

	INSPECTION REPORT		
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Job Report No. HYD00009443E	Inspection Date: May. 31-June 2, 2012
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CLIENT	LUMAR METALS	PROJECT	N/A
JOB	N/A	PURCHASE ORDER	GNL-1920A
VENDOR PLACE	CHENGDU DERBO STEEL CHINA	VENDOR JOB NUMBER	N/A
SUB-VENDOR PLACE	N/A	SUB-VENDOR JOB NUMBER	N/A
TYPE OF MATERIAL	SMLS bare pipes, Coated pipes, STUD bolt and nut, Tee, Elbow. Reducers, Weldolets.		
RULES AND CODES	Seamless carbon steel Elbow, Tee, Reducer per ASME B16.9 Stud bolts, nuts per ASME B16.5, ASTM A193/A194, ASME B18.2 Weldolet per MSS SP-97-2006 API 5L DIN30670		
SPCs AND DRWs	Purchase order # GNL-1920A		

Inspection Data sheet	☐ Not To Be Issued	☐ To Be Issued	☐ Quality Control Plan
Pre inspection meeting	☐ Already Done	☐ To Be Fixed	☐ See Sheet
Type of inspection	☐ Preinsp. Visit	☐ Construction Inspection	☐ Account
	☐ Interimmediate Test	☒ Pre-shipment inspection	☐ Balance (Whole Order)
Last Inspection	☐ Yes	☐ No	

Material / description / ref. documents	Type of test	W (1)	Results	DOC (2)
Elbow, LR SCH40 A-234 WPB, ASME B 16.9	Appearance and workmanship check	Yes	Passed	No
	Dimension check	Yes	Passed	No
	Marking check	Yes	Passed	No
	Packing check	Yes	Passed	No
	Certificate verifying	No	Passed	Yes

(1) W = Witnessed Yes or Not INCLUDED : Sheet Yes / No INSPECTOR: Mike Li
Pro QC on behalf of LUMAR METALS

(2) DOC - Document Yes or Not INSPEC DETAILED PROGRESS Yes / No

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Equal tee, SCH40 A-234 WPB, ASME B16.9	Appearance and workmanship check	Yes	Passed	No
	Dimension check	Yes	Passed	No
	Marking check	Yes	Passed	No
	Packing check	Yes	Passed	No
	Certificate verifying	No	Passed	Yes
Reducer (Concentric), SCH40 A234 WPB, ASME B16.9	Appearance and workmanship check	Yes	Passed	No
	Dimension check	Yes	Passed	No
	Marking check	Yes	Passed	No
	Packing check	Yes	Passed	No
	Certificate verifying	No	Passed	Yes
Stud Bolts & Nuts, LG A193-B7, A194-2H, HH	Appearance and workmanship check	Yes	Passed	No
	Dimension check	Yes	Passed	No
	Function check	Yes	Passed	No
	Packing check	Yes	Passed	No
	Certificate verifying	No	Passed	Yes
Weldolet AND SOCKOLET, A105, SCH40 MSS SP-97	Appearance and workmanship check	Yes	Passed	No
	Dimension check	Yes	Passed	No
	Marking check	Yes	Passed	No
	Packing check	Yes	Passed	No
	Certificate verifying	No	Passed	Yes
Bare pipe, SMLS, SCH 40 API 5L GR.B	Appearance and workmanship check	Yes	Passed	No
	Dimension check	Yes	Passed	No
	Marking check	Yes	Passed	No
	Packing check	Yes	Passed	No
	Certificate verifying	No	Passed	Yes
Coated pipe, ERW Steel pipes API 5L Gr. B 3LPE, DIN30670 DRL	Appearance and workmanship check	Yes	Passed	No
	Dimension check	Yes	Passed	No
	Marking check	Yes	Passed	No
	Packing check	Yes	Passed	No
	Certificate verifying	No	Passed	Yes

NOTES:

For 1", 2" 3" 4" and 6" SMLS bare pipes, the goods are packed with steel belt.
For 3", 4" and 6" coated pipes, the goods are packed with steel belt, too..
See Details & Result of Inspection on page 6 & 7 for ref.

