DANIELI CORUS	DC STANDARD No.: DC-PRO-001	Status: FINAL	
		Owner: A. HASELMAYER	
		Rev. 01	Pages: 26

PROCUREMENT

QUALITY ASSURANCE & -CONTROL STANDARD FOR THE MANUFACTURE OF MECHANICAL SUPPLIES

Notes:

1. Only the Owner and/or the Approver are allowed to modify this document.
2. Comments and modification requests shall be forwarded to the Owner and/or the Approver.
3. Only signed pdf-format copies shall be used for project documentation.

REV.	DATE	DESCRIPTION OF MODIFICATION	CREATED	CHECKED	APPROVED
05					
04					
03					
02					
01	July-2018	Global revision	A. Haselmayer	J. Grippeling	E. Molenaar
00	May-2007	First issue	A. Haselmayer	E. v/d Veldt	M. v/d Berg

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1. PURPOSE

The purpose of this standard is to assure that the documentation- and organizational requirements for Supplier's Quality Control (QC) and Danieli Corus' (DC's) inspections of fabricated Goods are clear and upheld.

This Standard supersedes document Z0000-D0-C002-F203 Rev.0 and is to read in conjunction with Chapter 7 of DC's latest issued 'General Purchase Conditions' (GPC) and the awarded Purchase Order (PO).

2. ABBREVIATIONS

See list in annex VIII.

3. APPLICATION

This Standard is applicable to the Supplier(s) for all manufactured Goods as referred in the PO.

4. DEFINITIONS

In addition to Section 2 of DC's 'General Purchase Conditions' and the terminology of ISO 8402 the listed terms are defined as follows:

- *"Quality Assurance" (QA)* means all planned and systematic activities implemented within a level of Supplier's Quality System, and demonstrated as needed, to provide an adequate confidence for DC.

- *"Quality Control" (QC)* means all operational techniques and activities that the Supplier will conduct to achieve full compliance with requirements as stipulated in the PO.

- *"Quality Plan" (QP)* means a document describing the specific practice, resources and sequence of QA/QC activities relevant to a particular product, project or contract. This plan refers to the Supplier's QA Manual and DC's PO, while also identifying the specific procedures which are utilized to keep the quality of fabricated Goods in check.

- *Inspection Levels*

    - *A - Joint inspection with Client Representative and/or Notified Body*

    - *B - Performance by DC Engineer and/or -Inspector*

    - *C - Performance by 2nd Party (external) Inspector*

    - *D - Performance by 2nd Party Inspector & DC Engineer and/or -Inspector*

    - *E - Performance by Supplier's QC personnel. Supplier to provide instantly after internal QC the effected quality records for review to DC. DC Inspection Coordinator (IC) to issue the 'Final Inspection Acceptance Note' (f_IAN) upon DC Engineer's satisfaction.*

- *F – External specialist and/or laboratory*

- *"Inspection & Test Plan" (ITP)* means a document describing specific QC activities, which is tailor made in compliance with the requirements of the Purchase Order.

- *"Inspector"* means the assigned person who conducts inspections on behalf of DC.

- *"Point of Intervention" (POI)* means a particular milestone where the stipulated criteria of the Goods will be examined. Such points are:

  - *"Hold Point" (H):* Supplier to invite DC for inspection as described herein. Work must not proceed before DC's waiver issuance or Inspector's witness.

  - *"Witness Point" (W):* Supplier to invite DC as described herein. Work may continue even if DC has not submit a waiver nor witnessed the notified QC activity. Supplier to immediately submit all effected quality records for review after accomplished QC activities.

  - *"Review" (R)*: Supplier to provide the DC engineer with documents, per VDC table, to prove the compliance with the PO.

  - *"Surveillance" (S):* Supplier to invite DC for monitoring a particular work process.

  - *"Verification" (V):* Supplier to provide the Inspector at the start of inspection with related quality records to prove that Goods are in compliance with the PO.
    Inspector to spot check achieved and reported quality criteria.

- *"Inspection"* means DC's scheduled activity in order to examine achieved quality criteria and traceable quality records thereof. The following types may apply:

  - *"First Part Inspection" (FPI):* Prototype inspection prior to commencing serial production.

  - *"In-process Inspection" (II):* Stage inspection during production (e.g. fit-up of tack welded parts).

  - *"Pre-Shipment Inspection" (PSI):* Comprehensive inspection of all, fully accessible, Goods together with the review / endorsement of the compiled final Manufacturing Data Book.

  - *"Packing Inspection" (PI):* Visual examination of packing measures at Supplier's or forwarder's works.

  - *"Re-Inspection" (RI):* Re-inspection of Supplier's confirmed and QC passed rectification of Goods previously not accepted.

  - *"Open Box Inspection" (OBI):* Visual inspection of packed Goods.

- *"Quality document"* means any DC- and/or approved Supplier document on which a quality criteria and Supplier's QC rests on or which is directly linked to an upcoming inspection from a previous point of view (reported pending actions).

- *"Quality record"* means a document providing objective and traceable evidence of the fulfilment of a requirement for quality and quantity.

- *"Vendor Document Control (VDC)"* means all documentation requirements which are laid out, in table format, in annex to the PO.

- *"Vendor Document List (VDL)"* means Supplier's DC approved table which identifies all documentation and related timely agreements in conjunction with the VDC table.

- *"Technical acceptance"* means DC accepts that the Supplier's examined Goods are in compliance with the PO.

5. REFERENCES

5.1 Danieli-Corus standards

AWM-PRO-H6020 Inspection and testing

5.2 International standards

ISO 8402 Quality Management and Quality Assurance - Vocabulary

6. RESPONSIBILITY

Supplier to

- only use approved vendor documents for execution showing the status "reviewed and accepted as final" (RAF) or "reviewed and accepted as noted" (RAN) if the therein mentioned remarks do not require technical clarification.
- consider documents indicating "reviewed, correct and resubmit" (RCR) as an "ON HOLD" status.
- obtain DC's clarification prior to commencing with related work, if comments submitted on the RAN document were unclear. Work which is not directly affected may continue at the Supplier's risk.
- assure that the Goods have full traceability (e.g. through traveller records) during all stages of their realization.
- assure that personnel is qualified for QC activities.

