

INSPECTION REPORT

Report No.: MIL G2NG-5-0001-01

Issued on: Jan 9<sup>th</sup>, 2012

Inspection Time: Jan 5<sup>th</sup>-6<sup>th</sup>,

|                            |
|----------------------------|
| P.O. No.<br>G2NG-5-0001-01 |
|----------------------------|

|                |                                                           |            |               |           |
|----------------|-----------------------------------------------------------|------------|---------------|-----------|
| Inspection     | SMLS Pipes                                                |            |               |           |
| Purchaser:     |                                                           |            |               |           |
| Specification: | API 5L 44 <sup>th</sup> Edition Gr.B /<br>ASTM A106 Gr. B | Inspector: | Lin<br>Gaojie | Stamp No: |

Visit Summary:

Scope of Inspection

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

Results of inspection to MIL G2NG-5-0001-01

● Process Verification

1. Visual Inspection

The pipes were good varnished and beveled well. Photo attachment as below



Bevel end in accordance with ASME B16.25, fig.

Bevel end in accordance with ASME B16.25, fig.

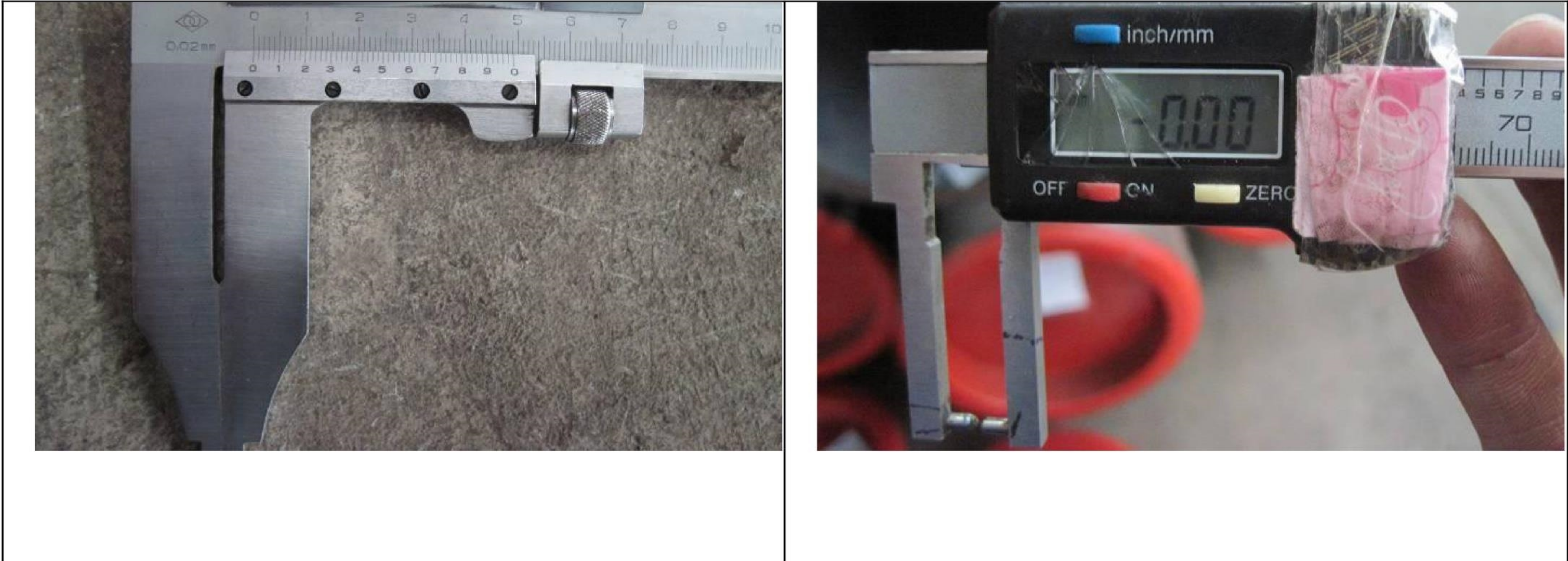
## 2. Dimension inspection

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

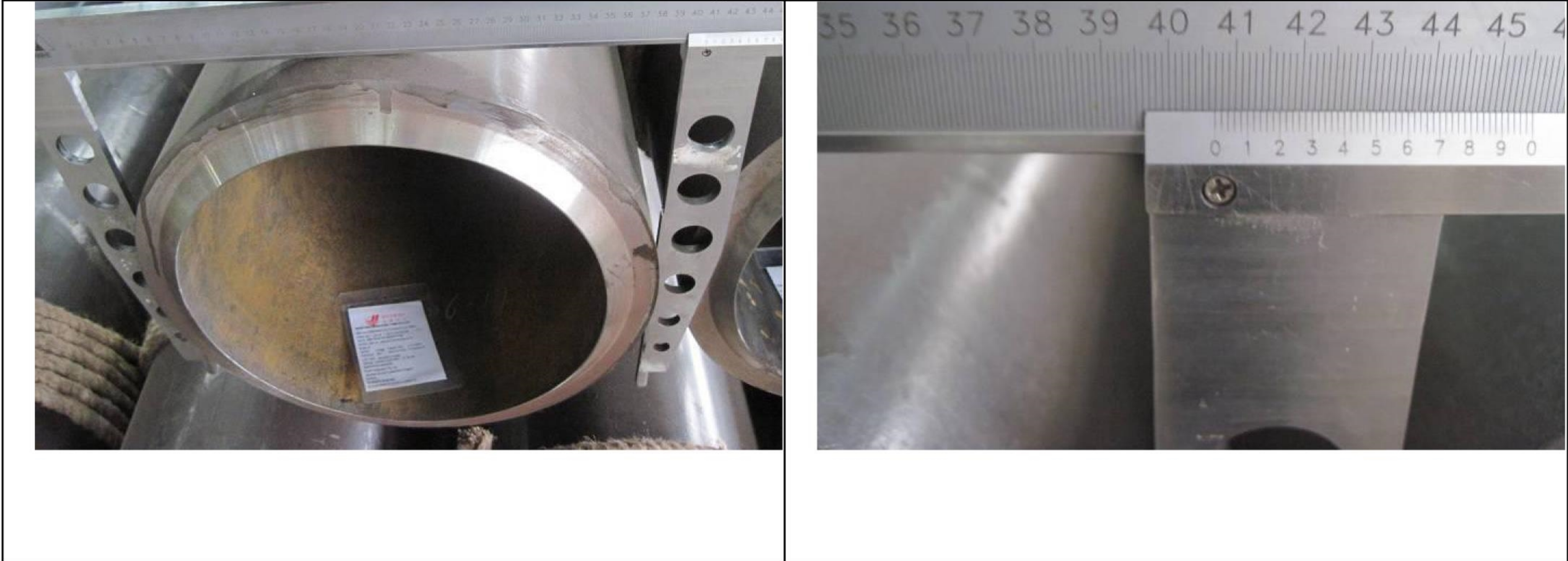
| Dimen<br>sio<br>(mm) | Heat<br>No.  | Batch<br>No &<br>Bundle | OD<br>(mm)     | WT<br>(mm)      | Lengt<br>h<br>(m) | Bev<br>el<br>angl | Bev<br>el<br>angl | Height<br>of<br>bevel | Ro<br>ot<br>fa |
|----------------------|--------------|-------------------------|----------------|-----------------|-------------------|-------------------|-------------------|-----------------------|----------------|
| 219.1*25.4           | 113307<br>3  | 82Z300340<br>K001       | 218.4<br>219   | 25.51~<br>26.66 | 6.88              | 8.8/9.5           | 37.0/36.5         | 19.5/20.4             | 1.2~2.<br>3    |
| 219.1*25.4           | 113307<br>3  | 82Z300340<br>K003       | 218.3<br>220.3 | 25.82~<br>26.86 | 7.05              | 9.0/9.4           | 36.0/37.0         | 19.4/19.9             | 1.1~2.<br>3    |
