


**PRASA PROJECT**



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

# SELF INSPECTION SHEET

**CONFIDENTIAL INFORMATION**

This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

**APPLICATION REFERENCE**


MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY ? 
				TC1	M1	M2	M3	TC2				
<input type="checkbox"/>	DTR31374497/3	AAD0001413329	CARBODYSHELL M2 ASSEMBLY	cb2210				X			PRA.cb2210.DTR313744 97/3.V25	YES
<input type="checkbox"/>												

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to cb2210	APPROVER	Itumeleng Modiba	12/12/2018
			CHECKER	Nosizo Pindela	12/12/2018
			REVISED BY	Ramokone Motama	12/12/2018
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Nfuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	21/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Mohlampe Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Zwane Ntokozo	
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welder traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

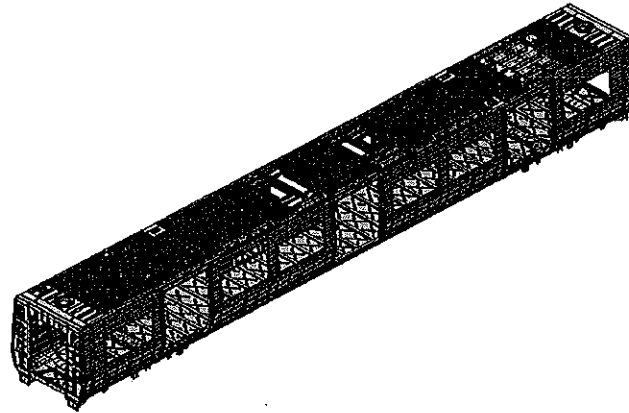
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
233	M2	GERALD / 426957	14/06/24	SI.CB2210.247.V28	17

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	

Car: M2	NCR:	Work station: CB2210
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Safety Related



### I - Documentation and Instruments Control

#### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	S	E	R	B						
DTR31374497/3			K								N/A	14/6/24

#### I.2 - Instruments Control






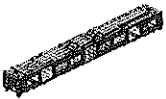




##### Monitoring and Measuring Instrument Control - Used for Special Process


Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	32823-2	15/03/25	✓		14/6/24	
laser tape	125425924	09/01/25	✓		14/6/24	
30M tape	GIBTP0102	18/11/24	✓		14/6/24	

#### 1.3 - Consumables

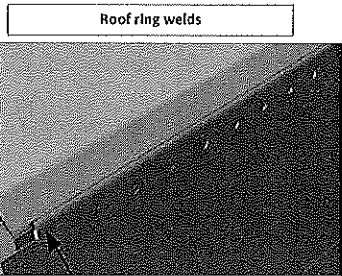
##### Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	314018-74047	MIG	✓		14/6/24	
ER 308 L	299687 70322	TIG	✓		14/6/24	

		<b>CARBODYSHELL M2 ASSEMBLY DTR31374497/3</b>		Rev. 28 Date 07/11/2023	<b>Project: PRASA SI.CB2210.247.V28</b>		
<b>II - Self Inspection - Items to Check</b>							
<b>II.1 - Items to check</b>							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	AA00001375051	✓		P. Masab 06/04/24	 14/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		P. Masab 14/06/24	 14/06/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		P. Masab 14/06/24	 14/06/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		P. Masab 14/06/24	 14/06/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		P. Masab 14/06/24	 14/06/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		P. Masab 14/06/24	 14/06/24
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		P. Masab 14/06/24	 14/06/24

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**Welder traceability**

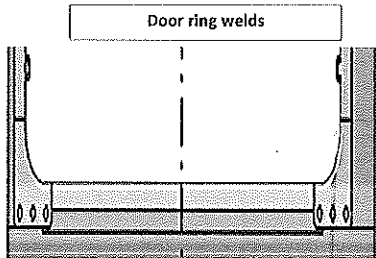


<u>LHS</u>	
Boiler maker (Name & Sign): <u>Justice</u>	Welder (Name & Sign): <u>MTHOKOZISI</u>
<u>RHS</u>	
Boiler maker (Name & Sign): <u>Justice</u>	Welder (Name & Sign): <u>MTHOKOZISI</u>

END 1

<u>LHS</u>	
Boiler maker (Name & Sign): <u>Justice</u>	Welder (Name & Sign): <u>MTHOKOZISI</u>
<u>RHS</u>	
Boiler maker (Name & Sign): <u>Justice</u>	Welder (Name & Sign): <u>MTHOKOZISI</u>

END 2



<u>LHS</u>	
Boiler maker (Name & Sign): <u>Imani</u>	
Welder (Name & Sign): <u>Thabang</u>	

<u>RHS</u>	
Boiler maker (Name & Sign): <u>LAWRENCE</u>	
Welder (Name & Sign): <u>Thabang</u>	



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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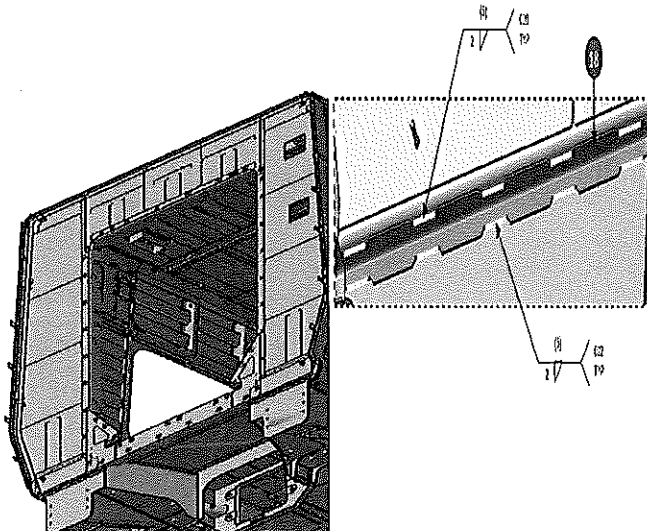
Date

07/11/2023

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SI.C82210.247.V28

EUJ Reinforcement Plates

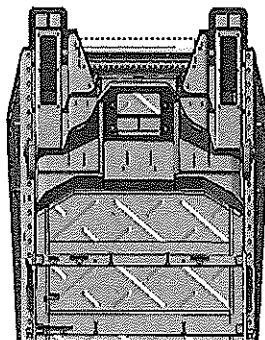


END 1

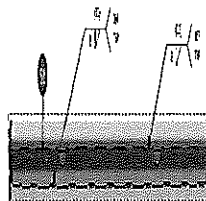
Boiler maker (Name & Sign): Lawrence Mjoko

Welder (Name & Sign): KEITH K. Moko

END 2



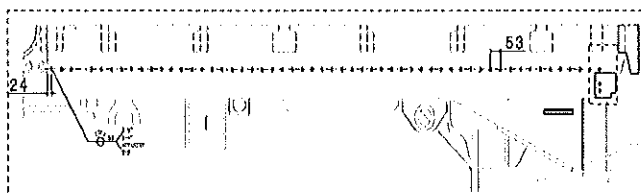
Underneath the CAR



END 2

Boiler maker (Name & Sign): Timothy

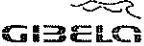
Welder (Name & Sign): SIPHOKAZI

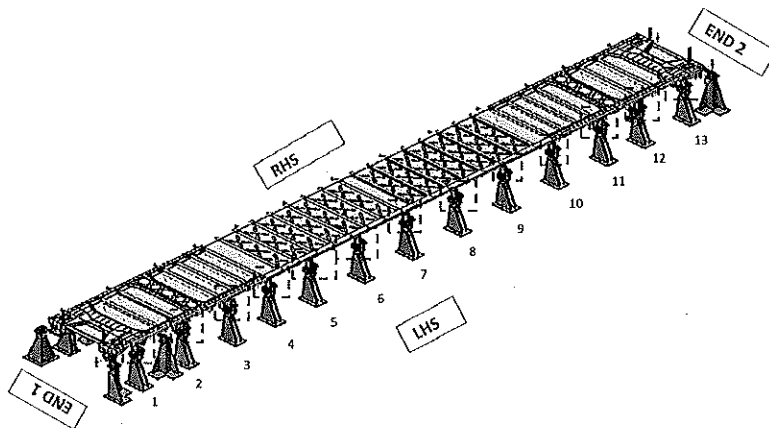


FE00LI

Operator:

BERBERT Moko

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	
Specifications of Details for CBS measurement			




Measure gap between jig pillar / chair and underframe = 0mm. No

After loading and clamping

Fill in the gap foundon each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side						NA							
Right Hand Side													

Signature Operations: 

Date: 08/06/24

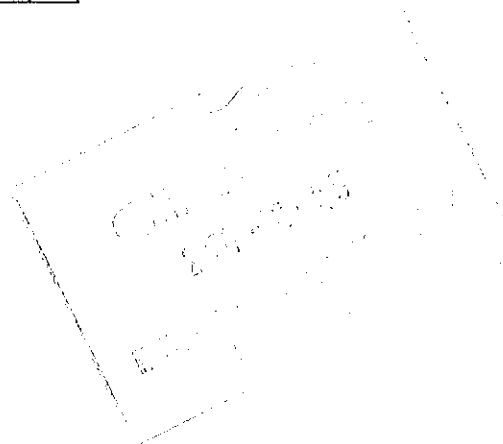
After Welding.

Fill in the gap found each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side				NA									
Right Hand Side													

Signature Industrial Quality: 

Date: 14/06/24





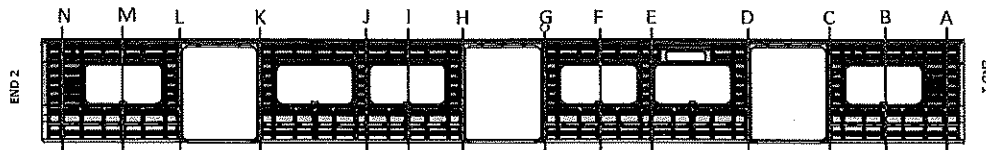
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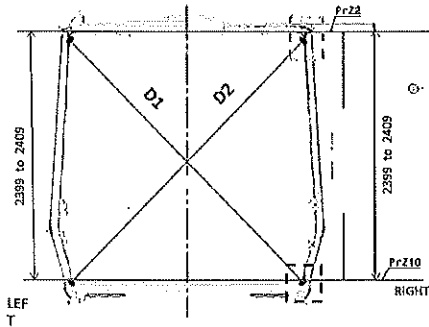
Project: PRASA  
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Date  
07/11/2023

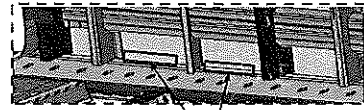
### Specifications of Details for CBS measurement



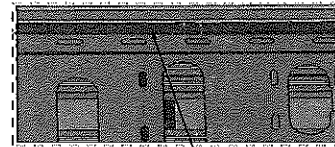
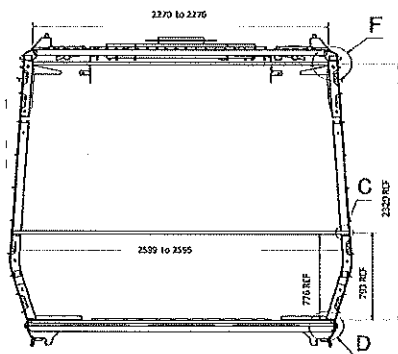
9



