

		STANDARD QUALITY PLAN										Valid From		
		ITEM :GALVANIZED TOWER STRUCTURES/PARTS (TRANSMISSION LINE/SUB STATION/ EQUIPMENT STRUCTURE)						SQP NO : TRN/QA/M/SQP/403 Version No : 1.2 Date : 23.06.2025			Approved By	Valid To		
SL No.	COMPONENT/ OPERATION	CHARACTERISTICS	CATEGORY OF CHECK	TYPE OF CHECK	QUANTUM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD		INSPECTION AGENCY			REMARKS
					M	C/A					M	C	A	
1	2	3	4	5	6		7	8	9	*D	**10			11
1	RAW MATERIAL													
1.1	STRUCTUAL STEEL (SECTIONS, SHEETS & PLATES)						IS 2062 / AESL TS/PO/RFP	Steel to be Procured from AESL Approved Source only.						Mild Steel (MS) or High Tensile steel (HT) as per IS: 2062 or contract specified steel as per relevant national / international standards.
1.2	Visual Inspection	Visual	Major	Visual	Manufacture's Plant Standard	N/A	IS 2062 / AESL TS	Material to be free from surface defects like laminations, rough, jagged, and imperfect edges, cracks, rounded apex, deep roll marks, pipy & any harmful defects.	Manufacturer Record		P	V	V	
1.3	DIMENSIONAL INSPECTION		Major	Measurement	Manufacture's Plant Standard	N/A	IS 808 / IS 1730 / IS 1852 / AESL TS							
a	Angle Section	Tolerances for Leg Length of Angles Equal / Un Equal	Major	Measurement	Manufacture's Plant Standard	N/A	IS 1852 / IS 808/AESL TS	For Equal : 1) Up to 45mm Leg Length - +/- 1.5mm 2) >45 to 100mm Leg Length - +/- 2.0mm 3) >100 mm Leg Length - +/- 2.0% of Leg Length. Difference between Leg Length of equal angles shall be limited to 75% of total tolerance (Plus or Minus).	Manufacturer Record		P	V	V	
b		Out of Square ness	Major	Measurement			IS 1852 / AESL TS	±1	Manufacturer Record		P	V	V	
c		Camber	Major	Measurement			IS 1852/AESL TS	1) For Flange <100mm - Reasonably Straight. 2) For Flange >= 100mm - Max. 0.2% of Length.	Manufacturer Record		P	V	V	
d		Root Radius	Major	Measurement			IS 808/AESL TS	IS 808/AESL TS	Test Report		P	V	V	
e		Weight Tolerance for Angle Section	Major	Unit Weight Test			IS 1852 / IS 808/AESL TS	1) Up to 3mm thick - +/- 5% 2) >3mm thick - +5% / -3% Over weights : AS per IS 808.	Manufacturer Record		P	V	V	

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f	Plate Section	Weight Tolerance	Major	Unit Weight Test	Manufacture's Plant Standard	N/A	IS 1852 / IS 1730/AESL Spec	+5 % / -2.5 %. Overweight : As per IS 1730	Manufacturer Record		P	V	V	
g		Thickness Tolerance	Major	Measurement			IS 2062 / IS 1730 / IS 1852/AESL TS	1) <8mm thick - + 12.5% / - 5% 2) 8mm to 12mm - + 7.5 % / - 5% 3) > 12mm - +/- 5 %	Manufacturer Record		P	V	V	
1.4	Chemical Composition	Chemical Analysis	Major	Chemical	Manufacture's Plant Standard	N/A	AESL TS / Approved Drawing / IS: 2062	AESL TS / Approved Drawing / IS: 2062	RMTC/ Third Party Lab Report		P	V	V	
1.5	Mechanical Properties													
a	Mechanical Properties	Test for Ultimate Tensile Strength	Major	Testing	Manufacture's Plant Standard	N/A	IS 2062/ AESL TS	IS 2062/ AESL TS	Manufacturer Record		P	V	V	
b		Yield Stress	Major	Testing					Manufacturer Record		P	V	V	
c		% Elongation Test, Min	Major	Testing					Manufacturer Record		P	V	V	
d		Bend Test	Major	Testing					Manufacturer Record		P	V	V	
e		Impact Test (Not Applicable Grade E250A & Grade E350A)	Major	Testing					Manufacturer Record		P	V	V	
1.6	Zinc	Chemical Composition	Major	Chemical Analysis	One Sample for 100MT or Part thereof	N/A	IS 209/ AESL TS	The molten metal in galvanizing bath shall not contain less than 98.5% by mass of zinc	MTC/ TPL		P	V	V	To be procured from Hindustan Zinc / Binani Zinc only. For any other source owner approval required prior to mfg. .
