



QUALITY ASSURANCE CYCLE

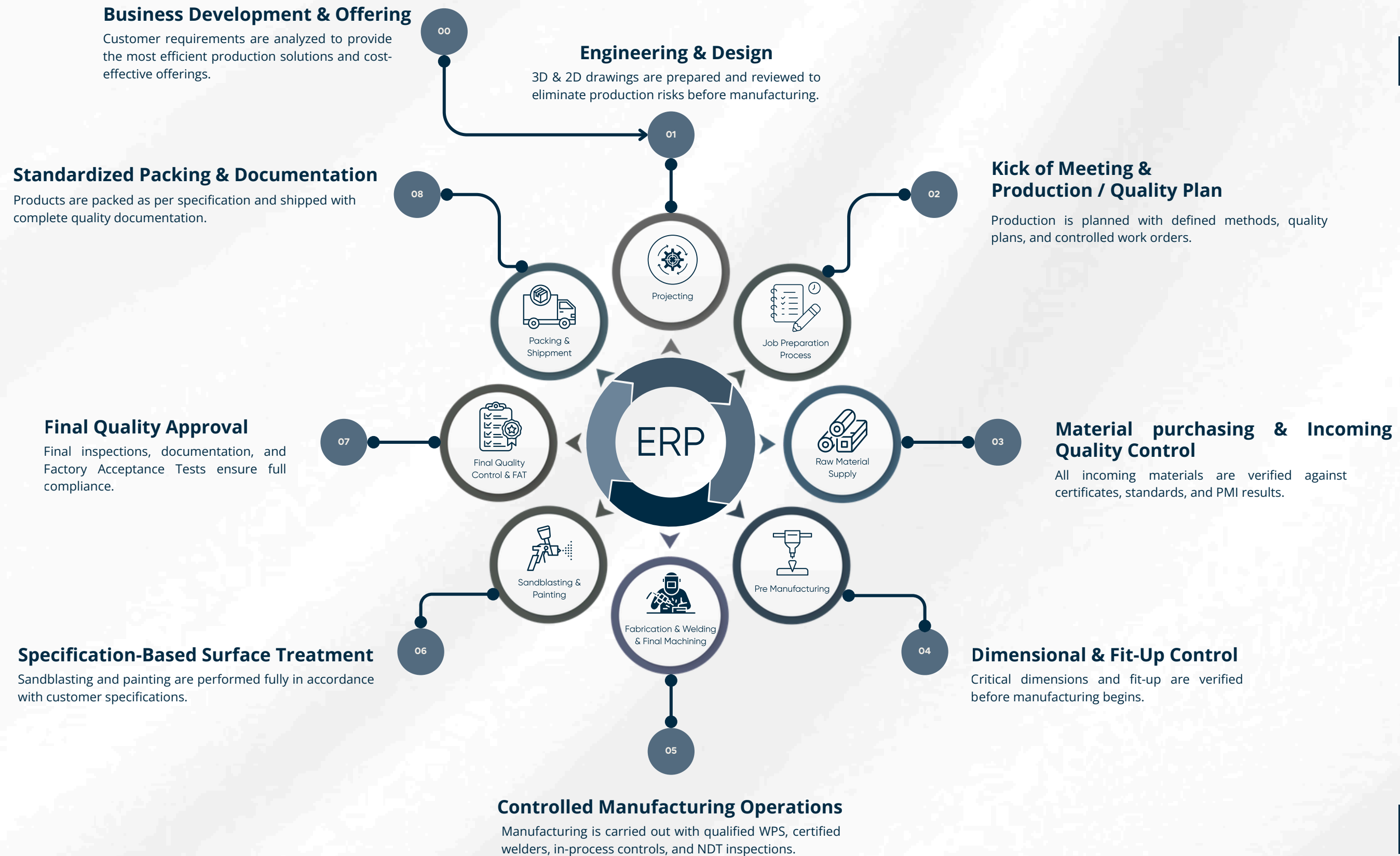
End-to-End Traceability. Zero Compromise.



All Process Starts with Quality Control

Workflow

Qc Cycle

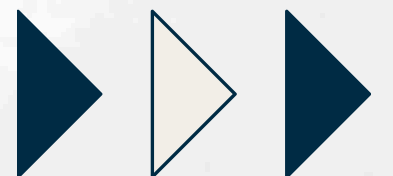
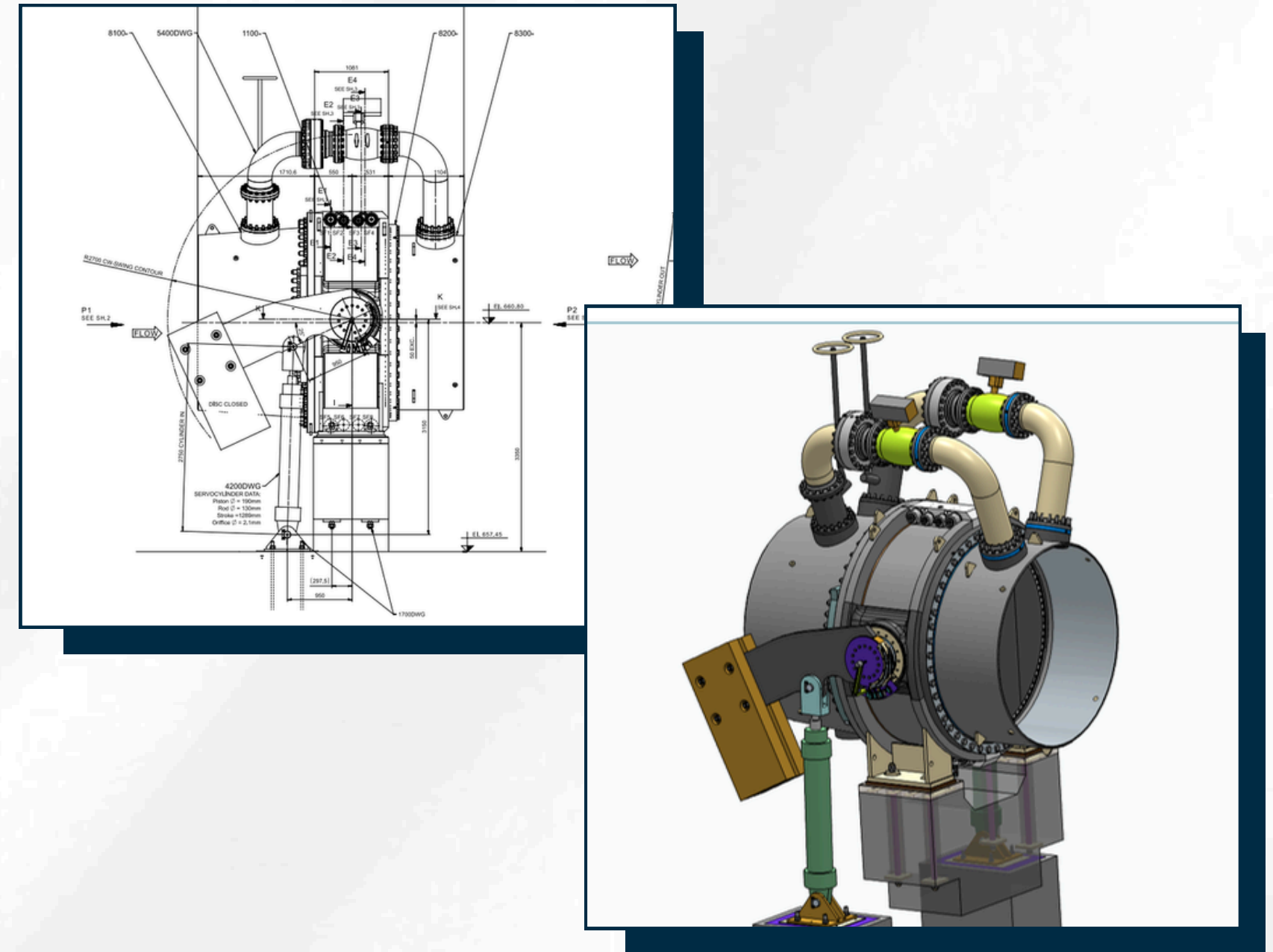




ENGINEERING & DESIGN

Engineering drawings are prepared in both 2D and 3D formats in accordance with customer specifications and submitted for customer approval prior to manufacturing.

All revisions are systematically documented to ensure version control, design traceability, and seamless project coordination throughout the engineering process.