| 406.4*40.4<br>9      | 1127562<br>V | 71Z400015<br>J217       | 408.2<br>409   | 39.73~<br>41.33 | 8.32              | 9.6               | 37.7              | 18.8                  | 1.2~1.<br>9    |
| 406.4*40.4<br>9      | 1127562<br>V | 71Z400015<br>J218       | 406.9<br>409.1 | 38.57~<br>41.48 | 8.48              | 10                | 37.4              | 20.5                  | 1.0~2.<br>0    |
| 406.4*30.9<br>6      | 1127551<br>V | 71Z400008<br>J173       | 407.2<br>409   | 30.14~<br>31.87 | 8.54              | 9.3               | 38                | 20                    | 1.4~1.<br>9    |
| 406.4*30.9<br>6      | 1127551<br>V | 71Z400008<br>J174       | 408.5<br>409.7 | 29.65~<br>33.10 | 8.45              | 9                 | 36.9              | 20.4                  | 1.1~2.<br>1    |
| 457.2*14.2<br>7      | 1127672<br>V | 71Z100103<br>J082       | 458.5<br>460.4 | 13.34~<br>16.48 | 9.8               | /                 | 37.6              | /                     | 0.9~2.<br>0    |
| 457.2*14.2<br>7      | 1127672<br>V | 71Z100103<br>J084       | 460.2<br>461.7 | 14.34~<br>14.79 | 10.55             | /                 | 37.1              | /                     | 1.1~1.<br>8    |
| 457.2*14.2<br>7      | 1221884<br>V | 72Z300387<br>J075       | 458.8<br>459.6 | 13.15~<br>14.43 |                   | /                 | 38                | /                     | 0.8~1.<br>2    |
| 457.2*14.2<br>7      | 1221884<br>V | 72Z300387<br>J077       | 458.8<br>459.2 | 13.96~<br>14.28 |                   | /                 | 37.5              | /                     | 1.0~1.<br>2    |
| 508*50.01            | 1127404<br>V | 71Y200129<br>J284       | 508.0<br>509.2 | 49.10~<br>52.81 | 8.77              | 9.5               | 38.2              | 19.4                  | 1.3~2.<br>0    |
| 508*50.01            | 1127402<br>V | 71Y200127<br>J236       | 509.4<br>510.8 | 50.57~<br>54.44 | 8.86              | 9.8               | 37                | 20                    | 1.6~2.<br>0    |
| 508*50.01            | 1127404<br>V | 71Y200129<br>J281       | 508.9<br>510.8 | 49.77~<br>53.44 | 8.82              | 9                 | 37.5              | 19.7                  | 1.6~2.<br>2    |

