



IND-EXPO CERTIFICATION LIMITED
INTEGRATED MANAGEMENT SYSTEMS CERTIFICATION SCHEME
NON-CONFORMITY REPORT

Name of Organization: N & A Engineering Services (Pvt) Ltd NC No. : 05 of 07
 Section : Management Team Leader : Mr. S C Banamurechhi
 Relevant Standard : ISO 9001:2008 Auditor : —
 Relevant Clause : 7.5.2 Date of audit : 2014-04-29
 Relevant company document : Section 2.2 of Quality Manual

Non-conformity detected

Category : Major/Minor

There is no evidence of specifically identifying special processes referred to in item 17 of Section 2.2 of Quality Manual.

Auditor

Team Leader :

Correction:

special processes identified and records will be maintained

Auditee

Root cause for Non-conformity

Adequate attention has not been paid for the identification of special processes

Auditee

Corrective action proposed/implemented:

Date of completion:

All evidences relevant for identifying special processes were collected and kept those records for future references and will be maintained.

Auditee

2014-05-27

Date

Verification of corrective action

NC Closed/Open

There is evidences of implements the agreed corrective actions

Auditor

2014/08/02

Date

Effectiveness of corrective action

status of implemented corrective actions have been verified and found to be effective

Auditor

2015-07-18

Date



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**STEEL ERECTION & FABRICATION
METHOD STATEMENT**

FOR

PROPOSED 3S FACILITY FOR FORD

AT

HECTOR KOBBEKADUWA MAWATHA, BATTARAMULLA.

BY

**N AND A ENGINEERING SERVICES (PVT) LTD
NO.81B, AVISSAWELLA ROAD,
NAWAGAMUWA, RANALA.**

CONTROLLED
N & A Engineering Services (Pvt) Ltd.

CONTROLLED
N & A Engineering Services (Pvt) Ltd

After reviewing the following processes, we sent for relevant consultant of the project to get the approval before commencing the work.

❖ STEEL ERECTION

1 PURPOSE

Purpose of this method statement is to describe the erection methods, handling techniques, quality assurance and quality inspections to be carried out during the steel erection process.

2 METHOD AND SEQUENCE OF THE WORK

2.1 ERECTION

- The erection of structural steel works will be carried out as per the approved shop drawings and specification given by the structural engineer.

2.1.1 TRANSPORTATION

- Steel will be transported to the site from the fabrication yard part by part as per the erection sequence.
- Special attention will be given to the safety measures during the transportation.

2.1.2 MARKING PLAN

- Each member will be marked according to the location it fits on the site.
- Officer in charge have to verify the markings prior to Transportation.
- Prior to marking material will be cross-checked by the officer in charge.

2.1.3 ERECTION SAFETY

- Utmost care will be taken for the safety during erection process.
- Only the Erectors and officers in charge will be allowed to be in the premises while the material is lifted to the position.

2.1.4 SITE PLANNING

- Necessary Space & firm space will be kept for truck & Crane operations.
- Material unloading & storage will be managed considering the safety & ease of handling.

2.1.5 ERECTION PLAN

- Erection Process will be started in Zone B.
- Columns C31A, C31B, C27, C27A, C24 & C25 will be erected first.
- Then the Major beams UB2, UB3, UB3-A & UB4 will be erected.
- Until the secondary beams are connected, connections will not be bolted totally.
- Then the secondary beams UB5 & UB6 will be erected.
- After the Beam grid is completed, Beams will be aligned and bolted completely.
- Only After the Structural Members are connected firmly, decking sheets will be laid.
- Shear studs & additional reinforcement will be added as per the structural engineer's instruction prior to casting the slab.
- Next Stage will be erection of mezzanine floor.
- As most of the columns span directly up to the roof level, they will be temporarily braced until the member is connected to the portal frame.
- Same as in ground level Slab, Major beams will be erected first and the secondary members will be erected after fixing of major beams.
- Same procedure is carried out in the first floor.
- Then the beams supporting the roof gutters and the roof will be erected.
- After casting the RCC roof gutters, only the roof covering will be installed.

❖ STEEL FABRICATION

1 PURPOSE

Purpose of this method statement is to describe the fabrication methods, welding techniques, quality assurance and quality inspections to be carried out during the steel fabrication process.

2 METHOD AND SEQUENCE OF THE WORK

2.1 FABRICATION

- The fabrication of structural steel works will be carried out as per the approved shop drawings and specification given by the structural engineer.

2.1.1 CUTTING PLANS

- Cutting plan should be prepared prior to commencement of any fabrication work.
- For the purpose of easy identification Material identification numbers will be provided.

2.1.2 MARKING

- Marking will be carried out as per the approved cutting plan.
- Officer in charge have to verify the markings prior to cutting.
- Prior to marking material will be checked for its identification and defects.
- No tolerances will be allowed in marking.

2.1.3 CUTTING

- Cutting edges will be maintained perfectly straight and uniform throughout.
- Cutting edges will be visually examined for laminations and inclusions.
- All corners will be shaped so as to be notch free.
- Sheared or cropped edges will be dressed to make them free from distortion and burrs.



2.1.4 STRAIGHTENING

- If any of the sections are distorted or twisted during transport or storage, they will be straightened under the ambient temperature.
- Some of the minor bends may have to be corrected by limited heating under supervision.

2.1.5 HOLES

- Holes will be created only by drilling.
- After drilling burrs will be removed carefully from the hole edges.
- All holes will be minimum of 1.5 mm larger than the size of the bolt.
- Special care will be taken to maintain necessary edge distances & spaces between adjacent holes.

2.1.6 NOTCHES

- Unless otherwise required, ends of beams and joints will be cut truly square.
- If notches are present, will be kept as small as possible.

2.2 WELDING

2.2.1 EDGE PREPERATION INSPECTION

- Edges or surfaces to be welded will be uniform, smooth and cleaned perfectly.
- Edge preparation will be verified for proper groove angle and root face dimensions.
- Prior to welding, dimension will be checked with shop drawings under tack-welded condition.

2.2.2 FIT UP ASSEMBLY

- Prior to welding operation, members and plates to be welded will fit-up, aligned and retained in position.
- Tack-welds will be used for secure alignment