7. QUALITY ASSURANCE & CONTROL

7.1 QUALITY ASSURANCE

7.1.1 Pre-inspection meeting (PIM)

If required (to be determined by DC), a Pre-inspection meeting (PIM) is to be held at all locations of the goods realization. The PIM is based on both the Supplier's production schedule and the ITP(s). Both of these documents must have been through a minimum of a first review by DC before the PIM is organized.

During the PIM the following topics will be discussed:

- Previous QC performance and NCR log (if applicable)

- Planning
  - Supplier's production schedule identifying suborders, material requisitions and POI's.
  - Manner of progress monitoring and -reporting
  - Current workload until ex-work date

- Documentation
  - Applicable documents in valid editions and their understanding in detail
  - Review of requisitions (un-priced suborders)
  - Exceptions / deviations or alternative materials used
  - Engineering status (drawings)
  - Pending vendor documents acc. current vendor document list (VDL)
  - Vendor documents to withdraw (if applicable)
  - Material supplies (code, certification, traceability)
  - Content and compilation of manufacturing data book
  - Manner and handling of Nonconformance Report (NCR)
  - Manner and handling of Inspection Acceptance Note (IAN)

- Welding & Heat Treatment
  - Weld coordination
  - Weld plan /-map
  - DT-/ NDT executed by manufacturer or accredited agency
  - DT-/ NDT reporting (forms) and traceability
  - Pre- / Post Weld Heat Treatment Procedure/-Record
  - Production test coupons (sampling, traceability, tests to perform and acceptance criteria)

- Inspections & Testing
  - Inspection test plan and points of intervention
  - Manner of recording and layout of blank QC report forms
  - Manner of material traceability
  - Measurement-/ Test Devices (calibration, certificates)
  - Manner and handling of Notification of Inspections (NOI)
  - Supplier's scheduled expediting - / inspection visits for sub-supplies
  - Assessment of measurement-/ test devices, check templates (calibration, certificates) and test facilities
  - Manner of trial fit assemblies and the reporting thereof (if applicable)
  - Factory Acceptance Tests (FAT)
  - Joint inspection with Client representatives
  - Third-party- and/or laboratory involvement
  - Reporting / disposition of non-conformities and handling of NCR
  - Painting, lining, preservation
  - Packing-, marking-/ tagging measures

- Refractory application (if applicable)

- Shop tour

7.1.2 Quality plan (QP) – if applicable as per VDL

Content:

- Brief description of the established and maintained QA/QC System.
- Terms, definitions and abbreviations
- Responsibilities of management and executing staff
- QC personnel (organization chart)
- Applicable manufacturing procedures and specifications
- Document- and data control
- Contract review
- Design control
- Purchasing
- List of approved suppliers
- Control of client provided product
- Control of changes
- Product identification and traceability
- Third party assignments and laboratories

Also to include in chronological sequence of the Good's realisation:

1. Control of fabrication
2. Control of measuring- and test equipment
3. QC-/ Test status (e.g. labelling)
4. QC forms to use
5. Kind and control of quality records
6. Control of sampling
7. Control of nonconforming product
8. Corrective and preventive action
9. Handling, storage, preservation, packing and delivery
10. Internal quality audits
11. Appendices

7.1.3 Quality assurance plan (QAP) – if applicable as per VDL

Supplier to prepare, after consultation with DC, a detailed QAP after completion of the detail engineering.

The document's approval shall be restricted to one(1) round only. Supplier to use the full content of a QAP as a basis for the ITP. It is mandatory to submit all therein indicated documents and QC Records within the agreed time schedule.

7.1.4 Inspection & test plan (ITP) – if applicable as per VDL

DC uses the approved ITP as the main interactive document for inspection activities. Supplier to submit this document for DC's approval prior to commencing with the realization of the Goods.

The following guidelines refer to the DC standard ITP format (see annex I). To propose the use of an alternative standard format, the Supplier must submit a copy of the proposed layout at the tender stage for review and approval. DC will, however, reserve the right to procure the ITP in the format attached.

Supplier to ensure that their ITP draft contains the following:

- covers the whole scope of work starting with reviewing quality documents as per VDC requirements and finishing with the review / endorsement of QC records compiled in the manufacturing data book (MDB).
- is structured using the DC form shown in annex or in a similar Supplier owned format
- refers to the break-up of the assembly or sub-assemblies & part, components or groups of equipment having the same specification.
- is in chronological order of realisation by referring to the following information in tabular style per line item:
  a. Sequence number
  b. QC activity
  c. Stage & frequency
  d. Test device
  e. Test extent
  f. Reference documents
  g. Acceptance criteria
  h. Quality records
  i. Points of intervention (POI)

Supplier to indicate POI's for own QC activities and any lower, sub-contracted tier(s). Ensure that DC's R-, H-, W-, S-Points are identified as milestones in the production schedule.

7.1.5 Concession request (CR) - Control of changes

Supplier to ensure that all products or components fully comply with the PO and that any nonconforming items are not incorporated in the final Good.

Supplier to use the form in annex IV to obtain either DC's approval for technical changes (alternatives, more suitable quality criteria) or the acceptance of a rejected nonconformity or to proceed with an authorized repair of a non-conforming Good.

7.2 QUALITY CONTROL

7.2.1 Product identification & traceability

7.2.1.1 General requirements

Specified material is material that is subject to inspection certificate 3.1/3.2 according to EN 10204. Supplier to ensure full traceability of this material even if the original identification markings are unavoidably cut out or the material is separated in parts.

Supplier to assure the identification by using one of the following methods:

- transfer the original material identification to a location where the marking will be visible on the completed Good.
- apply an indelible code marking (described in Supplier's Quality Manual) which can be traced back to the original marking.

7.2.1.2 Certificate of remarking

Any transfer of original material data in relation to the Inspection Certificate 3.1/3.2 according to EN 10204 shall be based on Supplier's written procedure and Certificate of Remarking. The latter document must have been issued by an officially accredited Notified Body (NOBO).

7.2.1.3 Material traceability record

Supplier to make an as-built sketch (or use the related drawing) with clearl indication of the marking locations and a tabulation of material qualities. The material quantities must refer to the related test certificates of the marked parts.

