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质量组织结构 QC organization chart

- JPMEC quality system is based on ASME , GB and ISO9001.

All QC work will follow the QC organization QC organization chart



质量控制计划 ITP

No.	Inspection Item 检验项目	Inspection & Test Activities 检验内容及要求	Reference Document 参考文件	Acceptance Criteria 验收标准	INSPECTION POINTS			Inspection Record 检验记录	Remarks (Report)
					JPMEC Inspector	JZ Inspector	KJVG Inspector		
1	Material Receipt & Identification 原材料接受检验	1. Packing List Verification 材料清单核对	Packing List	Packing List	H	R	SW	-	NA
		2. Checking of Heat No., Type, Size, Material Grade, Thickness, Diameter & Length 审核材料炉批号,型号,壁厚,直径,长度等	MII Certificates	ASME Section II				Signed MII Certificates	Y
		3. Transferring of original marking 原始标记转移	Marking and Tagging Procedure -G1-VE-M-6200-003MB7011006	-				Piping Material Identification Record	N
		4. 5% PMI Verification 5%的PMI的审核	MII Certificates	PMI marking on pipes				QC Piping Material Summary Sheet	Y
2	Fit-Up Inspection (contain branch pipe, main pipe and oxidation shield support fit-up, pipe bending and other component fabrication) 核对检验	1. Cutting 下料 2. Drilling and its Dimension 钻孔和方位尺寸 3. Misalignment 错边 4. Pipe Bending 弯管 5. Groove Angle 坡口角度 6. Root Face 钝边 7. Root Opening 根部间隙 8. Tack Weld 点焊 9. Purgig / O2 Level 气体纯度 10. Joint No. 焊缝号 11. Internal Cleanliness 焊缝内部清洁 12. End caps on all pipes 所有管子的封口 13. Any attachments, where applicable 所有附件	1. ASME B31.3 2. WPS and PQR-G1-VE-M-6200-P01MB7011015 3. Bend Procedure	Specification for Fabrication of Piping G1-TB-X-0000-SPC0110	H	W	SW	QC Piping Material Summary Sheet	Y
3	Welding Process Inspection (contain all welding) 焊接检查	1. Joint Cleanliness 焊接节点处清洁 2. WPS WPS 3. Welding Consumable 焊材 4. Weld No. 焊缝号 5. Interpass Temperature 层间温度	1. ASME B31.3 2. WPS and PQR-G1-VE-M-6200-P01MB7011015 3. Welding Material Control Procedure A/JPMEC-QCP-05	Specification for General Welding Requirements G1-TB-Z-0000-SPC0006	H	W	SW	QC Piping Material Summary Sheet	Y
		Check Weld Qualification and Weld examination Report 审核焊工资格及焊接检验报告			H	R	R		
4	Visual/Dimensional Inspection 目视/尺寸检验	1. Weld Profile 焊接外观 2. Weld Defect 焊接缺陷 3. Arc Strike 起弧点检查 4. Post Weld Cleanliness 焊后清洁 5. Spool No./Joint No. 管段号/焊缝号 6. Spool Dimensions 管段的尺寸	1. ASME B31.3 2. Spool Drawing 3. PFI-ES-3	Specification for Fabrication of Piping G1-TB-X-0000-SPC0110	H	R	W	1. Spool Drawing Sheet 2. QC Piping Material Summary Sheet	Y
4	NDE	1. RT 主管对接缝,支管与主管的对接缝 2. PT 所有焊缝做PT 检测	1. RT Procedure - G1-VE-M-6200-P03-MB701-1017 2. Liquid Penetrant Examination Procedure G1-VE-M-6200-P03-MB701-1006	Specification for Piping General Welding Inspection Requirements G1-TB-X-0000-SPC0107	H	W	SW	NDE Report	Y
		Check NDE Report 无所检测报告审核			H	R	R		
5	Weld Repair 焊接修补	1. Grinding 2. NDE	weld repair procedure-JP-1212-WRP-01	Specification for Piping General Welding Inspection Requirements G1-TB-X-0000-SPC0107	H	W	W	NDE Report	Y

预检验会议

Pre-inspection Meeting

- During the PIM. JPMEC, Contractor and Client will go through all requirements
- Resolve all pending problem at MOM



材料进场验收

Material receiving check

- JPMEC will check all receiving material according to “GENERAL MATERIAL CONTROL PROCEDURE” and “Receiving Inspection Procedure”
- JPMEC check the mill certificate, Size, dimension, vision checking, PMI and Mechanical properties as requirement.
- All checking result will be recorded in a form



焊接控制

Welding control

All operation and fit-up should follow the “Stainless steel Manufacture Operation and Handling Procedure”.

All welders are qualified by requirements

All machines are calibration and go well

All welding consumables are following WPS and good storage condition according to our procedure.



焊接控制 Welding control

All welding distortion should be concerned and prepare enough special tools

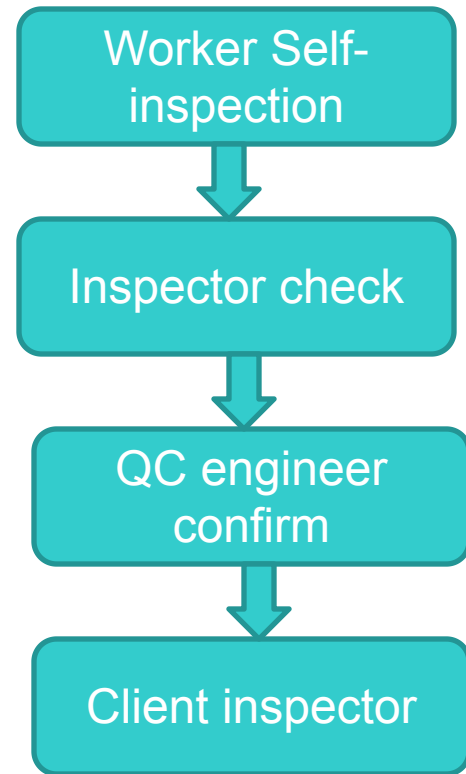
All welding operation should be follow the WPS and record should be done properly



尺寸检验

Dimension Control

- 所有的检验均按以下**3**个步骤执行
All inspection will be checked by 3 steps.
- **1**, 首先工人自检
1st Checked by worker. Then fill in the self check form
- **2**, 然后检验员检验确认并输入档案
2nd Checked by inspector, and approve the worker's self check form. Then input to company documentation
- **3**, 最后由质保工程师和客户检验员确认
3rd Re-confirmed by QC engineer and Client inspector



无损检测

NDT Control

- All procedure will be submitted to client and get approval.
- RT / UT / MT / PT / FT
- All NDE stuff are qualified by GB and ASME or requirements



水压试验 Hydrau-test

- All test should follow the procedure strictly
- All test instrument **are calibration and go well**
- **Cl- content should be control in 25pp for SS material.**
- **All water should be clean after test.**



预组装 Pre-Assembly

- In order to decrease the work in job site. All spool and structure steel should be pre-assembly at factory



表面处理 Surface treatment

- **Cleaning & Passivation Procedure for the Stainless Steel**
 - **Surface Preparation and Painting Procedure**
- 85%humidity , over 5 degree, and Dew point control**



包装发货 Packing Preparation

- Packing procedure
- Weight Management
- Quarantine Procedure
- All cargo will be checking and releasing after packing.

