



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

Code 1	Indicates place where testing is planned to be performed i.e. inspection location	Code 2	Indicates who has to perform the tests i.e. Testing Agency
A	At Equipment Manufacturer's works (Core Wire Manufacturer)	J	The Equipment Manufacturer (Core Wire Manufacturer)
B	At Component Manufacturer's works (Wire Rod/Zn. Ingot Manufacturer)	K	The Component Manufacturer (Wire Rod/Zn. Ingot Manufacturer)
C	At Authorized Distributor's place	L	The Third Party
D	At Independent Lab	M	The Turnkey Contractor (conductor manufacturer's works)
E	At Turn Key Contractor's location (conductor manufacturer's works)		
F	Not specified		
Code 3	Indicates who shall witness the tests i.e. Witnessing Agency	Code 4	Review of Test Report / Certificates
P	Component Manufacturer itself (Wire Rod/Zn. Ingot Manufacturer)	W	By Equipment manufacturer (Core Wire Manufacturer)
Q	Component Manufacturer and Equipment Manufacturer	X	By Contractor during product / process inspection (by conductor manufacturer)
R	Component Manufacturer, Equipment Manufacturer and Contractor	Y	By BSPTCL during product / process inspection
S	Equipment Manufacturer itself (Core Wire Manufacturer)	Z	By Contractor and/or BSPTCL during product/process inspection
T	At Turnkey Contractor (conductor manufacturer's works)		
U	Equipment Manufacturer, Contractor and BSPTCL		
V	Third Party itself		
Code 5	Whether specific approval of sub-vendor / Component make is envisaged?	Code 6	Whether test records required to be submitted after final inspection for issuance of Dispatch Clearances /Instructions ?
E	Envisaged	Y	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

N	Not Envisaged	N	Yes No
---	---------------	---	-----------

GENERAL NOTES

NOTES :

1. Proper co-relation of material with test certificate from Raw Material stage to finishing HTGS core Wire for all the coil shall be maintained.

STEEL WIRE RODS.

2. The equipment manufacturer(Core Wire manufacturer)shall obtain the following test certificate from component manufacturer for steel wire rod/zinc ingots for review by Manufacturer of conductor/BSPTCL
 - i) Chemical composition of steel wire rods
 - ii) Purity of Zinc
 - iii) All the test result of the test carried out by component manufacturer on the finished steel wire rod.
3. The following test facilities /calibration certificate shall be available at equipment manufacturer's premises
 - i) The calibration of various testing and measuring instruments.
 - ii) Facilities for Torsion Testing
 - iii) Testing facilities for all galvanizing tests.
 - iv) Testing facility for Microstructure
 - v) Tensile Testing Machine

ROUTINE AND ACCEPTANCE TESTS

20 % galvanized Steel wire and required to be tested by Equipment manufacturer (Core Wire Manufacturer) and for 10 % acceptance by ACSR Conductor manufacturer at there works or at the works of the Equipment manufacturer (Core Wire Manufacturer).



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

- All the process parameter like acid strength, Flux concentration, Zinc bath temperature etc, used for manufacturing Galvanised Steel Wire shall be maintained as defined.
- The steel wire rod / zinc shall be procured only for primary producers or any other BSPTCL approved sources.
- Equipment manufacturer ensures that accredited Lab/Agency will calibrate the UTM machine on yearly basis
- The quality plan should be read in conjunction with the applicable Technical Specification against which the HTGS Core Wire is being manufactured
- In case of any contradiction between Technical Specification, Approved drawing and MQP, detail mention in Technical Specification/Approved Drawing shall be final.

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
A. Section : RAW MATERIAL													
1.0.0	RAW MATERIAL SELECTION (High carbon Steel Wire Rod)										E		
1.1.1	Steel Wire rod chemical composition	Wet Analysis	1 No. sample per hear/per lot	IS 7904	%C 0.50 – 0.85 %Mn 0.50 – 1.10 %Si 0.10 – 0.35 %S 0.045 (Max) %P 0.035 (Max)	Wire Rod Supplier's TC	A / B	J / K	S / P	W / X	-	N	
1.1.2	Diameter of Steel wire rod and Ovality	Dimension	5 No. sample per hear/per lot	IS 7904	Min. 5.50 ± 0.30 mm Ovality ± 0.45 mm Max	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
1.1.3	Ultimate Tensile Test	Mechanical	5 No. sample per hear/per lot	IS 7904	Min. 95 kg/mm ²	Wire Rod Supplier's TC	A / B	J / K	S / P	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

