

INSPECTION REPORT

Report No.: MIL 16/11/2010

Issued on: Dec 22th, 2010

Inspection Time: Dec 8th&9th, 2010

P.O. No.96829

Inspection Subject: LSAW Pipes
Specification: API 5L B PSL2 Inspector: Lin Gaojie Stamp No:

Visit Summary:

Scope of Inspection

- UT verification.
- Visual inspection.
- Dimension inspection.
- Packaging, quantity and marking inspection.
- Documents review.
- Part photo service.

Results of inspection

● Process Verification

1. UT verification

We had verified the manual UT, and 6pcs of pipes (3pcs for 812.8*9.53mm*12m, 2pcs for 812.8*9.53mm*6m and 1pc for 914.4*9.53mm*12m) were all passed.

Photo attachment as below



Hole size ϕ 1.6



Ultrasonic fault detector calibration



UT

2. Visual Inspection

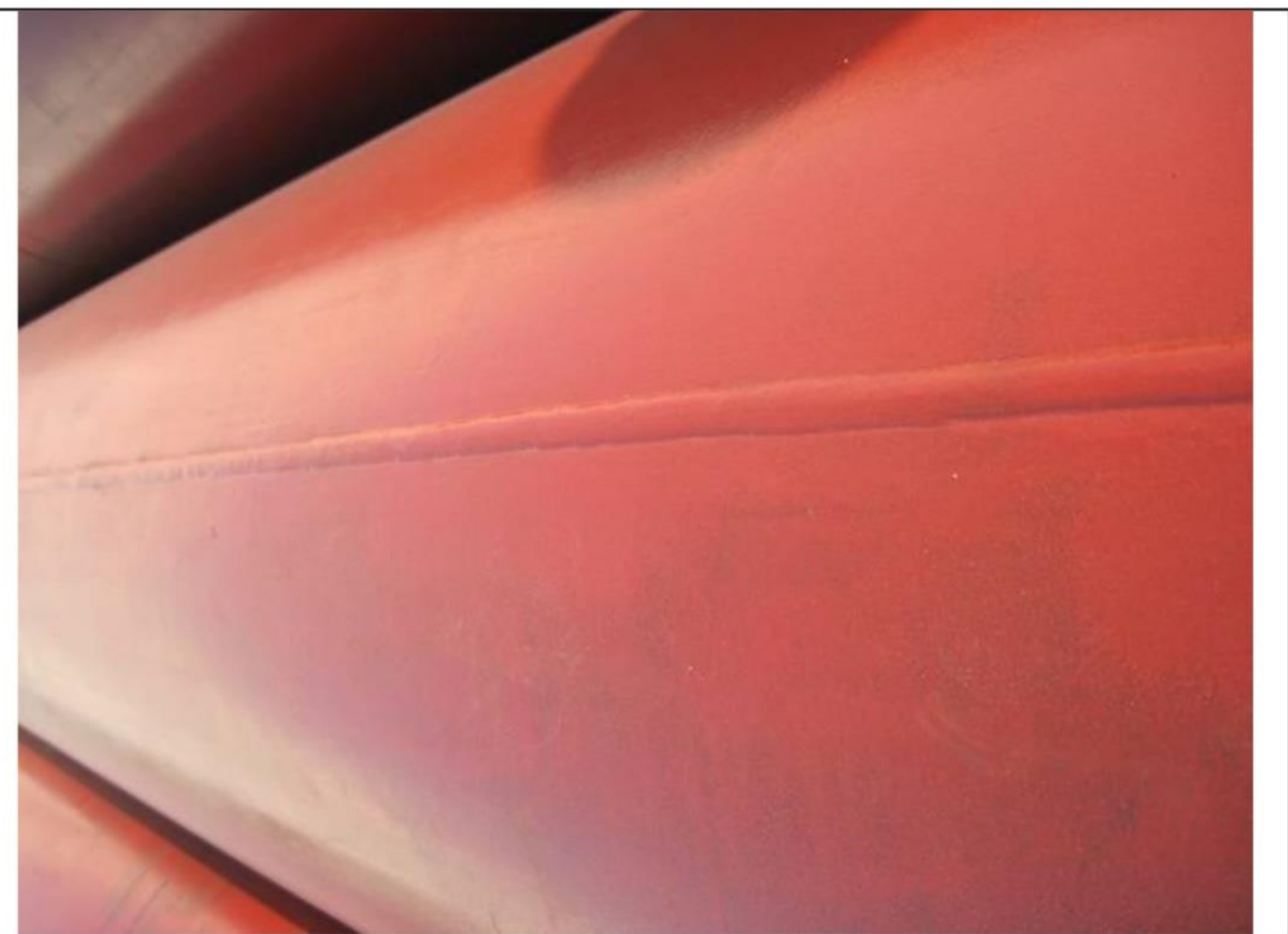
The details were as followed:

- 1) The pipes were painted with rust-proof paint by brush and **some uneven ones** had been painted again.