7.2.1.4 Method of marking

- All marks must be legible, permanent and readable in the direction of rolling.
- A mark shall comprise of the original heat number (as per certificate) and the personal sign (logo, sequence number) of the authorized designee.
- The transfer of the original heat number is to be made prior to cutting, framed with an indelible white paint marker and be identified/referred to through a sketch in annex to the material traceability list.
- All stamping to be done on material thicker than 6 mm with commercially available “low stress” dies.
- Positive identification beyond delivery to be done through an indelible white paint marker where the Good’s service conditions prohibit die-stamping or on material other than steel.

7.2.2 Material surface contamination

Supplier to:

- prevent the adverse contamination of Goods made of stainless steel.
- maintain the storage and fabrication of stainless steel throughout the whole work process in a segregated indoor area, preferably a sturdy and enclosed building.
- label the tools for manipulation and fabrication to avoid inadvertent use with materials other than stainless steel.

7.2.3 Inspections and tests

7.2.3.1 General

In addition to DC’s General Purchase Conditions paragraph 7 Supplier is not allowed to offer Goods for inspection in painted condition unless otherwise agreed in writing by DC.

Supplier to either assist the Inspector or demonstrate the applied measures for the notified QC event.

7.2.3.2 Safety measures

Supplier to introduce the Inspector, prior to entering the workshop, to the applicable safety regulations. Inspector will comply with the Supplier’s safety regulations at all times. Supplier to hand out appropriate and valid personal safety equipment (PPE) if necessary.

The Inspector will terminate work if feeling that safety conditions are jeopardized or tasks are affected adversely (e.g. through crane activities across the inspection zone or the pick-up of sand/dust through gusts in outdoor areas).

7.2.4 Calibration of measuring devices

Measuring devices used for QC and inspection must be supported by valid calibration certificates and be traceable through applied labels or stickers on the device.

Profile gauges and other specifically fabricated check templates must be based on the QC acknowledged dimensional protocols and be reviewed and acknowledged by the Inspector. Subsequently the physical devices must be marked with the Inspector's personal die-stamp as being released for usage.

7.2.5 Test certificates & sampling

Supplier must have specimens and test samples of materials which do not have traceable certified material test reports (CMTRs or inspection certificates according to EN10204 3.1/3.2). These samples need to be tested in their own laboratory at the Supplier's cost and effected reports be submitted to DC for review. The number of test samples (per heat/cast lot or batch of materials) to be taken and tested should follow the required code or equivalent international standards.

If the supplier does not have their own testing facilities, the samples and test pieces (selected by the DC inspector along with the supplier's representative) shall be sent to an accredited laboratory for the necessary testing at cost of the supplier.

Samples have to be clearly identified by numeric punch (die-stamp) or indelible marker along with a label referring to a heat number or an item description. Supplier to confirm the submission by transmittal and to save a twin sample for comparison. Supplier to provide the tracking number once the items to be sent have been picked up by the courier company.

7.2.6 Quality control data report in BettyBlocks (if applicable)

Supplier to submit revealed QC data for DC's review/approval prior to an inspection.

7.2.7 Inspection call (Notification of Inspection - NOI)

Supplier to submit a completed inspection notification (DC standard NOI form) when the equipment/ assembly/ sub-assembly is ready for inspection. Finished goods are ready for inspection when the stipulated S-, H-, and W-points, according to the approved ITP, have been accepted and signed off by Supplier's QC department.

The amount of days required for advanced notice is as stated in the DC Terms & conditions paragraph 7 or per previously agreed upon amount of time. The NOI's must be accompanied by the Supplier's related QC records for review by the inspector prior to arrival at the inspection location.

Suppliers must have carried out their own strict quality control on all goods that are being offered for inspection. The Suppliers' own findings and documentation must be elaborated on in the (red asterisk) areas of the NOI (see annex II).

An inspection call is considered invalid by DC if:

- **the form is not filled in correctly, or required fields are left blank.**
- **no requested QC records have been provided.**
- **QC data have not been duly reported through BettyBlocks. (only applicable for cooling members)**

7.2.8 Inspection waiver certificate (IWC)

Should an inspection not be conducted, then DC's IWC permits the Supplier to continue work pending DC's approval of the QC results. These QC records must be provided by Supplier for DC's review in order to attain this waiver.

DC reserves the right to waive POI's without any prejudice to DC's right to inspect or test the Goods at destination (e.g. site) or any other location.

7.2.9 Nonconformance report (NCR)

7.2.9.1 General

Any non-conformity revealed during Supplier's QC and being subject of repair must be reported in a NCR.

DC understands the following dispositions:
- Accept as built
- Subject of re-shoot (for RT examination only)
- Subject of repair
- Rejected (hence re-fabrication)

For treatment and document handling see annex III & V.

7.2.9.2 Specific

Supplier to mark any nonconforming Goods by means of labels, die-stamp or indelible marker and to submit to DC a fully traceable NCR containing at least;
- A comprehensive description of the nonconformity with respect to the stipulated criteria (according to the Good's applicable documents), nature, exact location, as well as the reason and probable cause.
  Support this description using pictures or a sketch for clarity.
- A Disposition Plan (accepted as built / use-as-is, repair / rework, rejected / scrap) or Concession Request (if applicable) including the signature and name of person who recommended the disposition / concession (see annex IV).
- The proposed corrective actions (or recommended remedy) with self-explanatory description of intended method or procedure for repair within an estimated time frame.
- The follow-up verification of remedy or Close-out
- The signature and name of person who;
  - prepared and authorized the NCR
  - accepted the mutually agreed method of repair (DC / Client)
  - verified the follow-up of the remedy or Close-out
  - witnessed the re-examination and confirmed the document's close-out (DC / Client)

A Good's repair must only be executed if DC accepts in writing the recommended remedy or method for repair through a granted concession request (CR).

Supplier to establish and maintain procedures to ensure that non-conforming Goods are prevented from inadvertent use or installation.
- Rejected Goods to be segregated from production.
- Rejected Goods may be scrapped exclusively upon DC's written consent.