1.1.4	Percentage reduction of area	Mechanical	5 No. sample per hear/per lot	IS 7904	Min – 30 %	Wire Rod Supplier's TC	A / B	J / K	S / P	W / X	-	N	
-------	------------------------------	------------	-------------------------------	---------	------------	------------------------	---------------------------	---------------------------	---------------------------	---------------------------	---	----------	--

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
1.1.5	Elongation	Mechanical	5 No. sample per hear/per lot	IS 7904	Min 8%	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
1.1.6	Cleanliness and surface smoothness (Visual Check)	Visual	100 % on each coil	IS 7904	The wire rod shall be round and free from harmful defect like fins, splits, surface flaws, jagged surface and imperfect edges and other harmful defect.	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
1.1.7 1.1.7.1	Microstructure Structure	Metallurgical	1 No. sample per Heat/Lot	IS 7904	The structure shall be fine parlite	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

1.1.7.2	Grain Size	Metallurgical	1 No. sample per Heat/Lot	IS 4748 & as per ASTM-112	Min 6 with 100 X Magnification	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
---------	------------	---------------	---------------------------	---------------------------	--------------------------------	----------------	---------------------------	---------------------------	---------------------------	---------------------------	---	----------	--

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
1.1.7.3	Inclusion Rating	Metallurgical	1 No. sample per Heat/Lot	IS 7904 & ASTM E-45	Max – 2 Thick Series	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
1.1.7.4	Surface Defects	Metallurgical	1 No. sample per Heat/Lot	IS 7904	1.0 % of dia Max	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
1.1.7.5	Decarburization	Metallurgical	1 No. sample per Heat/Lot	IS 7904	1.0 % of dia Max	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

2.1.0	Pickling in Hydrochloric Acid solution to be followed by rinsing in cold water	Chemical	1 Sample from Pickling bath Daily	Plant Standard	HCL Cons. 4 – 20% Iron Content – 12 % Max	BSPTCL REPORTS	A	J	S	W / X	-	N	
2.1.1	Surface Coating Phosphate & Borax	Chemical	1 Sample from Pickling bath Daily	Plant Standard	Phosphate Cons. 20 – 22 Be° & Borax conc. Minimum 30 Point temp Min 70°C	BSPTCL REPORTS	A	J	S	W / X	-	N	

Sl. No.	Components/ Operations &	Type of Check	Quantum of Check/	Reference Document	Acceptance Norms	Format of Record	Applicable Codes	Remarks
---------	--------------------------	---------------	-------------------	--------------------	------------------	------------------	------------------	---------



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

	Description of Test		Sampling with Basis	for Testing		1	2	3	4	5	6	
Section : RAW MATERIAL												
2.0.0	WIRE DRAWING Drawn on steel wire rod in to 3.45 mm Wire											
2.0.0	Diameter	Dimension	1 Sample per 5 coil	IS 398 (Part – 5 & Part - 2) Latest	As per Table 1	BSPTCL REPORTS	A	J	S	W / X	-	N
2.2.1	Breaking load	Mechanical	1 Sample per 5 coil	IS 398 (Part – 5 & Part - 2) Latest	As per Table 1	BSPTCL REPORTS	A	J	S	W / X	-	N
2.2.2	Torsion	Mechanical	1 Sample per 5 coil	IS 398 (Part – 5 & Part - 2) Latest	As per Table 1	BSPTCL REPORTS	A	J	S	W / X	-	N
2.2.3	Surface Finish	Visual	100 % on each coil	IS 398 (Part – 5 & Part - 2) Latest	The wire shall be smooth and free from all imperfection such as spills, splits scale inclusion, die mark, scratched fittings blowholes etc.	BSPTCL REPORTS	A	J	S	W / X	-	N



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

TABLE – I

Drawn Steel Wire					
Size (mm)	Normal Dia in mm	Dia in mm		Min B/L in kN	Specification
		Min	Max		
2.54	2.46	2.44	2.48	7.22	IS 398
3.18	3.10	3.07	3.14	10.88	IS 398
3.53	3.45	3.42	3.48	13.50	IS 398
2.21	2.16	2.14	2.18	4.49	IS 398
3.00	2.94	2.92	2.96	9.29	IS 398