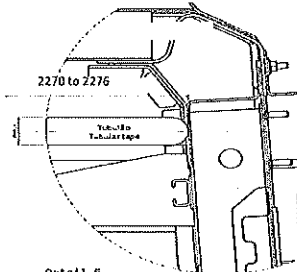
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F

Don't considering the reinforcement



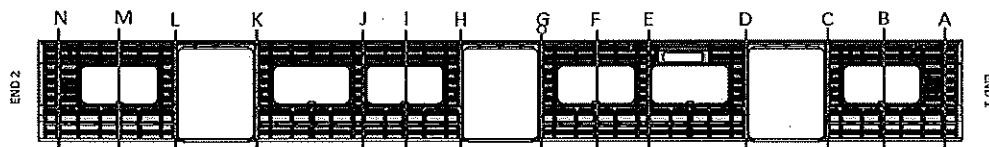
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Specifications of Details for GBS measurement

BEFORE WELDING



Note: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3268	3267	1	2405	2405	0
B	3266	3266	0	2406	2405	1
C	3265	3266	1	2406	2406	0
D	3266	3266	0	2406	2405	1
E	3265	3266	1	2404	2404	0
F	3266	3266	0	2405	2404	1
G	3266	3268	2	2406	2406	0
H	3268	3268	0	2406	2406	0
I	3268	3267	1	2406	2405	1
J	3266	3266	0	2405	2405	0
K	3266	3265	1	2406	2405	1
L	3266	3266	0	2405	2405	0
M	3266	3265	1	2406	2405	1
N	3265	3265	0	2405	2405	0

2018-03-28





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Date

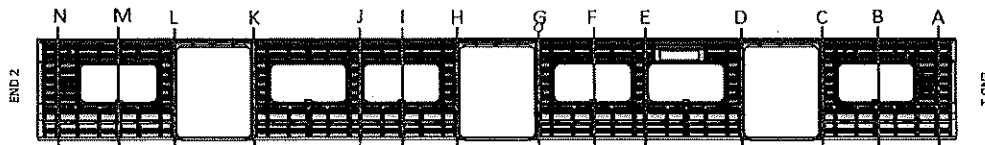
07/11/2023

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## Specifications of Details for CBS measurement

## AFTER WELDING

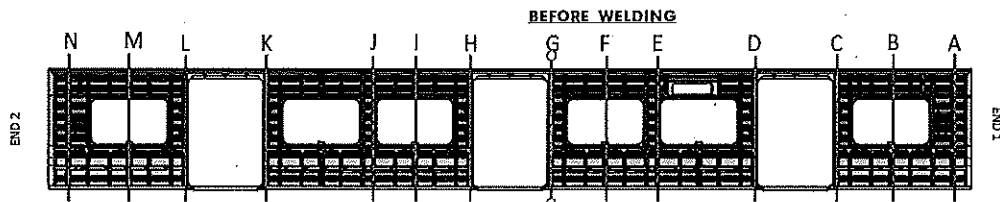


Note: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

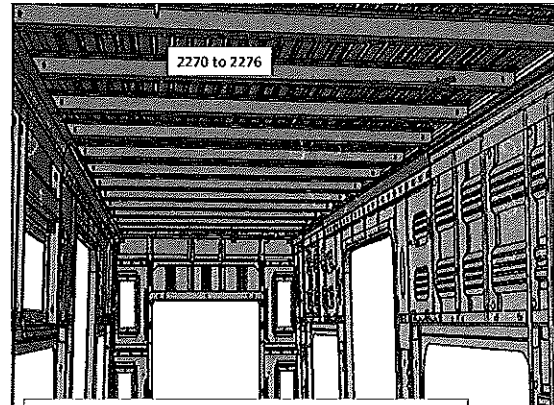
	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3296	3296	0	2406	2405	0
B	3265	3266	1	2406	2405	1
C	3295	3295	0	2405	2405	0
D	3296	3298	1	2404	2404	0
E	3268	3266	2	2405	2405	0
F	3266	3266	0	2405	2406	1
G	3296	3296	0	2406	2406	0
H	3296	3295	1	2405	2405	0
I	3266	3265	1	2406	2406	0
J	3268	3266	2	2405	2405	0
K	3295	3295	0	2405	2405	0
L	3296	3295	1	2406	2405	1
M	3265	3265	0	2404	2405	1
N	3298	3298	0	2405	2405	0

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		07/11/2023	

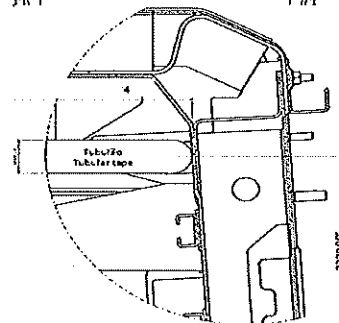
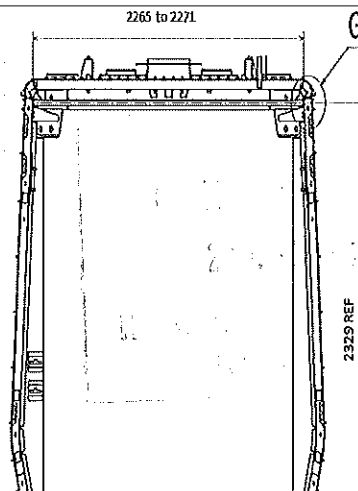
### CBS measurement



	2270 to 2276
A	2272
B	2275
C	2273
D	2274
E	2271
F	2276
G	2274
H	2275
I	2273
J	2272
K	2279
L	2275
M	2273
N	2272

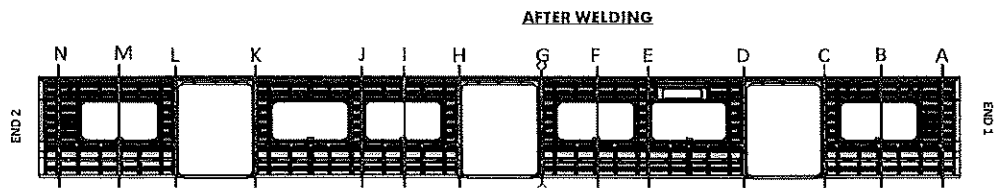


Do not consider reinforcement ( Take measurements top area of zee profile

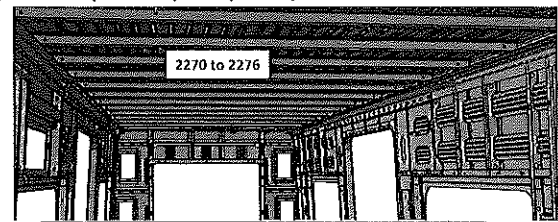


Detail 0

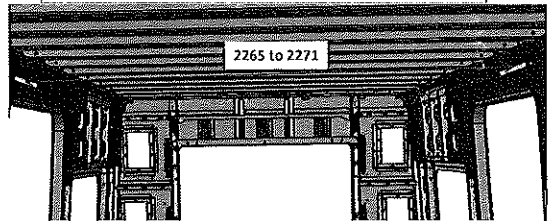
Considering the reinforcement plate



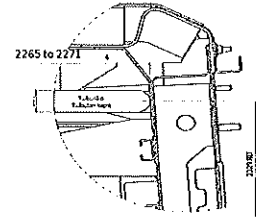
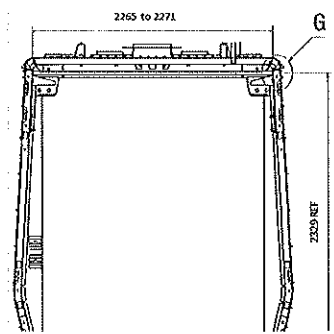
	2265 to 2271	2270 to 2276
A	2269	N/A
B	N/A	2274
C	2270	N/A
D	2271	N/A
E	N/A	2276
F	N/A	2273
G	2270	N/A
H	2269	N/A
I	N/A	2274
J	N/A	2275
K	2271	N/A
L	2270	N/A
M	N/A	2275
N	2269	N/A



Do not consider reinforcement ( Take measurements top area of zee profile



Take measurement close to radius ( considering reinforcement)



Detail G  
Gives the reinforcement place



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

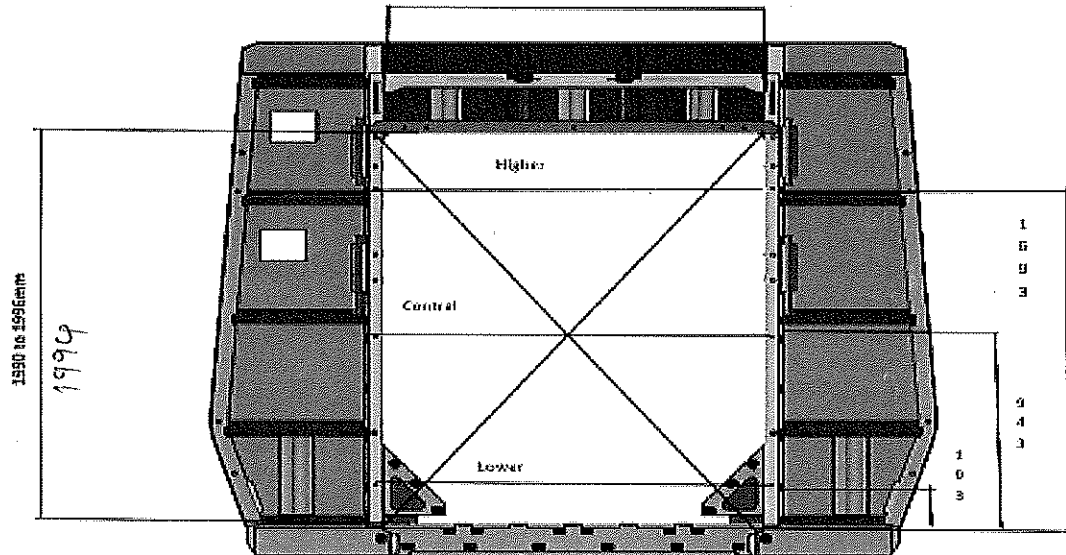
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CBS measurement

End frame 1

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1381

D1

2415

Central Dimension

1380

D2

2415

Lower Dimension

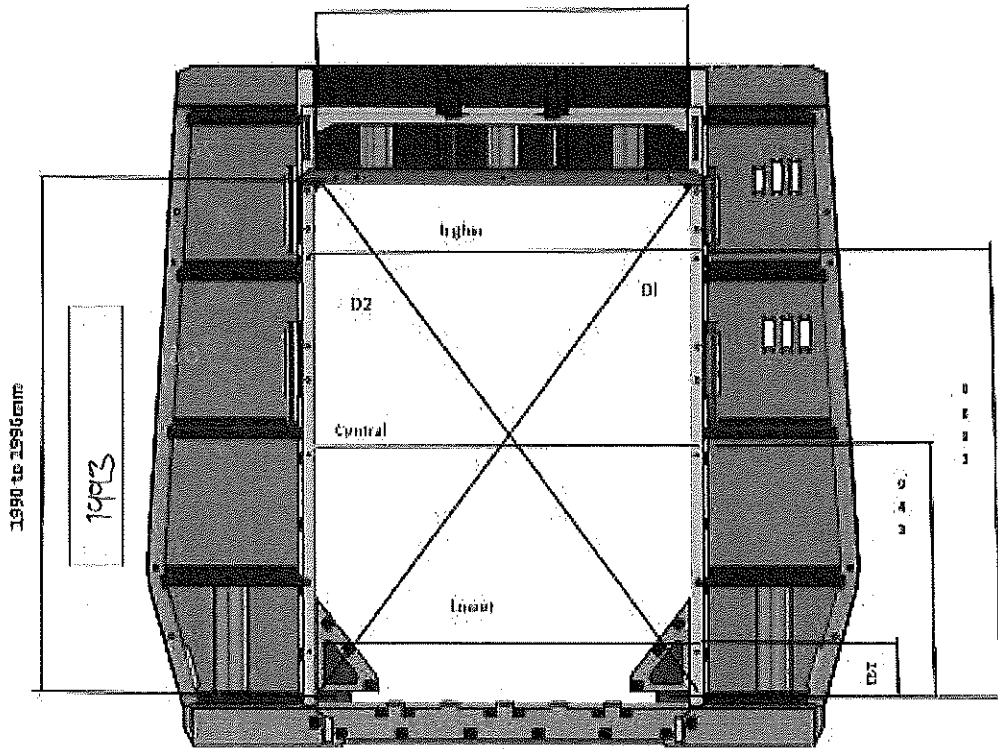
1380

D1-D2

0

Handwritten notes and signatures in the bottom right corner.

