

Maharashtra Seamless Limited
Pipenagar
Quality Assurance & Test Plan for seamless carbon steel pipes.

Customer :
 PO. No. :

QAP No. : MSL/QAP/0030/2021 Rev.0
 Date : 09/11/2021
 OC. No. :

Specification : ASTM A 106 Gr.B (2019) , IBR

Sl. No	Inspection/ Test stage	Checks	Type of Inspection	Frequency of checks	Material Identification	Acceptance Norm	Records	Inspection by	
								MSL	TPIA
A	Receiving Inspection Inspection of Billet	Results of supplier TCs	Review	On receipt of supplier TCs	Supplier Heat No.	As per PO./Spec.	RMTC	R	R
B	In-process & Final inspection / Testing stretch reducing mill	Surface Dimensional	Visual Measurement	Size setting subsequently hourly once in shift	Heat No.	As per PO./Spec.	IR	P
		Weight	Measurement						
2	Heat treatment (if applicable)	Temperature Soaking	Verification	hourly	Heat No.	As per PO./Spec.	IR	P	R
3	Physical testing	Mechanical properties	YST, UTS, %El. Bend/Flattening	One sample per heat	Heat No.	As per PO./Spec.	MTC	P	W
4	Chemical testing	Chemical composition	Spectro Analysis	Two sample per heat	Heat No.	As per PO./Spec.	MTC	P	R
5	Hydrostatic testing	Leak tightness	Record review	100%	Heat No.	As per PO./Spec. (ASTM A530)	MTC	P	R
6	Final Inspection	Surface Dimensional End finish Marking Coating-Varnish	Visual Measurement Visual Measurement Visual Visual	100% 10% 10% 10%	Heat No.	As per PO./Spec. (ASME B36.10M)	MTC	P	10% W (Random)
7	IRN & MTC	MTC EN 10204: 3.1	Review	Heat No.	As per PO./Spec.	MTC	R	R

Legends: PO: Purchase order, SPEC.: Specification, IR: Inspection report, R: Review, H: Hold, W: Witness, P: Perform
 MSL: Maharashtra seamless limited, MTC: Mill Test Certificates, VDI: Visual & Dimensional Inspection, TPIA: Third Party Inspection Agency
 Note:

- 1) Dimensional, Hydro Test, Chemical & Mechanical properties shall be maintained as per ASTM latest edition.
- 2) Marking will be done by paint stencilling on outer surface of pipes approximately 12" from one end.
- 3) Pipes shall be supplied with rust preventive black/transparent varnish coating on outer surface of pipes only.
- 4) All pipes shall be supplied with random length in SRL (4 - 7) or DRL (7 - 12) meter as specified in PO/OC.
- 5) Ready stock material is also acceptable with triple marking as "A 53 B/A 106 B/API 5L B PSL1/NACE"
- 6) Pipes below 2" shall be supplied with Plain end & other with Plain/Bevel end as per ASME B16.25 Fig2 (35° - 40°)
- 7) PO. Line item quantity ≤ 200 meter, scope of TPIA will be 10% VDI and review of documents only.



PREPARED BY:

REVIEWED BY

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