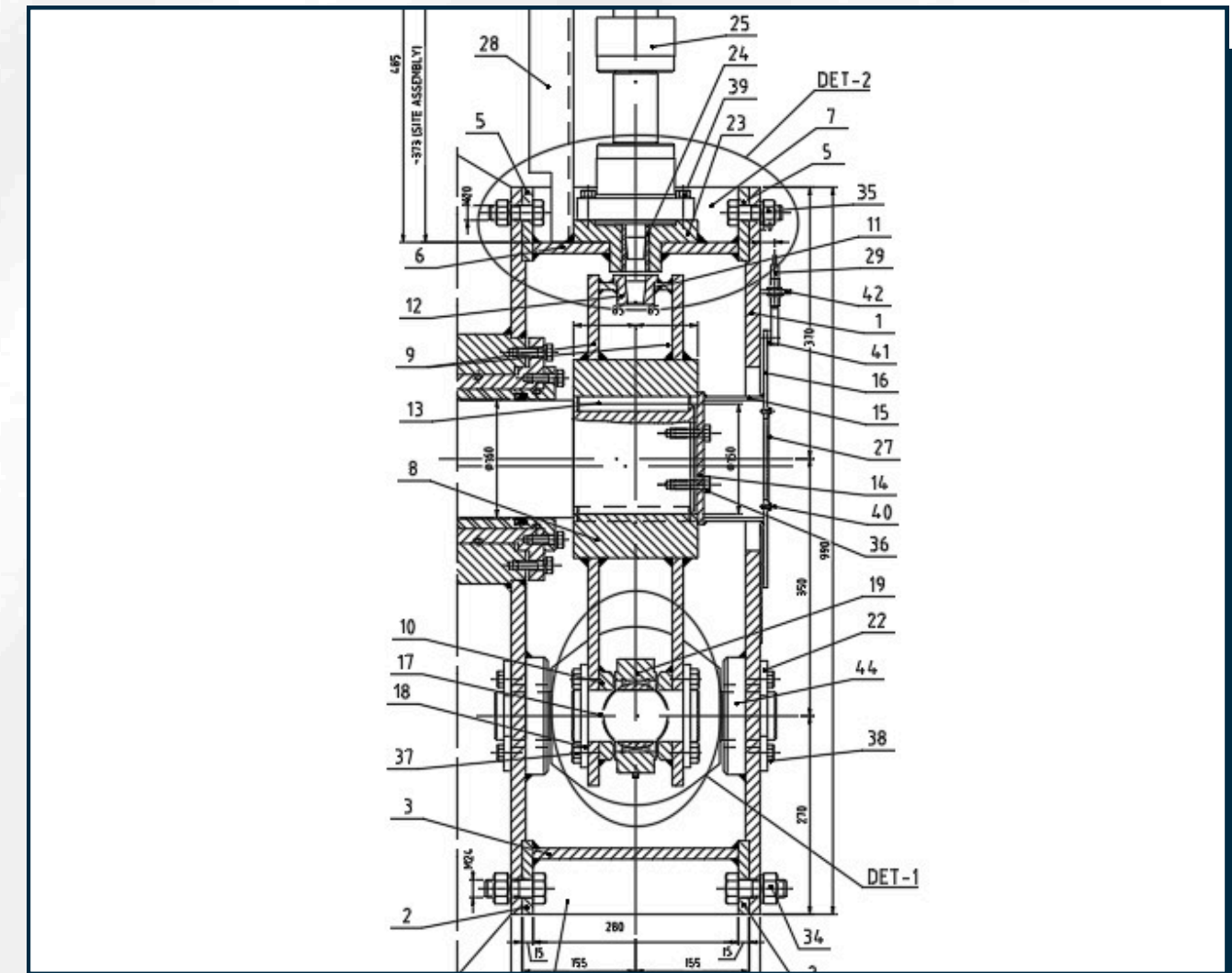


FROM DIGITAL DESIGN TO SMART MANUFACTURING

Seamless ERP integration of automated BOMs and parts lists ensures error-free procurement and flawless production execution.

POS NO	DESCRIPTION	QTY.	MATERIAL
1	≠ 20x990x1100	1	S355JR
2	≠ 15x100x450	2	S355JR
3	≠ 15x280x450	1	S355JR
4	≠ 5x75x280	4	S355JR
5	≠ 15x100x450	2	S355JR
6	≠ 15x280x450	1	S355JR
7	≠ 5x75x280	2	S355JR
8	∅270/∅150x170	1	42CrMo4
9	≠ 15x545x695	2	S355JR
10	∅120/∅70x20	2	S355JR
11	≠ 10x100x140	1	S355JR
12	∅60/∅28x40	1	S355JR
13	PIN ∅20x155	4	C-45
14	∅180x10	1	S355JR
15	≠ 5x85x518	1	S355JR

Bill of Material



Pos Number

PRODUCTION PLANNING

Following the kick-off meeting, production routes, inspection checkpoints and quality requirements are defined prior to manufacturing activities.

Production work orders, CAM programs and MES-based manufacturing tracking systems are prepared before manufacturing begins to ensure process standardization, full traceability and consistent quality control.

This structured workflow enables controlled, transparent and sustainable production management throughout the entire project lifecycle.

PS260101-JE0001

İŞ EMRİ NO
PS260101-JE0001

MÜŞTERİ
İDÇ

SİPARİŞ TARİHİ
05.03.2026

BAŞLAMA TARİHİ
07.04.2026

ÜRETİM ADETI
2

DURUM
Tamamlandı

PROJE NO
PS260101

PROJE ADI
VİNÇ TEKERLEĞİ İMALİ

TESLİM TARİHİ
20.04.2026

ÖNGÖRÜLEN BİTİŞ
—

MALZEME
—

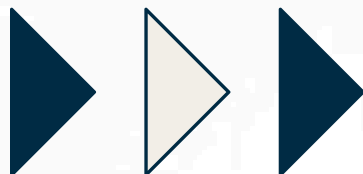
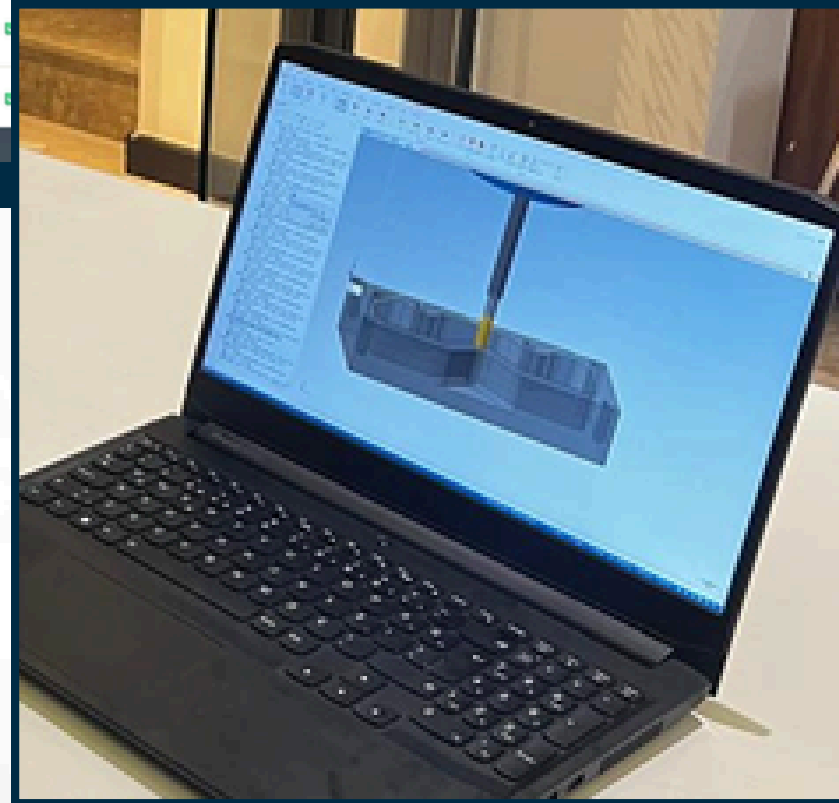
OLUŞTURAN
Yönetici

İş Emri Düzenle

Excel Kalite Raporu İndir

Operasyon Rotası

OP.NO	İŞLEM	TEZGAH	PERSONEL	TARİH	AÇIKLAMA	QC DURUMU	DURUM
10	Talaşlı İmalat	SE-UNVT-02	ATIF ZERRAK	2026-04-06	BÜTÜN ÖLÇÜLER 2 MM KABA İŞLENCEKTİR.	Geçti	Bitti
20	Fason	—	—	2026-04-07	TEKNİK RESİME GÖRE İSLAH SERTLÜĞÜ VERİLECEKTİR. Sertifik Kontrolü Yapılacaktır.	Geçti	Bitti
30	Talaşlı İmalat	SE-UNVT-02	—	2026-04-07	ÇAPLAR TEKNİK RESİME GÖRE FİNAL ÖLÇÜYE GETİRİLECEKTİR.	Geçti	Bitti
40	Talaşlı İmalat	SE-CNCF-01	—	2026-04-07	DELİKLER DELİNECEK, KAMA YERİ AÇILACAKTIR.	Geçti	Bitti



QUALITY PLANNING

Quality planning activities are carried out in accordance with applicable ITP requirements. Material certificates, technical documentation, and inspection requirements are verified during procurement, while welding operations are performed in line with approved WPS/PQR procedures. Weld Maps are prepared to ensure welding traceability.