End frame 2



1380 to 1382 mm

DIAGONAL DIFFERENCE  $D1-D2 \leq 3\text{mm}$

Higher dimension

1381

D1

2916

Central dimension

1381

D2

2915

Lower dimension


1381

D1-D2



1



[illegible]

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	14/06/20	Gerardo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	14/06/20	Reinmond Industrial Quality	
		NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

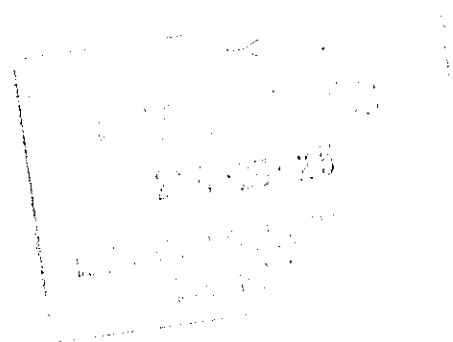
In case of "NO GO", describe blocking problems

In case of "NO GO", the operations manager must define below action plan to ensure "GO":


Item	Description		Responsible	Due date	Status

Operations

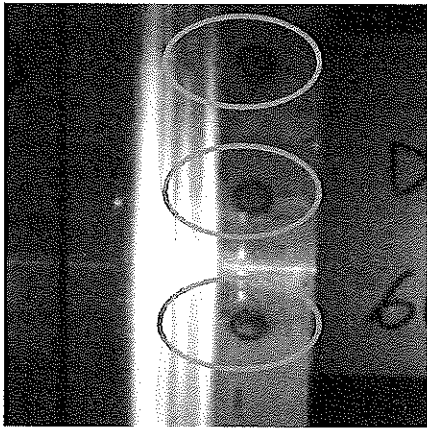
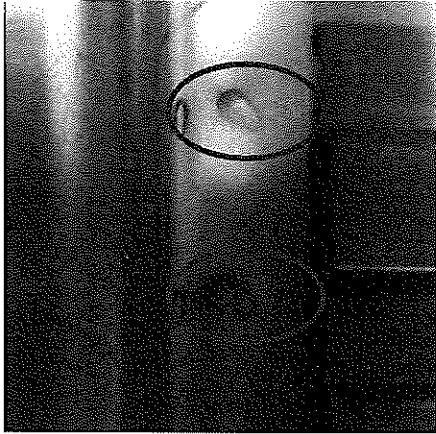
Quality






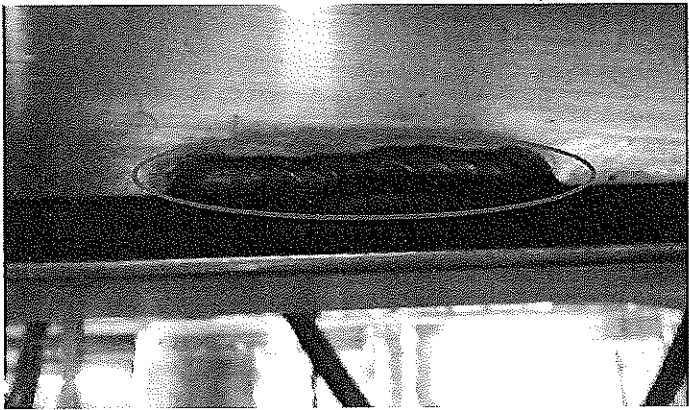
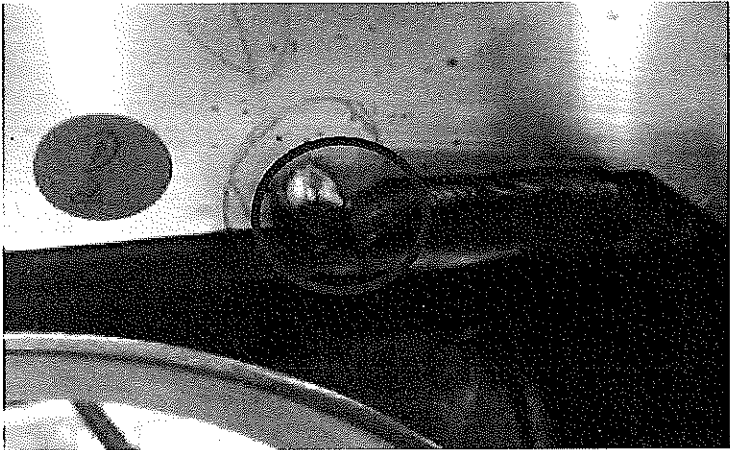
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	


**ANNEXURE A: Spot Welding Quality Acceptance Standard**



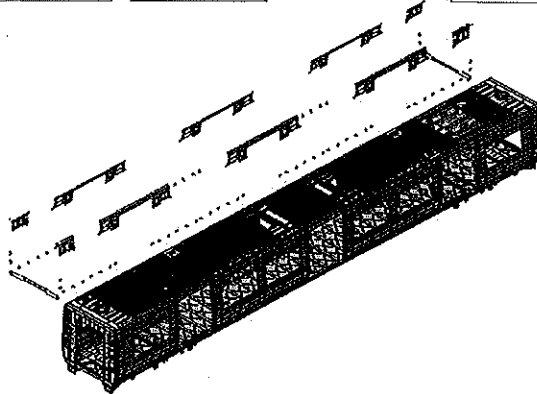









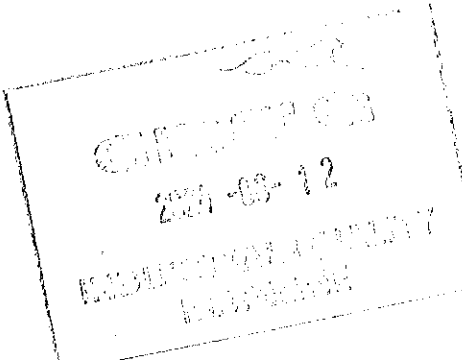
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	


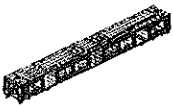
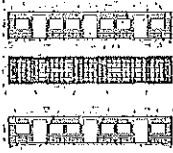
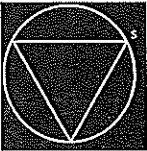
**ANNEXURE B: Arc Welding Quality Acceptance Standard**

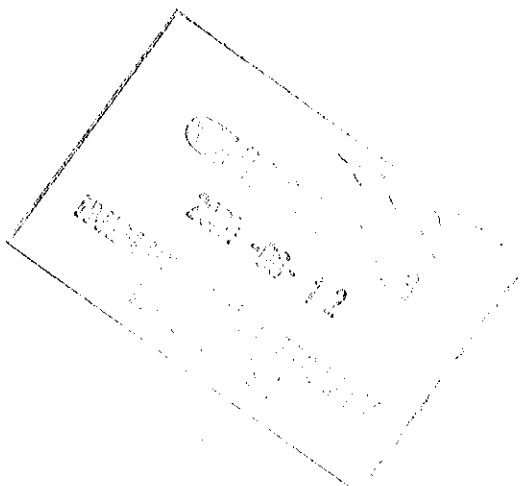



GIBELA		PRASA PROJECT										
												
APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1 <b>SELF INSPECTION SHEET</b>												
<b>CONFIDENTIAL INFORMATION</b> This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.												
APPLICATION REFERENCE												
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY	
				TC1	MA	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR000152655	AAD0001613929	CARBODYSHELL M2 ASSEMBLY	CB2220					X		PRA.CB2220.DTR3137 4497/2.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT		RESPONSIBLE	NAME	DATE						
0	01/02/2018	GIBELA NEW CREATION		APPROVER	Itumeleng Modiba	01/02/2018						
				CHECKER	Nosizo Pindela	01/02/2018						
				COMPILER	Thanyani Mathegu	01/02/2018						
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager		APPROVER	Itumeleng Modiba	18/05/2018						
				CHECKER	Nosizo Pindela	18/05/2018						
				REVISED BY	Ramokone Motama	18/05/2018						
2	2018/07/05	Certain dimensional checks added and others moved to CB1210		APPROVER	Itumeleng Modiba	2018/07/05						
				CHECKER	Nosizo Pindela	2018/07/05						
				REVISED BY	Ramokone Motama	2018/07/05						
3	2018/06/12	Width tolerance as per DT0000336500		APPROVER	Itumeleng Modiba	2018/06/12						
				CHECKER	Nosizo Pindela	2018/06/12						
				REVISED BY	Nosizo Pindela	2018/06/12						
5	24/01/2019	As per Baseline 10.2		APPROVER	Itumeleng Modiba	24/01/2019						
				CHECKER	Nosizo Pindela	24/01/2019						
				REVISED BY	Vanessa Ntuli	24/01/2019						
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove		APPROVER	Itumeleng Modiba	13/03/2019						
				CHECKER	Nosizo Pindela	13/03/2019						
				REVISED BY	Nosizo Pindela	13/03/2019						
7	27/05/2019	Removed measurement positions on the display windows		APPROVER	Itumeleng Modiba	27/05/2019						
				CHECKER	Nosizo Pindela	27/05/2019						
				REVISED BY	Nosizo Pindela	27/05/2019						
10	22/08/2019	New Baseline 10.2.5		APPROVER	Itumeleng Modiba	22/08/2019						
				CHECKER	Nosizo Pindela	22/08/2019						
				REVISED BY	Nosizo Pindela	22/08/2019						
15	06/08/2020	New Baseline 10.2.6		APPROVER	Timothy Maimela	06/08/2020						
				CHECKER	Bongane Masina	06/08/2020						
				REVISED BY	Bongane Masina	06/08/2020						
20	19/04/2021	New Baseline change 10.3		APPROVER	Timothy Maimela	19/04/2021						
				CHECKER	Bongane Masina	19/04/2021						
				REVISED BY	Bongane Masina	19/04/2021						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING		APPROVER	Mthembu Collins	17/08/2021						
				CHECKER	Mpho Mulaudzi	17/08/2021						
				REVISED BY	Mpho Mulaudzi	17/08/2021						
25	20/02/2022	New Baseline change 10.3.1		APPROVER	Mbhombhisi Collins	20/02/2022						
				CHECKER	Andani Muthelo	20/02/2022						
				REVISED BY	Andani Muthelo	20/02/2022						
26	14/06/2022	Update minimum temperature requirement for sealant application		APPROVER	Mbhombhisi Collins	14/06/2022						
				CHECKER	Andani Muthelo	14/06/2022						
				REVISED BY	Andani Muthelo	14/06/2022						
27	17/10/2022	Addition of traceability for sealant application and welding.		APPROVER	Mbhombhisi Collins	17/10/2022						
				CHECKER	Ntokozi Zwane	17/10/2022						
				REVISED BY	Amogelang Moflampe	17/10/2022						
28	14/04/2023	Added sealant batch number & welding consumables traceability		APPROVER	Vanessa Ntuli	14/04/2023						
				CHECKER	Ntokozi Zwane	14/04/2023						
				REVISED BY	Amogelang Moflampe	14/04/2023						
29	28/10/2023	Addition of bracket quantity		APPROVER	Ngobeni Tyson	28/10/2023						
				CHECKER	Mathapo Kelebone	28/10/2023						
				REVISED BY	Moflampe Amogelang	28/10/2023						
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES							
233	M02	11/04/2024 70877	15-06-24	SI.CB2220.276.V29	15							

