



**STANDARD QUALITY ASSURANCE PLAN (SQAP)
(Pre-Engineered Building)-INSPECTION TEST PLAN(ITP)**


PROJECT

MUMBAI METRO-NCCL/C102

NCC LTD--		
REF. NUMBER-		
RADIXUS ENGINEERS PVT. LTD.		B.O.Q No.-
PROJECT NO:		SHEET: REPL000165
PROJECT:		REV.No. 001
CLIENT:		DATE:
BUILDING:		CHECKER: Ms.AYMEN CHAUHAN
WORK ORDER NUMBER		DETAILER : SAMEER RAWAT
PHASE:		DESIGNER : SAMEER RAWAT
NOTE:		GRAND TOTAL (KG)

COMPANY-RADIXUS ENGINEERS PVT. LTD. CHANDIGARH		M/S RADIXUS ENGINEERS PVT. LTD.		SQAP-ITP NO. REPL/NCCL/MMC102 REV.:R0	
SCO. 13 NEAR GALI NUMBER 2, EKTA MARKETSECTOR 45 C- CHANDIGARH				TYPE OF RECORD	PERMANENT
CHANDIGARH GSTIN-GSTIN04AAHCR9305F1ZI				INSPECTION BY:	
DOCUMENTS NUMBER-REPL/NCCL/MMC102					

SR NO.	COMPONENT ACTIVITY	CHARACTERISTICS TO BE CHECKED	TYPE OF CHECK	FREQUENCY OF INSPECTION/TESTING	REFERENCE DOCUMENTS/ACCEPTANCE CRITERIA	FORMAT OF RECORD	TCSIPL	REPL	THIRD PARTY	REMARKS
1.0 RAW MATERIAL VERIFICATION										
1.1	PLATES,BEAM,CHANNEL, ANGLE & ROUND BAR, CHECQUERED PLATE,HOLLOW SECTION, TUBES	Chemical and Mechanical properties and other tests as required	Review of TC and Lab records	100%	IS:2062 ;2011 or ASTM A572 Gr.50 Min. YS-250 Mpa	Format No: REPL/QA/RIR/02	-	DR		OK
		Visual & Dimensional	Measurement	10%	IS :1852	Format No: REPL/QA/RIR/02	-	RW		10% per Lot
1.2	PROFILE SHEET & G.I. COIL	Chemical and Mechanical properties and other tests as required	Review of TC	100%	ASTM A792 and ASTM A653	Format No: REPL/QA/RIR/02	-	DR		OK
		Visual & Dimensional	Measurement	10%	ASTM A792 and ASTM A653	Format No: REPL/QA/RIR/02	-	RW		10% per lot
1.3	WELDING CONSUMABLES	Chemical and Mechanical properties and other tests as required	Review of TC	100%	ASTM A792 and ASTM A653	Format No: REPL/QA/RIR/02	-	DR		OK
		Visual & Dimensional	Measurement	10%	ASTM A792 and ASTM A653	Format No: REPL/QA/RIR/02	-	DR		10% per lot
1.4	PAINTS	Date of manufacturing and batch No.	Review of Batch Certificates	100%	Manufacturier batch Certificate	Format No: REPL/QA/RIR/02	-	DR		NA
1.5	FASTENERS	Chemical and Mechanical properties and other tests as required	Review of Batch Certificates	100%	Manufacturier batch Certificate	Format No: REPL/QA/RIR/02	-	RW		10% per lot
		Visual & Dimension	Measurement	10%	ASTM A325 for Gr-8.8 & IS:1364 for Gr-4.6	Format No: REPL/QA/RIR/02	-	DR		NA
1.6	DPT KIT	Date of manufacturing and batch No.	Review of Batch Certificates	100%	Manufacturier batch Certificate	Format No: REPL/QA/RIR/02				ok
2.0 MARKING AND CUTTING INSPECTION										
2.1	MARKING & CUTTING	Dimensions, layout & Cut back	Measurement	10%	Approved drawing	Format No: REPL/QA/IPIR/12	P			10% for Cut back & Layout only
3.0 FIT UP INSPECTION										
3.1	FIT UP (H BEAM)	Dimensional & Alignment	Measurement	100%	Approved drawing & IS; 7215	Format No: REPL/QA/IPIR/12	P			NA

