

**GOBINATHAN P****BE – Metallurgy, GCE Salem (Anna University), Tamilnadu, India**

Manager - QA/QC

Anand Engineering Product Private Limited

RT Malai, Trichy - Thogaimalai Road, Karur-621 313, Tamilnadu, India

Email : [nathangce@gmail.com](mailto:nathangce@gmail.com)Mobile No : **+91 9894973214****Present Address:**

No. 7, Iyappan illam, Sai garden,  
Uyakondan Thirumalai,  
Trichy, Tamilnadu, India - 620102

**Permanent Address:**

No. 608A, Solanmadevi,  
Udayarpalayam  
Ariyalur, Tamilnadu, India – 612902

**Technical Skills**

- Implementation of Quality management system, for foundries as per the ISO 9001:2015.
  - Complete document preparation which includes Procedure, work instruction, Documents, Records, Quality plan, Data sheet etc for Initial Certification of Foundry in ISO as per ISO 9001:2015 includes Risk management.
  - Train and Lead the quality team successfully to establish QMS in new foundry
- Capable of training team members for dimensional inspection using with FARO, CMM and Height gauge.
- Identify and Implement the suitable NDE method for reducing the castings processing time based on castings profile, type of defect and castings thickness.
- Avoid color patches on casting's through Electrode selection, Control Weld rod composition by MRIR, Current, Interpass Temperature and PWHT.
- Successfully developed Special alloys welding for Grade 5A, 6A, CK-20, CU5MCuC, CW6MC, CN7M & CN3MN with help of proper electrode selection, type of defect removable technique.
- Developed SMAW, GTAW & GMAW welding Process and implemented WPS & PQR as per the ASME SEC IX, ASTM A488, BS EN 15609/ EN ISO 15614, EN ISO 11970 & EN ISO 9096 in grade WCB/1.0619/1.0625, LCB, LCC/1.6220, CF3M/1.4409, CF3/1.4308, 4A/1.4470, 5A/1.4469, 6A/1.4417, CK-20, CU5MCuC, CW6MC, CN7M & CN3MN
- Achieved 100% Mechanical & Corrosion properties in first pass through control of Chemical composition, Knock out, Riser removal, Heat treatment process etc.,
- Cost Saving in SG iron Melting:
  - Without Nickel addition achieved impact values @-15°C Avg:12J
  - Reducing usage of alloy % in SG iron melting, by effective Alloy packing technique to achieve Min 0.035% residual Magnesium in the final sample and free from flake graphite.
  - Coconut coke having the more Sulphur & Low dissolvable in metal, meantime achieved Carbon pickup & 100% nodularity in SG iron by using Coconut coke.
- Process Improvements in SG iron Melting:
  - Elimination of Chunky graphite & Shrinkage in castings by using with % of CE & balancing of Ce & Sb addition the metal.
  - 100% production achieved as per the shift plan.

### **Additional Qualification**

- ASNT Level II in RT, PT, MPT & DPI Completed in 2006.
- ISO 9001:2015 Internal Auditor certified by TUV-Nord.
- Welding of High Alloy Castings certified by Bholer.

### **Overall Experience: 13+ Years**

- First 3years & 1month – Worked in Laboratory & Melting at MAGNA ELECTRO castings Limited - Coimbatore
- 1year & 8 Months – Worked in Third party inspection at SGS India private Limited – Coimbatore
- 1 year & 2 Months– worked in Melting & Lab at SEFORGE Limited – Coimbatore.
- 5 years – Worked in Virgo Valves & Controls Private Limited - Coimbatore
- 1 Year & 6 Month in M/S. Arihant Technocast India Private Limited - Coimbatore
- Now Working in M/S. Anand Engineering Product Private Ltd - Trichy

### **Current Employer:**

**M/S. Anand Engineering Product Private Limited** – Trichy, Tamilnadu.

Manufacturing of Valves, Automobile components in Grade SG & Grey Iron.

**Foundry established on 2017.**

- Designation: Manager – QA/QC & MR
- Duration: Dec 2018 to Apr 2019

### **Achievements:**

- Zero Metallurgical defects achieved.
- Zero Customer Rejection achieved.
- Internal rejection reduced from 13% to 10%.

### **Key Responsibilities:**

#### **I. Quality Management System ( QMS):**

- Create and Update Procedure, work instruction, Documents, Records, Quality plan, Data sheet etc as per the ISO9001:2015.
- Provide Training for new comers and existing employees through OJT or CRT.