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA																							
		29																								
		Date	SI.CB2220.276.V29																							
28/10/2023																										
Car: M2	NOR:	Work station:	CB2220																							
 Safety Related																										
																										
<b>I - Documentation and Instruments Control</b>																										
<b>I.1 - Documentation Control</b>																										
Document	Type of car	Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																				
DTR31374497/2	<table border="1"> <tr> <th>1</th> <th>2</th> <th>3</th> <th>4</th> <th>5</th> <th>6</th> <th>7</th> <th>8</th> <th>9</th> <th>10</th> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	1	2	3	4	5	6	7	8	9	10											29	28-10-2023	X	N/A	 15/06/24 15-06-24
1	2	3	4	5	6	7	8	9	10																	
<b>I.2 - Instruments Control</b>																										
Monitoring and Measuring Instrument Control - Used for Special Process																										
Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)																				
Tubular	52823	15/03/2025	X		 15-06-24	 15/06/24																				
measuring tape	6710710021	17/04/2025	X		 15-06-24	 15/06/24																				
<b>I.3 Consumables</b>																										
Welding Consumable Control - Used for Special Process																										
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)																				
308	52475719	MIG	X		 15-06-24	 15/06/24																				



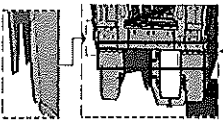

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 28	Project: PRASA											
		Date 28/10/2023	SI.CB2220.276.V29											
		II - Self Inspection - Items to Check												
II.1 - Items to check														
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)								
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220. DTR31374497/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220. DTR31374497/2	✓	15-06-24	15/06/24								
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTDC0000210675	✓	15-06-24	15/06/24								
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	15-06-24	15/06/24								
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	15-06-24	15/06/24								
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓	15-06-24	15/06/24								
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTDC0000210658.	As the welding procedure IND-SAL-WMS-018 and DTDC0000210658	✓	15-06-24	15/06/24								
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions <table border="1"> <tr> <th colspan="2">Specified</th> </tr> <tr> <td>Temperature Min - Max (°C)</td> <td>Min-Max</td> </tr> <tr> <td>Relative humidity 24h - Max (%)</td> <td>24h - Max</td> </tr> <tr> <td></td> <td>COX.</td> </tr> </table>	Specified		Temperature Min - Max (°C)	Min-Max	Relative humidity 24h - Max (%)	24h - Max		COX.	Sealant Batch No: 83491 Exp Date: 01/06/24 Actuals Temperature: 18°C Humidity: 40%	✓	15-06-24	15/06/24
Specified														
Temperature Min - Max (°C)	Min-Max													
Relative humidity 24h - Max (%)	24h - Max													
	COX.													
08	NA	Verification of sealant application in certain regions in the drawing	AAD00001413329	✓	15-06-24	15/06/24								



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	



SEALANT APPLICATION



  


AREA 1 & 2 END 1

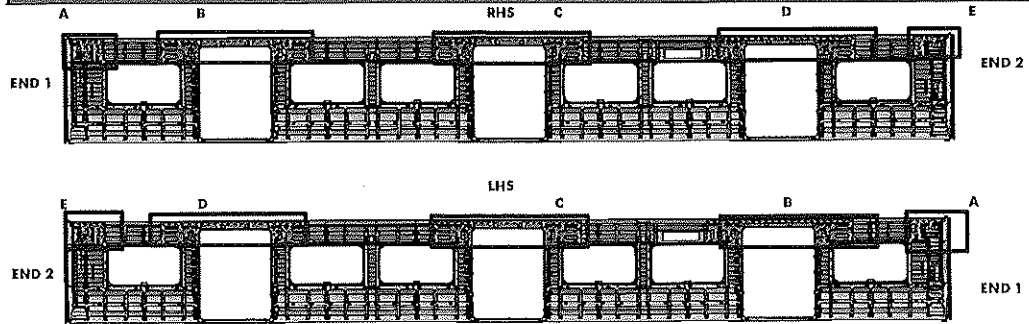
Operator (Name & sign): *Priscilla*

Operator (Name & sign): *Priscilla*

  
2023-03-12  


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRA5A SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	


**II - Self Inspection - Items to Check**



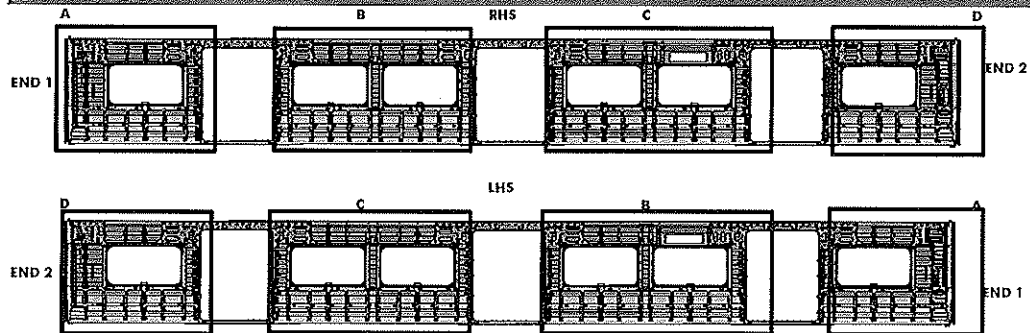
**REINFORCEMENT WELDING**

AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDA [signature]</u>	<u>[signature]</u>
B	Operator (Name&sign): <u>LINDA [signature]</u>	<u>[signature]</u>
C	Operator (Name&sign): <u>[signature]</u>	<u>MONTENEGRO [signature]</u>
D	Operator (Name&sign): <u>[signature]</u>	<u>[signature]</u>
E	Operator (Name&sign): <u>[signature]</u>	<u>[signature]</u>



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		28	
		Date	SI.CB2220.276.V29
		28/10/2023	

**II - Self Inspection - Items to Check**



**BRACKETING**

**INSTALLATION**

C-RAILS: Operator: Asad DA

Operator: \_\_\_\_\_

DOOR MECHANISMS: Operator: [Signature]

Operator: \_\_\_\_\_

TAPPING PADS Operator: MATSUOKA Man End 2

Operator: \_\_\_\_\_

**INSTALLATION & VERIFICATION**

SEAT & LUGGAGE BRACKETS: Operator: Mashud Mashud

Operator: \_\_\_\_\_

SEAT BRACKETS VERIFICATION: Operator: Mashud Mashud

Operator: \_\_\_\_\_

**WELDING**

**AREA**

**LHS**

A (Seat brackets) : Operator (Name&sign): LINDO

(C-rails, Luggage and earth bushes) : Operator (Name&sign): LINDO

B (Seat brackets) : Operator (Name&sign): MATSUOKA Man / LINDO

(C-rails, Luggage and earth bushes) : Operator (Name&sign): LINDO

C (Seat brackets) : Operator (Name&sign): [Signature] / MATSUOKA Man

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]

D (Seat brackets) : Operator (Name&sign): [Signature]

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]

**RHS**

A (Seat brackets) : Operator (Name&sign): LINDO

(C-rails, Luggage and earth bushes) : Operator (Name&sign): LINDO

B (Seat brackets) : Operator (Name&sign): MATSUOKA Man / LINDO

(C-rails, Luggage and earth bushes) : Operator (Name&sign): LINDO

C (Seat brackets) : Operator (Name&sign): [Signature] / MATSUOKA Man

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]

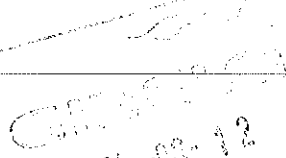
D (Seat brackets) : Operator (Name&sign): [Signature]

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]


**ENDS**

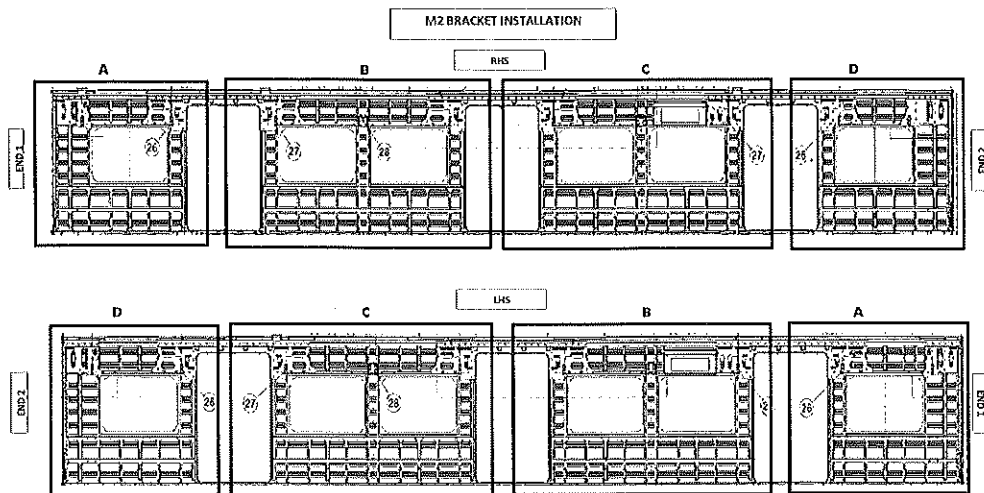
END 1 TAPPING PADS WELDING: Operator (Name&sign): Jolly

END 2 TAPPING PADS WELDING: Operator (Name&sign): MATSUOKA Man

  
2023-08-12  
12:00:00, 12:00:00  
12:00:00



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project PRASA
		29	
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RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	8		
	B	8		
	C	8		
	D	2		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	2		
	B	4		
	C	6		
	D	3		