2	INPROCESS INSPECTION													
2.1	Fabrication of Tower Parts						IS 802 Part II/ IS 7215/ Shop Sketches							
2.1.1	Fabrication of Tower Parts	Straightening	Major	Visual	100%		IS 802-2 / IS 7215 / AESL Approved Drg. / Shop Sketches.		Manufacturer Record					
2.1.2		Cropping (Cutting)	Major	Dimensional	1st piece & Every 50th Piece		IS 802-2 / IS 7215 / AESL Approved Drg.. / Shop Sketches.	Length Tolerance : +/- 2mm The Cut Surface to be clean, reasonable square & free from distortion. Latter Size AS per AESL Norms.	Manufacturer Record		P	V	V	
2.1.3		Stamping	Major	Visual	1st piece & Every 50th Piece		IS 802-2 / IS 7215 / AESL Approved Drg.. / Shop Sketches.		Manufacturer Record		P	V	V	

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2.1.4	Fabrication of Tower Parts	Punching / Drilling	Major	Dimensional	1st piece & Every 50th Piece			Holes for bolts shall be drilled or punched with a jig but drilled holes shall be preferred. The punching may be adopted for thickness up to 12mm. Tolerance regarding punch holes should be as follows. 1) Holes must be perfectly circular & no tolerance allowed. 2) The Max. allowable difference in dia.. of the holes on two sides of plates or angle is 0.8 mm. i.e. the allowable taper in a punched hole should not exceed 0.8 mm on dia.meter. 3) Holes must be square with the plates or angles and have their walls parallel.	Manufacturer Record		P	V	V	
2.1.5		Edge Security	Major	Dimensional	1st piece & Every 50th Piece		IS 802-2 / IS 7215 / AESL Approved Drg.. / Shop Sketches.		Manufacturer Record					
		a) For 13.5 mm dia.. Hole	Major	Dimensional				AS per approved Drawing / Sheared 20 mm Min. Rolled 16 mm Min.		P	V	V		
		b) For 17.5 mm dia.. Hole	Major	Dimensional				AS per approved Drawing / Sheared 23 mm Min. Rolled 20 mm Min.		P	V	V		
		c) For 21.5 mm dia.. Hole	Major	Dimensional				AS per approved Drawing / Sheared 28 mm Min. Rolled 25 mm Min.		P	V	V		
		d) For 25 mm & 25.5 mm dia.. Hole	Major	Dimensional				As per AESL Approved Drg...		P	V	V		
2.1.6		Drilling & Punching Hole to Hole Distance	Major		1st piece & Every 50th Piece		IS 802-2 / IS 7215 / AESL Approved Drg.. / Shop Sketches.	AS per approved Drawing / Tolerance Cumulative & between consecutive hole shall be with in +/- 2mm and +/- 1mm respectively.	Manufacturer Record		P	V	V	

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2.1.7	Fabrication of Tower Parts	Notching Flange Cut Corner Cut Bevel Cut	Major		1st piece & Every 50th Piece		IS 802-2 / IS 7215 / AESL Approved Drg.. / Shop Sketches.	AS per approved Drawing / + 5 mm on specified length of cut operationally shearing up to 12 mm thick by gas cutting for material above 12 mm thick. For Members >12 mm Gas cutting to be adopted as followed.	Manufacturer Record		P	V	V	
2.1.8		Heel Cutting	Major	Dimensional	1st piece & Every 50th Piece		AESL Approved Drg..s. / Shop Sketches	AS per approved Drawing / By Grinding / Machine cutting, tolerance on Heel cutting length + 10 mm.	Manufacturer Record		P	V	V	
2.1.9		Bending	Major		100% Pieces		IS 802-2 / IS 7215 / AESL Approved Drg.. / Shop Sketches.	1) HT Sections / Plates. All Sections & all plates to be Hot bent. 2) M.S Section a) Cold - Sections up to 75x75x6 - Angle up to 10 Degree. B) Cold - Sections up to 100x100x8 - Angle up to 5 Degree. c) Hot - Section above 75x75x6 - Angle above 10 Degree. d) Hot - Section above 100x100x8 - Angle above 5 Degree. 3) M.S Plates a) Cold up to 12 mm thick Up to 15 Degree. b) Hot - Other	Manufacturer Record		P	V	V	