Photo attachment as below



For checking



Surface



3. Dimension inspection

We had measured pipe dimensions.
 The detailed data is in the following table.

Spec (mm)	Inspection Amount (pc)	OD of pipe body (mm)	OD of pipe ends (mm)	Out-of-roundness (mm)	WT (mm)	Length (mm)	Straightness (mm)	Out-of-squareness (mm)
812.8*9.53* 12000	3	813.0~814.6	813.0~814.3	7~15	9.4~9.9	12012~12019	3~5	1
812.8*9.53* 6000	3	813.3~814.3	813.6~815.5	10	9.7~10	6005~6016	2	2.0~2.5
914.4*9.53* 12000	2	912.6~915.2	913.9~915.8	6~8	9.5~9.7	12005~12018	2~3	3

Photo attachment as below



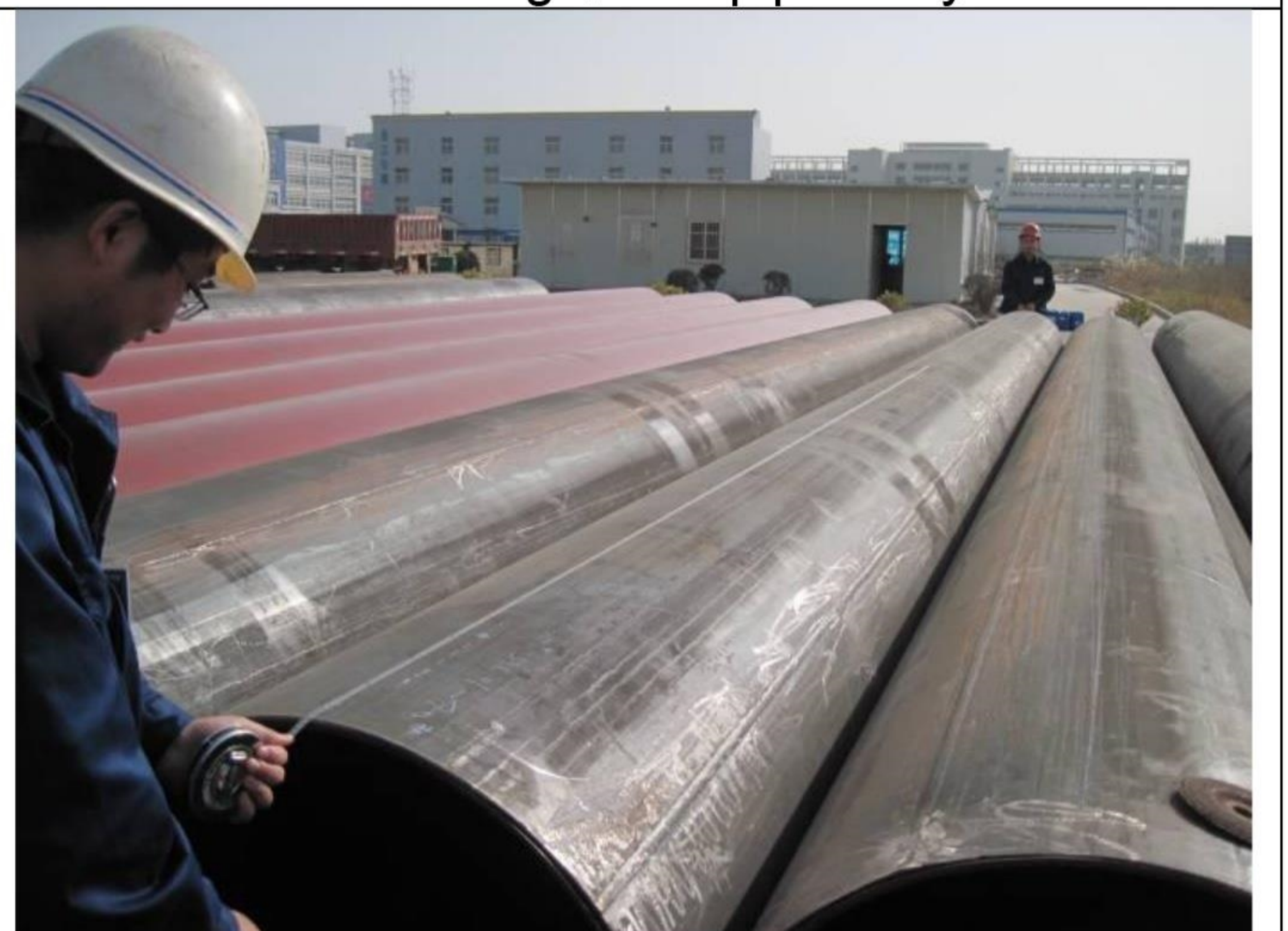
coating thickness gage



Measuring OD of pipe body



Measuring WT



Measuring length



Measuring straightness

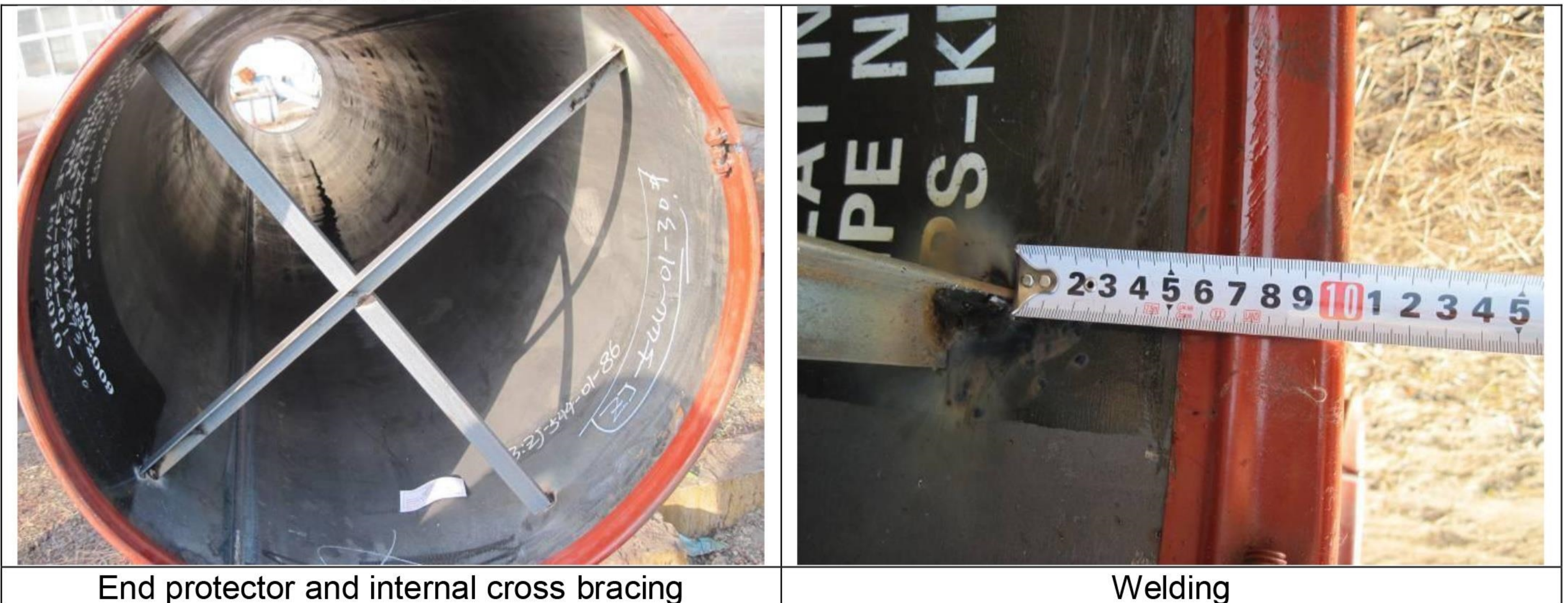


Measuring out-of-squareness

4. Packaging, quantity and marking inspection

- 1) The mill had fixed end protectors on both of pipe ends;
- 2) The internal cross bracings were welded on the place about 200mm far away from end to avoid deformation.
- 3) The quantity was right;
- 4) The shipping mark was right;
- 5) The marking was right.