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
Section : INPROCESS INSPECTION													
2.2.4	Wrapping Test	Mechanical	1 Sample per 5 coil	IS 398 (Part – 5 & Part - 2) Latest	Wrap – 8 Un Wrap – 6 Wrap – 6 Mandrel having dia equal to 4 times the dia of the wire shall not crack or break	BSPTCL REPORTS	A	J	S	W / X	-	N	
2.2.5	Joints	Visual	100 % on each coils	IS 398 (Part – 5 & Part - 2) Latest	No joints allowed	BSPTCL REPORTS	A	J	S	W / X	-	N	
2.2.6	Microstructure Structure	Metallurgical	1 No. sample per Heat/Lot	IS 7904	The structure shall be fine parlite	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
2.2.7	Grain Size	Metallurgical	1 No. sample per Heat/Lot	IS 4748 & as per ASTM-112	Min 6 with 100 X Magnification	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
2.2.8	Inclusion Rating	Metallurgical	1 No. sample per Heat/Lot	IS 7904 & ASTM E-45	Max – 2 Thick Series	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

2.2.9	Surface Defects	Metallurgical	1 No. sample per Heat/Lot	IS 7904	1.0 % of dia Max	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
2.3.0	Decarburization	Metallurgical	1 No. sample per Heat/Lot	IS 7904	1.0 % of dia Max	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
Section : INPROCESS INSPECTION													
2.3.1	Micro Etching	Metallurgical	1 No. sample per Heat/Lot	IS 7904	No Defects	BSPTCL REPORTS	A / B	J / K	S / P	W / X	-	N	
3.0.0 GALVANIZING													
3.1.1	Degreasing Caustic Soda	Chemical & Measurement	1 sample from bath daily	Plant Standard	Conc. Min – 5% Temp. 50 – 70°C	BSPTCL REPORTS	A	J	S	W / X	-	N	
3.1.2	Acid Cleaning	Chemical & Measurement	1 sample from bath daily	Plant Standard	Conc. Min 8% Iron Max. 16%	BSPTCL REPORTS	A	J	S	W / X	-	N	
3.1.3	Flux Coating mixture of NH ₄ Cl; ZnCl ₂	Chemical & Measurement	1 sample from bath daily	Plant Standard	Sp. Gravity 5 – 8 Be° Temp. 40 – 60°C	BSPTCL REPORTS	A	J	S	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

3.1.4	Molten Zinc Bath	Measureme nt	After every 2 hours	IS 2629	Temp. 450±10°C	BSPTCL REPORTS	A	J	S	W / X	-	N	
3.1.5	Chemical analysis of Molten Zinc Bath	Spectro Analysis	1 sample every month	Purity of Zinc	Minimum 98.5%	BSPTCL REPORTS	D	L	V	W / X	-	N	

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
Section : INPROCESS INSPECTION													
4.0	Finished Galvanized Steel Wire												
4.1	Diameter	Dimension	1 Sample per 5 Coils	IS 398 (Part – 5 & Part - 2) Latest	As per Table - II	BSPTCL REPORTS	A	J	S	W / X	-	N	
4.2	Breaking Load	Mechanical	1 Sample per 5 Coils	IS 398 (Part – 5 & Part - 2) Latest	As per Table - II	BSPTCL REPORTS	A	J	S	W / X	-	N	
4.3	Torsion	Mechanical	1 Sample per 5 Coils	IS 398 (Part – 5 & Part - 2) Latest	20 Nos. Minimum on 100 X dia length	BSPTCL REPORTS	A	J	S	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

4.4	Elongation	Mechanical	1 Sample per 5 Coils	IS 398 (Part – 5 & Part - 2) Latest	4.5 % Min. on guage length of 200 mm	BSPTCL REPORTS	A	J	S	W / X	-	N	
4.5	Wrapping Test	Mechanical	1 Sample per 5 Coils	IS 398 (Part – 5 & Part - 2) Latest	Wrap – 8 Un Wrap – 6 Wrap – 6 Mandrel having dia equal to 4 times the dia of the wire shall not crack or break	BSPTCL REPORTS	A	J	S	W / X	-	N	

TABLE – II

Finish Galvanised Steel Wire

Size (mm)	Normal Dia in mm	Dia in mm		Min B/L in kN	Min Mass of Zinc Coat in Gm/m ² & no of	Specification
		Min	Max			



