

**JINDAL PIPES LIMITED (ERW PIPES)  
QUALITY INSPECTION PLAN**

Specification – IS:1239 & IS:3589

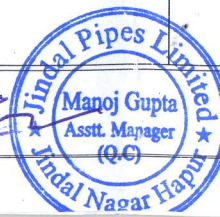
QAP No. : JPL/ERW/IS:1239 & IS-3589  
Rev. No. : 00  
Date : 17/07/2018  
Page : 1 of 3

Sl. No	Inspection / Test Stage	Checks	Type of Inspection	Frequency of Check	Reference Documents	Acceptance Norms	Format of Record	Inspection By			Remarks
								P	W	R	

<b>1.0</b>	<b>Receiving Inspn &amp; Testing</b>										
1.1	Inspection of H.R. Coils.	Suppliers approval	Review of records	On receipt of material	Suppliers Heat No. / Coil No. /	Approved vendor list	H.R coil Inspn. & Test Report	1	-	-	
		Results of supplier's T.C	-do-	T.C for each coil	P.O / Material specification	IS 10748 / IS 3589/1239	Suppliers T.C	1	-	-	
		Marking & Heat No	Visual	Each coil	P.O / Material specification	IS 10748	H.R coil Inspn. & Test Report	1	-	-	
		Width and Thickness	Measurement	Each coil	P.O / Material specification	IS 10748	H.R coil Inspn. & Test Report	1	-	-	
		Surface defects & packaging condn.	Visual	Each coil	P.O / Material specification	IS 10748	H.R coil Inspn. & Test Report	1	-	-	
		Chemical Elements	wet. analysis	One sample Per heat	P.O / Material specification	IS 10748 / IS 3589/1239	H.R coil Inspn. & Test Report	1	-	-	
		Mechanical Properties	Mechanical Testing	One Sample Per Heat	P.O / Material specification	IS 10748 / IS 3589/1239	H.R coil Inspn. & Test Report	1	-	-	

P – Perform By, R – Review By, W - Witness By, 1- JPL , 2 - Third Party / Customer

JINDAL PIPES LIMITED



Approved By

**JINDAL PIPES LIMITED (ERW PIPES)  
QUALITY INSPECTION PLAN**

Specification – IS:1239 & IS:3589

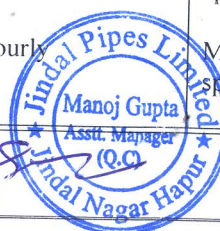
QAP No. : JPL/ERW/IS:1239 & IS-3589  
Rev. No. : 00  
Date : 17/07/2018  
Page : 2 of 3

Sl. No	Inspection / Test Stage	Checks	Type of Inspection	Frequency of Check	Reference Documents	Acceptance Norms	Format of Record	Inspection By			Remarks
								P	W	R	

2.0	<b>In-Process Inspn</b>											
2.1	Edge Preparation Trimming/Milling	Width & thickness	Measurement	5 times/coil	---	Strip width Chart	Slitting/Milling Rpt.	1	-	-		
2.2	Pipe manufacture	Surface defects	Visual	Continuous monitoring	P.O / Material specification	IS: 3589/1239	Slitting/Milling Rpt.	1	-	-		
		<b>Dimensional</b>										
		Out side diameter	Measurement	As per relevant specification	Material specification	As per IS: 3589/1239	Mill Inspn. Rpt.	1	-	-		
		Thickness	Measurement	-DO-	Material specification	As Per P.O/ IS: 3589/1239	Mill Inspn. Rpt.	1	-	-		
		Length	Measurement	-DO-	Material specification	As Per P.O/ IS: 3589/1239	Mill Inspn. Rpt.	1	-	-		
		Straightness	Measurement	-DO-	Material specification.	As Per IS: 3589/1239	Mill Inspn. Rpt.	1	-	-		
		<b>Mech. Property</b>										
		YS, UTS, %El	Mechanical Test	As Per Relevant Specification	Material specification	As Per IS: 3589/1239	Mech. Testing Rpt.	1	-	-		
		Flattening	Flattening	As per relevant specification	Material specification	As Per IS: 3589/1239	Flattening Test Rpt.	1	-	-		
2.3	End Preparation	Bevel Angle & Root Face	Measurement	Hourly	Material specification	As Per IS:3589/1239	Bevelling Inspn. Rpt.	1	-	-		

P – Perform By, R – Review By, W - Witness By, 1- JPL , 2- Third Party / Customer

JINDAL PIPES LIMITED



Approved By

**JINDAL PIPES LIMITED (ERW PIPES)  
QUALITY INSPECTION PLAN**

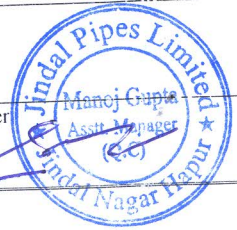
Specification – IS:1239 & IS:3589

QAP No. : JPL/ERW/IS:1239 & IS-3589  
Rev. No. : 00  
Date : 17/07/2018  
Page : 3 of 3

Sl. No	Inspection/ Test Stage	Checks	Type of Inspection	Frequency of Check	Reference Documents	Acceptance Norms	Format of Record	Inspection By			Remarks
								P	W	R	
2.4	Hydrostatic Test	Leakage	Visual	Each Pipe	Material specification	As Per P.O/ IS: 3589/1239	Hydrostatic Test Rpt.	1		2	
2.5	Galvanizing (if applicable)	Mass of zinc coating	Weight & calculation	As per relevant specification	Material specification	As per IS: 4736	Inspection Rpt./MTC	1	-	2	**if applicable **
		Threading	Visual	-DO-	-Do-	IS554/ As Per P.O	Inspection Rpt./MTC	1	-	2	
3.0	<b>Final Inspection</b>	<u>Y.S. U.T.S. % El &amp; Flattening</u>	Mechanical Test	As Per IS:4711	QCP-303	As Per P.O/ IS: 3589/1239	Test Report	1		2	
		<u>Visual &amp; Dimn. Surface condition</u>	Visual	As Per IS: 4711	-do-	-do-	Insp. Reports	1	2	-	
		O.D	Measurement	-do-	-do-	-do-	Insp. Reports	1	2	-	
		Wall Thickness	Measurement	-do-	-do-	-do-	Insp. Reports	1	2	-	
		Length	Measurement	-do-	-do-	-do-	Insp. Reports	1	2	-	
		Marking	Visual	-do-	-do-	-do-	Insp. Reports	1	2	-	
		Straightness	Measurement	-do-	-do-	-do-	Insp. Reports	1	2	-	
								MTC			
4.0	<b>Issue of Test Certificate</b>	Conformance to specification	Review of all Tests	All Test	-do-	-do-					

P – Perform By, R – Review By, W - Witness By, 1- JPL, 2 - Third Party / Customer

JINDAL PIPES LIMITED



Approved By