

Surveillance Audit Report

Manufacturer:	Wärmetauscher Sachsen GmbH	Audit (1/1):	15 July 2022
Location:	Lindenstraße 5, D-09526 Olbernhau	Auditee:	Enrico Böhme
Certificate holder:	Duschkraft GmbH		
Certificate(s):	K102770/01		
Guideline(s):	BRL-K656: Heat exchangers intended for the indirect heating of drinking water.		
QMS ISO9001:	Certificate no.: 01 100 2141383 Expiry date: 25/4/2024 Certification body: TÜV Rheinland <input checked="" type="checkbox"/> Scope checked		
Type of Audit	<input checked="" type="checkbox"/> Onsite	<input type="checkbox"/> Remote Audit	<input type="checkbox"/> Special Audit
Internal Quality Schedule	Dated: N/A	Update required: <input type="checkbox"/> Yes <input type="checkbox"/> No	

General Aspects	Yes	No	Remarks
Are there changes in the organization and responsibilities applied to design, production and control	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/> Not applicable
If there were any nonconformities entered in the previous inspection report, have these been corrected?	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> See NCF <input checked="" type="checkbox"/> Not applicable
Certified products in production during visit	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Selection and shipping of (re-) examination sample(s)	<input type="checkbox"/>	<input checked="" type="checkbox"/>	No sampling required.
The use of logo(s), icons, certificate is in accordance with the regulations.	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Website verified

Calibration or verification of measuring equipment **Not applicable**

No calibrated measuring devices used in production.

Verification of purchased components and materials **Conform**

The documented information / procedures have been checked.

Incoming components / materials are checked visually / CoA before use.

The following components / materials have been checked to prove compliance (latest orders for certified products):

Welded tube made of 1.4301, test certificate 10204-3.1 No. 16031504 dated 15.03.2015 by Changshu Xintonglian Steel Tube Co. Ltd.

Aluminium foils batch A8011 & O, material test certificate dated 14.07.2014 by Yhal Industry Co. Ltd.

Verification of used components in finished products **Conform**

The documented information / procedures have been checked. To assure the correct use of components the bill of material was available. The following finished products have been checked to prove compliance:

Heat exchangers ordered by Duschkraft GmbH, Order No. A0521323, 500 pcs.

Monitoring of production process **Conform**

The documented information / procedures have been checked. The production process is monitored by means of controls by workers.

Tightness tests with air-under-water are performed after assembly. Traceability is guaranteed by the production order No. Production information and documentation is kept.

The following production period was part of the investigation: 15.07.2022, copper production hall and stainless-steel production hall with Schweißzentrum 2 (laser welding) and test bath.

The heat exchangers are constructed and categorized, and a production order is released. It includes the technical drawings, circuitry, list of materials, working items, test pressures. The production order 0522134FE01 was reviewed. The technical drawings are also available on screen at some stations. The status of each production order is displayed on a screen in production.

Template for test protocol with work steps: FB-10.01.

Reviewed documentation of last production for Duschkraft GmbH, Order No. A0521323.

Batch release tests & Process verification tests**Conform**

The documented information / procedures have been checked. Selected tests are performed to verify compliance with the applicable BRL in set intervals.

The following tests are performed during the audit: Air-under-water for 5 minutes, pressure according to production order. Reviewed test station "Tauchbecken Edelstahllinie".

Last test protocol for Duschkraft GmbH dated 27.08.2021, Order No. A0521323: 16 bar, 5 minutes, result: leaktight.

Control of non-conforming and/or rejected products**Conform**

The documented information / procedures have been checked. Products which do not fulfill the requirements are clearly marked / blocked in ERP / put into quarantine to avoid unintended use.

Corrective actions are taken (if needed) to avoid recurrence.

The following registration/actions have been checked:

- If a heat exchanger is leaky during the pressure test, the spot(s) are marked and welded/ brazed again. A re-test is performed afterwards.
- Corrective actions were taken after customer complaints, reviewed overview of complaints for 2021 and the complaints of June 2022.

Handling and storage**Conform**

The documented information / procedures have been checked. Handling and storage do not influence the quality of the final product.

This has been checked during plant tour.

The heat exchangers are cleaned with different methods after production, e.g. pickling, ultrasonic bath, hot water.

The products are shipped in customized boxes.

Customer complaints**Conform**

The documented information / procedures have been checked. Customer complaints are registered. An Investigation is done to justify the complaint. If the complaint is justified a settlement with the customer is done.

The following complaint is checked to prove compliance: The complaints are registered per month. The overview of complaints for 2021 and the complaints June 2022 were reviewed.

Product marking (logo) / Manufacturer's declaration**Not applicable**

Installation instructions**Not applicable**

Maintenance of production equipment**Conform**

The documented information / procedures have been checked. Production equipment is maintained in set intervals to prevent downtime and unwanted production errors.

The following documents have been reviewed:

- Maintenance protocol for Lamellenstanze CeBi 12/2018 – 07/2022
- External technical assistance by CE.BI HI-Tech s.r.l dated 07/2022 for Lamellenstanze CeBi.

Training and competence of personnel**Conform**

The documented information / procedures have been checked. For personnel involved production/testing, the training records have been reviewed.

Certificate acc. to DIN EN ISO 3834-2 (Quality requirements for fusion welding of metallic materials), valid till September 2022, TÜV Süd Industries Service GmbH.

Reviewed job description „Mitarbeiter Organisation Fertigung/Logistik“.

Informative remarks

This audit was witnessed by Dietmar Altemeier, Kiwa GmbH.

The certificate K102770 of Duschkraft GmbH will be terminated as of October 1st 2022.

Copies sent to:

boehme@waetas.de

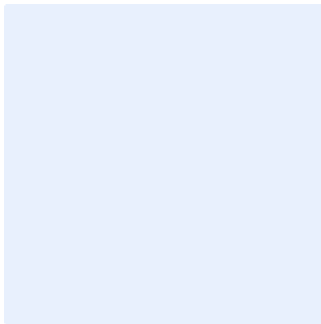
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Corrective actions in response to inspector's evaluation

No unsatisfactory findings.		<input checked="" type="checkbox"/>
Minor non conformity report(s).	Manufacturer's corrective action(s) will be checked at next visit.	<input type="checkbox"/>
Major non conformity reports(s)	Manufacturer shall confirm corrective action(s). Special or early routine inspection recommended for checking corrective action(s).	<input type="checkbox"/>

Signature:



Patrick Pistorius (B.Eng.)

An electronic copy of this report shall be send to the manufacturers contact within one week after the audit. If the manufacturer does not agree with the content of this report, a written complaint shall be sent to the local office of Kiwa within two weeks after receipt of the report.