7.2.10 Inspection acceptance note (IAN)

Only Goods without nonconformities will be declared as technically acceptable by means of a Final Inspection Acceptance Note (f_IAN).

Goods with minor nonconformities will be declared as provisionally technically acceptable by means of a Preliminary Inspection Acceptance Note (p_IAN).

Both documents do not imply the release of shipment!

For treatment and documentation handling see annex III & VI.

7.2.11 Manufacturing data book (MDB)

Supplier's MDB (quality dossier) to contain at least QC documents and -records as indicated in the PO related VDC table or approved VDL.

Supplier to ensure that the MDB
- is up-to-date at the start of each inspection.
- is provided with a specific and DC approved table of contents as shown in annex VII.
- contains separator sheets to easy the finding of documents
- contains only full readable and by QC acknowledged copies
- includes quality documents showing DC's approval stamp with status 'final' (RAF).
- exclusively contains QC records fully traceable to the PO and endorsed by Supplier's QC department.
- is reviewed and the QC records are endorsed by the inspector at the start of each inspection.

In case of electronically submission all file names must be in compliance with the MDB's table of content. Files may not be larger than 10MB.

DC reserves the right to hold the technical acceptance of Goods, hence payment, until the MDB has been reviewed and accepted by DC.

8. RELEASE FOR SHIPMENT

The release for shipment is based on a f_IAN or in specific granted cases on a p_IAN and will be given exclusively in writing by DC's project expeditor.

Compliance with DC's Terms & conditions paragraph 6.d is mandatory.

DANIELI CORUS

ANNEX I INSPECTION & TEST PLAN

Project: [insert text] **Client:** [insert text] **Doc.no. / Rev.:** [insert text] **Issue date:** [insert text]	**INSPECTION TEST PLAN** ***FABRICATION - MECHANICAL***		DANIELI CORUS		**[Insert Supplier Logo]**
Area: **[insert text]** **Equipment:** **[insert text]** **Quantity:** **[insert text]**	**Manufact. Spec. (MS):** [insert Doc. No.] **Tolerance Spec. (TS):** [insert Doc. No.] **Welding Spec. (GWS):** [insert Doc. No.]		**Purchaser:** DANIELI CORUS **Ref. no.:** [insert PO No.] **Supplier:** [insert text] **Ref. no.:** [insert text]		**Dwg:** [insert Doc. No.]
Part: **[insert text]**	**QA/QC Spec. (QS):** [insert Doc. No.] **Material Spec. (MatS):** [insert Doc. No.] **Bill of Material (BOM):** [insert Doc. No.] **Identification List (IL):** [insert Doc. No.]		**Inspection Rec. (IR):** [insert Doc. No.] **Installation Rec. (IR):** [insert Doc. No.]		

Seq. No.	Area / Subject QC Activity	Stage / Frequency	Test Device	Test Extent	Reference Document	Acceptance Criteria	Quality Record	Points of Intervention M/S	DC	CE	C	AI	Inspection Remarks
1	**Quality documents**												
1.1													
1.2													
2	**Assessment of Tooling & Measuring Devices**												
2.1													
2.2													
3	**Material requisition / -preparation, PMI**												
3.1													
3.2													
4	**Welding, Pre- / PWHT**												
4.1													
4.2													
5	**DT, NDT**												
5.1													
5.2													
6	**Dimensional control**												
6.1													
6.2													
7	**Leak- / Pressure- / Pressure drop- / Load- / Function test**												
7.1													
7.2													
8	**Surface preservation / Coating**												
8.1													
8.2													
9	**Marking- / Packing measures**												
9.1													
9.2													
10	**Manufacturing data book (Quality dossier) - MDB**												
10.1													
10.2													

Supplemental instructions:

1. Non-applicable chapters (1 – 10) shall not be deleted but crossed out.
2. *Points of Intervention* to be signed-off stage wise upon satisfaction by all parties involved.
3. DC Inspector to endorse *Review Points* upon duly verification of quality documents showing DC's approval status "RAF".
4. Inspector to verify previously granted (stage-wise) *Inspection Acceptance Notes*.

	Created	Checked	Approved
Manufacturer / Supplier			
Danieli Corus			
Client (engineer)			
Authorized Inspector			

Points of Intervention:	**Lower Tier's obligation regarding a next Upper Tier's defined Point of Intervention:**
Review (R):	Provide quality documents for review / approval prior to commencing with related work.
Verification (V):	Provide traceable quality records to prove the work in compliance with stipulated criteria.
Surveillance (S):	Invite for monitoring the work throughout a determined period.
Hold (H):	Invite for inspection / testing. Work shall not continue until further notice.
Witness (W):	Invite for inspection / testing. Work may continue although the event has not been waived. Provide instantly any effected quality record for review.
Participants:	**M/S**–Manufact./Supplier, **DC**–Danieli Corus, **CE**–Client Engineer, **C**-Client, **AI**–Author. Inspector

ANNEX II NOTIFICATION OF INSPECTION

DANIELI CORUS — NOTIFICATION OF INSPECTION

Supplier to input data and make selection for matters with *

PROJECT :	[Type project description]
DOC. NO. :	NOI [Select] - [Type purchase order no.]

PURCHASER :	Danieli Corus BV, fax. no. +31 (0)251 500 501		
CONTACT AT DC :	[Type name of DC designee] [Select Function]		
PHONE/E–MAIL :	[Type phone no and e-mail address of contact at DC]		
*DC'S PO NO. :	[Type purchase order no.]		
*SUPPLIER :	[Type supplier's company name]		
*CONT. AT SUPPL. :	[Type name and function of contact at supplier]		
*PHONE/E–MAIL :	[Type phone no. and e-mail address of contact at supplier]		
*SUPPLIER'S REF. :	[Type supplier's reference]		
*ISSUE DATE :	[Type date of issue]	*BY :	☐ DC ☐ Supplier

We hereby *Select the execution of *Select at the following parts:

*MATERIAL DESCRIPTION (in compliance with DC's **Bill of Materials**)	*UNIT	*P.O. LINE NO.	*P.O. QTY'S	*QTY'S PREVIOUS ACCEPTED	*QTY'S NEW OFFERED	QTY'S GRANTED F. INSPECTION