2.1.10		Welding	Major	a) WPS Approval (Welding Procedure Specification) b) PQR / WQR Approval (Procedure/Welder Qualification record)			AS per AESL TS / AESL Approved Drg.. / AESL Approved Welding Procedure & Welding Qualification.		Manufacturer Record		P	V	V	WPS and Welder's qualification shall be done in line with Welder's Qualification Guideline
	Major		a) DP Test b) Dimensional & Visual for welding tower parts	Random Basis		AS per AESL TS / AESL Approved Drg.. / AESL Approved Welding Procedure & Welding Qualification.		Manufacturer Record		P	V	V		

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2.1.11	Final Inspection of Fabricated Parts (Black Stage)	Final Inspection of Fabricated Parts (Black Stage)	Major		Random Basis		All Parameters from 2.1.1 to 2.1.10 shall be checked & Maintain record before releasing the material for Galvanizing.		Manufacturer Record		P	V	V	
2.2	GALVANIZING (Surface Preparation Procedure)													
2.2.1	Surface Preparation Procedure	Degreasing	Major	Chemical	One Sample Daily		IS: 2629 (Part-13)	Manufacturer Plant standard/ IS	Manufacturer Record		P	V	V	
2.2.2		Pickling	Major	Chemical	One Sample Daily		IS: 2629 (Part-13)	Manufacturer Plant standard / IS Iron Content 100 to 120 gram/litre. Max	Manufacturer Record		P	V	V	
2.2.3		Rinsing	Major	Chemical	One Sample Daily		IS: 2629 (Part-13)	Manufacturer Plant standard /IS	Manufacturer Record		P	V	V	
2.2.4		Pre-Fluxing	Major	Chemical	One Sample Daily		IS: 2629 (Part-13)	IS: 2629 (Part-13) / Mfg. Plant Std.	Manufacturer Record		P	V	V	
2.2.5		Pre-Heating	Major	Measure of Temp.	One Sample Daily		IS: 2629 (Part-13)	IS: 2629 (Part-13) / Mfg. Plant Std.	Manufacturer Record		P	V	V	
2.2.6	Surface Preparation Procedure	Dipping	Major					Purity of molten zinc bath 98.5% Min.	Manufacturer Record		P	V	V	#. Double dipping is not acceptable. #. After drying is over the material is dipped in molten zinc. Following parameters are controlled
a		Zinc Bath Temperature	Major	Hourly Check			IS: 2629 (Part-13)	450 +/- 10 Deg. Cent.	Manufacturer Record		P	V	V	
b		Immersion & Withdrawal time.	Major	Hourly Check			IS: 2629 (Part-13)	IS: 2629 (Part-13) / Mfg. Plant Std.	Manufacturer Record		P	V	V	
2.2.7		Quenching in Running Water	Major				IS: 2629 (Part-13)	IS 2629	Manufacturer Record		P	V	V	
2.2.8		Dichromating	Major	Hourly Check	One Sample Daily		IS: 2629 (Part-13)	IS: 2629 (Part-13) / Mfg. Plant Std.	Manufacturer Record		P	V	V	

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2.3 GALVANIZING CHECKING														
2.3.1	GALVANIZING CHECKING	Visual Checking	Major	Visual	100%		IS 2629	Surface to be free from defects like black spot, heavy ash & flux inclusion, lumps, pimples etc.	Manufacturer Record		P	V	V	
2.3.2		Thickness of Zinc Coating	Major	Measurement	8 Sample/ shift		IS 4759 / AESL TS	AESL -PO/RFP/BOQ/TS/Approved Drawing *For Non coastal Area : Minimum average value of Coating thickness. 1) 5mm thick & over - 86 Microns 2) Under 5mm, but not less than 2mm - 65 Microns. *For Coastal Area : Minimum average value of Coating thickness. 1) 5mm thick & over - 127 Microns 2) Under 5mm - 87 Microns. * Other than Non Coastal & Coastal area : Minimum average value of coating thickness shall be as per the project specific contract agreement.	Manufacturer Record		P	V	V	* Please coordinate with AESL engineering for clarity on material will use in coastal area OR Non Coastal area before manufacturing and confirmation for the same shall be provided to inspector during inspection. * Don't go with assumption during mfg. / inspection. Req. of owner confirmation is mandatory * Please refer General Note no. 11 for coastal area definition