Required NDT inspections (VT, MT, PT, UT, RT), heat treatment, blasting, and painting activities are conducted under controlled conditions in accordance with relevant standards and procedures. Coating quality is verified through X-cut, Cross-cut, Pull-off, and Holiday tests.

All quality control and inspection activities are properly recorded and documented in line with ITP requirements.



Inspection Plan Overview (IPO)

Examinations

1	2	3	4	5	6										7					
Serial No.	pieces / Bauteile	group No. / Gruppen-Nr.	component / Bauteil drawing No. / Zeichnungs-Nr. Quality plan / Prüfplan	material Werkstoff standard Norm	material testing Materialprüfung										testing during / Fertigung welded joints / Schweißnaht					
															without / before annealing ohne / vor d. Glühen		After a nach d.			
1		PL FG	VALVE BODY SLV24-MIV-1150 SLV24-MIV-0403	S355J2+N EN 10025-2 S325G (Bosses) EN 10250-2	CC 3.1	TT 3.1	17) CV ₂₀ 3.1	16) Z35 3.1	7) UT 3.1						3) MT 3.1	4) UT 3.1	6) VT 3.1	3) MT 3.1 AH	4) UT 3.1 AH	
2		C	VALVE BODY HUB SLV24-MIV-1155, 1156 SLV24-MIV-0401	G20Mn5 QT EN 10293	CA 3.1	TT 3.1	CV ₂₀ 3.1			1) MT 3.1	1) UT 3.1		2) MT 3.1		1)8) MT 3.1	1)8) UT 3.1	1) VT 3.1	1)8) MT 3.1	1)8) UT 3.1	
3		PL	VALVE DISC SLV24-MIV-2150 SLV24-MIV-0404	S355J2+N EN 10025-2	CA 3.1	TT 3.1	17) CV ₂₀ 3.1	16) Z35 3.1	7) UT 3.1						3) MT 3.1	4) UT 3.1	6) VT 3.1	3) MT 3.1 AH	4) UT 3.1 AH	
4		C	VALVE DISC HUB SLV24-MIV-2164,2165 SLV24-MIV-0402	G20Mn5 QT EN 10293	CA 3.1	TT 3.1	CV ₂₀ 3.1			1) MT 3.1	1) UT 3.1		2) MT 3.1		1)8) MT 3.1	1)8) UT 3.1	1) VT 3.1	1)8) MT 3.1	1)8) UT 3.1	
5		PL FG FG	UPSTREAM PIPE SLV24-MIV-8150 SLV24-MIV-0411	S355J2+N EN 10025-2 S325G (Bosses) EN 10250-2 X2CrNi18-9 (Round bar) EN 10088-3	CA 3.1	TT 3.1	17) CV ₂₀ 3.1	16) Z35 3.1	7) UT 3.1						3) MT 3.1	4) UT 3.1	6) VT 3.1	5) PT 3.1	3) MT 3.1 AH	4) UT 3.1 AH

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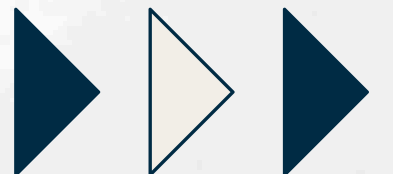
[illegible][illegible]

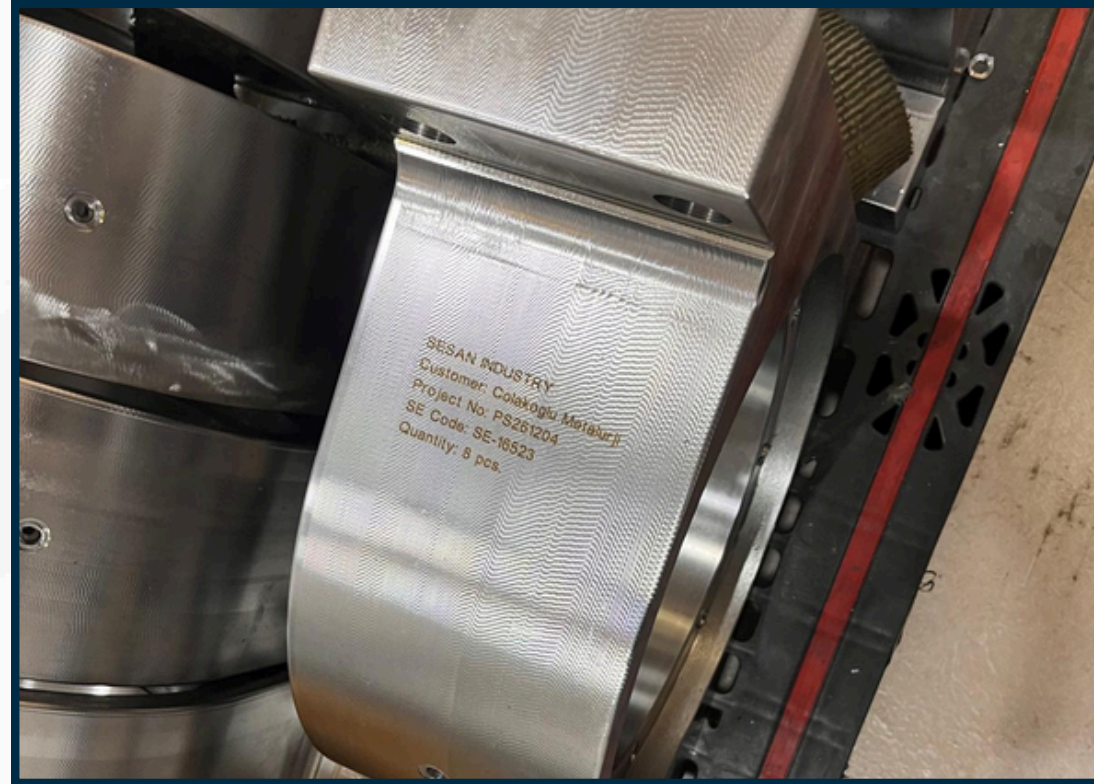
TRACEABILITY REPORT			Revizyon tarihi Revision date	18.03.2025
			Sayfa No Page no	1/1
Proje Numarası	PS252701	Rapor No Report No	ANDR	
Alt Yüklenici Subcontractor	Sesan Industry	Parça No Part No	P-4151 , P-11	
OK	Impact Test -20°	OK	UT	OK
2393C10002004	A1032212393C10002004	25-368		
Ölçü DIAMETER	KALINLIK THICKNESS	DÖKÜM / LOT NO HEAT / LOT NO	İZLENEBİLİRLİK NO TRACEABILITY NO	SONUÇ RESULT
670X670 Ø669.95 Ø465.05	130	23401417	SE 16257	OK
446X1619	130	23401417 →	SE 16257	OK
"	"	"	"	"

ERDEMİR				
ÜRÜN BİLGİLERİ				
Tonaj (KG)	Döküm No	Bobin / Paket / Levha No	Dilim Adedi	Normalize Durumu
20,550	23401417	44022142000		
8,480	437493	44023475000		

Material Traceability Management

After all incoming inspections are completed, each material receives a unique SE Code, which is linked to its Heat Number to ensure full traceability and certificate compliance.

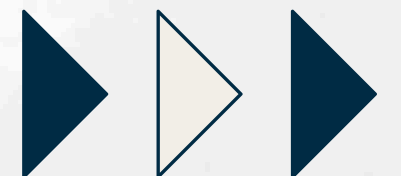




Material Identity Card		
Material Group	Sheet Metal Materials	
Material Name	S235JR 15*1500*12000 MM SHEET	
Material Issue Date	29.12.2025	
Project Name	GULEKER-GUIDED LINE CLOSING	
Traceability Code	SE-16448 / PS250207	
Cast/Heat Number	25229387	
PMI Control	OK	
		

Incoming Quality Control & Supplier Management

All raw materials are sourced from approved suppliers and systematically verified through material certificates, PMI reports and incoming inspections. Each project is assigned a unique PS code, while all materials and components are tracked with traceability codes and laser markings throughout the entire production process to ensure full traceability and quality compliance.





