

CUSTOMER Name.

CUSTOMER ORDER No.

PROJECT NAME

QP No.

Issue No

SSE REF

This Quality Plan defines the specific activities in accordance with the stated specifications/procedures.
It supplements the SSE Q.A. Manual and procedures to satisfy the requirements of BS EN ISO 9002

UNLESS OTHERWISE STATED ALL SPECIFICATIONS / PROCEDURES ARE TO THE LATEST REVISION

Op. No.	OPERATION	Reference Document/Procedure No.	Inspection Requirements			Verifying Documents
			SSE	Client	3rd Party	
01	Contract Review	SSE SQP 11/1-01	R1,R			Enquiry Purchase Document SSE 004
02	Purchasing of Raw Materials	SSE SQP 3/1-01	R1,R			SSE Purchase Order
03	Check Incoming Raw Material	SSE SQP 5/2-01	A1,R1,R			Start Material Mill Certification EN10204.3.1.B
04	Prepare SSE Route Card	SSE SQP 2/1-02	R1,R			SSE Route Card
05	Cut Blanks and Check Transfer of Material Identity to Route Card	SSE SQP 7/1-01	A2			SSE Route Card
06	Prepare Blanks and Form, Including Intermediate Heat Treatment If Applicable	SSE SQP 7/3-01 No. 142	A2			SSE Route Card
07	Degrease	SSE SQP 7/3-01 QP No 040	A2			SSE Route Card
08	Solution Heat Treatment	SSE SQP 7/3-01 QP No	A2,R			SSE Route Card Heat Treatment Chart
09	Machining	ASME B16.9	A2			SSE Route Card
10	Testing					
	a) Mechanical	ASTM A.	A1,R1			Test House Report
	b) Chemical	ASTM A.	A1,R1			Test House Report
	c) Inter-crystalline Corrosion	ASTM A.	A1,R1			Test House Report
	d) Charpy Impact	ASTM A.	A1,R1			Test House Report
	e) Radiography	ASTM A.	A1,R1			Test House Report
	f) Ultrasonic	ASTM A.	A1,R1			Test House Report
11	Pickle/Passivate/Rinse	SSE SQP 7/3-01 No.	A2			SSE Route Card
12	Dye Penetrant Inspection	SSE SQP 7/3-01 QP106 & Clients/Specification	A1			SSE Route Card
13	Final Visual & Dimensional Inspection	SSE SQP 5/3-01	A1			SSE Route Card
14	Hardness check to Nace MR 01-75	SSE SQP 7/3-01 QP No147 and Nace Mr-01-75.	A1			SSE Route Card
15	Marking & Colour Coding of Product	SSE SQP 7/3-01 No. 116 & Client requirements	A1			Marking on Product
16	Final Document check		A1			
	a) SSE Manufacturing Cert.	ASTM A. and NACE MR 01-75	R1,R			EN 10204 31.B SSE Manufacturing Cert.
	b) Start Material Certificate	ASTM A.	R1,R			Start Material Mill Certification EN10204.3.1.B
	c) Dye Penetrant Inspection	ASME VIII & Clients Requirements	R1,R			Dye Penetrant Report
	d) Test House Report	ASTM A.	R1,R			Test House Report.
	d) Advice Note	SSE SQP 12/4-01	R1,R			Advice Note
17	Packing/Despatch	SSE SQP 12/3-01	S			Carriers Signature

Key : A1 - 100% Actual Inspection A2 - Sample Inspection W1 - 100% Witness W2 - Sample Witness R1 - 100% Review of Documents R2 - Sample Review of Documents
S - Surveillance AP - Procedure to be Approved by Customer R - Records retained by SSE

		Applicable Specifications	Documents for Approval	Quality Plan Requirements Fulfilled	
				Sign	Date
Prepared By	ASTM A. ASME B16.9 ASME B16.28		SSE	
Approved By	Client /Project Specification		Client	
Date Issued			3rd Party	