|           |              |                   |                |                 |      |          |           |           |             |
|-----------|--------------|-------------------|----------------|-----------------|------|----------|-----------|-----------|-------------|
| 508*15.09 | 1221882<br>V | 72Z100311<br>J108 | 509.2<br>511.5 | 14.75~<br>16.43 | 9.73 | /        | 37.0/36.5 | /         | 1.0~2.<br>0 |
| 508*15.09 | 1221882<br>V | 72Z100311<br>J084 | 510.7<br>512.4 | 14.84~<br>16.48 | 9.57 | /        | 37.0/37.5 | /         | 1.1~1.<br>8 |
| 508*50.01 | 1210803<br>V | 72Z400245<br>J185 | 508.1<br>510.8 | 48.65~<br>52.16 | 8.9  | 9.5/9.0  | 37.5/36.5 | 18.0/19.5 | 0.9~1.<br>8 |
| 508*50.01 | 1210803<br>V | 72Z400245<br>J187 | 508.2<br>510.2 | 47.81~<br>51.22 | 8.6  | 9.5/10.0 | 37.5/37.0 | 19.0/20.5 | 1.0~1.<br>9 |
| 508*50.01 | 1221889<br>V | 72Z400244<br>J167 | 508.6<br>510.8 | 48.89~<br>50.60 | 8.79 | 9.5/9.0  | 37.2/36.5 | 20.0/19.0 | 1.0~2.<br>1 |
| 508*50.01 | 1221889<br>V | 72Z400244<br>J162 | 508.6<br>510   | 47.30~<br>50.90 | 8.13 | 9.2/9.8  | 36.5/36.5 | 20.0/20.5 | 1.1~2.<br>2 |