2.3.3	GALVANIZING CHECKING	Weight of Zinc Coating	Major	Measurement	3 Samples / Shift		IS 4759 / IS 6745 / AESL TS	AESL -PO/RFP/BOQ/TS/Approved Drawing *For Non coastal Area : Minimum value Mass of Zn Coating 1) 5mm thick & over - 610 gm/m2 2) Under 5mm, but not less than 2mm - 460 gm/m2 3) Under 2mm but not less than 1.2mm - 340 gm/m2 *For Coastal Area : Minimum value Mass of Zn Coating 1) 5mm thick & over - 900 gm/m2 2) Under 5mm - 610 gm/m2 * Other than Non Coastal & Coastal area : Minimum value of Mass of Zn coating shall be as per the project specific contract agreement.	Manufacturer Record		P	V	V	* Please coordinate with AESL engineering for clarity on material will use in coastal area OR Non Coastal area before manufacturing and confirmation for the same shall be provided to inspector during inspection. * Don't go with assumption during mfg. / inspection. Req. of confirmation is mandatory * Please refer General Note no. 11 for coastal area definition
2.3.4		Uniformity of Zinc Coating	Major	Measurement	3 Samples / Shift		IS 2633	Material to withstand 4 dips of 1 minute each without showing sign of copper deposits.	Manufacturer Record		P	V	V	
2.3.5		Adhesion Test of Zinc Coating	Major	Pivoted Hammer Test	3 Samples / Shift		IS 2629	No removal or lifting of coating in areas between hammer impressions.	Manufacturer Record		P	V	V	

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3	FINAL INSPECTION & TESTING													
TOWER PARTS ITEMS : PI. ensure below requirements prior to start insp. and found any deviation pl. coordiante with CQA , AESL AND without confirmation from AESL CQA insp. shall not start. Drawings : PI. ensure the approved drawings are in CAT-1/ CAT-1* or an extension of earlier project-approved drawings for the respective project with the stamp of " Release for Model " from AESL Engineering prior to inspection. BOM : The project-specific approved BOM in CAT-1 / CAT-1*, Also note that if the BOM is approved in CAT-1, then the drawing must also be approved in CAT-1. SUBSTATION STRUCTURE 1.The project specific approved documents (BOM & Drawing) in Cat 1/Cat-1* 2. The drawing is either "CAT-IV" or with comments " Proto is required ", in such case ensure proto corrected drawings shall be approved by AESL engineering OR waiveoff mail from AESL engineering.														
3.1	Visual	Visual Inspection	Major	Visual	100%	#100%	IS 2062 : 2011 & IS 2629 Annexure - A/ AESL Approved Drg	Material to be free from surface defects like laminations, rough, jagged, and imperfect edges, cracks, rounded apex, deep roll marks, pipy & any GI defects.	Test Report	√	P	H	H	#Physical verification of lot as per offer list for material readiness
3.2	Dimensional	Dimensional Inspection	Major	Measurement	1 Sample for Every 50 MT / Section / Lot or part there of	# 1 Sample for Every 50 MT / Section / Lot or part there of	IS 2062 : 2011 & IS 2629 Annexure - A/ AESL Approved Drg	Material to be free from surface defects like laminations, rough, jagged, and imperfect edges, cracks, rounded apex, deep roll marks, pipy & any GI defects.	Test Report	√	P	H	H	#The Dimension reports with mark number shall be submitted as a part of FAT Reports.
