;</p> <p>As per QAP Clause no.1b) Test certificate of Bought out item as provided by the supplier Found to meet material specification requirements.</p> <p>All measuring instruments/ equipment were verified for continued suitability for intended use, proper identification, calibration status, traceability to national standards & found satisfactory.</p>
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Details of Equipment(s) / Instrument(s) used for measuring / testing during Inspection: (Refer Notes)

Sr. No.	Detail of Equipment(s) / Instrument(s)	Range	ID	Validity till Date	Calibration Certificate Number	NABL / OTHER CERT. BODIES / NABL Traceability	NON-NABL
						Please tick whichever is applicable	
						See Note 1 & 2	See Note 3
1	Calibration status Attached					✓	

Notes:

- Other Certifying bodies are: NPL-India, CIPM (International Committee for Weights & Measures), ILAC & APLAC MRA Signatories.
- Visiting inspector to ensure continued suitability for intended use, periodic maintenance, proper identification and valid calibration records and traceability to known National / International standards of the measuring instrument(s) / testing equipment(s).
- Non NABL: If the calibration certificate(s) for the measuring instrument(s) / equipment(s) used during inspection do not have traceability to NABL / Other certifying bodies, then the scope of review is limited only to technical content in the calibration certificate.
- In lieu of table above inspectors may collect master list from manufacturer / vendor/ sub vendor with all above details clearly highlighting the details of instrument(s) / equipment(s) used during inspection.

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Conclusion (Acceptable / Not Acceptable / Acceptance subject to) :		
M/s. Autodata to obtain acceptance from the client for the observations as mentioned in Area of concern.		
Pending Activities from this Visit:		
None		
Identification of Inspected Item(s):		
Soft Stamped as "  "(Test sample selected double) on Witnessed HFTR Panel.		
Areas of Concern:		
1) Final touch up paint to be done wherever required before despatch. 3) As per approved QAP Raw Material: Mech. & Chem. Properties. - Test report to be submitted (For CRCA sheets & Bus Bar) 4) Castel Key Interlock is in client scope. 5) Charge Ratio internally check by Manufactured. 13) BOM to be AS BUILT for a) Uninyvin 00 b) 6" FAN & Filter c) terminal block QTY 84 instead of 67 Nos d) CT Ratio observed 200/5A 5VA Class 0.5 instead of 250/5A 10 VA.Class 1 e) CT Make observed NEWTEK instead of RECO. f) Ammeter observed 200/5A instead of 250/5A. g) Thyristor Assembly THY-0721-1300-02 h) Verified BOM attached. HV Duct With TR set base frame 1) Stand as per approved drg 160mm required, Observed 170mm. 2) IP -55 for marshalling Box declared by vendor.		
Non Conformities raised / Discrepancies observed during Inspection (If Any, Mention TUV India NCR Number) :		
None		
Attachments:		
<input checked="" type="checkbox"/> Inspection records – Total Page Nos.	1set	<input checked="" type="checkbox"/> Master List of calibrated Instruments / equipment 1set
<input checked="" type="checkbox"/> Inspection Photos – Refer Page Nos.	3 to 12	<input checked="" type="checkbox"/> Others (Specify) : None.
Authorised Signatures:		
TUV India Inspector(s):		Vendor / Sub Vendor Representative: (If Applicable)
Name: Milind Surve	Date: 21-08-2021	Name: Mr. Satish Chavan
Distribution List: <input checked="" type="checkbox"/> TUV India Client / End User <input checked="" type="checkbox"/> TUV India Executing / Originating Branch <input checked="" type="checkbox"/> Vendor / Sub Vendor		
Revision Number (If Applicable) : 00 – Type Reason for revision here		
This Document Supersedes IVR No. : Mention Previous IVR Number.		

Inspection Pictures:

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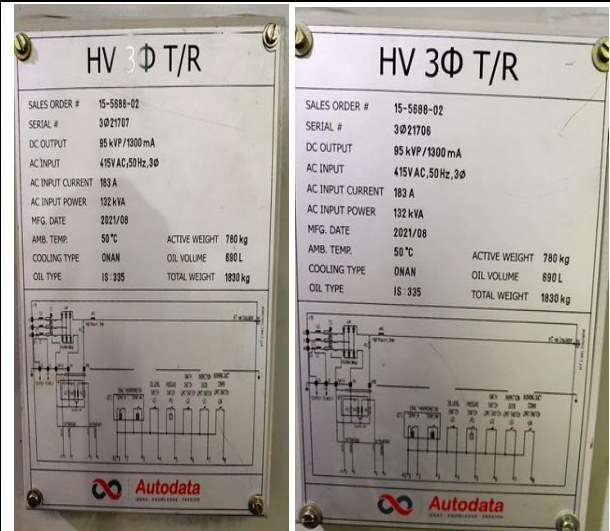
TRCC Panel