**ROOF ENDS:**

CRAILS 2 OFF EACH END

EARTH BUSH 6 OFF EACH END

VERIFICATION BY: ASAMIDA 


LHS

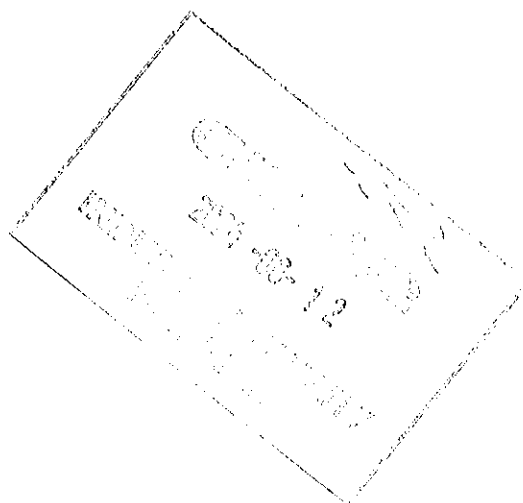
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	9		
	B	11		
	C	11		
	D	12		
SEAT BRACKETS	A	12		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	8		
	D	2		

**ROOF ENDS:**

CRAILS 2 OFF EACH END

EARTH BUSH 6 OFF EACH END

VERIFICATION BY: ASAMIDA 



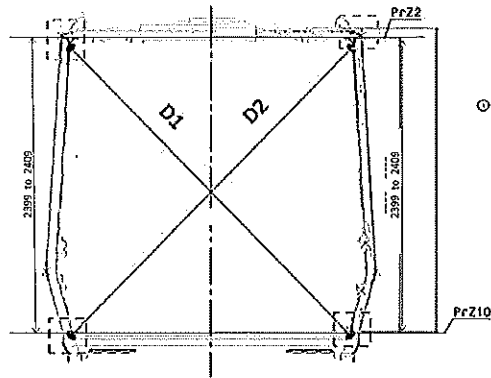


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

Rev.  
29  
Date  
28/10/2023

Project: PRASA

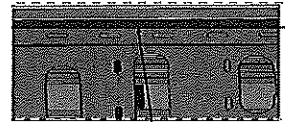
SI.CB2220.276.V29



Q



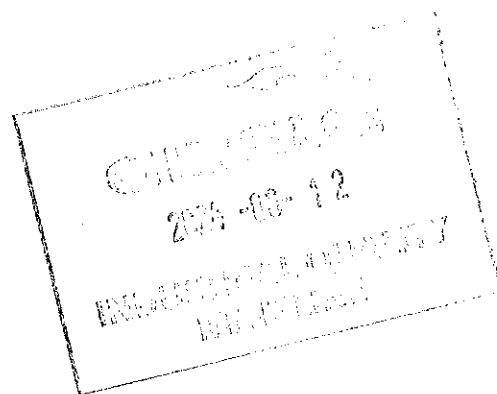
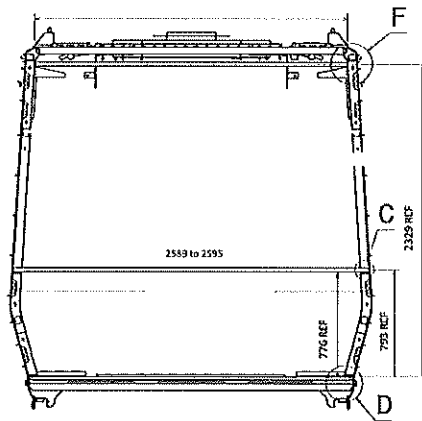
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



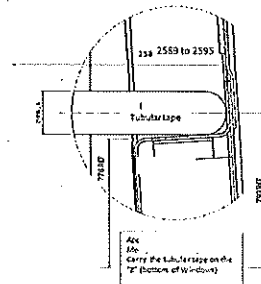
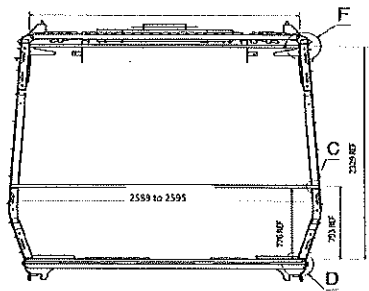


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

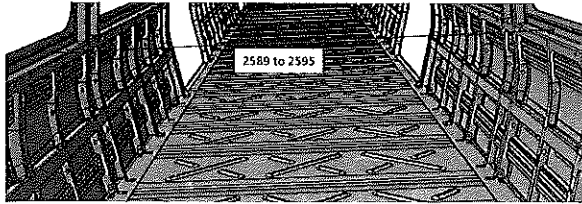
Rev.  
28  
Date  
28/10/2023

Project: PRASA

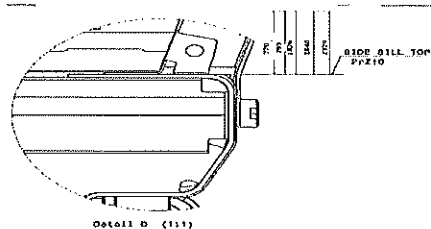
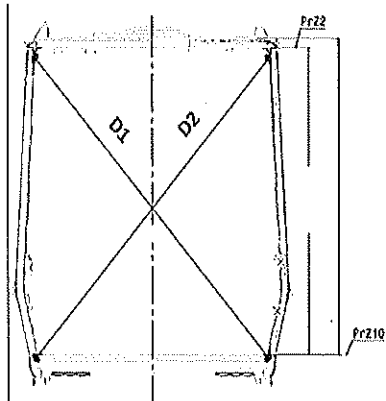
SI.CB2220.276.V29



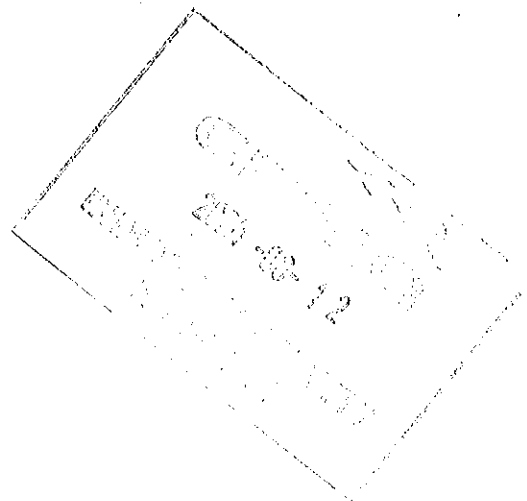
Detail C

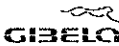
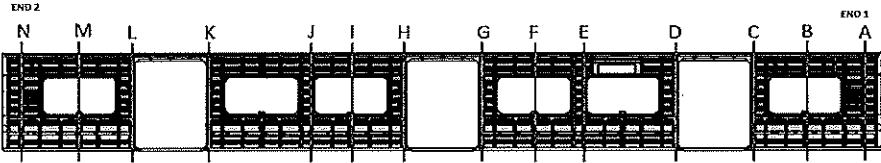


Take measurement close to  
radius




Detail D (1:1)




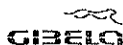
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		29	
		Date	
		28/10/2023	
CBS measurement			
			

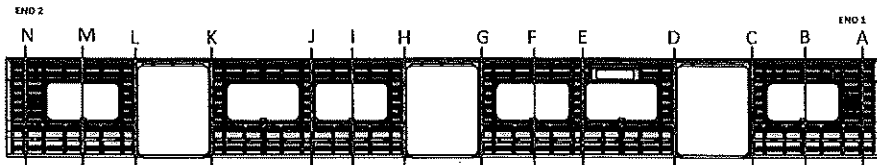
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3297	3299	0	—
B	3262	3265	3	—
C	3294	3294	0	—
D	3296	3293	3	—
E	3264	3267	3	—
F	3263	3264	1	—
G	3296	3297	2	—
H	3296	3294	2	—
I	3266	3266	0	—
J	3266	3265	1	—
K	3299	3292	7	—
L	3298	3293	5	—
M	3270	3263	7	—
N	3298	3298	0	—

  
15-06-24

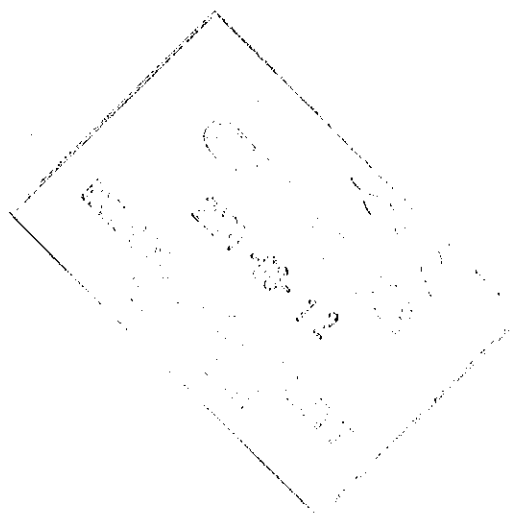
  
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15-11-12

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 29	Project: PRASA  SI.CB2220.276.V29
		Date 28/10/2023	
		CBS measurement	

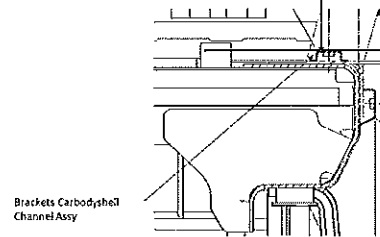
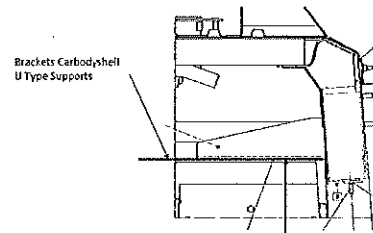
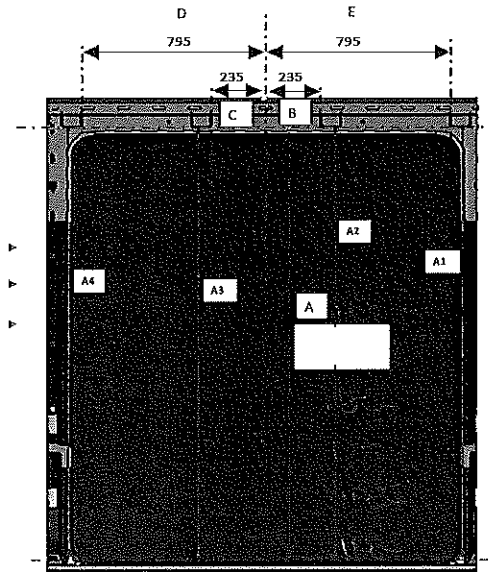
  


AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3294	1	2594
B	3264	3260	4	2591
C	3291	3293	2	2589
D	3276	3297	1	2589
E	3261	3264	3	2591
F	3264	3260	0	2591
G	3294	3294	0	2589
H	3294	3294	0	2589
I	3263	3264	1	2592
J	3264	3268	4	2594
K	3299	3292	7	2589
L	3294	3300	6	2591
M	3269	3262	7	2595
N	3298	3295	3	2595



Specifications of Details for CBS measurement CB1220



DOOR 1 - LHS		
	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	794

DOOR 2 - LHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	795

DOOR 3 - LHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

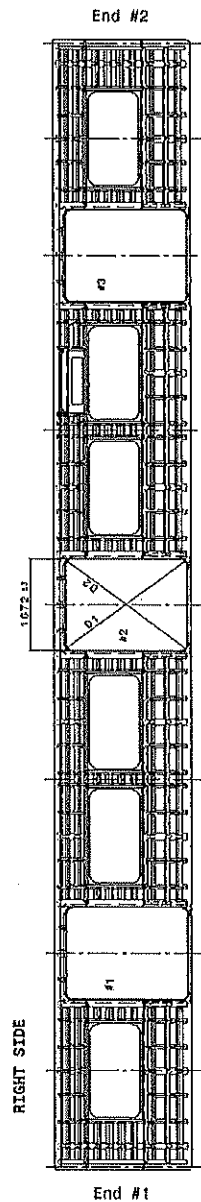
DOOR 1 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