Notes for copper cooling members

1. *Figures without brackets refer to goods for which inspection is granted without objections.*
2. *Figures between ( ) refer to goods with pending CQTT progress (physical QC data) at supplier's end.*
3. *Figures between { } refer to goods liable to DC's pending evaluation of supplier's physical QC data.*
4. *Figures between [ ] refer to goods liable to DC's pending RT evaluation.*
   NOTE: Goods between brackets will be potentially granted in addition once available in the CQTT inspection screen.
5. *Goods (Qty's) which are not granted for inspection have been rejected upon DC's RT evaluation.*

*ORDER COMPLETE :	☐ Yes ☐ No *Pending items/matters:
*SUBJECT OF QC :	(refer to witness / hold point according to ITP or briefly describe tasks)

QUALITY DOCUMENTS	*DC DOCUMENT NUMBER (SO FAR APPLICABLE)	*REVISION	*APPROVAL STATUS
INSPECTION TEST PLAN :			
SPECIFICATIONS, PROCEDURES :			
VENDOR DOCUMENTS :			
CONCESSION REQUEST :			
WELD PLAN :			
DRAWINGS :			
MDB INDEX :			

PREVIOUS REPORTS PENDING ACTIONS	*DC DOCUMENT NUMBER (SO FAR APPLICABLE)	*REVISION	
PUNCH LIST/ - ITEM :			
NON-CONFORM. REPORT :			
INSPECTION REPORT :			

*PROPOSED DATE, TIME :	,		
CONFIRMED DATE, TIME :	,		
(CPL. ADDR.) *INSPECT. VENUE :			
(IF APPL.) *NEAREST AIRPORT :			
*MANUF. REPRESENTATIVE :		*PHONE :	
*SUPPL. REPRESENTATIVE :		*PHONE :	
DC [Select] :		PHONE :	
[Select]REPR. :		PHONE :	
Select :		PHONE :	

ANNEX II NOTIFICATION OF INSPECTION

*SUPPLIER DECLARES THAT:	
a) All with this inspection related vendor documents are accept as final (RAF).	*Select
b) Above referred parts passed DC's RT evaluation successfully.	*Select
c) Above referred parts will be available unpacked and fully accessible.	*Select
d) Above referred parts will have passed Supplier's quality control in reference with DC General Purchase Conditions clause 7c.	*Select
e) Related traceable quality records will be available for review / endorsement and as-built incorporated in the up to date manufacturing data book(s).	*Select
f) Clearance from Notified Bodies (Third Party Inspector) has been obtained.	*Select
Reasons for any item declared by NO (refer to item in specific):	
*	

ATTACHMENT :	[Type doc. name] [Type doc. no.] [Type number of pages]

DISTRIBUTED ON [Type date]	(COMPLETION BY DC INSPECTION COORDINATOR)
CLIENT :	[Type name] / to confirm attendance or provide waiver certificate
DC PM :	[Type name] / for information
DC PROC. MANAGER :	[Type name] / for information
DC PLANNER :	[Type name] / for information
DC ENGINEER :	[Type name] / for information
DC EXPEDITOR :	[Type name] / for information
DC INSPECTOR :	[Type name] / for information
[Select] :	[Type name] / for information
SUPPLIER :	[Type name] / for duly preparing the event
DC SITE MANAGER :	[Type name] / for information
SITE CONTRACTOR :	[Type name] / to confirm attendance

ANNEX III PROCEDURE "NON–CONFORMANCE / TECHNICAL ACCEPTANCE"

CON-CERNED MATTER	REPEAT INSP.	INSPECTOR	SUPPLIER	INSPECTION COORDINATOR
None	Not appl.	Issues *Final* **IAN** [0, 12, 13)] • mutually signed in footer section	Obtains the *Release for Shipment* from DC Expeditor	
Sample testing	Not appl.	Issues *Preliminary* **IAN** [0, 12, 14)] • mutually signed in footer section	Conveys the selected sample(s) as per DC's QC Specification and *requests* the *Release for Shipment* from DC Expeditor	- obtains engineer's acceptance (signature in IAN) [9)] for passed laboratory tests and signs for close-out in footer section - provides the amended *Final* **IAN** to parties
Minor deviation [7)]	Not appl.	Issues *Preliminary* **IAN** incl. remarks [0, 1, 12)] • mutually signed in footer section	- Confirms the QC passed rectification in the IAN [2)] and provides the amended document with sufficient *QC records & pictures* to DC Inspection Coordinator - Obtains the *Release for Shipment* from DC Expeditor	- obtains engineer's / inspector's acceptance (signature in IAN) [3)] and signs for close-out in footer section - provides the amended *Final* **IAN** to parties
Major deviation [8)]	Not appl.	Issues **NCR** [10, 12)] • each item with stipulated disposition [5)] [11)] • mutually signed in footer section	- Confirms the QC passed rectification in the NCR [4)] and provides the amended document with sufficient *QC records & pictures* to DC Inspection Coordinator - Obtains the *Release for Shipment* from DC expeditor	- refers eventually Concession Request (CR) - obtains engineer's / inspector's acceptance (signature in NCR) [6)] and signs for close-out in footer section - provides the *Final* **IAN** for Supplier's countersignature
Major deviation [8)]	Applicable	Issues **NCR** [10, 12)] • each item with stipulated disposition [5)] [11)] • mutually signed in footer section Re-examines the rectified goods and confirms the acceptance (signature in NCR) [6)] Provides the mutually signed *Final* **IAN**	- Confirms the QC passed rectification in the NCR [4)] and provides the amended document with sufficient *QC records & pictures* together with a fresh *Notification of Inspection (NOI)* to DC Expeditor - Obtains the *Release for Shipment* from DC expeditor	- refers eventually CR in NCR - provides the amended NOI to parties involved - provides the closed-out NCR to parties involved

For the superscript numbers see next page.

