



INSPECTION REPORT Nr. IDD/B-08/102

☐ Interim
☒ Final

BV Job nr: IDD/B-12/102

PROJECT: BLACK STEEL SEAMLESS PIPES	Ref: IDD/B-12/102
BV Client: Asia Electro Mechanical Co., Ltd	P/o nr: IDD/B-12/102 (client to BV)
Manufacturer: Chengdu Derbo Steel Co.,Ltd	P/o nr: HEBEI120723 (client to Manufacturer)
Inspection requested by: Asia Electro Mechanical Co., Ltd	

SUPPLY / SUBJECT OF INSPECTION	ITEM / TAG Nr	PCS
Black Steel Seamless Pipe According to Standard ASTM A106 GR.B/A53 GR. B, Length equal to 5.8 Meters, Black Varnish Coating, Both ends with plastic caps. Detailed pipes as following page.		

DOCUMENTS OF REFERENCE : See continuation sheet for additional documents: ☐ Yes ☒ No

Title	Reference n°	Rev.	Approved by	Date
Standard specification for seamless carbon steel pipe for high-temperature service	ASTM A106		ASTM	
Standard specification for Pipe, steel, black and hot-dipped, zinc-coated, welded and seamless	ASTM A53		ASTM	
Proforma Invoice				Jul.23,2008

INSPECTIONS :**Inspection place & Date or Period:**Yanshan County, Cangzhou City, Hebei
Oct.13--17, 2008**Stage of inspection :**

- ☐ Before manufacturing
☐ During manufacturing
☒ Final
☐ Packing

Kind of inspection:

- ☐ Pre-inspection meeting
☐ Witnessing tests
☒ Final inspection
☒ Document review
☐ Expediting & vendor assessment
☐ Packing
 (for details see continuation sheet)

Stamping :
☒ No ☐ ☐
Results of inspection : ☒ Satisfactory ☐ Unsatisfactory**Non Conformities Reports (NCR):**

o NCR's issued during reported period :
None

o List of outstanding NCR's :
None

Main Conclusions & Remarks: (for details see continuation sheet)

BV surveyor performed the final inspection for the pipes listed above at manufacturer's workshop; the inspection result is acceptable in accordance with relative standard and contract.

M/S. BUREAU VERITAS CONFIRMING SUCCESSFUL COMPLETION OF THE WORKS.

For more detail, please refer to inspection details

Next visit scheduled:

N/A


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(continued)

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SUPPLY / SUBJECT OF INSPECTION	ITEM / Weight	PCS
3/4"xsch40 (26.7x2.87mm)	14700 kg	1500 PCS
1"xsch40 (33.4x3.38mm)	50750 kg	3500 PCS
1 1/4"xsch40 (42.2x3.56mm)	19700 kg	1000 PCS
1 1/2"xsch40 (48.3x3.68mm)	3525 kg	150 PCS
2 1/2"xsch40 (73.0x5.16mm)	5010 kg	100 PCS
3"xsch40 (88.9x5.49mm)	5240 kg	80 PCS
4"xsch40 (114.3x6.02mm)	9320 kg	100 PCS
5"xsch40 (141.3x6.55mm)	12630 kg	100 PCS
6"xsch40 (168.3x7.11mm)	16390 kg	100 PCS
8"xsch40 (219.1x8.18mm)	24680 kg	100 PCS
10"xsch40 (273.0x9.27mm)	41964 kg	120 PCS
12"xstd (323.8x9.52mm)	12837 kg	30 PCS
Total	216746 kg	6880 PCS

Description of the inspections carried out:

§ Introduction

This is to report that inspector of Bureau Veritas Consulting (Shanghai) Company, at the request of Asia Electro Mechanical Co., Mr. Zheng Wang carry out Third Party Inspection for seamless steel pipe from Oct. 13 ~ 17, 2008, more details described as following:

* Scope of work:

Visual inspection

Dimensional control

Document review

§ Applicable Documents & Status of Approval

Raw material quality certificate

Mill Test Certificate

§ Manufacturing Progress Status

When BV surveyor carrying out inspection, all pipes has been finished, but plastic caps for

pipes without fixing, manufacturer said that they will finish these work before delivery.

§ Details of inspection activities carried out with respect to scope of work. Surveillance with reference to ITP

1. Visual and marking inspection

The visual and marking quality were checked at 10% random. Marking includes executive product standard, size, schedule no, length, heat no, WUXI TAIHU CHINA

Marking example: **ASTM A53/A106 GR. B 3" xSCH40x5.8 MTR HEAT NO WB82-2739**

WUXI TAIHU CHINA

The result is acceptable.