CUTTING & BENDING

Cutting operations are performed in accordance with approved fabrication drawings and applicable procedures. Material identification/traceability and cutting parameters are verified prior to processing. During production, dimensional accuracy, cutting quality, and surface conditions are inspected and recorded.

Bending operations are carried out in accordance with approved fabrication drawings and applicable procedures. Material verification and bending parameters are checked prior to processing. During production, angle, dimensional accuracy, and surface conditions are inspected and recorded.

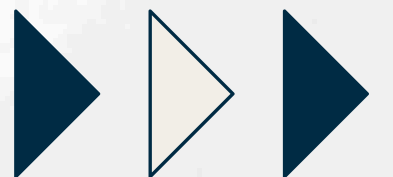
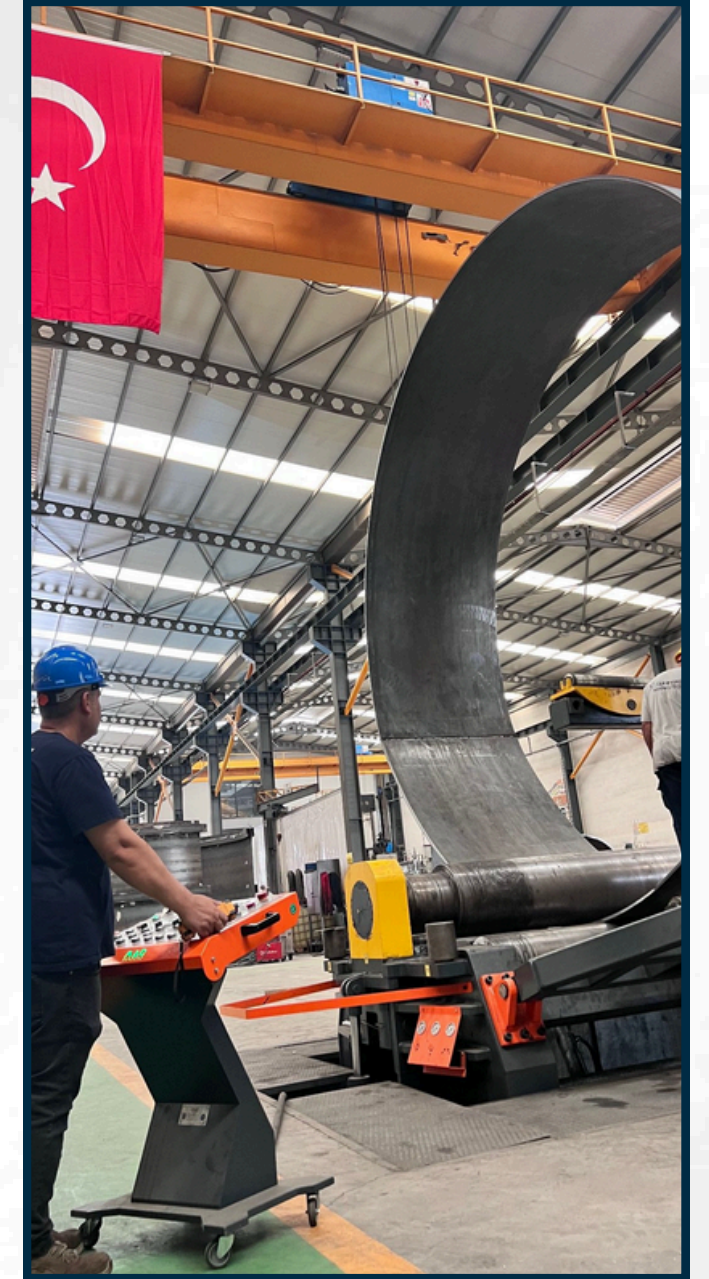
SESAN
INDUSTRY

Firma Adı	AJAN Electronics		Makine tipi	Plasma	Program Adı	
Levha Ölçüleri	12000X1500 mm	Program Tekrarı (Bacadet)	1	Kalınlık (mm)	15	Kesim Amperi
Sol Kenar	1 mm	Sağ Kenar	1 mm	Alt Kenar	1 mm	Üst Kenar
						1 mm

Kesim Süresi =	1:03:24
Toplam Piercing Zaman =	0:00:35
Dönüş/Çıkış Süresi =	0:00:33
Torch Boşta Geçiş Süresi =	0:00:51
Dönüş	0:00:00
Punta	0:00:00
Ortak Kesim	0:00:00
Markalama	0:00:00
Toplam Kesim Süresi =	1:13:23

Toplam Patlama Sayısı =	
Toplam Parça Ağırlık (Kg) =	
Kullanılabilir Levha Ağırlığı (Kg) =	
Hurda Levha Ağırlığı (Kg) =	
Toplam Levha Ağırlığı (Kg) =	
Kesme Yolu Uzunluğu (mm) =	
Yol Uzunluğunu İşaretleme (mm) =	

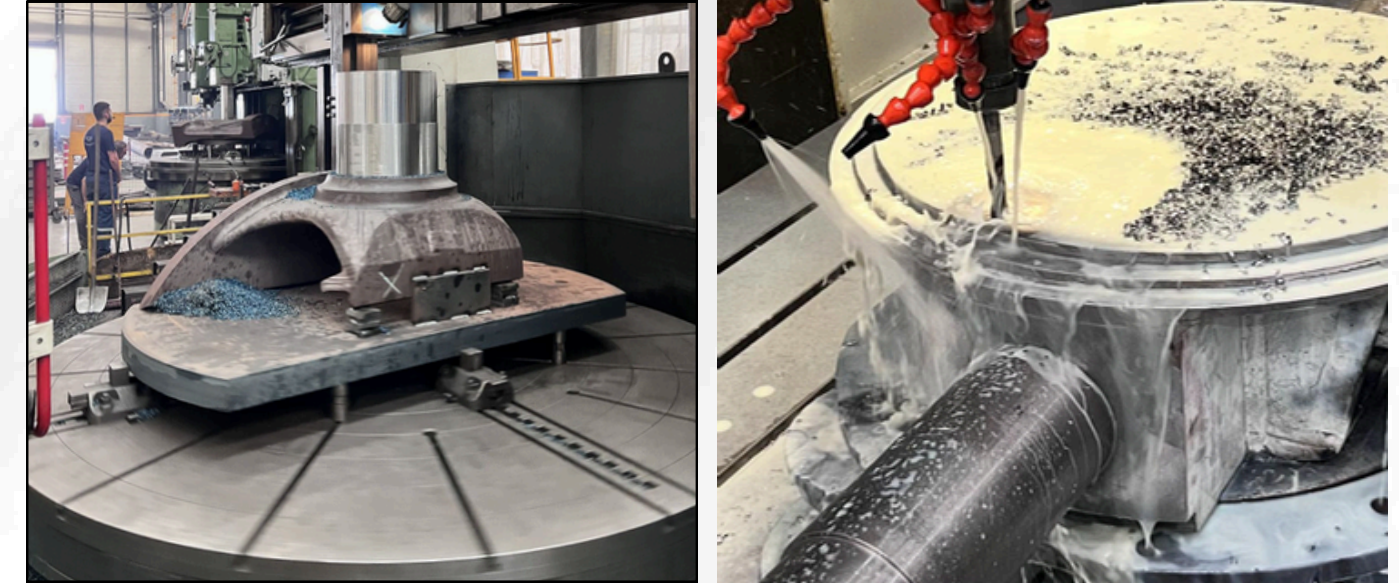
Poz No	Parça Adı	Parça Ölçüsü	Parça Ağırlık (Kg)	Kesim Süresi	Adet	Parça Kesim Boyu (mm)
1	YP-6	1145X307	20.005	0:01:34	11	2559.43
2	FIRE	200X200	4.722	0:00:30	5	800.00
3	FIRE	100X100	1.181	0:00:15	45	400.00