0) in table “Material Description” to refer all items according Bill of Material
1) in text block “Following has to be done prior to shipment”
2) in section “Rectification confirmed [Supplier]”
3) in section “Technical Acceptance [Danieli Corus]”
4) in column “Rectification / Executed & Supplier’s QC passed”
5) in column “Accept as built” or “Subject of repair (or reshoot regarding radiographs)” or “Rejected”
6) in column “Rectification / Accepted by DC engineer or inspector”
7) refers to documentary matters or marking-/ packing-/ BOM matters or others (e.g.paint container)
8) refers to hardware related matters in conjunction with not met quality criteria
9) in section “We hereby certify” next to applicable check box and text
10) follow-up through DC Expeditor
11) for likely feasible repair obtain supplier’s and DC engineer’s advice
12) if the form must be amended to suit a specific need then proceed with instruction ‘Permission to edit DC inspection forms’
13) if table ‘Material Description’ exceeds five(5) rows then simply refer the related BOM and if part acceptance bring the document in marked-up condition into annex
14) indicate in section “We hereby certify” under Remark: *Sample testing still pending*

Annex IV DC Concession Request

PROJECT :	[Type project description]
DOCUMENT NO. :	CR[Select]- [Type purchase order no.]

PURCHASER :	Danieli Corus BV, fax. no. +31 (0)251 500 683
CONTACT AT DC :	[Type name of DC designee], [Select Function]
PHONE / E–MAIL :	[Type phone no and e-mail address of contact at DC]
DC REFERENCE :	[Type purchase order no.]
SUPPLIER :	[Type supplier's company name]
CONTACT AT SUPPLIER :	[Type name and function of contact at supplier]
PHONE / E–MAIL :	[Type phone no and e-mail address of contact at supplier]
SUPPLIER REFERENCE :	[Type supplier's reference]
ISSUE DATE :	[Type date of issue]

EQUIPMENT DESCRIPTION

Reference document:

☐ CHANGE DESCRIPTION ☐ CONCESSION DESCRIPTION
☐ REMEDIAL ACTION FOR NCR DOC. NO.: ITEM NO.:

Supporting drawings, sketches, repair procedures and other data (indicate total pages in annex):

Repair procedure:

ORIGINATOR (NAME, FUNCTION, LOCATION, DATE, SIGNATURE)	
CLIENT :	[Type name, location, date and place signature]
DANIELI CORUS :	[Type name, location, date and place signature]
[Select] :	[Type name, location, date and place signature]

CLIENT RESPONSE

DANIELI CORUS RESPONSE

[Select] RESPONSE

EVALUATION (NAME, FUNCTION, LOCATION, DATE, SIGNATURE)		Approved	Approved as Noted	Rejected
CLIENT :	[Type name, location, date and acquire signature]	☐	☐	☐
DANIELI CORUS :	[Type name, location, date and place signature]	☐	☐	☐
[Select] :	[Type name, location, date and place signature]	☐	☐	☐

CONCESSION REQUESTS AND RELATED CORRESPONDENCE TO BE ADDRESSED TO THE DESIGNATED CONTACT PERSON OF DANIELI CORUS AS ANNOUNCED IN THE HEADER SECTION.

DANIELI CORUS

Annex V NON CONFORMANCE REPORT

PROJECT :	[Type project description]
DOCUMENT NO. :	NCR[Select] - [Type purchase order no.]

PURCHASER :	Danieli Corus BV, fax. no. +31 (0)251 500 683
CONTACT AT DC :	[Type name of DC designee], [Select Function]
PHONE / E–MAIL :	[Type phone no and e-mail address of contact at DC]
DC REFERENCE :	[Type purchase order no.]
SUPPLIER :	[Type supplier's company name]
CONTACT AT SUPPLIER :	[Type name and function of contact at supplier]
PHONE / E–MAIL :	[Type phone no. and e-mail address of contact at supplier]
SUPPLIER REFERENCE :	[Type supplier's reference]
ISSUE DATE :	[Type date of issue]

	DESCRIPTION OF NON-CONFORMITY	DISPOSITION				RECTIFICATION	
Sequ. No.	Referring to associated product identification (tag no.) and applicable document. Supplemental information see inspection report no. **IR**[Select]-[Type purchase order no.]	Accept as built	Subject of reshoot	Subject of repair	Rejected	Executed & Supplier's QC passed	Accepted by DC engineer or inspector

REMEDIAL ACTIONS :	**Concession Request:** [Type doc. no.] [Type agreed measures] **Approved by:** [Type function] [Type name],[Type date]

SUPPLEMENTAL INSTRUCTIONS :	Mark and segregate 'rejected' goods from production in order to avoid inadvertent use.

ATTACHMENT :	[Type doc. name] [Type doc. no.] [Type number of pages]

RE–[Select] REQUIRED :	☐ Yes, at [Type agreed location], date [Type date] ☐ No

CLIENT REPRESENT. FOR INFORMATION :	[Type name, location, date and acquire signature]
[Select] ON BEHALF OF DANIELI CORUS :	[Type name, location, date and place signature]
[Select] ACKNOWLEDGED :	[Type name, location, date and acquire signature]
CLOSE-OUT BY DC INSPECTION COORD. :	[Type name, location, date and place signature]

UPON ACCOMPLISHED RECTIFICATION SUPPLIER TO CONFIRM BY SIGNING IN COLUMN "EXECUTED & SUPPLIER'S QC PASSED" AND RESUBMITTING THE DOCUMENT TO DC EXPEDITING DEPT. FOR FURTHER PROCESSING.

DANIELI CORUS

ANNEX VI INSPECTION ACCEPTANCE NOTE
MECHANICAL SUPPLIES

PROJECT :	[Type project description]
DOC. NO. :	IAN[Select] - [Type purchase order no.]

PURCHASER :	Danieli Corus BV, fax. no. +31 (0)251 500 683
CONTACT AT DC :	[Type name of DC designee] [Select Function]
PHONE/E–MAIL :	[Type phone no and e-mail address of contact at DC]
DC REF. :	[Type purchase order no.]
SUPPLIER :	[Type supplier's company name]
CONT. AT SUPPL. :	[Type name and function of contact at supplier]
PHONE/E–MAIL :	[Type phone no. and e-mail address of contact at supplier]
SUPPLIER'S REF. :	[Type supplier's reference]
ISSUED :	[Type date of issue]

WE HEREBY CERTIFY

☐ FINAL TECHNICAL ACCEPTANCE OF THE BELOW LISTED GOODS.

