

		QUALITY ASSURANCE PLAN PRE-ENGINEERED STEEL BUILDING						DOCUMENT NO : PCT/QC/QAP/	
		NAME OF CUSTOMER :						REVISION NO : 00	
JOB NO :		DATE :							
DESCRIPTION	CHARACTERISTIC	TYPE OF CHECK	EXTENT OF CHECK	SPEC. CODES & STANDARDS FOR ACCEPTANCE CRITERIA	INSPECTION BY		FORMAT OF RECORDS	REMARKS	
					PCT	CLIENT			
1 RAW MATERIAL									
1.1	Steel Plate	a) Chemical Properties b) Mechanical Properties-Tensile, Bend & Impact c) Dimensions	a) Mill TC Verification b) Mill TC Verification c) Measurement	a) 100% b) 100% c) 10% of lot	ASTM A-572 Gr 50 or equivalent Matl. ASTM A-572 Gr 50 or equivalent Matl.	a) R b) R c) I		a) Mill TC b) Mill TC c) PCT-Inspection Report	
1.2	Hot Rolled Section (Beam/Channel/Angle Round Bar, Beams etc.)	a) Chemical Properties b) Mechanical Properties c) Dimensions	a) Mill TC Verification b) Mill TC Verification c) Measurement	a) 100% b) 100% c) 10% of lot	IS-2062 Gr B IS-2062 Gr B IS-1852	a) R b) R c) I		a) Mill TC b) Mill TC c) PCT-Inspection Report	
1.3	Galvalume Sheeting Coil (Plain/Pre-painted)	a) Chemical Properties b) Mechanical Properties c) Dimensions d) Coating	a) Mill TC Verification b) Mill TC Verification c) Measurement d) Coating thickness	a) 100% b) 100% c) 10% of lot d) 10% of lot	A-792 Gr.345/ 550 Mpa A-792 Gr.345/ 550 Mpa	a) R b) R c) I d) I		a) Mill TC b) Mill TC c) PCT-Inspection Report d) PCT-Inspection Report	
1.4	Plain / Galvanized Coil (For secondaries / Purlins)	a) Chemical Properties b) Mechanical Properties c) Dimensions d) Coating	a) Mill TC Verification b) Mill TC Verification c) Measurement d) Coating thickness	a) 100% b) 100% c) 10% of lot d) 10% of lot	ASTM A-653 - 345 Mpa ASTM A-1011/570 Gr.50	a) R b) R c) I d) I		a) Mill TC b) Mill TC c) PCT-Inspection Report d) PCT-Inspection Report	
1.5	Hollow sections (Pipe, Tubes & Sq. Pipes)	a) Chemical Properties b) Mechanical Properties c) Dimensions	a) Mill TC Verification b) Mill TC Verification c) Measurement	a) 100% b) 100% c) 10% of lot	IS-4923, IS-1239,IS-1161	a) R b) R c) I		a) Mill TC b) Mill TC c) PCT-Inspection Report	
2 BOUGHT OUT ITEMS									
2.1	Bolts	a) Chemical properties b) Mechanical properties c) Dimension	a) Mfr. TC Varification b) Mfr.TC varification c) Measurement	a) 100 % b) 100 % c) Sample-3 in 1000 / 5 in 5000	ASTM A-325, Type 1 ASTM A-325, Type 1	a) R b) R c) I		a) Manufacturer TC b) Manufacturer TC c) PCT-Inspection report	
2.2	Nuts	a) Chemical properties b) Mechanical properties c) Dimension	a) Mfr. TC Varification b) Mfr.TC varification c) Measurement	a) 100% b) 100% c) Sample-3 in 1000 / 5 in 5000	ASTM A-563, Gr 10 S ASTM A-563, Gr 10 S	a) R b) R c) I		a) Manufacturer TC b) Manufacturer TC c) PCT-Inspection report	
2.3	Washers	a) Chemical properties b) Mechanical properties c) Dimension	a) Mfr. TC Varification b) Mfr.TC varification c) Measurement	a) 100% b) 100% c) Sample-3 in 1000 / 5 in 5000	ASTM F-436, Gr C45 ASTM F-436, Gr C45	a) R b) R c) I		a) Manufacturer TC b) Manufacturer TC c) PCT-Inspection report	
2.4	Insulation	a) Dimension b) Properties	a) Measurement b) T.C verification	a) 3 Rolls in -100 Rolls b)100 %	IS-8183 / IS 3144	a) I b) R		a) PCT-Inspection report b) Manufacturer TC	
2.5	Doors/Windows/Louvers Shutters/Vents /Skylites Etc.	a) Dimension b) Visual	a) Measurement b) Visual	a) 10% of lot b) 100%	a) Drawing	a) I		a) PCT-Inspection report	
2.6	Paints	a) Properties	a) Mfr. TC Varification	a) Per batch	a) As per manufacturer & client specification	a) R		a) Mfr. TC	
2.7	Welding Consumables	a) Chemical properties b) Mechanical properties c) Dimension	a) Mfr. TC / Lab Report b) Mfr. TC / Lab Report c) Measurement	a) 100% a) 100% of lot c) Per batch	AWS D1.1 ASME Sec II	a) R b) R c) I		a) Mfr. TC b) PCT-Inspection report	