DOOR 2 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

DOOR 3 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2234
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	234
C	234 to 236	235
D	794 to 796	794
E	794 to 796	796

2023-10-28 12:00:00  
2023-10-28 12:00:00  
2023-10-28 12:00:00

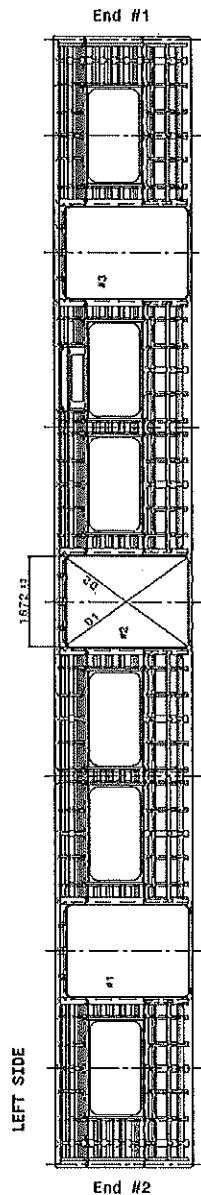
Specifications of Details for CB5 measurement CB1220



Doors diagonal D1-D2 maximum difference  $\leq 4\text{mm}$

	#1	#2	#3
D1	2748	2747	2745
D2	2746	2746	2744
D1-D2	2	1	1

Doors length - 1672 $\pm 3\text{mm}$			
	#1	#2	#3
HIGHER DIMENSION	1673	1674	1673
CENTRAL DIMENSION	1673	1672	1672
LOWER DIMENSION	1672	1671	1671



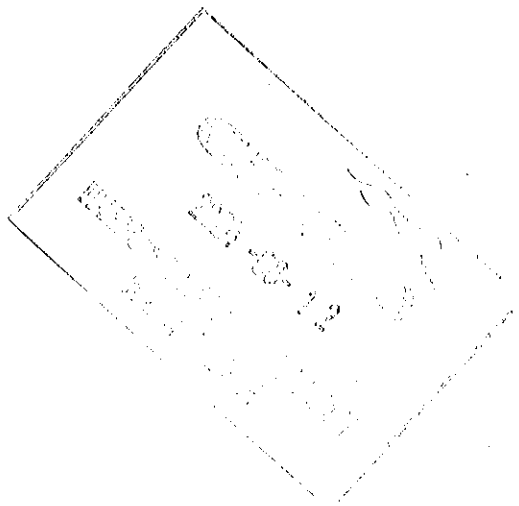
Vão de Portas - 1672  $\pm 3\text{mm}$

Vão de Portas - 1672 $\pm 3\text{mm}$			
	#1	#2	#3
DIENSÃO SUPERIOR HIGHER DIMENSION	1674	1672	1673
CENTRAL DIMENSION	1673	1672	1673
LOWER DIMENSION	1671	1671	1671

4mm



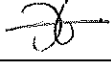
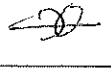
	#1	#2	#3
D1	2746	2745	2746
D2	2745	2745	2743
D1-D2	1	0	2

1672-3mm






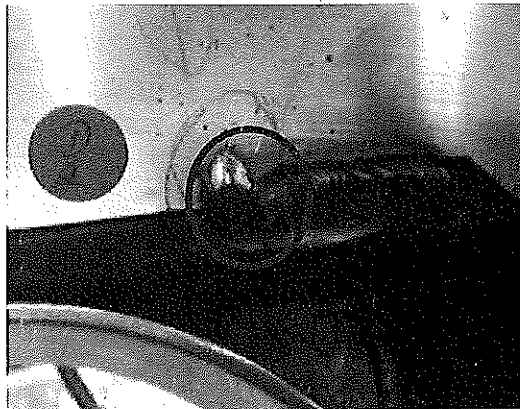




	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA		
		29			
		Date	SI.CB2220.276.V29		
		28/10/2023			
Self Inspection - Final Result					
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If facilities are not complete, the missing activities must not impact the next stage)	15-06-24	ASAP-DA	
		Every audit inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	19/06/24	Arndani	
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)	15/06/24	Arndani	
In case of "NO GO", describe blocking problems missing luggage brackets					
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description	Responsible	Due date	Status	
		<div style="display: flex; justify-content: space-between;"> <div>Operations</div> <div>Quality</div> </div>			



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	

**ANNEXURE A: Arc Welding Quality Acceptance Standard**



GIBELA		PRASA PROJECT										
												
APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1 <b>SELF INSPECTION SHEET</b>												
<b>CONFIDENTIAL INFORMATION</b> This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.												
APPLICATION REFERENCE												
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 	
				TC1	MA	M1	M2	M3	TC2			
<input type="checkbox"/>	AA00001374497	AA00001413329	CARBODYSHELL M2 ASSEMBLY	CB1230				X			PRA.CB1230.AA00001374497.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT			RESPONSIBLE		NAME		DATE			
0	2018/08/02	GIBELA NEW CREATION			APPROVER	Phlpe Marques			2018/08/02			
					CHECKER	Nosizo Pindela			2018/08/02			
					COMPILER	Nosizo Pindela			2018/08/02			
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager			APPROVER	Itumeleng Modiba			30/5/2018			
					CHECKER	Nosizo Pindela			30/5/2018			
					REVISED BY	Nosizo Pindela			30/5/2018			
2	2018/05/07	Certain dimensional checks moved to CB1220			APPROVER	Itumeleng Modiba			2018/05/07			
					CHECKER	Nosizo Pindela			2018/05/07			
					REVISED BY	Ramokone Motama			2018/05/07			
5	24/01/2019	As per Baseline 10.2			APPROVER	Itumeleng Modiba			24/01/2019			
					CHECKER	Nosizo Pindela			24/01/2019			
					REVISED BY	Vanessa Ntuli			24/01/2019			
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements			APPROVER	Itumeleng Modiba			13/03/2019			
					CHECKER	Nosizo Pindela			13/03/2019			
					REVISED BY	Vanessa Ntuli			13/03/2019			
10	23/03/2019	New Baseline 10.2.5			APPROVER	Itumeleng Modiba			23/03/2019			
					CHECKER	Nosizo Pindela			23/03/2019			
					REVISED BY	Nosizo Pindela			23/03/2019			
	06/08/2020	New Baseline 10.2.6			APPROVER	Timothy Maimela			06/08/2020			
					CHECKER	Bongane Masina			06/08/2020			
					REVISED BY	Bongane Masina			06/08/2020			
20	19/04/2021	New Baseline change 10.3			APPROVER	Timothy Maimela			19/04/2021			
					CHECKER	Bongane Masina			19/04/2021			
					REVISED BY	Bongane Masina			19/04/2021			
25	20/02/2022	New Baseline change 10.3.1			APPROVER	Collins Mbombhli			20/02/2022			
					CHECKER	Andani Muthelo			20/02/2022			
					REVISED BY	Andani Muthelo			20/02/2022			
26	14/06/2022	Update minimum temperature requirement for sealant application			APPROVER	Collins Mbombhli			14/06/2022			
					CHECKER	Andani Muthelo			14/06/2022			
					REVISED BY	Andani Muthelo			14/06/2022			
27	26/07/2022	Threshold measurement addition			APPROVER	Collins Mbombhli			27/07/2022			
					CHECKER	Andani Muthelo			27/07/2022			
					REVISED BY	Andani Muthelo			27/07/2022			
28	17/10/2022	Addition of traceability for sealant application			APPROVER	Collins Mbombhli			17/10/2022			
					CHECKER	Ntokozo Zwane			17/10/2022			
					REVISED BY	Amogelang Mohlampe			17/10/2022			
29	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER	Vanessa Ntuli			14/04/2023			
					CHECKER	Ntokozo Zwane			14/04/2023			
					REVISED BY	Amogelang Mohlampe			14/04/2023			
30	06/11/2023	Added traceability on thresholds for boiler makers and welders			APPROVER	Ngobeni Tyson			06/11/2023			
					CHECKER	Andani Muthelo			06/11/2023			
					REVISED BY	Ntokozo Zwane			06/11/2023			
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER			PAGES				
233	1102	Exilumelo 426763		18/06/24	SI.CB1230.277.V29			11				



CARBODYSHELL M2 ASSEMBLY AA00001374497

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Car:

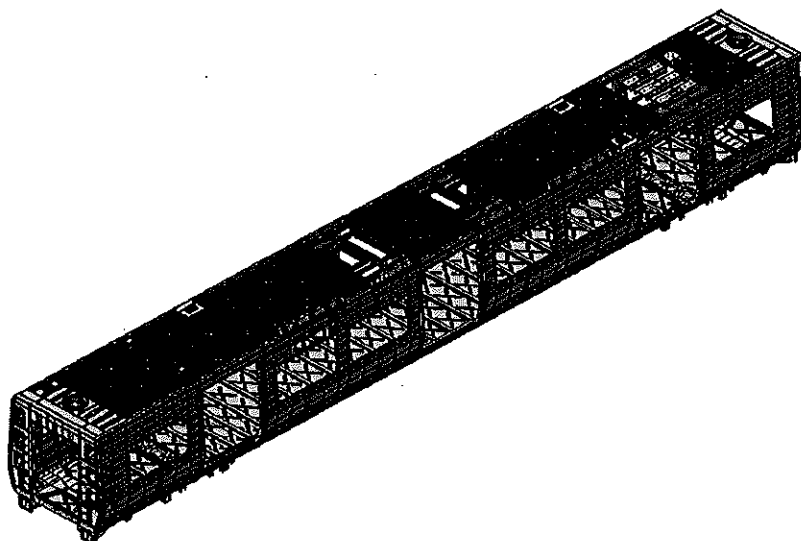
NCR:

Work station:

CB1230



Safety Related



## I - Documentation and Instruments Control

## I.1 - Documentation Control

Document	Type of car						Revision	Obsevation	OK	NOK	REWORK	Signature/Date (Operations)	Signature/Date (Quality)
	T01	M1	M2	M3	M4	T02							
PRA.CB1230.AA00001374497			X				29		X		N/A	WMDIST 18/06/24	15/06/24

## I.2 - Instruments Control

## Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Combination Square	GBS00100	27/07/2024	X		WMDIST 18/06/24	15/06/24
Caliper	3223-3	16/03/2024	X		WMDIST 18/06/24	15/06/24
Measuring Tape	GBTA0401	2024/04/22	X		WMDIST 18/06/24	15/06/24

## 1.3 Consumables

## Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	373779	Mig welding	X		WMDIST 18/06/24	15/06/24



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## II - Self Inspection - Items to Check

## II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.AA00001374497 Verification of filament for all brackets.	PRA.CB1230.AA00001374497	X			 18/06/24	 15/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X			 18/06/24	 15/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	X			 18/06/24	 15/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	X			 18/06/24	 15/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	X			 18/06/24	 15/06/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	X			 18/06/24	 15/06/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 80%	Sealant Batch No: B51321-F02 Exp Date: 04 / 08 / 24 Actuals Temperature: 15°C Humidity: 68%	X			 18/06/24	 15/06/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	X			 18/06/24	 15/06/24