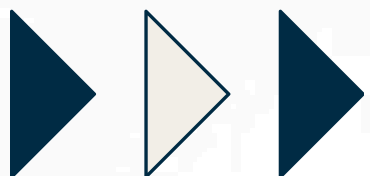
PRE-MACHINING

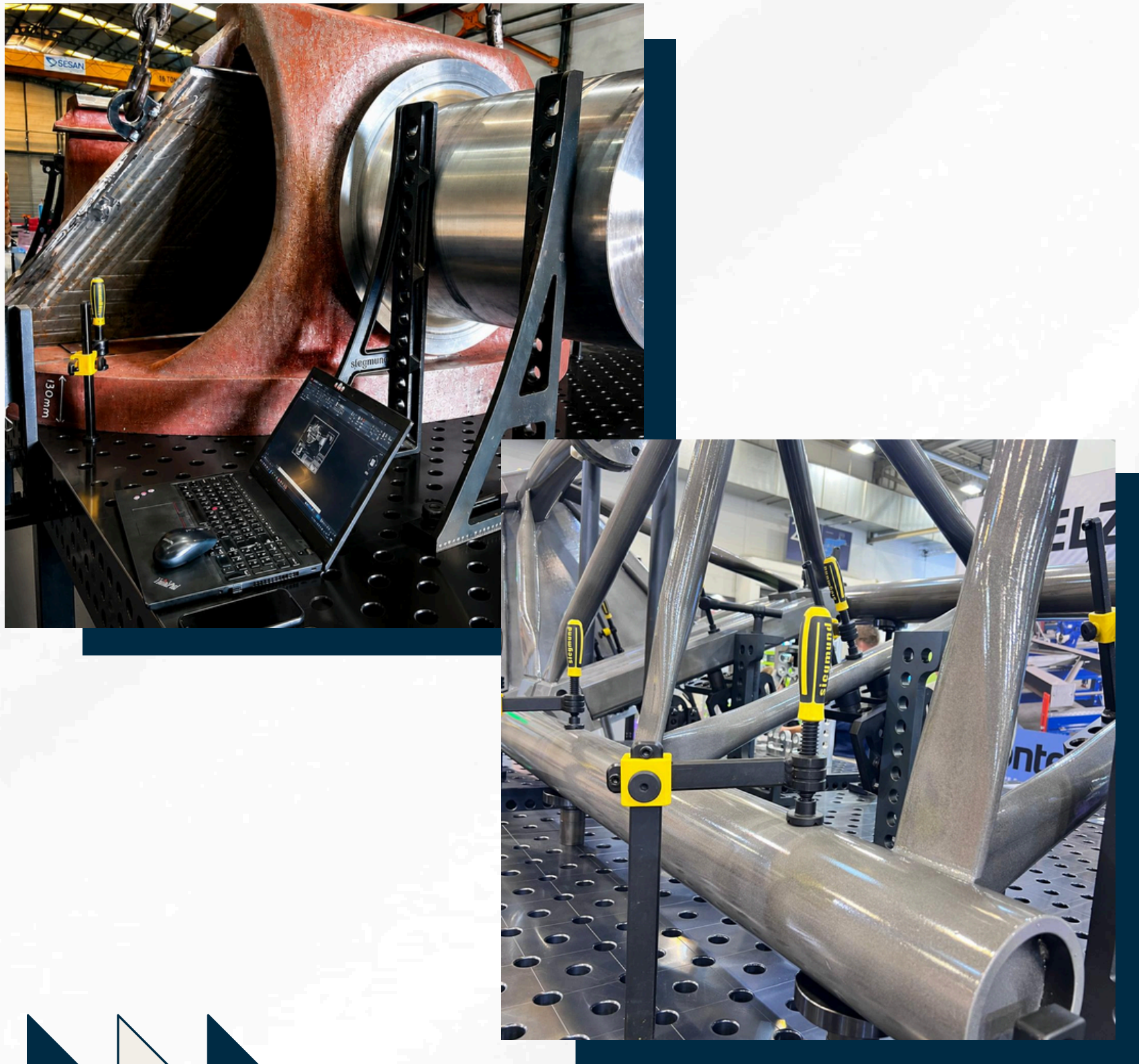
At the pre-machining stage, reference surfaces and critical dimensions are inspected to prepare the component for rough machining prior to welding operations. Geometrical deviations and tolerance variations resulting from cutting and bending are evaluated.

Where necessary, corrective actions are planned to establish proper references for fit-up and welding operations. This stage ensures dimensional stability before final machining.



WORK ORDER								
	İŞ EMRİ NO	PS261205-IE0001	ÖLÇÜMLEME TARİHİ	01.06.2020				
	SİPARİŞ TARİHİ	01.04.2020	TESLİM TARİHİ	10.08.2020				
	PROJE ÜRÜN KODU		MALZEME					
	REVİZYON NO		ÜRETİM ADETİ	6				
	ÖNGÖRÜLEN BİTİŞ TARİHİ							
HAMMADDE BİLGİLERİ								
	MALZEME KALİTESİ	SERTİFİKALOT ID	GRK NO	MALZEME SE KODU				
	S355J2+N	H2026-4521	5128451	SE-16471				
ÖLÇÜLEN TARİHİ GGÇ & BİTİŞ	İŞLEM ADIMLARI	İMALAT TEKNİK RESMİ/REV.NO	TEZGAH NO	ÜRETİLEN MİKTAR	CNC CAM NO	PERSONEL İMZA	ÖZEL AÇIKLAMA	
16-04-22	Plazma Kesim	LH063-14-OP2-R02	SE-CNCPT-01			ÖRKEŞ GÜNGÖRMEZ	KESİM PLAN NO: SE-S.NES-2194	☐ Uygun
16-04-22	Talaş İmalatı	LH063-14-OP2-R02	SE-UNVT-01			ATIF ZERRAK	DIŞ ÇAP KABA VE MALZEME BOYUNA GETİRME	☐ Uygun
16-04-22	Talaş İmalatı	LH063-14-OP2-R02	SE-CNCT-01			KADIR CULUM	FINISH İŞLEMİ	☐ Uygun

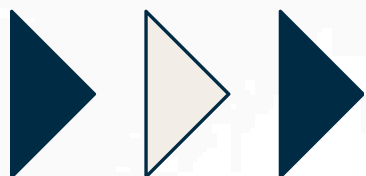




FIT-UP OPERATIONS

Fabrication begins with CNC cutting and forming operations, followed by dimensional fit-up verified against customer-approved 2D drawings. All critical dimensions are inspected prior to welding and recorded in the project's quality dossier.

In-house machining capability allows precise preparation of components requiring tight tolerances before assembly.





Total Station Controls

		ÖLÇÜ KONTROL RAPORU DIMENSIONAL CONTROL REPORT		Döküman No / Doc.Nr 89-KAL-003			
				Yayın Tarihi/Publish Date 19.4.2018			
				0			
				Revizyon No./Rev. Nr 0			
				Revizyon Tarihi/Rev. Date 0			
				Sayfa No /Page Nr 1/1			
Adı Item Name	Tosyalı Cezayir	Ürün Adı Item Name	ŞASE CBX GİRİŞ ŞUT ROLL				
Rapor No Report No	-	Rapor No Report No	SES-CBX-100				
No	181120 112 01 00100	Pafta No Sheet No	181120 112 01 00100				
Standart Standard	TS EN ISO 2768-1						
ÇİZİM / SKETCH							
Tosyalı Cezayir		ELEMENT					
181120 112 01 00100		SES-CBX-100					
Kullanılan ekipmanlar Examination devices used		METRE(5M)	Caliper(300)				
Seri No Serial No		SES-ŞMT-002	1213180328				
Kalibrasyon Tarihi Calibration Date		8.11.2025	8.11.2025				
Sertifika No Certificate No		0004K-1025-02469	0004K-1025-02458				
No ss.	Proje Değeri Project Value	Tolerans Tolerance	Mevcut Değer Actual Value	Fark Distinction	KABUL ACC.	RED REJ.	AÇIKLAMALAR REMARKS
	1395	±1.2	1395	0	ACC	-	-
	1304	±1.2	1303	1	ACC	-	-

