



**VOLTA GREEN STRUCTURES PVT. LTD.
QUALITY ASSURANCE PLAN**

PROJECT:
QAP NO: VGSPL/QAP/001-Rev 00

JOB No-
Dated - 11.02.2016

SL.NO.	DESCRIPTION	CHARACTERSTICS	TYPE OF CHECKS	EXTENT OF CHECK	REF.OF STANDARDS / DOCUMENTS	SCOPE OF INSPECTION		REPORT/FORMAT NO.
						VGS	Customer	
1	RAW MATERIAL:							
1.1	H.R.PLATES	a) Chemical Composition	Mill T.C.verification	T.C.Verification	IS2062:2011 E350Br/ Equivalent Grade	P	R	VGS/QC/IW/001
		b) Mechanical properties	Mill T.C.verification	T.C.Verification				
		c) Dimension	Measurement & Visual	10% of a total lot				
		d) Identification	Traceability numbers & Internal lab report	Heat Chart				
1.2	HOT ROLLED SECTIONS (ISMB/ISA/ISMC)	a) Dimension & Visual	Measurement & Visual	10% of a total Lot.	IS :2062 Gr A Class-2 or IS2062 E250 2011	P	R	VGS/QC/IW/001
		b) Mechanical Properties.	Mill T.C.Verification	T.C.Verification				
		c) Chemical Composition	Mill T.C.Verification	T.C.Verification				
		d) Identification	Traceability numbers & Internal lab report	Heat Chart				
1.3	ROUND BARS/ NB PIPES/CHQ.PLATES	a) Dimension & Visual	Measurement & Visual.	10% of a total Lot.	IS :2062 Gr A Class-2 or IS2062 E250 2011	P	R	VGS/QC/IW/001
		b) Mechanical Properties.	Mill T.C.Verification	T.C.Verification				
		c) Chemical Composition	Mill T.C.Verification	T.C.Verification				
		d) Identification	Traceability numbers & Internal lab report	Heat Chart				
2	BOUGHT OUT ITEMS:							
2.2	WELDING CONSUMABLES (ESAB,ADOR,KISWEL,HYUNDAI)	Chemical Composition & Mechanical Properties.	T.C.Verification.	100%	AWS D 1.1/ASME Part II C.	P	R	-----
2.3	PRIMER & Finish Paint	Test. Certificate.	TC Verification.	100%	BERGER	P	R	



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3	Welder's Qualification:Process: SAW/GMAW/SMAW	WPS/PQR/WPQ	Verification	100%	AWS D1.1:M2010	P	R	WPS/PQR/WPQ
4	FABRICATION:							
4.1	INPROCESS : a)Flange to Flange & Web to Web Fit up and Welding b) Flange to Web Welding by Auto SAW Welding M/C c) Both side SAW welding only for Crane Beams	a) Dimension & Visual. Welding Procedure	b) a) Measurement & Visual b) WPS verification	10% of a Lot	AWS D 1.1/Shop Drawings/WPS	P	R	-----
4.2	Fit up of Base Plates /connection plates/ holes/ Cleats/Stiffeners/Bracings & other Parts.	Dimension & visual.	Measurement & Visual	100%	Shop Drawings/ASME std. for tolerance .	P	R	VGS/QC/001
4.3	Identification or part marks to punch on both sides of connection plate by using metal punch 12 " size	Visual	Visual	100%	Shop drawings	P	R	



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5	WELDING INSPECTION	a) Visual & Welding parameters b) Free from Welding Defects	a) Visual & monitoring b) D.P.T.	a)100% b) 10% D.P.T.	IS 814/AWS D 1.1	P	R	VGS/QC/002 VGS/QC/03
6	PAINTING INSPECTION	a) Shot blasting finish SA 2.5	a) Visual	a)100%	IS 1477/ As per Client Specification	P	R	VGS/QC/004
		b) Painting Preparation by spary Paint	b) DFT Measurement	b)100%				
		c)Two coat of zinc phosphate primer each 25 microns	c) DFT Measurement	c)100%				
		d) Two coat of epoxy polyimide based enamel paint each 35 microns	d) DFT Measurement	d)100%				
7	FINAL INSPECTION	a) Identification b) Dimension	a) Visual b) Measurement	a)100% b) 100%	Shop Drawings	P	R	VGS/QC/005
9	SECONDARY MEMBERS(Anchor bolts/Sag Rods/Brace Rods & Angles,clips,Plates etc)	a) Identification b) Dimension	a) Visual b) Measurement	a)10% Random b) 10% Random of total lot	Shop drawings.	P	R	VGS/QC/005

LEGENDS:P:Perform, R: Review ,VGS: Volta Green Structures , WPS: Welding Procedure Specification, PQR:Procedure qualification record , WPQ: Welder's performance qualification , DPT: Dye Penetrant test , SAW: Submerged Arc welding , GMAW: Gas Metal Arc welding ,SMAW: Shielded Meatl Arc Welding , DFT: Dry Film thickness.

PREPARED BY: QC Engineer

REVIEWED/APPROVED BY : Operation Manager