(1) W = Witnessed	Yes or Not	INCLUDED : Sheet	Yes / No	INSPECTOR: Mike Li
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ATTENDEES:

Mr. Gao from Eastern
Mr. Han from Eastern
Mr. Mike Li, Pro QC inspector on behalf of HYDERCO UK

SCOPE OF INSPECTION:

DESCRIPTION	RESULT
Pre-shipment inspection of elbow per ASME B16.9	Passed
Pre-shipment inspection of equal tee per ASME B16.9	Passed
Pre-shipment inspection of reducer(concentric) per ASME B16.9	Passed
Pre-shipment inspection of stud bolts and nuts per ASME B 16.5, ASTM A193, ASTM A194, ASME B18.2	Passed
Pre-shipment inspection of weldolet per MSS SP-97-2006.	Passed
Pre-shipment inspection of SMLS bare pipes per API 5L	Passed
Pre-shipment inspection of coated pipes per DIN 30670 DRL	Passed

DOCUMENT USED:

DOCUMENT USED	DOC. NUMBER	REV.	ISSUE DATE
Purchase Oder	GNL-1920A	N/A	March 21, 2012
Standard Specification for Carbon Steel Forgings for Piping Applications	ASTM A105/A105M-05	N/A	N/A
Factory-Made Wrought Butt welding Fittings	ASME B16.9-2003	N/A	N/A
Integrally Reinforced Forged Branch Outlet Fittings	MSS SP-97-2006	N/A	N/A
Square and Hex Bolts and Screws	ASME B18.2.1a-1999	N/A	N/A
Standard specification for Alloy-steel and stainless steel bolting materials for high temperature or high pressure service and other special purpose applications	ASTM A193/A193M-07	N/A	N/A
API SPECIFICATION 5L	API 5L	N/A	October 1, 2007
Polyethylene coating for steel pipe and fittings Requirements and testing	DIN 30670	N/A	April 1, 1991
Standard Specification for Carbon and Alloy Steel Nuts for Bolts for High Pressure or High Temperature Service, or Both	ASTM A194/A194M-04a	N/A	N/A
Standard Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and	ASME A234/A234M-07	N/A	N/A

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High Temperature Service			
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TEST INSTRUMENTS USED:

EQUIPMENT NAME	MANUFACTURER	MODEL	NEXT CALIBRATION
Caliper	China domestic	0-200mm	Dec. 10, 2012
Thickness tester	China domestic	0-10mm	Dec. 10, 2012
Measuring Tape	China domestic	50m max.	N/A
Caliper	China domestic	0-500mm	Dec. 10, 2012

ATTACHMENTS:

DESCRIPTION	TYPE (Letter, fax, certificates....)	PAGES	REMARK
Mill Certificate of elbows	Certificate	8	
Mill Certificate of Tee	Certificate	5	
Mill Certificate of reducer concentric	Certificate	5	
Mill Certificate of stud bolts & nuts	Certificate	1	
Mill Certificate of weldolet	Certificate	13	
Mill Certificate of SMLS bare pipes	Certificate	5	
Mill Certificate of ERW coated pipes	Certificate	4	

1. - Material Inspected:

M A T E R I A L I N S P E C T E D		Q U A N T I T Y (P C S)			
ITEM NO	BRIEF DESCRIPTION	TOTAL ORDER	PRESENTED	ACCEPTED	ACCEPTED TO DATE
1	1" SMLS BARE PIPE SCH 40 API 5L GR.B SRL	200 meter	204 meter	204 meter	204 meter
2	2" SMLS BARE PIPE SCH 40 API 5L GR.B SRL	200 meter	204 meter	204 meter	204 meter
3	3" SMLS BARE PIPE SCH 40 API 5L GR.B DRL	200 meter	200.6 meter	200.6 meter	200.6 meter
4	4" SMLS BARE PIPE SCH 40 API 5L GR.B DRL	200 meter	200.6 meter	200.6 meter	200.6 meter
5	6" SMLS BARE PIPE SCH 40 API 5L GR.B DRL	200 meter	200.6 meter	200.6 meter	200.6 meter
6	COATED ERW STEEL PIPES API 5L GR.B 3" X 5.49 3LPE COATING, 2.7mm thickness Min, DIN30670 DRL	1500 meter	1498.6 meter	1498.6 meter	1498.6 meter
7	COATED ERW STEEL PIPES API 5L GR.B 4" X 6.02 3LPE COATING, 2.7mm	2000 meter	2006 meter	2006 meter	2006 meter