TR Verification



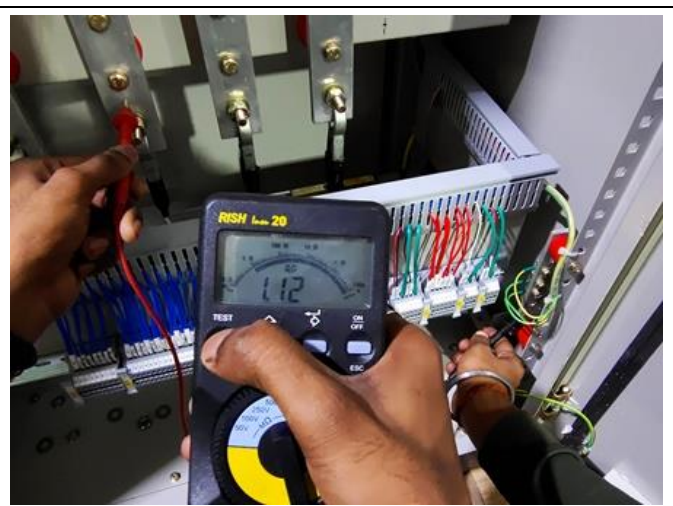
TAG Plate verification



TAG Plate verification



IR Test



IR Test

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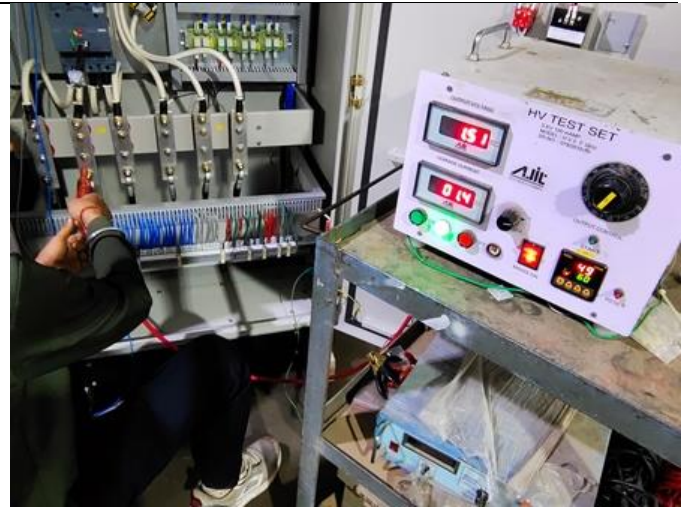
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HV TEST



HV TEST



Paint thickness verification



Paint thickness verification



Paint Shade check



Paint Shade check

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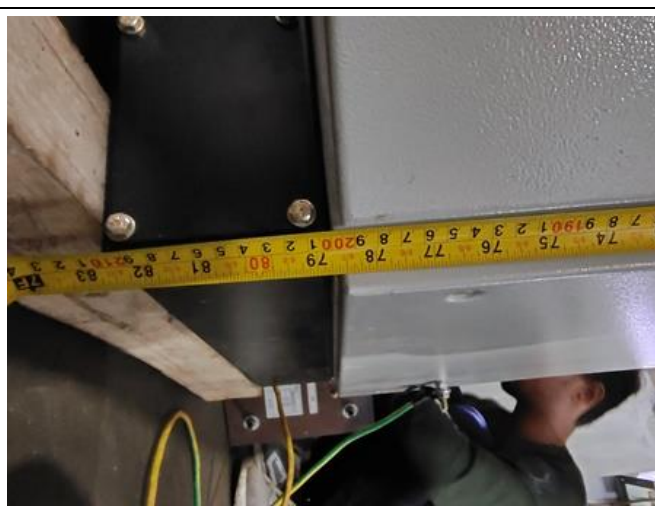
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Feedback check



Dimension check



Dimension check



Dimension check



Verification for HT porcelain



Oil level check

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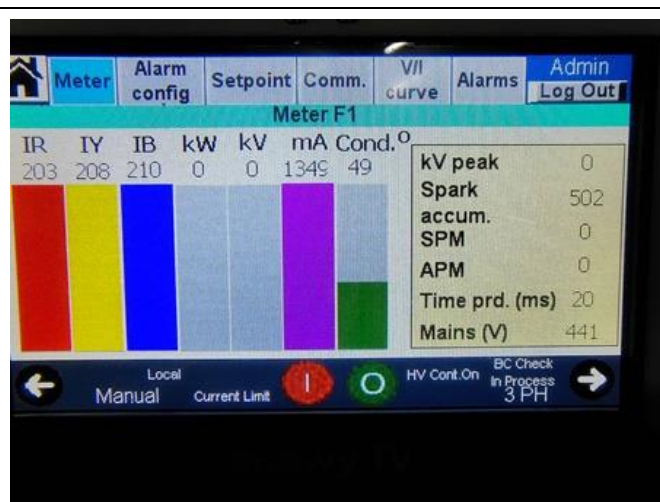
Short CKT test