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3 FABRICATION PROCESS									
3.1	Cutting of Steel Plate / Sheet	a) Dimension	a) Measurement	a) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
3.2	Flange to flange & Web to web fit up	a) Dimension	a) Measurement	a) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
3.3	Welding Qualification	a) Procedure Specification b) Procedure Qualification c) Welder Qualification	a) Verification b) Verification c) Verification	a) 100% B) 100% C) 100%	a) AWS D 1.1	a) I		a) WPS b) PQR c) WPQR	
3.4	Punching & Drilling of Holes on flange & Base Plates	a) Dimension	a) Measurement	a) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
3.5	Web to Flange Fit up	a) Dimension	a) Measurement	a) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
3.6	Inspection of Flange to Web fillet welding at Conrac weld station	a) Dimension b) Weld Fillet profile & size c) Visual Defects	a) Measurement b) Physical c) Visual	a) 10% b) 10% c) 100 %	As Per Drawing / MBMA AWS D1.1	a) I		a) PCT-Inspection report	
3.7	Fit up of base Plate/Splice plate/Clits, gussets & Other parts	a) Dimension	a) Measurement	a) 100%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
3.8	Welding Inspection (NDT - fillet & Butt weld)	a) Free from cracks, inclusions, porosity, etc. defects	a) Visual b) DP Test & UT test	a) 100% b) 1 Sample / Shift	a) AWS D1.1 & ASME - Sec:V	a) I		a) PCT-Inspection report	
3.9	Final Inspection (Before Painting)	a) Dimension b) Physical damage c) Part Identification	a) Measurement b) Visual c) Varification	a) 100% b) 100% c) 100 %	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
4 Surface Cleaning & Painting									
4.1	Surface Cleaning & Painting Process	a) Surface preparation b) DFT	a) Measurement b) Measurement	a) Random b) Random	As per Client requirement and SSPC	a) I		a) PCT-Inspection report	
5 Forming									
5.1	Cold Form "C" AND "Z" Sections	a) Dimension b) Visual	a) Measurement b) Visual	a) 10% b) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
5.2	Roof/Wall sheeting	a) Dimension b) Visual	a) Measurement b) Visual	a) 10% b) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
5.3	Deck panel / Down spout Curved Panel/Ridge Panel	a) Dimension b) Visual	a) Measurement b) Visual	a) 10% b) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
5.4	Round bar section (Anchor bolts/brace rods)	a) Dimension b) Visual	a) Dimension b) Visual	a) 10% b) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
5.5	Flashings/Trims/Gutters	a) Dimension b) Visual	a) Dimension b) Visual	a) 10% b) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	
5.6	Loose Clips, gussets, Angles, Stairs & Misc. Parts	a) Dimension b) Visual	a) Dimension b) Visual	a) 10% b) 10%	As Per Drawing / MBMA	a) I		a) PCT-Inspection report	

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6 Shipping								
6.1	Shipping Inspection	a) Material identification b) Inspection status c) Physical damage	a) Verify drawing b) Verify Inspection report c) Visual	a) 100% b) 100% c) 100%	As Per Drawing	a) I		a) PCT-Inspection report
LEGEND :- R - Review I - Inspection W - Witness RW-Random Witness PCT - Phenix Construction Technologies AWS - American Welding Society ASTM - American Society for Testing & Material MBMA - Metal Building Mfrs. Association ASME - Americal Society of Mechanical Engineers SSPC - Society for Protective coating								
Prepared by : _____ Phenix Construction Technologies - Head Q.A./Q.C.						Reviewed & Approved by : _____ Customer / Third Party Insp.		