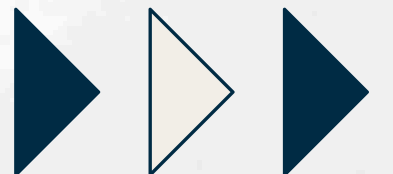
Dimensional Control Report



Laser Measuring Controls

FIT-UP CONTROLS

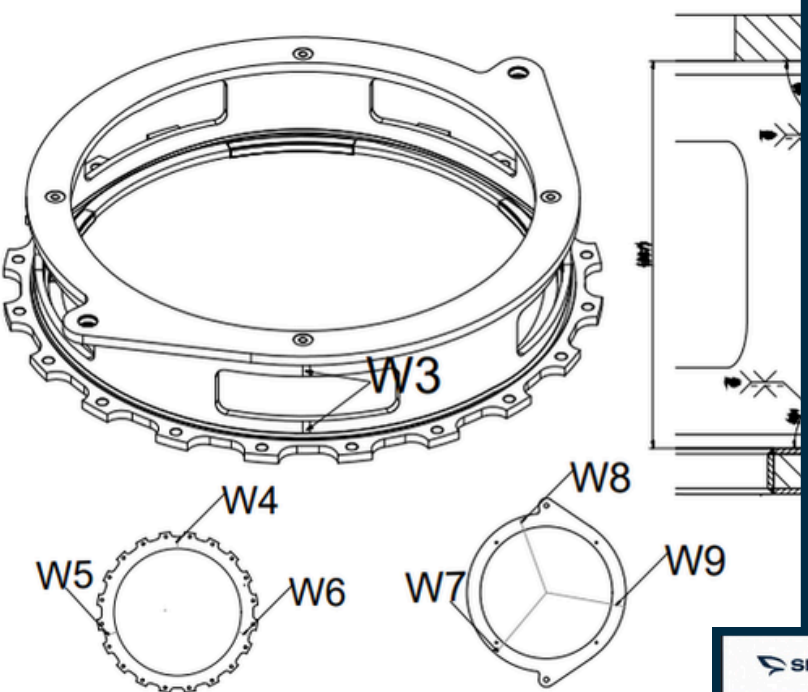
Prior to welding, all critical dimensions and assembly tolerances are verified through fit-up controls and recorded in dimensional control reports. For large-scale or precision-positioning components, Total Station measurements are applied to verify axis alignment, elevation and reference points – ensuring geometric accuracy before any welding operation is authorized.



WELDING OPERATIONS

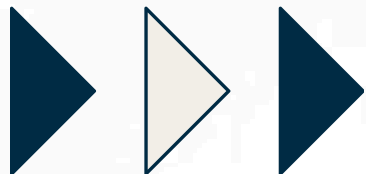
All welding operations are performed exclusively by certified welders under approved Welding Procedure Specifications & Weldmap in accordance with EN ISO 15614 and/or ASME Section IX. In-process controls – including preheat, interpass temperature, and visual inspection – are applied at every stage.

Each weld is traceable through welder ID, WPS reference, and material heat number, all linked to the project PS code.



WELD MAP NO: SSN-REG-001

 Sesan Kaynaklı Üretim İş Emri Formu Welded Production Work Order Form			
Proje / Project		PS252702	Tarih / Date:
İş Emri No / Work Order No:		SSN-KI-REG-003	Miktar / Quantity:
A- Genel Bilgiler / A- General Information			
Firma Adı / Company Name:		ANORITZ	
Proje Adı / Project Name:		REGULATING RING U-1	
Yapılacak İşin Adı / Description of Work:		REGULATING RING KAYNAK SÜRECİ	
Proje Resim No / Project Drawing No:		SLV24-TUR-3150	Yaklaşık Ağırlığı(kg.) / Approxim.
B- Malzeme ve Yöntem Bilgileri / B- Material and Process Information			
Malzeme Kalitesi / Material Grade:	S355J2+N	Kaynak Teli / Filler Wire:	GEKA SG3
Malzeme Kalınlığı / Material Thickness:	30mm/50mm	Kaynak Yöntemleri / Welding Process(es):	GMAW
Wps-Pqr No / WPS-PQR No:	SESAN-PQR-10	Kaynak Tipleri / Weld Type(s):	PA
Top.Kaynak Metrajı / Total Weld Length:		Kaynak Testleri / Welding Tests:	VT/MT/UT
Kaynak Başlangıç Tarihi / Welding Start Date:		Kaynak Bitiş Tarihi / Welding Completion Date:	
Kaynak Personeli / Welding Personnel:		İmza / Signature:	Kay. Wel.
C- Kalite Kontrol Bilgileri / C- Quality Control Information			
Kaynak Kontrol / Welding Control:	Tarih / Date:	12.09.2025	Onay / Approval:
Ölçü Kontrol / Dimension Control:	Tarih / Date:	5.09.2025	Onay / Approval:
Temizlik Kontrol / Cleaning Control:	Tarih / Date:	12.09.2025	Onay / Approval:
Son Ürün Kontrolünü Yapan / Final Product Inspection By:			
Teslim Alan / Received By:		Açıklamalar / Remarks:	
D- Proses Takip Bilgileri / D- Process Tracking Information			
Durum / Status	Tarih / Açıklama / Date / Description	Süreç Detayları / Process Details	
1 Kaynak / Welding	15.09.2025		
2 Temizlik / Cleaning	16.09.2025		
3 NDT (Isıl İşlem Öncesi) / NDT (Before Heat Treatment)	22.09.2025		
4 Isıl İşlem / Heat Treatment			
5 NDT (Isıl İşlem Sonrası) / NDT (After Heat Treatment)			
6 Son Kontrol / Final Inspection			
E- Önemli Uyarılar ve Açıklamalar / E- Important Warnings and Explanations			
Ürün Kontrolleri Teknik Resim/Numuneye uygun olarak yapılmıştır. / Product inspections have been carried out in accordance with the technical drawing/sample.			





WELD LOG												
JOINT DATA					ITEMS							
ART NAME	WELD MAP	WELD NO	WELD TYPE	WELD SIZE	WELDING	Page No	Σ T _W (hrs)	Material Description	Pos No	Material Quality	SCR	THK (mm)
Body-CH900	SSN-TTW1-100	W1	T.B.W	K	Shop	TTW-71-U004		PLATE	P-16	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W2	T.B.W	K	Shop	TTW-71-U004		PLATE	P-15	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W3	T.B.W	K	Shop	TTW-71-U004		PLATE	P-20	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W4	T.B.W	K	Shop	TTW-71-U004		PLATE	P-15	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W5	T.B.W	K	Shop	TTW-71-U004		PLATE	P-16	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W6	T.B.W	K	Shop	TTW-71-U004		PLATE	P-16	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W7	T.B.W	K	Shop	TTW-71-U004		PLATE	P-15	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W8	T.B.W	K	Shop	TTW-71-U004		PLATE	P-15	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W9	T.B.W	K	Shop	TTW-71-U004		PLATE	P-16	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W10	T.B.W	K	Shop	TTW-71-U004		PLATE	P-16	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W11	T.B.W	K	Shop	TTW-71-U004		PLATE	P-15	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W12	T.B.W	K	Shop	TTW-71-U004		PLATE	P-20	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W13	T.B.W	K	Shop	TTW-71-U004		PLATE	P-15	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W14	T.B.W	K	Shop	TTW-71-U004		PLATE	P-16	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W15	T.B.W	K	Shop	TTW-71-U004		PLATE	P-16	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W16	T.B.W	K	Shop	TTW-71-U004		PLATE	P-15	S355J2+H	20	24
Body-CH900	SSN-TTW1-100	W17	T.B.W	K	Shop	TTW-71-U004		PLATE	P-12	S355J2+H	20	24

Weld Log



QUALIFICATION OF A WELDING PROCEDURE (WPQR)

CERTIFICATE 09-702-01.C-05-2015-34034-5

Authority: TÜV Teknik Kontrol ve Belgelendirme A.Ş.

File No.: 34034-5

WPQR-No.: PQR 10

Revision: 00

WPS No: WPS 10

Manufacturer: Sesan Endüstri San. ve Tic. Ltd. Şti.