3.3	Mechanical Properties	UTS Test	Major	Testing	For Sample Calculation 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) For Witnessing MS Items 25% Randomly to be selected from the above samples HT Items 50% Randomly to be selected from the above samples	For Sample Calculation 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) For Witnessing MS Items 25% Randomly to be selected from the above samples HT Items 50% Randomly to be selected from the above samples	IS 2062 / AESL TS	IS 2062 / AESL TS	Test Report		P	H	H	
		Yield Stress Test	Major	Testing					P	H	H			
		% Elongation Test, Min	Major	Testing					P	H	H			
		Bend Test	Major	Testing					P	H	H			
		Impact Test (Not Applicable Grade E250A & Grade E350A)	Major	Testing					Test Report	√	P	H	H	
3.4	Chemical Analysis	Chemical Analysis	Major	Spectro Analysis	For Sample Calculation 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) For Witnessing MS Items 25% Randomly to be selected from the above samples HT Items 50% Randomly to be selected from the above samples	For Sample Calculation 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) For Witnessing MS Items 25% Randomly to be selected from the above samples HT Items 50% Randomly to be selected from the above samples	IS 2062 / AESL TS	IS 2062 / AESL TS	Test Report	√	P	H	H	

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3.5	Galvanizing Test	Thickness of Zinc Coating	Major	Testing	<u>For Sample Calculation</u> 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) <u>For Witnessing MS Items</u> 25% Randomly to be selected from the above samples <u>HT Items</u> 50% Randomly to be selected from the above samples	<u>For Sample Calculation</u> 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) <u>For Witnessing MS Items</u> 25% Randomly to be selected from the above samples <u>HT Items</u> 50% Randomly to be selected from the above samples	IS 4759 / AESL TS	AESL -PO/RFP/BOQ/TS/Approved Drawing *For Non coastal Area : Minimum average value of Coating thickness. 1) 5mm thick & over - 86 Microns 2) Under 5mm, but not less than 2mm - 65 Microns. *For Coastal Area : Minimum average value of Coating thickness. 1) 5mm thick & over - 127 Microns 2) Under 5mm - 87 Microns. * Other than Non Coastal & Coastal area : Minimum average value of coating thickness shall be as per the project specific contract agreement.	Test Report	√	P	H	H	* Please coordinate with AESL engineering for clarity on material will use in coastal area OR Non Coastal area before manufacturing and confirmation for the same shall be provided to inspector during inspection. * Don't go with assumption during mfg. / inspection. Req. of owner confirmation is mandatory * Please refer General Note no. 11 for coastal area definition
		Weight of Zinc Coating	Major	Testing	<u>For Sample Calculation</u> 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) <u>For Witnessing MS Items</u> 25% Randomly to be selected from the above samples <u>HT Items</u> 50% Randomly to be selected from the above samples	<u>For Sample Calculation</u> 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) <u>For Witnessing MS Items</u> 25% Randomly to be selected from the above samples <u>HT Items</u> 50% Randomly to be selected from the above samples	IS 4759 / IS 6745 / AESL TS	AESL -PO/RFP/BOQ/TS/Approved Drawing *For Non coastal Area : Minimum value Mass of Zn Coating 1) 5mm thick & over - 610 gm/m2 2) Under 5mm, but not less than 2mm - 460 gm/m2 3) Under 2mm but not less than 1.2mm - 340 gm/m2 *For Coastal Area : Minimum value Mass of Zn Coating 1) 5mm thick & over - 900 gm/m2 2) Under 5mm - 610 gm/m2 * Other than Non Coastal & Coastal area : Minimum value of Mass of Zn coating shall be as per the project specific contract agreement.	Test Report	√	P	H	H	* Please coordinate with AESL engineering for clarity on material will use in coastal area OR Non Coastal area before manufacturing and confirmation for the same shall be provided to inspector during inspection. * Don't go with assumption during mfg. / inspection. Req. of confirmation is mandatory * Please refer General Note no. 11 for coastal area definition
		Uniformity of Zinc Coating	Major	Testing	<u>For Sample Calculation</u> 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) <u>For Witnessing MS Items</u> 25% Randomly to be selected from the above samples <u>HT Items</u> 50% Randomly to be selected from the above samples	<u>For Sample Calculation</u> 1 Sample / 50 MT / Section / Source (Reroller/Manufacture) <u>For Witnessing MS Items</u> 25% Randomly to be selected from the above samples <u>HT Items</u> 50% Randomly to be selected from the above samples	IS 2633	Material to withstand 4 dips of 1 minute each without showing sign of copper deposits.	Test Report	√	P	H	H	
		Adhesion Test of Zinc Coating	Major	Testing			IS 2629	No removal or lifting of coating in areas between hammer impressions.	Test Report	√	P	H	H	

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3.6	Identification & Marking	Marking	Major	Visual	100%	100%	Parts No as Per AESL Approved Drg...	Parts No as Per AESL Approved Drg.	Packing List		P	V	V	
3.7	Packing, Storing, Bundling & Handling	Packing, Storing, Bundling & Handling	Major	Visual	100%	100%	As per AESL TS /DRAWING / PO/ RFP.	As per AESL TS /DRAWING / PO/ RFP.	Packing List	√	P	V	V	All Materials shall be packed item wise in one bundle. All the bundles will be strapped with G.I.Strip. Cleat Angles, Gusset Plates, brackets, fillet plate and similar loose pieces shall be wired through wholes.
