


A.B. INDUSTRIES						QAP 13 ( 00/17.09.2020 )		
QUALITY ASSURANCE PLAN FOR FORGING								
CUSTOMER NAME:- HLE GLASCOAT LIMITED,			Purchase Order No/Date		18739 / 08-07-2020		Co No.	
MATERIAL:- SA 181M Class 60, ASME, Sec II, Part-A, Edition 2017			Purchase Order No/Date		19856 / 17-09-2020			
Sr. No.	DESCRIPTION OF ACTIVITY	EXTENT OF CHECK	ACCEPTANCE NORMS	VARIFYING DOCUMENTS	INSPECTION BY			REMARK
					AB IND	TUV	SGEL	
1	FORGINGS							
1.1	Material Identification	Chemical Composition	As Per ASME Sec-II Part A ED 2017	Mfrs T.C. of Identification Report	PR	R	R	*
1.2	Forging	Size (Forging Ratio)	As Per P.O.	Mfrs T.C. of Identification Report	PR			
1.3	Heat Treatment of Forgings	N/A						
1.4	Test Piece Identification Per heat	As Per ASME Sec II Part A ED 2017	As Per ASME Sec-II Part A ED 2017 PED 2014/68/EU	Report	PR	W	R	Refer foot note CL.9 & 12 of SA181M CL60& CL.19 of SA 961M
1.5	Mechanical Testing Before & after SHT	Physical/Mechanical Properties	As Per ASME Sec-II Part A ED 2017 PED 2014/68/EU	Test Report	PR	W	R	
1.6	Mechanical Testing	Impact Test	As Per PED ISO: 148-1at Minus 25°C Centigrade - Req. 27Joules (Minimum) PED 2014/68/EU	Test Report	PR	W	R/W	
1.9	Material Testing Report/Final Certificate of Forging	100%	As Per EN 10204 Type 3.2	Manufactures Test Certificate & Lab Trest Report	PR	R	R	Lab test Report shall be submitted along with TC. CL.11.1 of Ssa181m CL60&CL.20 of SA961M
1.10	Final Marking on forging	100%	As Per ASME Sec-II Part A ED 2017 PED 2014/68/EU	Manufactures Test Certificate	PR	V	V	
Legend:- PR:- Perform and Record, R:- Review, W:- Witness, V:- Verify								
Simulation HT of Test Piece only:- As Per Specification MTS No.:- KIS002/3A DATE :- 18/05/2019								
No Repair by welding allowed								



Approved  
[Signature]  
Approved By  
[Signature]  
07.10/9/2020