☐ PRELIMINARY TECHNICAL ACCEPTANCE OF THE BELOW LISTED GOODS.

☐ CONSENT TO [Select]

Remark:

- ☐ By [Select] as per the issued inspection report [Type Document No.]
- ☐ By Inspection Coordinator according the packing released CQTT items (see table next two pages)
- ☐ By [Select] as per the [Select] [Select] [Type Document No.] (pending item:)
- ☐ By Inspection Coordinator based on supplier's quality records such as [Type Document], reviewed and approved by [function] [name],[date]
- ☐ By Inspection Coordinator upon performed laboratory tests of samples. Report [Type Document] reviewed and approved by [function] [name],[date]
- ☐ By Inspection Coordinator based on the issued inspection report [Type Document No.] and [Select Function] unconditional acceptance of supplier's evidence [Type Document].
- ☐ By Inspection Coordinator based on [Select Function] unconditional acceptance.

PO SEQ. NO.	MATERIAL DESCRIPTION	UNIT	P.O. QTY	QUANTITY PREVIOUS	ACCEPTED TODAY	TOTAL

POS. NO.	FOLLOWING HAS TO BE DONE [Select] (TO CHECK):	RECTIFICATION CONFIRMED [SUPPLIER]	TECHNICAL ACCEPTANCE [DANIELI CORUS]

REMARK :	[Type text]

ATTACHMENT :	[Type doc. name] [Type doc. no.] [Type number of pages]

SIGNATURES (NAME, LOCATION, DATE, SIGNATURE)	
CLIENT :	[Type name, location, date and acquire signature]
[Select] ON BEHALF OF DANIELI CORUS :	[Type name, location, date and place signature]
[Select] :	[Type name, location, date and acquire signature]
[Select] :	[Type name, location, date and acquire signature]
DC INSP. COORD. :	[Type name, location, date and place signature]

MENTIONED ITEMS HAVE BEEN INSPECTED AND PRELIMINARY/FINAL TECHNICALLY ACCEPTED BUT NOT RELEASED FOR SHIPMENT.

STATUS PRELIMINARY ACCEPTANCE WILL CHANGE TO FINAL UPON SATISFACTORY LABORATORY TEST RESULTS.

THIS ACCEPTANCE NOTE DOES NOT RELIEVE THE SUPPLIER FROM HIS RESPONSIBILITIES AS STIPULATED IN THE PURCHASE ORDER.

ANNEX VII MANUFACTURING DATA BOOK

[Insert Client logo]	DANIELI CORUS P.O.Box 10000 Address code 3J31 1970 CA IJmuiden The Netherlands	[Insert Supplier logo]	[Insert Supplier address]

MANUFACTURING DATA BOOK of

Project Name: [Type description in compliance with purchase order]

DC Reference: [Type DC's purchase order number]

DC Doc. No.: [Type number as advised by DC document control]

Supplier Reference: [Type number in compliance with purchase order]

Equipment Description / Tag No.: [Type description in compliance with the purchase order]

Manufacturing Data Book – Table of contents

DC Document No.:

Section	Description	No. of pages	Remark
1.1	Quality Certificate (ISO 9000 series, ASME, PED, etc.)	1 -	
1.2	Quality Plan (QP)	1 -	
1.3	Quality Assurance Plan (QAP)	1 -	
1.4	Quality Control Plan (QCP)	1 -	
1.5	Inspection and Test Plan (ITP)	1 -	
2.1	Concession-/ Change Request	1 -	If applicable
3.1	Drawings (as built)	1 -	
3.2	Isometrics (as built)	1 -	
4.1	Report – Incoming Goods Inspection	1 -	
4.2	Material Traveller, Routing Card	1 -	
4.3	Certificate of Re-marking	1 -	
4.4	Material Traceability Record (heat-/ charge no. ID)	1 -	
4.5	Test Report (2.2 acc. EN 10204)	1 -	
4.6	Inspection Certificate (3.1 / 3.2 acc. EN 10204)	1 -	
4.7	Certified Mill Test Report (CMTR)	1 -	
4.8	Positive Material Identification Certificate (PMI)	1 -	
4.9	Laboratory Test Report (chemical analysis)	1 -	
4.10	Laboratory Test Report (mechanical properties)	1 -	
4.11	Material Safety Data Sheet (MSDS)	1 -	
4.12	DT Report - Impact Test	1 -	
4.13	DT Report - Bend Test	1 -	
4.14	DT Report - Tensile Test	1 -	
4.15	DT Report - Hardness Test	1 -	
4.16	DT Report - Macroscopic Examination	1 -	
5.1	Welding Quality Certificate acc. ISO 3834 series	1 -	
5.2	Welding Coordinator Credential acc. ISO 14731	1 -	
5.3	Welding Personnel Qualification (WPQ)	1 -	
5.4	Weld Plan	1 -	
5.5	Preliminary Welding Procedure Specification (pWPS)	1 -	
5.6	Welding Procedure Specification (WPS)	1 -	
5.7	Welding Procedure Qualification Record (WPQR) incl. DT & NDT Results of test coupons	1 -	
5.8	Welding Consumable Certificate	1 -	
5.9	Line Inspection Summary List (LISL)	1 -	
5.10	Weld Map	1 -	
5.11	Weld Repair Procedure	1 -	
5.12	Weld Repair Report	1 -	
6.1	Heat Treatment Procedure	1 -	
6.2	Heat Treatment Report (Graph)	1 -	
7.1	Letter of Accreditation acc. to ISO/IEC 17020	1 -	
7.2	NDT Operator Qualification Record (level II, III)	1 -	
7.3	NDT Traceability Sketch	1 -	