LEGEND:- D* Records identified with tick () shall be essentially included by supplier & manufacturer in Quality Documentation package.														
** M: Manufacturer / Sub-Supplier, C: Main Supplier, A: ADANI or their authorized representative.														
Use the following term as appropriate in columns 10. P: Perform, V: verification and H: Customer Hold Point to be witnessed and work shall not proceed till it is witnessed and cleared in writing.														
GENERAL NOTE : 1) This is generalised SQP, Hence should be read in conjunction with AESL TS / RFP / PO / BOQ/GTP / Drawing and shall deem to include additional test / requirements / Stringnet parameter asked if any as per the contract specific requirements as applicable to specific contract and Bidder shall compliance the same without any commercial implication to owner. 2) Nuts, Bolts & Step Bolts, Nuts & Other bought out items to be procured from AESL Approved Vendors only. 3) Welding Procedure & Welders Performance Qualification approved by AESL is required in case welding is involved at any stage of Fabrication / Erection work. 4) Testing Instruments used during Inspection must be calibrated from NABL accredited lab only. Instruments used during testing should be within valid calibration date. 5) Manufacturer shall ensure that all the test mentioned in technical specification of project / package need to be carried out strictly without fail. If it is not covered under SQP. 6) The manufacturer shall maintain the proper correlation from raw material test certificates / records to finish product and records should be offered for verification during inspection by AESL / Their nominated TPIA. 7) Whenever Indian standard / International standard are referred their latest amended shall be included. The same shall be applicable if manufacturer specification / plant standard also so long as these changes are made with the approval of competent authority of manufacturer. 8) AESL may review the effective implementation of the processes during the product stage / final inspection. 9) Piece of light sections to be wire bundled & of heavy sections to be supplied loose. Stacking to have proper ventilation and kept inclined. Damage to Galvanization coating to be avoided while handling. The Fabricator to ensure sequential supplies and other details as per AESL Technical Specification. 10) Dispatch of the inspected tower parts shall be done with each tower / panel wise bundling in order to ensure availability of complete tower parts without missing of any member at site. 11) The area / location consider under coastal area if it is following under 30 km radius from sea shore or as specified in section-project. 12) As per Plastic Waste Management Rules, 2016, rule 4 clause (d) the contractor/Supplier/Vendor shall not use plastic sheet of less than 50 (Fifty) microns in thickness for the purpose of packing or wrapping the commodity/Commodities supplied to Adani Transmission Limited. 13) In case of any tests being carried out at third party laboratory, such laboratory/facility shall be NABL accredited/acceptable to Adani. 14) In case of any failure of samples during mechanical or chemical testing, retesting shall be carried out to nullify any possibility of error during sample preparation or testing. While selecting samples for retesting, one sample shall be taken from the very same section of Tower structure from which the original test sample was taken and another sample shall be selected from any other member (section of same size) in the offered lot. The lot of this particular section size shall be considered acceptable only if both the samples selected for retesting are conforming to acceptance parameters against the test performed. Else particular sections lot shall be rejected.														