Photo attachment as below



Gage calibration



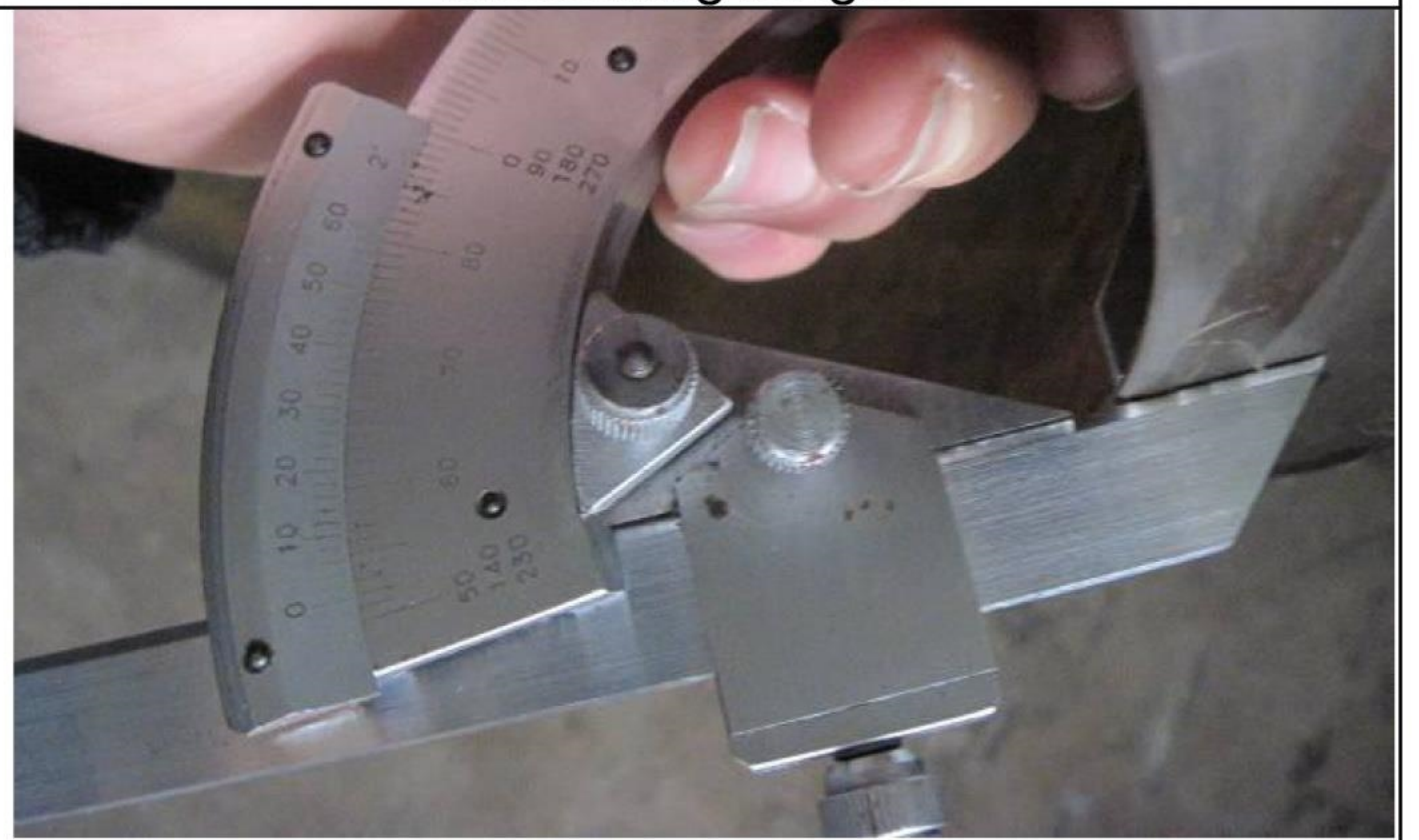