Address: Adana Orta Çiğekil San. Sitesi Yeşiloba Mah. 43/2 Sk. B B1 No:1 Seyhan / ADANA

Requirements: DIN EN ISO 15614-1 / PED 97/23/EC

	TEST PIECE	RANGE OF QUALIFICATION
Welding process(es):	136	136
Type of weld and joint:	BW	BW, PW
Parent mat. group(s) and sub-group(s):	1.2 (EN 10025 S355J2 C+N)	1a-1 (a covers the equal or lower specified yield strength steels of the same group)
Parent material thickness (mm):	25	12.5 mm to 50 mm
Throat thickness(mm):	-	-
Single run/multi run:	multi run	-
Pipe outside diameter(mm):	N/A	D=500 mm all, D>150 mm PA/PC rotated
Filler metal designation and size:	EN ISO 17632-A:09 T 42 2 P C 1 20/2	equivalent mechanical properties, same type of covering gas or flux, same root face preparation and venting
Shielding or backing gas/ flux:	ISO 14175 C1	DC(+)
Type of welding current and polarity:	DC(+)	Identical
Mode of metal transfer:	Globular Transfer	the upper limit of heat input qualified is 20% greater than test piece.
Heat input:	max. 1.87 kJ	Welding of a test in any one position (pipe or plate) qualified for welding in all positions (pipe or plate) except for PQR and J-coult where a separate welding procedure has to be required.
Welding positions:	PF	
Preheat temperature:	100°C	min 100°C

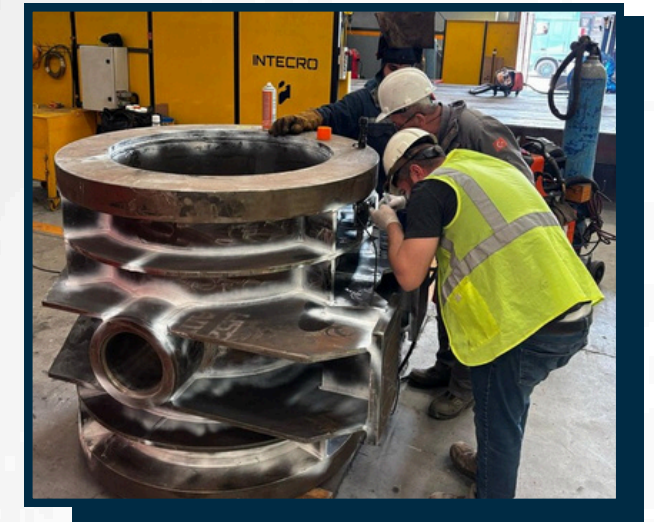
WPS & PQR



Welding



Robotic Welding



NDT

From Weld Map To Final Inspection

Every welding operation is performed in accordance with approved WPS and PQR documents. Manual and robotic welding are controlled through defined process parameters to ensure compliance with applicable standards.

Pre-weld preparation includes fit-up and HAZ cleaning. After welding, post-weld cleaning is carried out and inspections include VT and in-house NDT (PT, MT, UT), while RT is performed by an approved external provider.

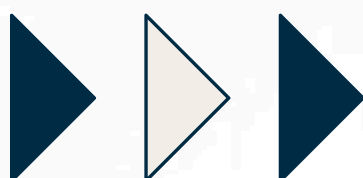
When required, heat treatment is applied, followed by post-heat treatment inspection and repeat NDT. Full traceability is maintained from welder ID and weld logs through to final acceptance.



FINAL MACHINING

Final machining is performed after completion of all welding and assembly operations. Welding-related distortions, misalignments, and flatness deviations are corrected to ensure geometric accuracy.

Functional surfaces and reference datums are machined to final tolerances, while critical criteria such as parallelism, perpendicularity, concentricity, and surface finish are verified.

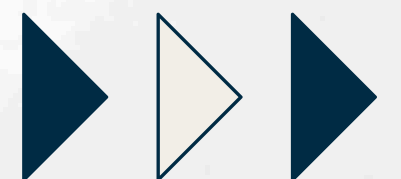
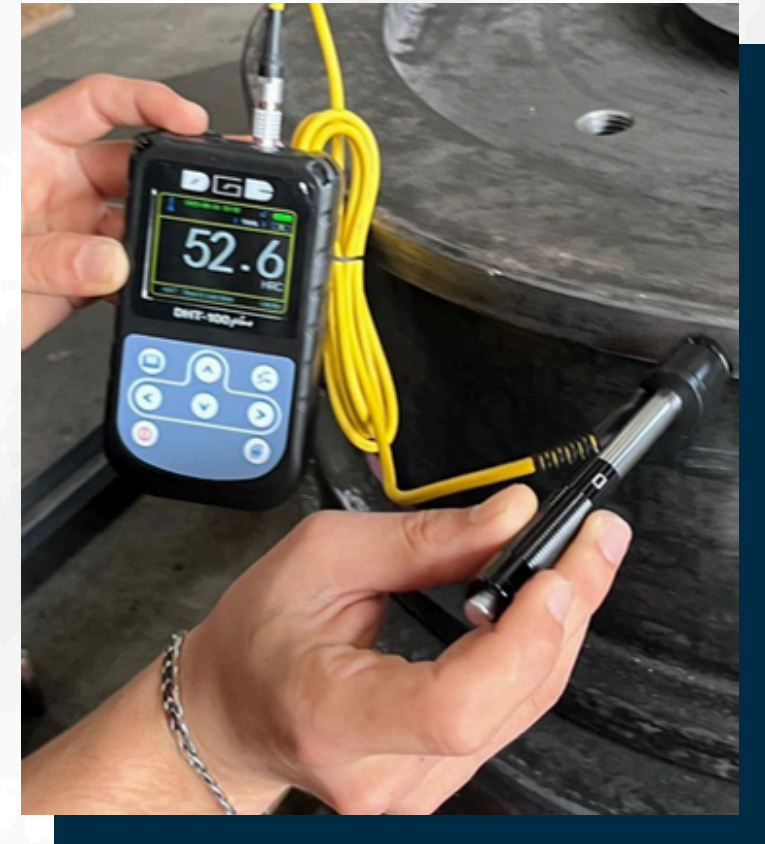


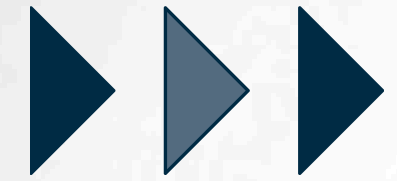


SURFACE CONTROL

Final machining operations are validated through dimensional, mechanical, and functional inspections.

Hardness and surface roughness tests are performed in accordance with project specifications and applicable standards to ensure product reliability, performance, and full compliance before delivery.



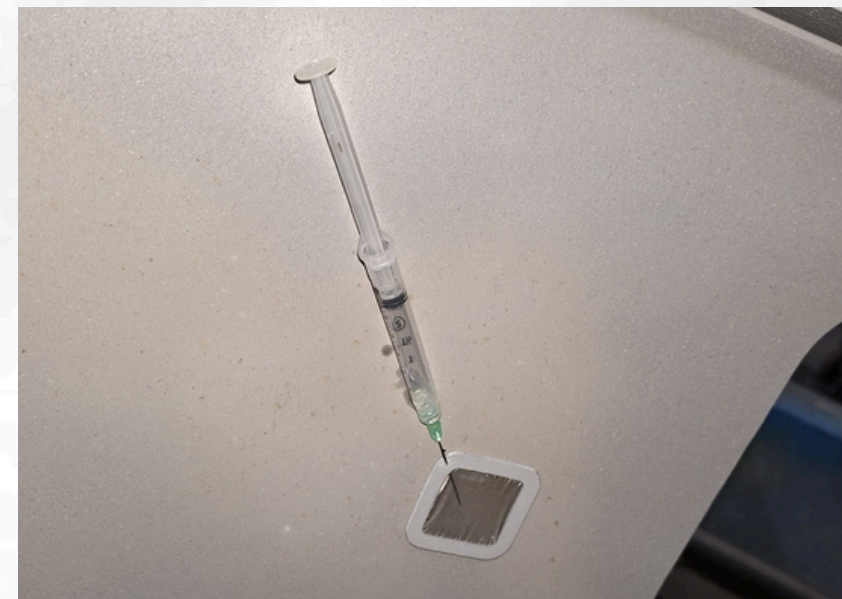
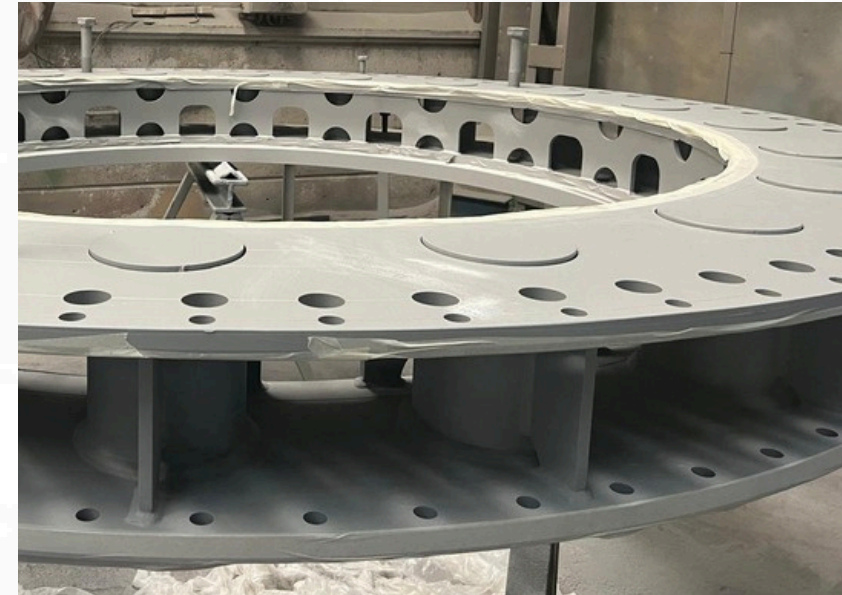


SANDBLASTING

Blasting and coating processes are carried out under controlled environmental conditions (temperature, humidity, and surface conditions) in accordance with the ISO 8501-1 Sa 2.5 surface preparation standard.