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	thickness Min, DIN30670 DRL				
8	COATED ERW STEEL PIPES API 5L GR.B 6" X 7.11 3LPE COATING, 2.7mm thickness Min, DIN30670 DRL	2000 meter	2006 meter	2006 meter	2006 meter
9	Stud Bolt and Nut 3/4" x 115mm, A193 B7/A194.2H, SBN/ 115	300 sets	300 sets	300 sets	300 sets
10	Stud Bolt and Nut 3/4" x 110mm, A193 B7/A194.2H, SBN/110	300 sets	300 sets	300 sets	300 sets
11	Stud Bolt and Nut 7/8" x 130mm, A193 B7/A194.2H, SBN/130	300 sets	300 sets	300 sets	300 sets
12	Stud Bolt and Nut 5/8" x 95mm, A193 B7/A194.2H, SBN/95	300 sets	300 sets	300 sets	300 sets
13	2" 45 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
14	3" 45 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
15	4" 45 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
16	6" 45 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
17	8" 45 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
18	2" 90 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
19	4" 90 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
20	6" 90 DEGREE ELBOW LR SCH 40 A234 WPB ASME B16.9	50pcs	50pcs	50pcs	50pcs
21	EQUAL Tee 2",SCH 40. A-234 WPB, ASME B 16.9	20pcs	20pcs	20pcs	20pcs
22	EQUAL Tee 3",SCH 40. A-234 WPB, ASME B 16.9	20pcs	20pcs	20pcs	20pcs
23	EQUAL Tee 6",SCH 40. A-234 WPB, ASME B 16.9	20pcs	20pcs	20pcs	20pcs
24	1/2" PRESSURE INDICATOR PI/25/05 150#	5pcs	0	0	0
25	1/2" PRESSURE INDICATOR PI/605 150#	5pcs	0	0	0
26	6"x4" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	15pcs	15pcs	15pcs	15pcs
27	6"x3" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	15pcs	15pcs	15pcs	15pcs
28	4" STEEL EQUAL TEE SCH 40 A234 WPB ASME B 16.9	10pcs	10pcs	10pcs	10pcs
29	3"x2" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	10pcs	10pcs	10pcs	10pcs
30	4"x3" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	10pcs	10pcs	10pcs	10pcs
31	6"x3" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	10pcs	10pcs	10pcs	10pcs
32	6"x4" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	10pcs	10pcs	10pcs	10pcs
33	3"x2" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	10pcs	10pcs	10pcs	10pcs
34	4"x2" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	10pcs	10pcs	10pcs	10pcs
35	4"x3" STEEL CON. REDUCER SCH 40 A234 WPB ASME B 16.9	20pcs	20pcs	20pcs	20pcs

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44	2"×4", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
45	2"×3", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
46	3"×6", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
47	4"×6", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
48	3"×4", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
49	3"×12", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
50	4"×12", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
51	6"×12", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
52	2"×12", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
53	3"×18", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
54	4"×18", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
55	6"×18", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs
56	2"×18", WELDOLET SCH 400 A105, MSS SP-97	10pcs	10pcs	10pcs	10pcs

2. - Details and results of inspection:

Appearance check

All the items have been visual checked for appearance defects and bad workmanship. Acceptable.
All the elbows, Tees, reducers have been bevelled at the ends and black painted. Acceptable.
The workmanship of machining parts like weldolets, bolts & nuts, is satisfactory.