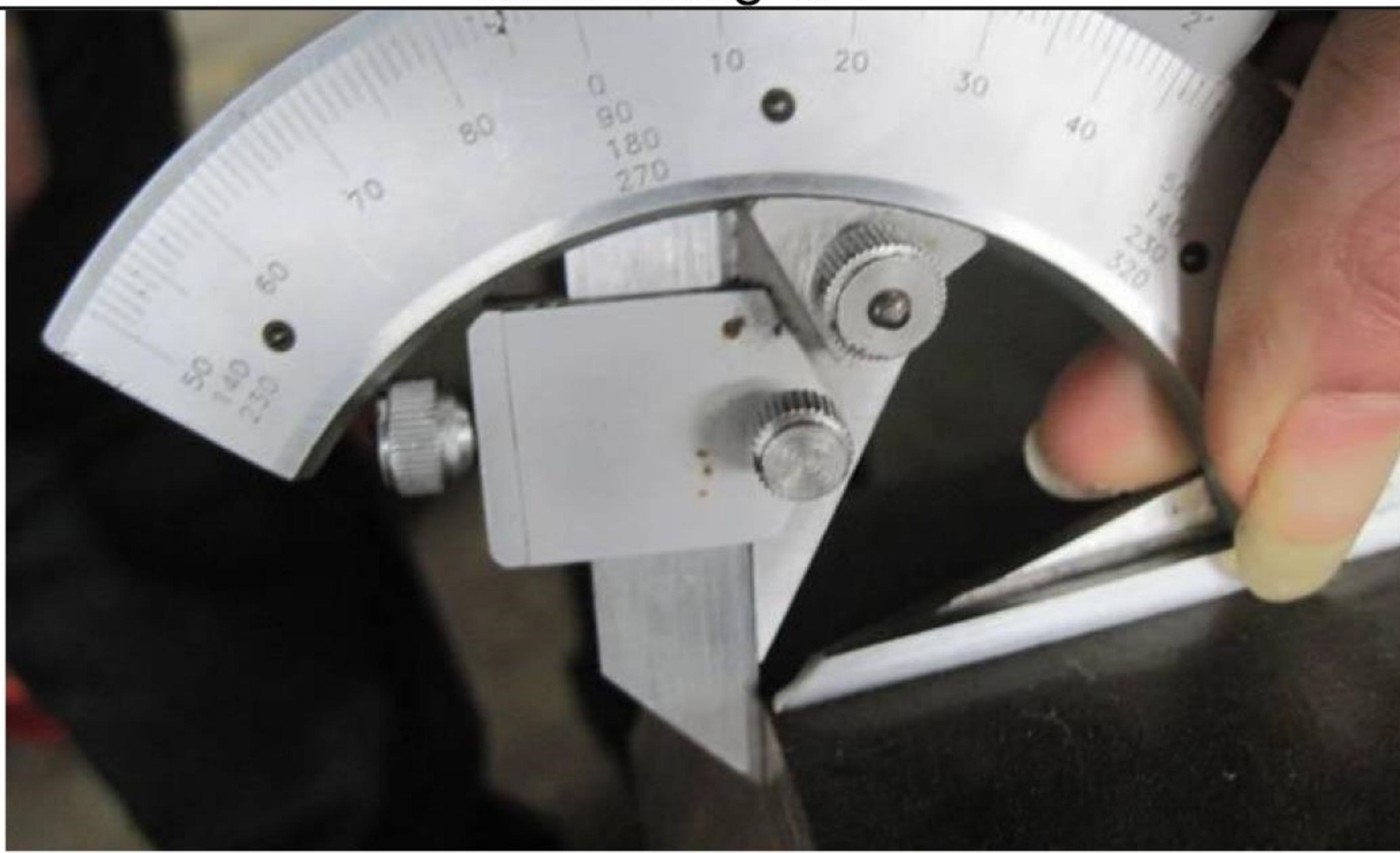
Measuring OD