#### **II. Quality:**

- Ensuring 5S & Safety at work area.
- Daily conduct meeting for internal rejection, internal issue's & Customer related activities.
- Monitoring and controlling sand properties, chemical, metallurgical & mechanical properties through SPC, 7QC tools.
- Monitoring and controlling raw material inspection, in-process inspection, final and machining inspection.
- Handling NCR's for internal and customer through 8D, RCA etc.
- Handling certification audit, customer audit, internal audit & supplier audit.
- Preparation of QAP for particular job or customer.
- Ensure the calibration of equipment & instruments.

#### **III. Melting:**

- Ensuring 5S & Safety at work area.

- Man power allocation as per shift schedule.
- Ensure raw material availability as per the production plan.
- Ensure the ladle lining, furnace lining and sintering.
- Monitoring and controlling Charge mix, sampling, sampling temp, ladle temp, Tapping temp, pouring temp, alloy packing, residual magnesium & nodularity.

#### **Previous Employer:**

**M/S. Arihant Technocast India Private Limited – Coimbatore, Tamilnadu.**

Manufacturing of Valves, Pump & Earth moving equipments in Grade Carbon steel, Low alloy steel, Stainless Steel, Duplex Stainless steel & Nickel Base alloy.

**Foundry established on Jan2017.**

- Designation: Manager – QA/QC & MR
- Duration: June 2017 to Dec 2018

#### **Achievements:**

- Successfully completed ISO 9001:2015 and PED certification audit within 4months for New start-up company.
- Customer Rejection Maintaining < 1%
- Internal Rejection maintaining within 1%.
- Foundry approval for customer from various industries like Valves, Pumps and Engineering (Caterpillar Through Pricol, Blackwood, Weir BRK, TALGO-Spain, KSB- Valves- Spain, ITT, Sulzer)

#### **Key Responsibilities:**

##### **IV. Quality Management System ( QMS):**

- **Establish and Implement Quality management system as per the ISO 9001:2015**
  - Create and update Quality manual.
  - Risk identification for the foundry process
  - Create and Update Procedure, work instruction, Documents, Records, Quality plan, Data sheet etc.

##### **V. Non Conformance( CAR / 8D / Fish born ):**

- **Monitoring and control Customer complaint/ Customer rejection/ Internal Rejection/ Internal complaint.**
  - Identify the root cause, taking corrective action for the root cause, follow-up and Result of the corrective action to be updated.

##### **VI. Analysis ( 7QC Tools & SPC):**

- **Rejection analysis/ Non Conformance analysis/ Welding rework analysis/ NDE Repair Analysis / Chemical & Mechanical analysis**
  - Analysis with respect to defect wise, grade wise and Item wise

##### **VII. Performance Evaluation.**

- Conducting Management Review Meeting (MRM)
- Monitoring and updating Customer satisfaction
- Conducting Internal & Supplier audit.

##### **VIII. Handling Audits:**

- Customer audits.
- Certification audits.

## **IX. Welding:**

- Prepare WPS, PQR & WPQ as per the ASME SEC IX, ASTM A488, BS EN 15609/ EN ISO 15614, EN ISO 11970 & EN ISO 9096 w. r. t welding Process as well as Grade.
- Ensure PO requirement such as Customer approval needed for welding, Impact requirement & if any Special requirement required in welding.
- Monitor Welder Continuity record as per ASME Sec XI, EN ISO 9096 & EN 287.
- Monitor Weld repair record and PWHT.
- Analysis of the Weld rod consumption Monthly & Yearly basis with respect to grade wise, Defect wise, Customer wise & NDE wise.

## **X. Inspection**

### ➤ **NDT Inspection**

- Prepared and Maintaining the NDT procedure as per the ASME Sec V.
- NDT personnel qualification as per SNTC-1A
- Identify and Implement the suitable NDE method for reducing the castings processing time based on castings profile, type of defect and castings thickness
- Visual Inspection of the casting's as per ASME SEC V, MSS- Sp-55, ASTM A802 & SCRATA

### ➤ **Dimensional Inspection**

- Monitoring and Measuring of Dimensional inspection of the Sample & Bulk castings as per the ISO 8068 & IS4867.

## **XI. Other Activities**

- Review of PO's for customer requirements.
- Monitoring and Verifying Laboratory activities such as MRIR & In process testing.
- Approval of Material Test Certificates (MTC)
- Conduct Shop floor & Class Room Training for existing employees and upcoming new comers such as QMS, Welding, NDE, Heat Treatment, Lab testing's & Metallurgy.

## **Previous Employer:**

**M/S. Virgo Valves & Controls Private Limited** – Coimbatore, Tamilnadu, Foundry established on May 2012.

One of the world leading Valves manufacturing company across the world in Grade Carbon steel, Low alloy steel, Stainless Steel, Duplex Stainless steel & Nickel Base alloy

- Designation: Engineer – QA/QC & AMR
- Duration: June 2012 to June 2017

## **Key Responsibilities:**

### **I. Handling Special Process:**

#### ➤ **Heat Treatment:**

- Ensure Provision for the Heat Circulation between the job for temperature uniformity.
- Ensure Holding Time, Holding Temperature & Quenching Media, before performing the Heat Treatment.
- Measure & Control the water temperature during the Quenching
- Heat treatment furnace temperature uniformity survey.

