

ABSTRACT

The company in this research is one of the engineering industrial companies in the oil and gas pipeline that produces Split Body Ball Valves. Split Body Ball Valves are spare parts in the form of exhaust gas cover pipes produced for domestic and foreign industries. Along with the increase in production capacity in the manufacture of Split Body Ball Valves, there are 9pcs defects caused, namely seamless pipe welding defects. Of the two process defects, seamless pipe welding process defects have the highest number of defects. The defects caused are in the checking process (NDT) Non Destructive Test and Welding porosity (perforated defects) in the welding process. Therefore, it is necessary to conduct research to improve quality and eliminate problems that arise in the process of making Split Body Ball Valves which is the highest type of defect using Pareto diagrams with a percentage of 14.8% and assisted by fishbone diagrams and FMEA. Types of defects and provide recommendations using the DMAIC method (Define, Measure, Analyze, Improve, Control) and also provide suggestions for improvements with 5W + 1H by controlling each process in the production of Split Body Ball Valves.

Keywords : DMAIC (Define, Measure, Analyze, Improve, Control), Quality, defect, Pareto Diagram, Fishbone Diagram, 5W+1H



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