Function check



Feed back check



Function check



Spark Test



Spark Test

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Meter	Alarm config	Setpoint	Comm.	V/I curve	Alarms	Admin Log Out
Tumbling rapper motor config. F1						
	Enable/Disable	On Time (s)	Off Time (min.)	feedback scheme	Trip scheme	Power off rapping
Rapper 1	OFF	10	1	NO	NC	Enable
Rapper 2	ON	20	1	NO	NC	Enable
Rapper 3	OFF	30	1	NO	NC	Enable
Rapper 4	OFF	40	1	NO	NC	Enable
Start delay (s)	1	Sequence start	ON	Rapper status	Rapper 1 OFF	Rapper 2 ON
					Rapper 3 OFF	Rapper 4 OFF

Rapper check



Cable gland as per BOM

Meter F1 20/08/21 17:22:5		
Alarm history F1		
Time	Date	Alarms
15:54	20/08/21	SCR over temperature F1
15:55	20/08/21	T/R oil over temperature F1
15:55	20/08/21	T/R oil temp. high trip F1

Alarm Check

Meter F1 20/08/21		
Alarm history F1		
Time	Date	Alarms
15:58	20/08/21	Emergency on F1
16:06	20/08/21	DC Under voltage F1
16:07	20/08/21	T/R Primary Over Current F1

Alarm Check



Indication check



BDV Test

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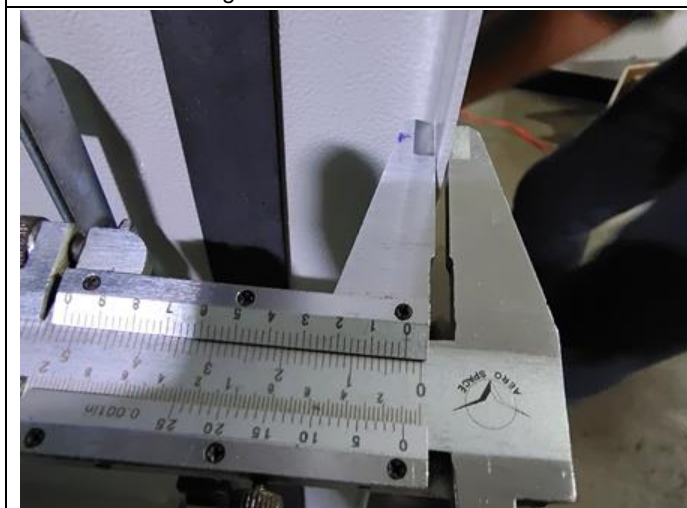
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Induced Over voltage.



Reverse polarity check



Door thickness check



Cable gland plate dimension check



Dimension check



Dimension check

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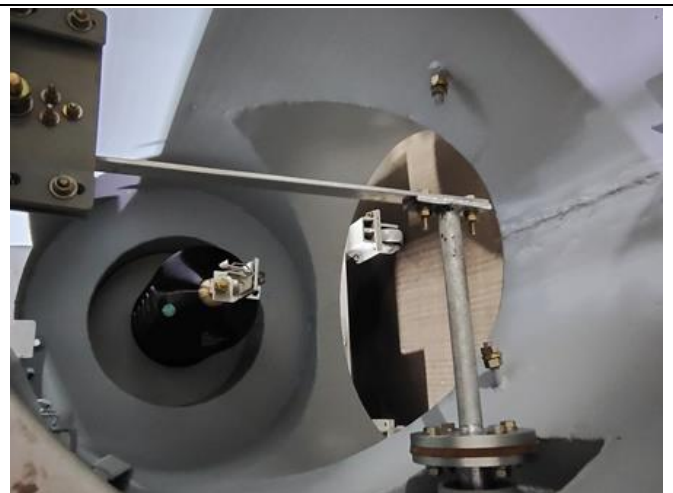
C.R Check



Duct.



Pressure test



Earth switch check

ELAK001625 Manual HT.Earth Switch for 83KV/1205mA HFTR



Earth Switch check



Earth Switch check

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Dimension check



Dimension check



Dimension check



Dimension check



TAG Plate



TAG Plate

Disclaimer: This IVR shall not be considered as final acceptance of inspected item(s). The final acceptance will be given through Inspection Release Note.

The inspection by TUV India Pvt. Ltd., review of Test Certificates / Reports and issue of Inspection Visit Report does not relieve the Client / Supplier / Manufacturer / Stockiest from their responsibility towards the Client / End User to supply the genuine material / item(s) and document(s) in full compliance with applicable Order, Specification, Technical, Quality, Quantity, Warranty, Guarantee requirements. Supplier / Manufacturer / stockiest is wholly legally responsible for genuineness of the material / item(s) supplied and document(s) submitted. TUV India's responsibility is only limited to correctness of inspection results including review of the documents, within its agreed scope against written requirements and neither TUV India nor any of its group companies, associates or employees are in any way legally responsible for genuineness of the material / item(s) and document(s). If the calibration certificate(s) for the measuring instrument(s) / equipment(s) used during inspection do not have traceability to NABL / Other certifying bodies, then the scope of review is limited only to technical content in the calibration certificate.

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Paint shade check



Paint thickness verification.

End of Report

Disclaimer: This IVR shall not be considered as final acceptance of inspected item(s). The final acceptance will be given through Inspection Release Note.

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