3.2	FIT UP ASSEMBLY	Dimensional & Alignment	Measurement	100%	Approved drawing & IS; 7215	Format No: REPL/QA/IPIR/12	P			NA
3.3	VISUAL APPEARANCE	Visual Inspection	VT	100%	Approved drawing & IS; 7215	Format No: REPL/QA/IPIR/12	P			NA
4.0 WELDING ESTABLISHMENT & WELDER QUALIFICATION										
4.1	WELDING PROCEDURE & QULAIFICATION	WPS	Review	100%	AWS D1.1 or ASME Sec IX or IS 9595	WPS/PQR	-			WPS
		PQR	Test				P			PQR
4.2	WELDER PERFORMANE /IDENTIFICATION	Performance Monitoring	Measurement	100%	Welder Performance Record	WPQR & identity card	P			by Monthly
5.0 WELDING NDT & FINAL INSPECTION										
5.1	WELD VISUAL & WELD SIZE	Visual Inspection	VT	100%	AWS D1.1	REPL/QA/FIR/05	P			OK
5.2	FINAL DIMENSION	Item completeness, Alignment, Length, Width, Diagonal, flatness, Squariness , twist etc.	Dimensional	10%	Approved drawings & IS 7215 or MBMA	REPL/QA/FIR/05	RW			one sample to be checked per mark no.
5.3	LIQUID PENETRATION TEST (LPT)	Detection of Surface Defect	VT, LPT	100%	Approved drawings. & ASME sec. V	REPL/QA/FIR/06	P			All butt Weld -CJP Joint
5.4	ULTRASONIC TEST (UT/RT)	Detection of Internal Flaws in weld	VT, UT	10%	Approved drawings. & ASME sec. V	REPL/QA/FIR/07	P			NA
6.0 SURFACE PREPARATION, GALVANIZING & PAINTING										
6.1	SURFACE CLEANING	Surface should be from Oil, Grease, rust, weld spatters etc.	VT	100%	Approved drawing & Relevant Specification	REPL/QA/SP/002	P			as per specification of Galvanizing
6.2	SURFACE PREPARATION	Blasting	VT & Measurement	10%		REPL/QA/SP/002	P			Done
6.3	PRIMER APPLICATION	As per Customer Requirement, DFT	Thk. of Primer coating	10%		REPL/QA/SP/002	P			NA
6.4	MIO PAINTING	As per Customer Requirement, DFT	Thk. of Finish coating	10%		REPL/QA/SP/002	P			NA
6.5	FINISH COAT AND APPLICATION	As per Customer Requirement, DFT	Thk. of Finish coating	10%		REPL/QA/SP/002	P			NA
6.6	GALVANIIZING 85 Micron	As per Customer Requirement, DFT,NABL Test Report	Thk. of Finish coating	10%		REPL/QA/SP/003	P			85-90 micron
7.0 DOCUMENTATION										
7.1	DOCUMENTATION	SYSTEM DOSSIER	DOCUMENT REVIEW	100%	DOSSIER AS PER RELEVANT SYSTEM	DOSSIER	P			Ready
		LEGENDS								
		P	PERFORM							
		H	HOLD							
		DR	DOCUMENT REVIEW							
		RW	RANDOM WITNESS							
PREPARED BY: DIRECTOR REPL			RECOMMENDED BY:			APPROVED BY:				
SIGNATURE:			SIGNATURE:			SIGNATURE:				
NAME-			NAME: HARERAM SHARMA			NAME:				
DESIGNATION: MANAGING DIRECTOR			DESIGNATION: QUALITY MANAGER REPL			DESIGNATION:				
DATE:13-07-2023			DATE: 13-07-2023			DATE: 13-07-2023				
							APPROVED BY CLIENT			
							SIGNATURE:			
							NAME:			
							DESIGNATION:			
							DATE:			