- Calibration for the furnace, thermocouple, recorder, and controller as per API 6D, API 6A, API 6HT & ASTM A991.

➤ **Welding:**

- Prepare WPS, PQR & WPQ as per the ASME SEC IX, ASTM A488, BS EN 15609/ EN ISO 15614, EN ISO 11970 & EN ISO 9096 w. r. t welding Process as well as Grade.
- Repair removable type & Ensure with help of NDT.
- Monitoring the MRIR inspection for filler metal composition, mechanical strength as per ASME Sec IX.
- Monitoring the Weld Rod storage, issue & control
- Weld repair record along with Defect sketch, Expected weld rod classification of the minor and major weld, PWHT, NDE etc.
- Ensure PO requirement such as Customer approval needed for welding, Impact requirement & if any Special requirement required in welding.
- Preheat, Interpass temperature & PWHT as per the WPS.
- Maintain Welder Continuity record as per ASME Sec XI, EN ISO 9096 & EN 287.
- Analysis of the Weld rod consumption Monthly & Yearly basis with respect to grade wise, Defect wise, Customer wise & NDE wise.

➤ **Acid pickling**

- Acid pickling mixture prepared as per the ASTM A380 & A967.
- Ensure Fe contamination in castings by using Ferroxyd or Copper sulfate test as per ASTM A380.

**II. Implement the following as per the ISO 9001: 2008**

- Quality Assurance Manual
- QMS (Procedure, Work Instruction, Flow chart, Data sheet, QTP as per the Current process)
- Conducted MRM as per the time schedule

**III. Handling Audit's**

- Department wise internal audit for both Process & Product
- External Audit for Out fettling, Heat treatment, RT & Pattern shop
- Customer Audit, ISO 9001:2008 & PED

**IV. NDT Inspection**

- Prepared and Maintaining the NDT procedure as per the ASME Sec V.
- NDT personnel qualification as per SNTC-1A
- Identify and Implement the suitable NDE method for reducing the castings processing time based on castings profile, type of defect and castings thickness
- Visual Inspection of the casting's as per ASME SEC V, MSS- Sp-55, ASTM A802 & SCRATA

**V. Additional Activities**

- Handling Internal Rejection, Customer Rejection & Customer Compliant.
- Ensured Calibration for Monitoring and Measuring Equipment & Instrument.
- Handling TPI inspection
- Dimensional inspection of the Sample & Bulk castings as per the ISO 8068 & IS4867.

**Previous Employer:**

M/S.SEFORGE Limited – Coimbatore

- Designation: Engineer – QA
- Duration: April 2011 to June 2012

### Key Responsibilities:

- Ensured Raw material for melting
- Fresh Lining as well as production lining to be verified for every heat
- Prepared charge calculation
- Controlled Bath Chemistry, Final Chemistry, Bath temperature, Pouring temperature, Inoculation, Mg addition.
- Ensured Ladle & Pouring Basin temperature before tapping
- Achieved 100% Microstructure and Nodularity.
- Minimized chunky graphite by using with balance CE, Ce & Sb.
- Maintained Carbon Equivalent

### Previous Employer:

SGS India private Limited – Coimbatore

- Designation: Inspection Engineer
- Duration: July 2009 to March 2011

### Key Responsibilities:

- Witnessing of All NDT inspection (UT, MPT & RT) of the Wind Turbine components
- Witnessing of Mechanical Testing & Nodularity of the Castings
- Witnessing of Dimensional Inspection.
- Preparing the Inspection Documents
- Visual inspection of the Castings
- Painted component inspection
- WPS, PQR & WPQ Approval

### Previous Employer:

M/S. MAGNA ELECTRO castings Limited–Coimbatore

Designation: QA Engineer

Duration: June 2006 to July 2009

- Incoming Raw Material Inspection Scrap, Pig iron, Sand, Resin, Catalyst & Coatings.
- Tested Tensile, Impact & Hardness
- Calibrated spectrometer.
- checked and ensured Bath & Final Chemistry.
- Specimen Preparation for Metallography inspection.
- tested Green Sand Properties Moisture %, Shatter Intex, Compression strength, AFS no & Fines.
- Tested Furan Sand Properties Compression Strength, AFS no, Fines & LOI.

### Personnel Details

Farther Name : Mr. Palanivel  
Mother Name : Dhanalakshmi  
Date of Birth : 11.07.1984  
Marital Status : Married

## Reference

1. SETHURAMAN. S  
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