After blasting, surfaces are subjected to chloride (salt contamination) testing, dust level checks, and surface profile (Rz) measurements.

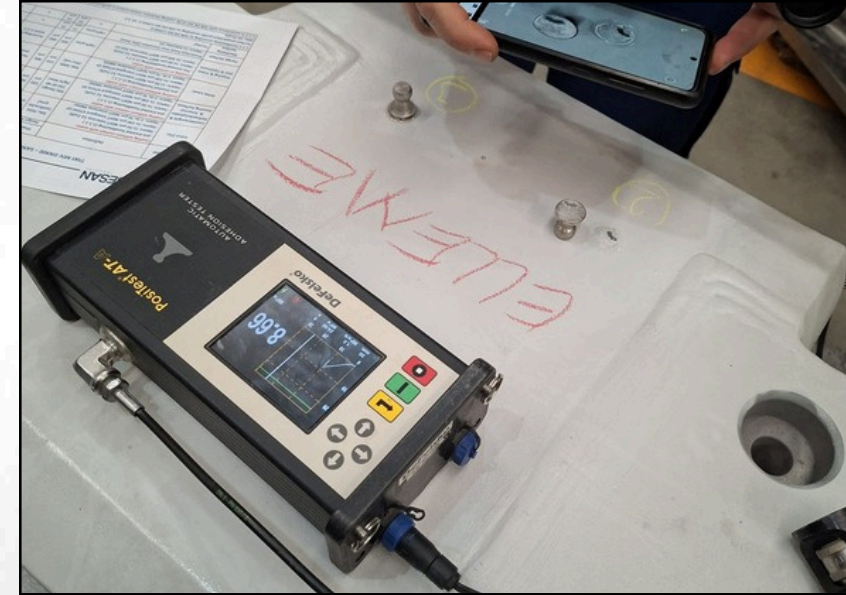
Our in-house blasting and painting facility is equipped with a climate control system to maintain controlled environmental conditions throughout the process.



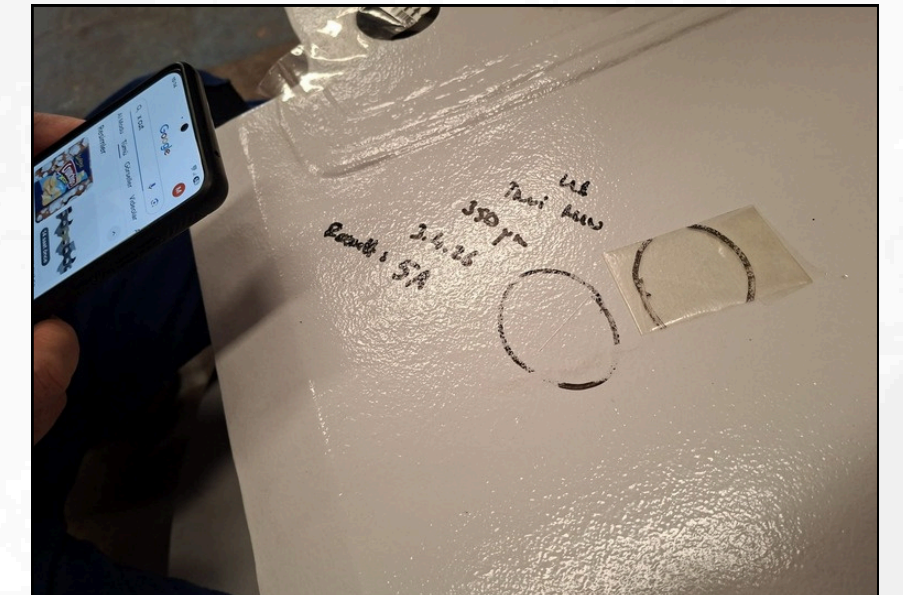
PAINTING

Coating applications are performed in compliance with ISO 12944 requirements. Surface preparation and application conditions are controlled to ensure coating integrity.

After application, coating quality is verified and recorded through DFT (Dry Film Thickness) measurements, adhesion tests (cross-cut / pull-off), holiday testing, and blade tests where applicable. All related forms and test records are maintained throughout the process.



BOYA KONTROL RAPORU											Doküman	
Paint Control Report											Yayın Tarihi	
ORTAM ŞARTLARI VE BOYA BİLGİLERİ											Revizyon	
YALILI CBX ŞASE					Hava Sıcaklığı (°C) / Temperature					Revizyon		
E CBX GİRİŞ ROLL					Bağıl Nem %RH / Relative Humidity					Sayfa No		
GİRİŞ ROLL					Yüzey Sıcaklığı (°C) / Surface Temp.							
					Boya Cinsi / Paint Type					SİSTEM A: Penquard HSP 2		
										SİSTEM B:RAL 5012 – Light		
181120 112 01 00100		BOYA KALINLIK ÖLÇÜMLERİ (µm)										
		1	2	3	4	5	6	7	8	9	10	GEÇERLİLİK
Kuru Film Kalınlık 100µ		90	120	110	100	140	95	120	130	135	115	
Kuru Film Kalınlık 200µ		210	230	190	205	220	230	195	240	200	210	
1.2025												





FINAL ASSEMBLY

Final assembly is carried out in accordance with approved procedures and technical specifications to ensure dimensional accuracy, structural integrity, and operational reliability.

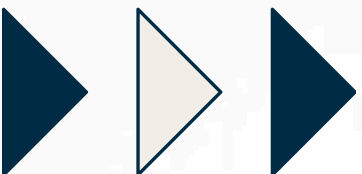
Alignment controls, fit-up inspections, and functional verifications are performed throughout the process.

All assembly activities are documented and fully traceable within the project quality system.

Pressure & Leakage Test

Pressure and leakage tests are conducted using calibrated equipment in accordance with approved procedures and international standards. Hydrostatic and pneumatic testing methods are applied according to design requirements to verify pressure resistance and sealing integrity.

Pressure stability, leakage control, and visual inspection are monitored throughout the test process. All results are recorded and fully traceable through project quality documentation.





FINAL INSPECTION

Prior to shipment, all production and quality records are reviewed to ensure compliance with customer requirements and approved standards. Dimensional and visual inspections are performed, and weld, surface, and assembly quality are verified.

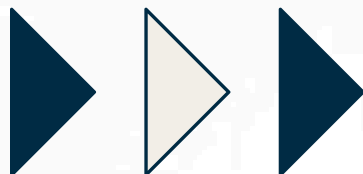
Where required, functional tests and FAT are conducted. Final approval is issued after all inspections are completed, and the product is released for shipment.



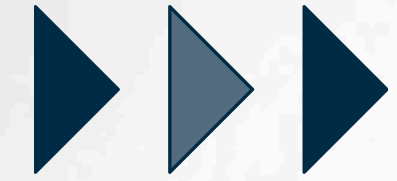
FİNAL KALİTE KONTROL CHECKLIST

Müşteri: Arcelor Mittal Méditerranée
Ürün Adı / Parça Kodu: Confection section 2 TTSF
Sipariş No: PS250905
Kontrol Tarihi: 14.09.2025

No	Kontrol Noktası	Kontrol Yöntemi	Uygun	Uygunsuz	Açıklama
1	Ürün teknik resme uygun mu?	Teknik resim kontrolü	☒	☐	



The prepared quality file serves as technical evidence for all production stages, from raw material procurement to final inspection. The file content includes raw material certificates, in-process inspection forms, destructive/non-destructive testing (NDT) reports, paint thickness measurement forms, and final dimensional inspection data. These intermediate records and comprehensive documentation, meticulously completed at every stage of production, provide our customers with full compliance with international standards and end-to-end traceability assurance.



PACKAGING & SHIPPING

Products that have successfully passed final inspections are packaged in accordance with customer specifications and transportation requirements. Protective materials are used to ensure damage-free delivery, and all shipping documentation is prepared completely and accurately.



Secure Packaging & Shipping for Every Project.

THANK YOU



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