Photo attachment as below



End protector and internal cross bracing

Welding

● **Review of Documentation**

Raw Material Test Certificate.

Hydrostatic Test Record.

UT Record.

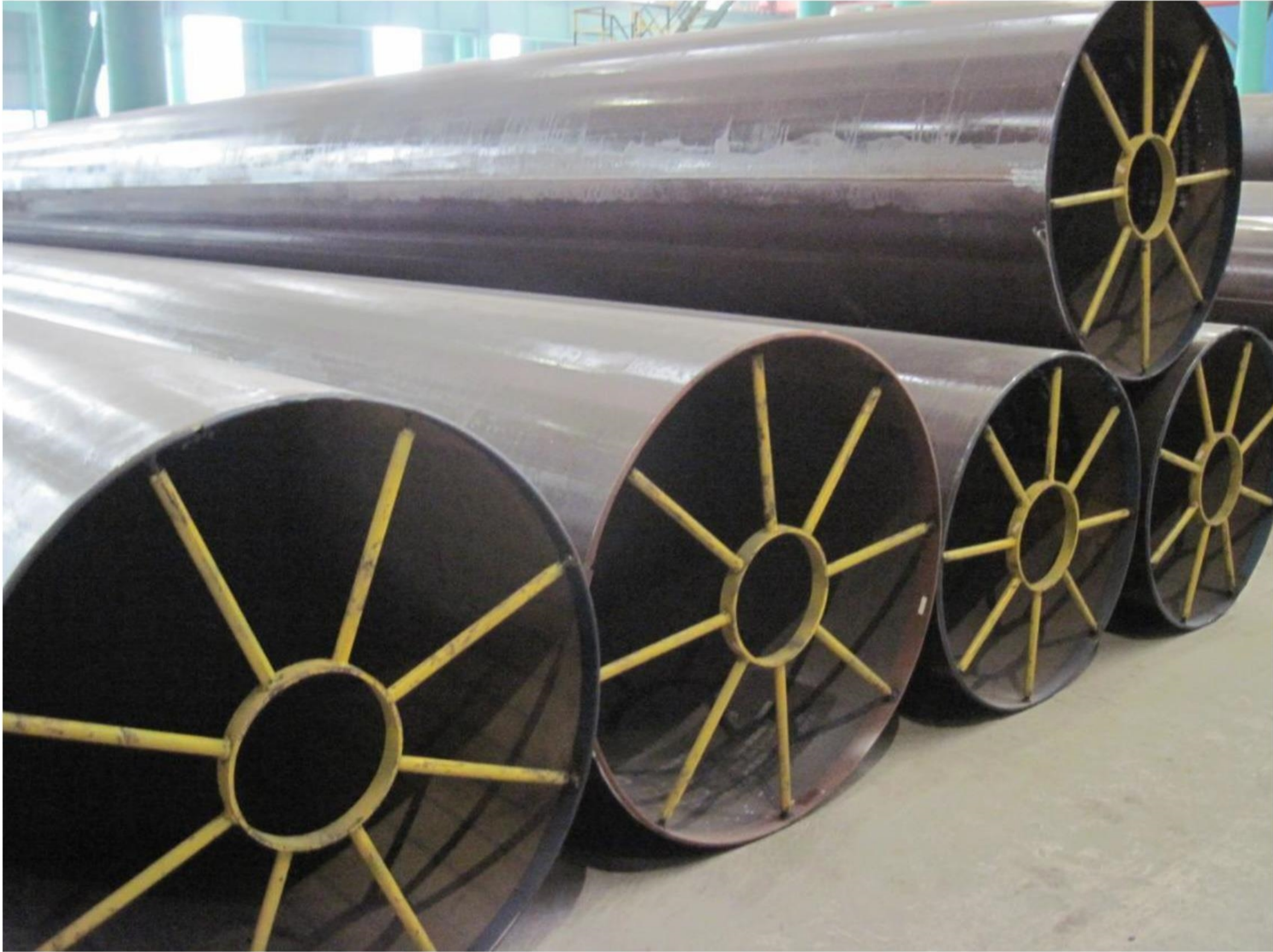
Physical Inspection Report. Inspection

Report of Finished product.

● **Conclusions:**

The inspection results shows that the pipes are in compliance with the specifications and client's requirements.

Metals End Protectors with Steel Cross Section



Liquid Epoxy Lined and FBE Coated Pipe