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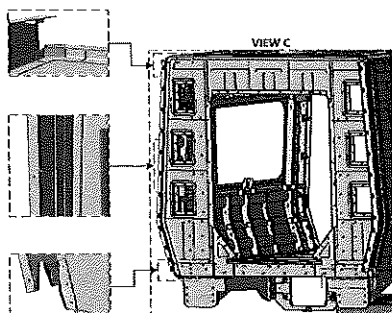
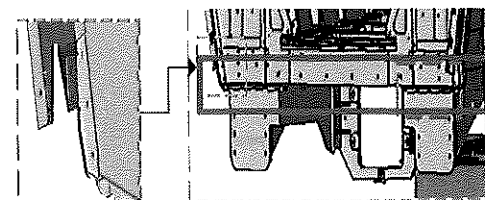
Date

06/11/2023

Project: PRASA

SI.CB1230.277.V29

## AREA 1



## END 2 SEALANT

OPERATOR  
(Name & sign):

Leroy

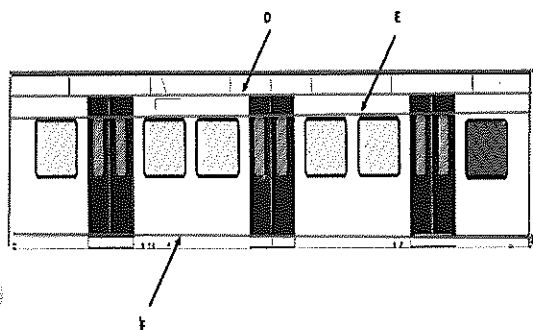
OPERATOR  
(Name & sign):

Leroy

OPERATOR  
(Name & sign):

Leroy

H



Area D,E,F,G,H,I

Operator (Name &amp; sign):

LHS

D,E,F,G,H,I

RHS

D,E,F,G,H,I

Operator (Name &amp; sign):

Pierato

Sihle

Operator (Name &amp; sign):

Operator (Name &amp; sign):

Nonibanda

Tshenolo

Operator (Name &amp; sign):

Operator (Name &amp; sign):



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Date

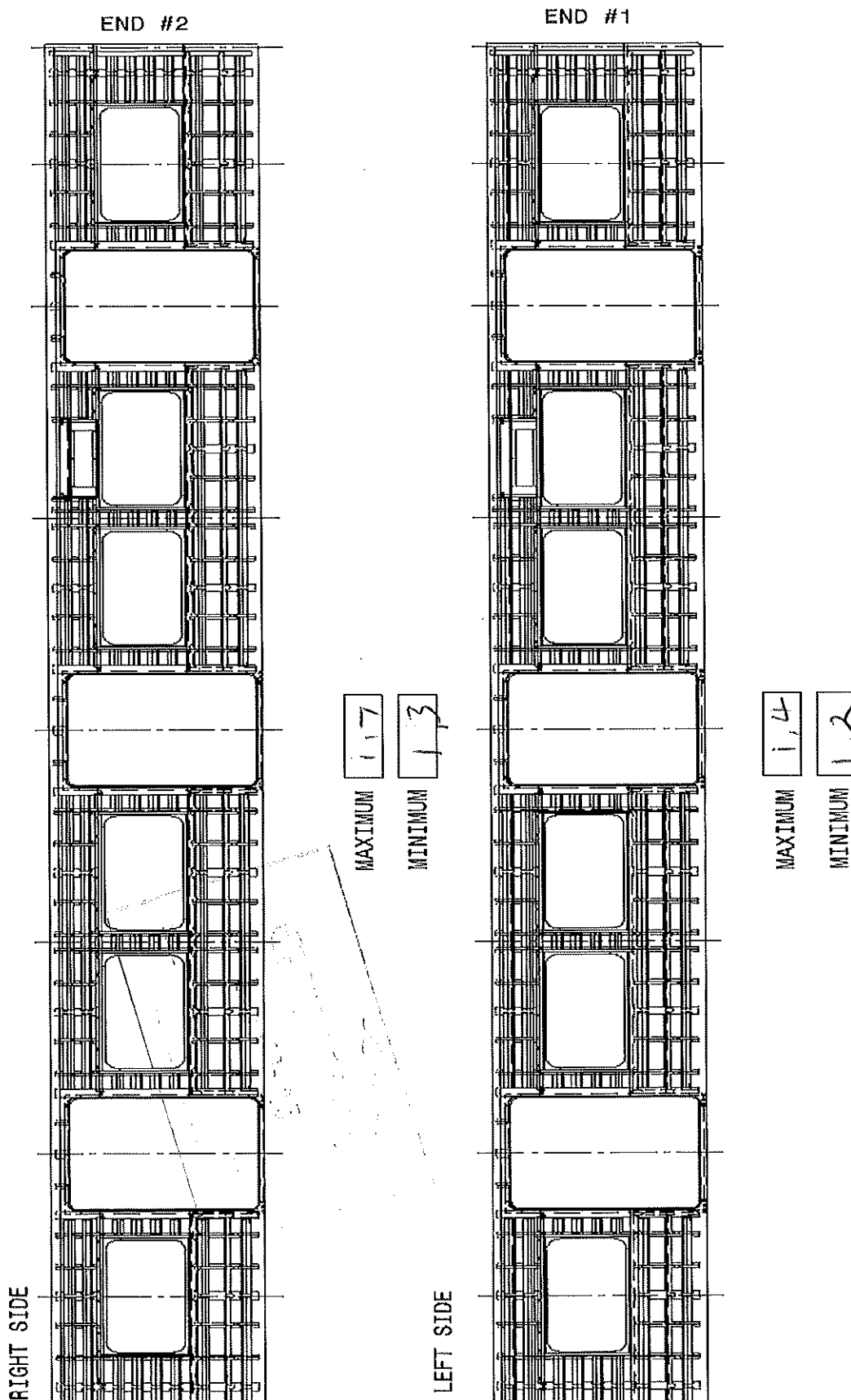
06/11/2023

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Specifications of Details for CBS measurement CB1230

latness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value four and indicate the corresponding region.





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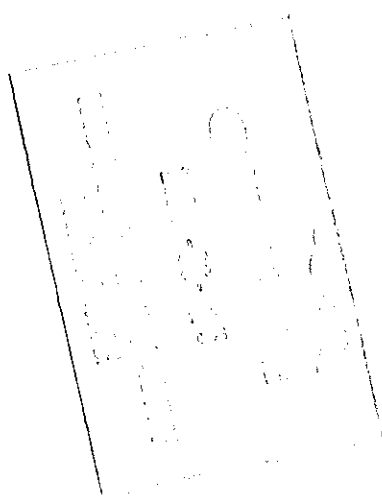
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END #1

END #2







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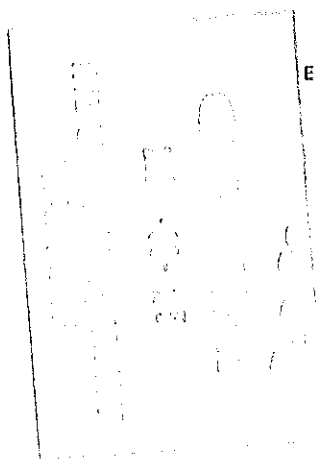
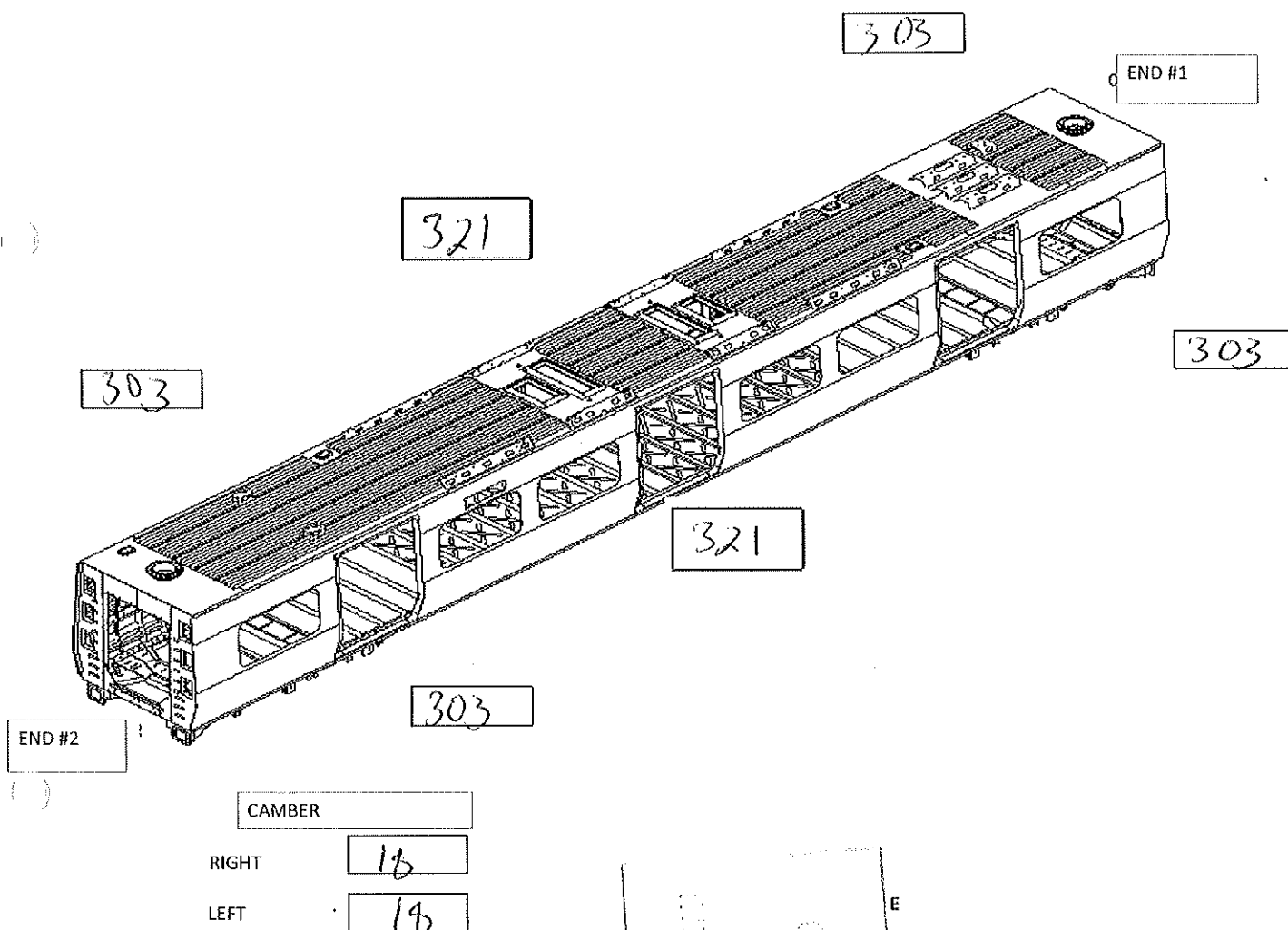
06/11/2023

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## Specifications of Details for CBS measurement CB1230

Specified Camber for car out of jig is 18mm(-0mm + 2mm)