Section	Description	No. of pages	Remark
7.4	NDT Procedure - Visual Test (VT)	1 -	
7.5	NDT Report - Visual Test (VT)	1 -	
7.6	NDT Report - Video Remote Control (Endoscope)	1 -	
7.7	NDT Procedure - Liquid Penetrant Test (PT)	1 -	
7.8	NDT Report - Liquid Penetrant Test (PT)	1 -	
7.9	NDT Procedure - Magnet Particle Test (MT, MPI)	1 -	
7.10	NDT Report - Magnet Particle Test (MT, MPI)	1 -	
7.11	NDT Procedure - Ultrasonic Test (UT)	1 -	
7.12	NDT Report - Ultrasonic Test (UT)	1 -	
7.13	NDT Procedure - Radiographic test (RT)	1 -	
7.14	Radiographic Technique Sheet	1 -	
7.15	NDT Report - Radiographic Review (RT)	1 -	
7.16	Radiographs (in portions prior to each inspection)	1 -	
8.1	Leak Test Procedure	1 -	
8.2	Leak Test Report	1 -	
8.3	Hydrostatic (Pressure) Test Procedure	1 -	
8.4	Hydrostatic (Pressure) Test Report	1 -	
8.5	Pneumatic (Pressure) Test Procedure	1 -	
8.6	Pneumatic (Pressure) Test Report	1 -	
8.7	Pressure Drop Test Procedure	1 -	
8.8	Pressure Drop Test Report	1 -	
9.1	Assessment Report for Measuring Devices / Check Templates	1 -	
9.2	Assessment Report of Trial Fit Assembly Platform	1 -	
9.3	Calibration Certificate (measuring-/test equipment)	1 -	
9.4	Inspection Record	1 -	
9.5	Dimensional Sizing Sheets of Shapes (Refractory)	1 -	
9.6	Dimensional Sizing Sheets of Pre-Assemblies (Refractory)	1 -	
9.7	Dimensional Test Report	1 -	
9.8	Dimensional Survey (Trial Fit) Procedure	1 -	
9.9	Dimensional Survey (Trial Fit) Report	1 -	
10.1	Functional- / Performance Test Procedure	1 -	
10.2	Assessment Report of Test Facility	1 -	
10.3	Balancing Report	1 -	
10.4	Alignment Test Report	1 -	
10.5	Functional- / Performance Test Report	1 -	
10.6	Final Acceptance Test (FAT) Procedure	1 -	
10.7	Final Acceptance Test (FAT) Report	1 -	
10.8	Vibration Test Report	1 -	
10.9	Sound Test Report	1 -	
11.1	Fire Safety Certificate	1 -	
11.2	UL Certificate	1 -	

Manufacturing Data Book – Table of contents

DC Document
No.:

Section	Description	No. of pages	Remark
11.3	PED Certificate	1 -	
11.4	ATEX Certificate	1 -	
11.5	Type Test Certificate	1 -	
11.6	Routine Test Certificate	1 -	
12.1	PCCP- Class 2 Certificate acc. to SSPC QP3	1 -	
12.2	Paint Data Sheet	1 -	
12.3	Paint Batch Certificate	1 -	
12.4	Surface Texture Test Report	1 -	
12.5	Sample Test Report (shot blasting material)	1 -	
12.6	Paint Monitoring Report	1 -	
12.7	Daily Paint Report	1 -	
12.8	Pull-off Test Report	1 -	
12.9	Cross-cut Test Report	1 -	
12.10	Spark (holiday) Test Report	1 -	
12.11	Pickling & Passivation Procedure	1 -	
12.12	Surface Cleanliness Test Report	1 -	
13.1	"II A" Declaration of Conformity - Machinery	1 -	
13.2	"II A" Declaration - Electrical Equipment - Low Voltage	1 -	
13.3	"II A" Declaration - Electromagnetic Compatibility	1 -	
13.4	"II A" Declaration - Pressure Equipment	1 -	
13.5	"II A" Declaration - Simple Pressure Vessels	1 -	
13.6	"II A" Declaration - Equipment in Explosive Atmospheres	1 -	
13.7	"II A" Declaration - Lifts	1 -	
13.8	"II A" Declaration - Construction Products (DoP)	1 -	
13.9	“II B” Declaration of the Manufacturer	1 -	
14.1	Field Inspection Report (Authorized Inspector)	1 -	
14.2	Manufacturer's Data Report (Authorized Inspector)	1 -	
14.3	Inspection Report (IR)	1 -	
14.4	Refractory Installation Record	1 -	
14.5	Non–conformance Report (NCR), Inspection Memo	1 -	If applicable
14.6	Inspection Acceptance Note (IAN), Inspection Certificate	1 -	
15	Photo of Name Plate	1 -	

SUPPLIER	**DANIELI CORUS**	**CLIENT**	**AUTHORITY**
Name: Place: Date: Seal / Signature			

Acknowledgment confirms the records duly review and completeness in compliance with the purchase order.

Annex VIII List of Abbreviations

AI	Authorized Inspector (commissioned)
CR	Concession Request
DT	Destructive Testing
f_IAN	Final Inspection Acceptance Note
GPC	General Purchase Conditions
H	Hold Point
IR	Inspection Report
ITP	Inspection & Test Plan
IWC	Inspection Waiver Certificate
MDB	Manufacturing Data Book
MT	Magnetic Particle Test
N/A	Not Applicable
NCR	Non-Conformance Report
NDT	Non-Destructive Testing
NOBO	Notified Body
NOI	Notification of Inspection
PIM	Pre-Inspection Meeting
PMI	Positive Material Identification
POI	Point of Intervention
PT	Liquid (Dye) Penetrant Test
PWHT	Post Weld Heat Treatment
pWPS	Preliminary Welding Procedure Specification
p_IAN	Preliminary Inspection Acceptance Note
QCP	Quality Control Plan
QD	Quality Document
QP	Quality Plan
QR	Quality Record
R	Review of Documentation
RAF	Reviewed & Accepted as Final. Work may proceed
RAN	Reviewed & Accepted as noted. Revise & resubmit. Work may proceed.
RCR	Reviewed & Returned. Correct & resubmit. Related work not to proceed.
RT	Radiographic Test
S	Surveillance
UT	Ultrasonic Test
V	Verification of QC records and spot check on Goods quality criteria
VDC	Vendor Document Control
VDL	Vendor Document List (approved)
VT	Visual Test
W	Witness Point
WPQ	Welder / Weld Operator Performance Qualification
WPQR	Welding Procedure Qualification Record
WPS	Welding Procedure Specification