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

4.6	Adhesion Test	Mechanical & Chemical	1 Sample per 5 Coils	IS 4826	The Zinc coating shall remain adherent to the steel wire when wound 10 turns on a mandrel having dia equal to 4 times the dia of the wire.	BSPTCL REPORTS	A	J	S	W / X	-	N	
4.7	Weight of Zinc Coating	Chemical	1 Sample per 5 Coils	IS 4826 & IS 6745	As per Table - II	BSPTCL REPORTS	A	J	S	W / X	-	N	
4.8	Preece Test	Chemical	1 Sample per 5 Coils	IS 4826 & IS 2633	As per Table - II	BSPTCL REPORTS	A	J	S	W / X	-	N	
4.9	Joints	Visual	100 % on each coil	IS 398 (Part - 5 & Part - 2) Latest	No joints and weld allowed	BSPTCL REPORTS	A	J	S	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
Section : INPROCESS INSPECTION													
Finished Galvanized Steel Wire													
4.10	Surface Finish	Visual	100 % on Each Coil	IS 398 (Part - 5 & Part - 2) Latest	Galvanized wire shall free from defects such as bare patches, Ash, Flux, Dross inclusion/Carry over etc.	BSPTCL REPORTS	A	J	S	W / X	-	N	
C. Section : FINAL INSPECTION													
5.0 Acceptance Test on Individual Galvanized Steel Wire													
5.1	Diameter	Dimension	1 Sample per 5 Coils	IS 398 (Part - 5 & Part - 2) Latest	As per Table - II	BSPTCL REPORTS	E	M	T	Z	-	N	
5.2	Breaking Load	Mechanical	1 Sample per 5 Coils	IS 398 (Part - 5 & Part - 2) Latest	As per Table - II	BSPTCL REPORTS	E	M	T	Z	-	N	
5.3	Torsion	Mechanical	1 Sample per 5 Coils	IS 398 (Part - 5 & Part - 2) Latest	20 Nos. Minimum on 100 X dia length	BSPTCL REPORTS	E	M	T	Z	-	N	
5.4	Elongation	Mechanical	1 Sample per 5 Coils	IS 398 (Part - 5 & Part - 2) Latest	4.5 % Min. on gauge length of 200 mm	BSPTCL REPORTS	E	M	T	Z	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

5.5	Wrapping Test	Mechanical	1 Sample per 5 Coils	IS 398 (Part - 5 & Part - 2) Latest	Wrap – 8 Un Wrap – 6 Wrap – 6 Mandrel having dia equal to 4 times the dia of the wire shall not crack or break	BSPTCL REPORTS	E	M	T	Z	-	N	
-----	---------------	------------	----------------------	-------------------------------------	---	----------------	----------	----------	----------	----------	---	----------	--

Sl. No.	Components/ Operations & Description of Test	Type of Check	Quantum of Check/ Sampling with Basis	Reference Document for Testing	Acceptance Norms	Format of Record	Applicable Codes						Remarks
							1	2	3	4	5	6	
C. Section : FINAL INSPECTION													
5.6	Adhesion Test	Mechanical & Chemical	1 Sample per 5 Coils	IS 4826	The Zinc coating shall remain adherent to the steel wire when wound 10 turns on a mandrel having dia equal to 4 times the dia of the wire.	BSPTCL REPORTS	E	M	T	Z	-	N	
5.7	Weight of Zinc Coating	Chemical	1 Sample per 5 Coils	IS 4826 & IS 6745	As per Table - II	BSPTCL REPORTS	E	M	T	Z	-	N	
5.8	Preece Test	Chemical	1 Sample per 5 Coils	IS 4826 & IS 2633	As per Table - II	BSPTCL REPORTS	E	M	T	Z	-	N	
D Section : IDENTIFICATION, PACKING, DESPATCH													
6.0	Check for identification and checking												
6.1	Proper Packing	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

6.2	Manufacturers name	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	
6.3	Diameter	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	
6.4	Products	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	
6.5	Date of Manufacturing	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	
6.6	Batch No./Lot No.	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	
6.7	Coil No.	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	
6.8	Weight of each coil	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	
6.9	Length	Visual	100 % on Coils	----	----	BSPTCL REPORTS	A	J	S	W / X	-	N	

List of Component Manufacturer



BIHAR STATE POWER TRANSMISSION COMPANY LIMITED

Manufacturing Quality Plan -- ACSR CORE WIRE

Manufacturer Name and Address	Customer	Venders Code	ITEM	MQP No. 041	Valid From	15.01.2016
	BSPTCL		ACSR CORE WIRE	Rev 00	Valid Upto	Till Revision

1. High carbon Steel Wire rods

TATA Steel, SAIL RINL Bhushan Steel & Power Ltd
Jindal Steel and Power limited

2. Electrolytic Zinc

Hindusthan Zinc Limited
Binani Zinc Ltd.