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Date

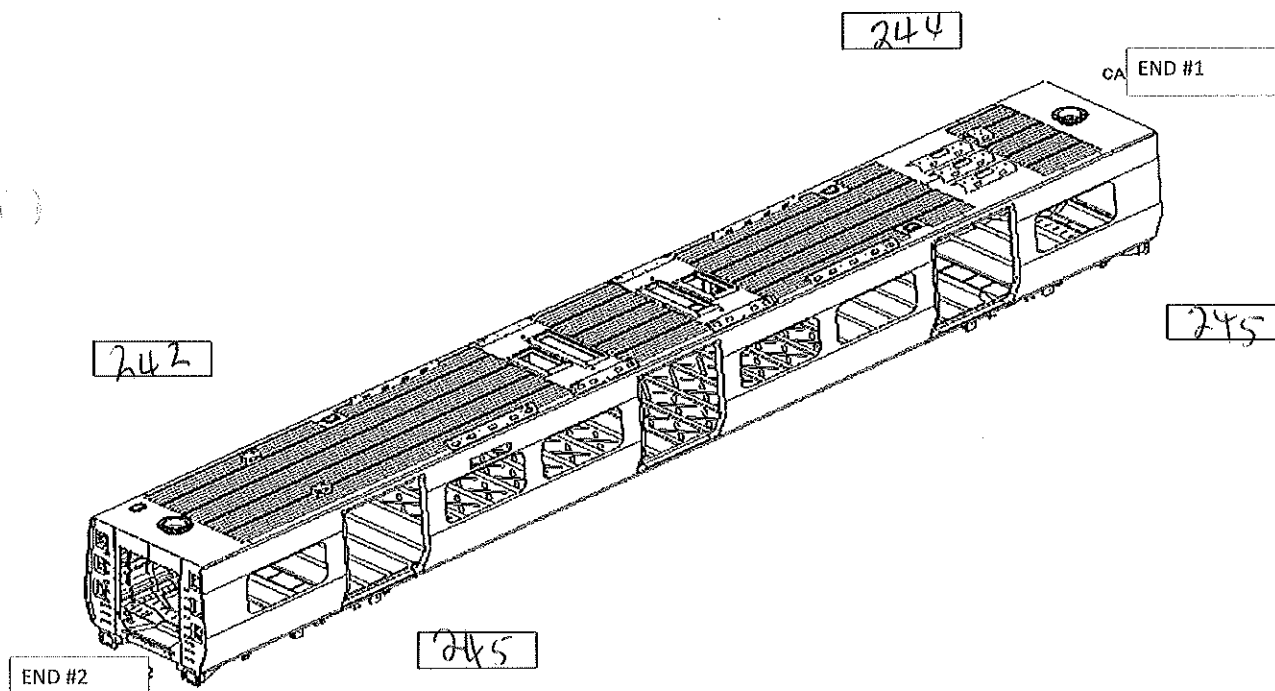
06/11/2023

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## Specifications of Details for CBS measurement CB1230

Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 following twist measurement document.



TWIST FOUND ON END 1

TRANVERSE

3

LONGITUDINAL

2

TWIST FOUND ON END 2

TRANVERSE

1

LONGITUDINAL

0



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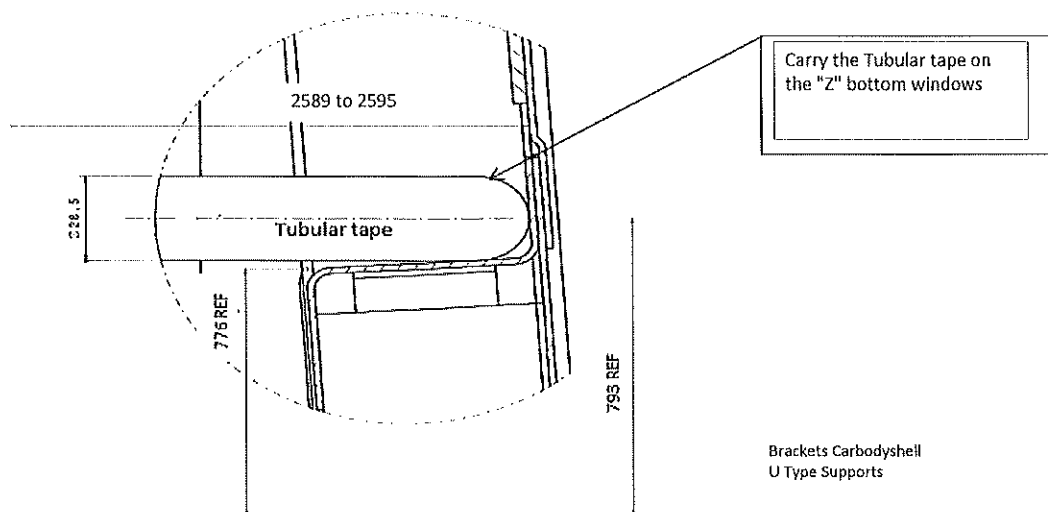
Date

06/11/2023

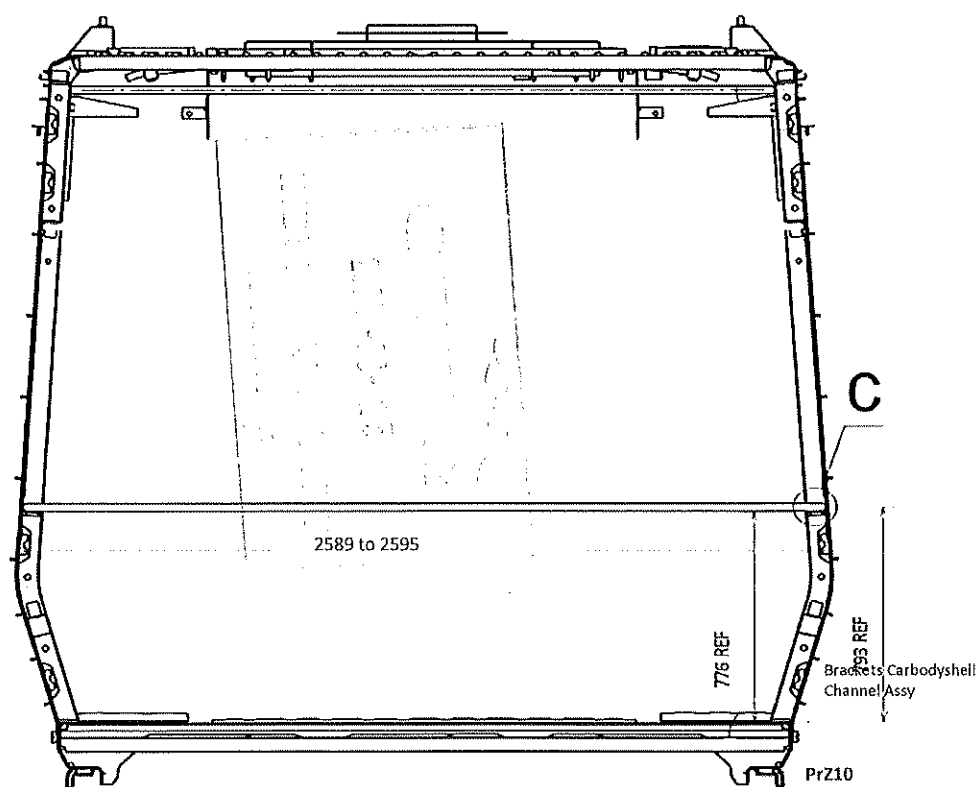
Project: PRASA

SI.CB1230.277.V29

## Specifications of Details for CBS measurement CB1230



Detail C





CARBODYSHELL M2 ASSEMBLY AA00001374497

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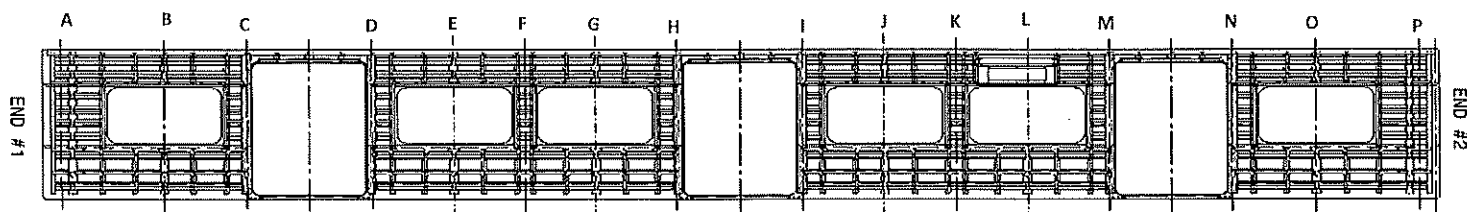
Project: PRASA

Date

06/11/2023

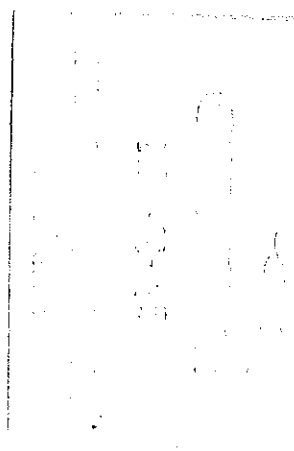
SI.CB1230.277.V29

## Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2593
B	2594
C	2589
D	2589
E	2591
F	2590
G	2591
H	2589
I	2589
J	2592
K	2594
L	2589
M	2589
N	2589
O	2595
P	2595



Threshold verification				Nominal value :38	
Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	38	38	38	38
Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	38	38	38	38	38

BOILER MAKER:

Boitumelo #1 ADPSE

WELDER:

Emmanuel Enofume



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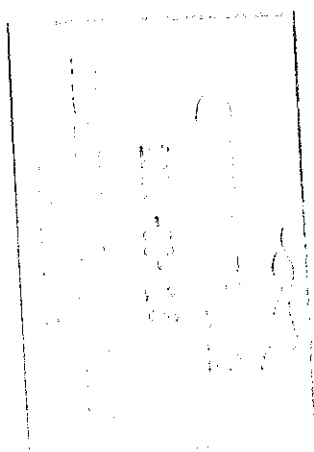
06/11/2023

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**Dye penetrant test**

Dye-penetration test to be performed by quality personnel





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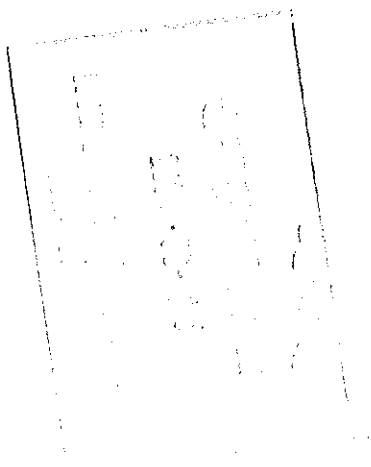
## Specifications of Details for CBS measurement


Item	Description of the Issue	OK	Signature/Date (Operations)	Signature/Date (Quality)

## II.2 - Check List REX

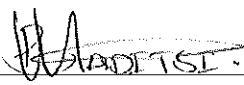

## Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX	X			18/06/24	



	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA  SI.CB1230.277.V29
		Date 06/11/2023	


## Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)		18/06/24	Boitumelo Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)		18/06/24	Mokoro Industrial Quality	
	NO GO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality	

In case of "NO GO", describe blocking problems

In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

  
 Operations

 \_\_\_\_\_  
 Quality



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Date

06/11/2023

Project: PRASA

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**ANNEXURE A: Arc Welding Quality Acceptance Standard**