Dimension check

The dimensions were checked according to the contract and technical standards.
Tees', Reducers' and elbows' dimensions were checked per ASME B16.9. The result is satisfactory.
Stud bolts and nuts dimension per ASME B16.5, ASTM A193/A194 & ASME B18.2.1a-1999. The result is satisfactory.
The weldolets' dimension were in accordance with MSS SP-97.
The bare pipes were SMLS, also the dimension were in accordance with API 5L.
The ERW coated pipes were in accordance with DIN30670.

Marking check

The elbows, reducers, Tees, weldolets, gaskets, bare pipes and ERW coated pipes are with stamps on the body.
The stamp markings on the weldolets are in accordance with corresponding standards.

Packing check

All elbows, reducers, and tees are packed on wooden pallets fastened with steel band and then wrapped with poly sheets. Acceptable.
All the bolts & nuts are packed into the carton. Acceptable.
All the weldolets are packed into the carton with poly bag. Acceptable.

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Function check

The bolts+nuts sets were function checked by screw the bolt in and out of the nut to the whole length of the bolts. Satisfactory.

Certificate verifying

All the certificates have been reviewed by the inspector. The certificates are in accordance with corresponding standards.

3. - Outstanding Action:

For the SMLS bare pipes, the quantity is followings:

1"---34pcs x 6meter, 2"---34pcs x 6meter,
3"---17pcs x 11.8meter, 4"---17pcs x 11.8meter, 6"---17pcs x 11.8meter,

For the ERW coated pipes, the quantity is followings:

3"---127pcs x 11.8meter, 4"---170pcs x 11.8meter, 6"---170pcs x 11.8meter,

The supplier needs to pack all weldolets and bolts, nuts which had been packed into the carton into the wooden case before shipment.

According to the statement from the supplier, the client had cancelled the item no.24 and item no.25 (Pressure Gauges), so the quantity inspected is zero.

4. - Conclusion:

All the parts have been checked according to purchase order # GNL-1920A and corresponding technical standards. The result is satisfactory.

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A. Product Storage and Packaging Conditions



Storage-1



Storage-2



Storage-3



Storage-4



Packaging-1



Packaging-2

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Packaging-3



Packaging-4



Packaging-5



Packaging-6



Packaging-7



Packaging-8

B. Products view and marking

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Marking-item 14



Marking-item 14



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View-item 15



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view-item 16



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View-item 29



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View-item 30



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View-item 31



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View-item 28



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View-item 46



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View-item 56



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View-item 10



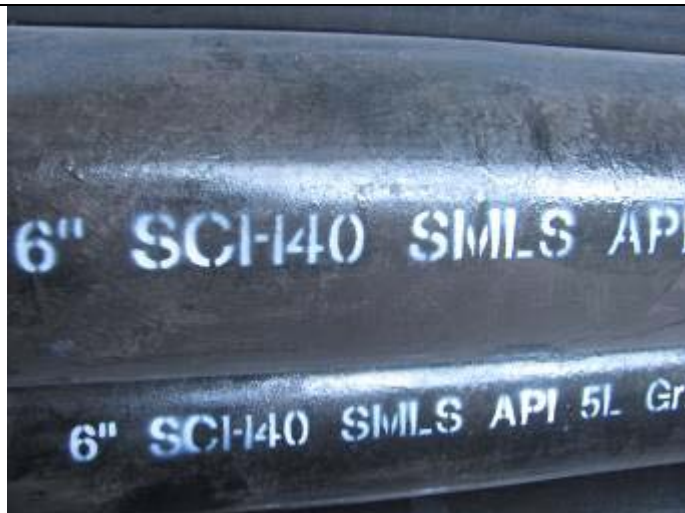
View-item 11



View-item 12



View-item 5



Marking-item 5



Marking-item 5

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View-item 4



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View-item 3



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Marking-item 1



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View-coated pipe



Marking-item 6



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C. Dimension check and quantity check

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#1, Lane 89 Hsing Yi Road, Peitou, Taipei, Taiwan, R.O.C. Tel: +886-2-2871-0188 Fax: +886-2-2872-1227 E-mail: proqc@proqc.com



Dimension check



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