Measuring OD of pipe end

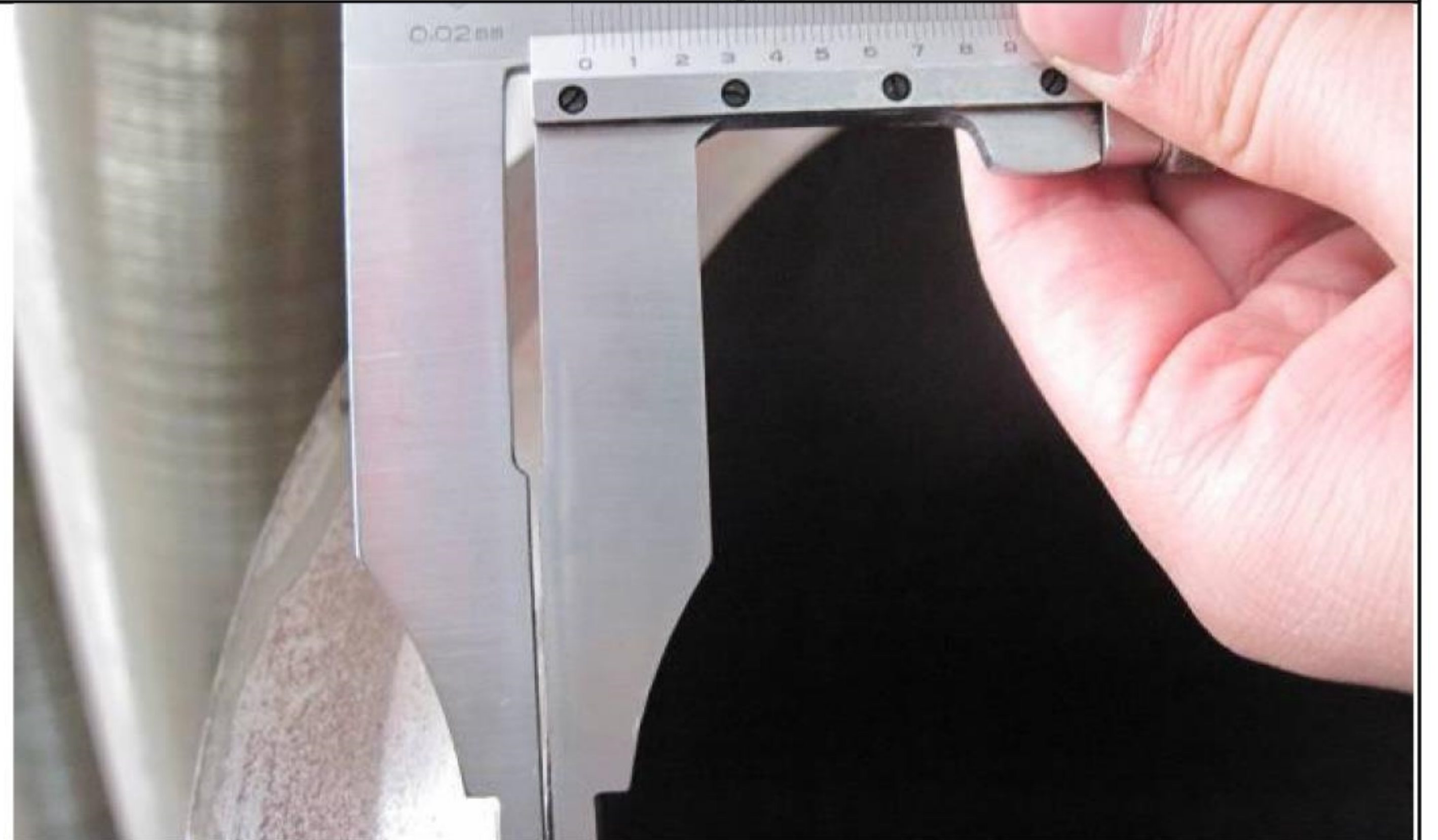
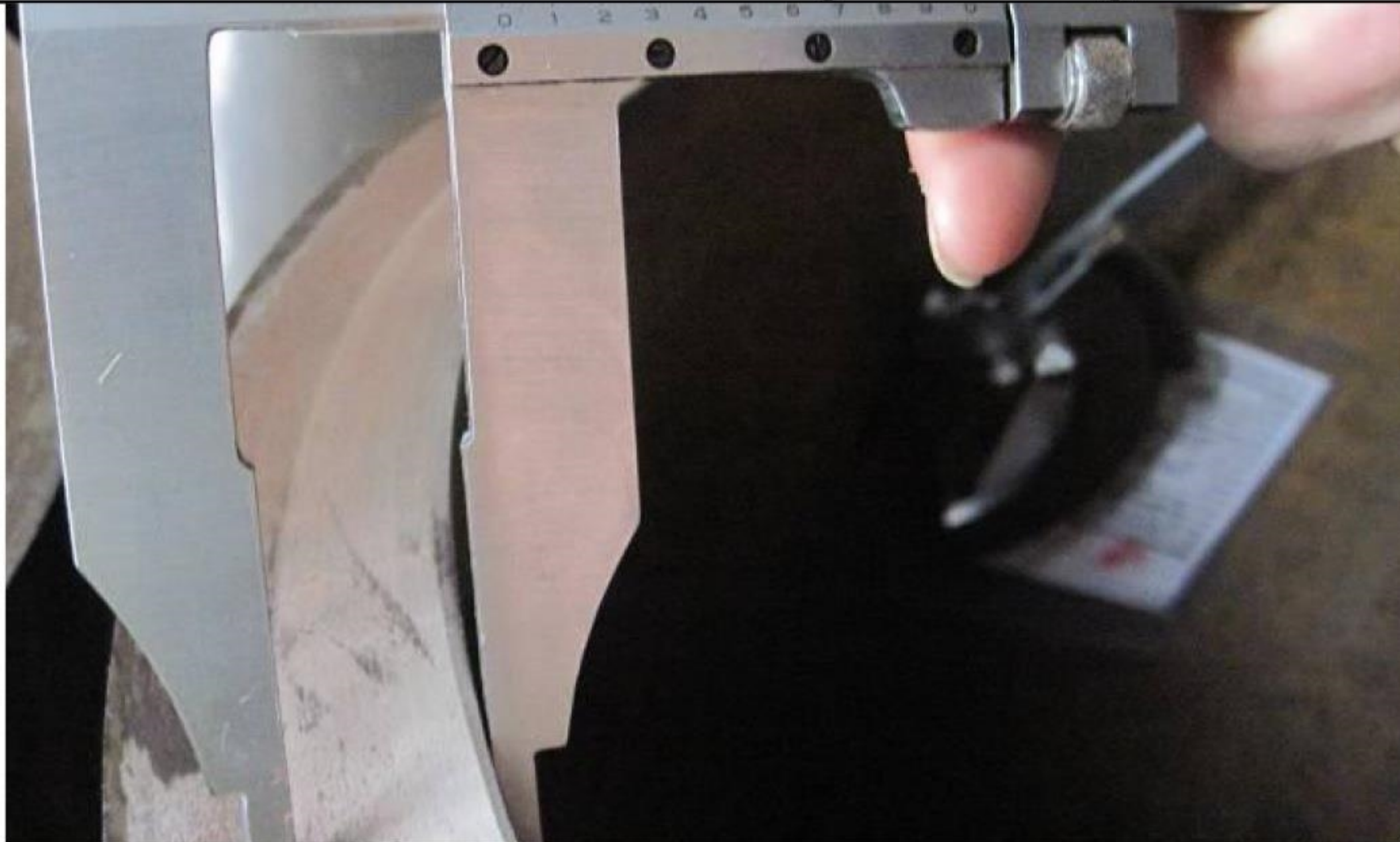


Measuring WT

Measuring length



Measuring bevel angle in accordance with ASME B16.25, fig. 3a



Measuring height of bevel angle and root face in accordance with ASME B16.25, fig. 3a

### **3. Packaging, quantity and marking inspection**

- 1) The mill had fixed end protectors on both of pipe ends;
- 2) The quantity of the finished pipes was right;
- 3) The mark was right;
- 4) The shipping marking was right.

Photo attachment as below

- **Review of Documentation**

The mill provided Material Test Certificate.

The mill provided UT Record.

The mill provided Hydrostatic Test Record.

The mill provided Physical and Chemical Inspection Report.

The mill provided Inspection Report of Finished product.