See below photos on site:



Overview



Marking

2. Dimension inspection

There are 12 types seamless carbon steel pipes in total, the outside diameter, thickness and length were checked by BV surveyor at random 10%.

After inspection, the result meets the relative requirement. See below tables:

3/4" SCH40 (26.7mm*2.87mm) pipes, total 1500 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	26.7 mm (+0.4, -0.8)	26.9-27.1	Pass
Thickness	2.87 mm (+0.57, -0.36)	3.0-3.4	
Length	5.8 m	5.81-5.835	

1" SCH40 (33.4mm*3.38mm) pipes, total 3500 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	33.4 mm (+0.4, -0.8)	33.1-33.4	Pass
Thickness	3.38 mm (+0.67, -0.42)	3.7-4.0	
Length	5.8 m	5.82-5.835	

1 1/4" SCH40 (42.2mm*3.56mm) pipes, total 1000 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	42.2 mm (+0.4, -0.8)	42.1-42.3	Pass
Thickness	3.56 mm (+0.71, -0.44)	3.6-3.85	
Length	5.8 m	5.82-5.83	

1 1/2" SCH40 (48.3mm*3.68mm) pipes, total 150 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	48.3 mm (+0.4, -0.8)	48.1-48.2	Pass
Thickness	3.68 mm (+0.74, -0.46)	3.8-3.9	
Length	5.8 m	5.81-5.83	

2 1/2" SCH40 (73.0mm*5.16mm) pipes, total 100 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	73.0 mm (+0.8, -0.8)	72.7-73.4	Pass
Thickness	5.16 mm (+1.0, -0.64)	5.3-5.5	
Length	5.8 m	5.81-5.83	

3" SCH40 (88.9mm*5.49mm) pipes, total 80 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	88.9 mm (+0.8, -0.8)	88.9-89.1	Pass
Thickness	5.49 mm (+1.23, -0.69)	5.3-5.7	
Length	5.8 m	5.81-5.825	

4" SCH40 (114.3mm*6.02mm) pipes, total 100 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	114.3 mm (+1.59,-0.79)	114.2-114.4	Pass
Thickness	6.02 mm (min5.26mm)	5.4-6.0	
Length	5.8 m	5.82-5.83	

5" SCH40 (141.3mm*6.55mm) pipes, total 100 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	141.3 mm (+1.59,-0.79)	141.1-142	Pass
Thickness	6.55 mm (min5.74mm)	6.3-6.7	
Length	5.8 m	5.825-5.83	

6" SCH40 (168.3mm*7.11mm) pipes, total 100 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	168.3 mm (+1.59,-0.79)	168.0-168.3	Pass
Thickness	7.11 mm (min6.22)	6.5-7.3	
Length	5.8 m	5.82-5.84	

8" SCH40 (219.1mm*8.18mm) pipes, total 100 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	219.1 mm (+1.6, -0.8)	218.5-219.1	Pass
Thickness	8.18 mm (+1.84, -1.0)	8.0-8.4	
Length	5.8 m	5.815-5.82	

10" SCH40 (273mm*9.27mm) pipes, total 120 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	273.0 mm (+2.4, -0.8)	273.0-274.0	Pass
Thickness	9.27 mm (+2.08, -1.16)	9.1-9.6	
Length	5.8 m	5.81-5.825	

12" STD (323.8mm*9.52mm) pipes, total 30 pcs:

Inspection Items	Tolerance or Requirement	Actual value	Result
Outside Diameter	323.8 mm (+2.4, -0.8)	323.3-325	Pass
Thickness	9.52 mm (+2.14, -1.19)	9.8-10.5	
Length	5.8 m	5.81-5.82	

Photos on site as follow:



Outside diameter, wall thickness, length checking

3. Documents review

Raw material quality certificates, Mill Test Certificate are provided by manufacturer, after BV

surveyor reviewing, they are acceptable.

§ **Results of Inspection**

Based on above evidence, all the pipes are deemed to meet sales contract and ASTM A53/A106 requirements.

The result of inspection is satisfactory.

§ **Problems pending:**

None

ANNEXES ☒ Yes (Total number of pages: 12) ☐ No

Inspected by:

Name: Wang Zheng & Wang Piyuan

Signature:

Zhang Wang Wang Piyuan



Checked by:

Name: Wan Ke

Signature:

Wan Ke

Date of issue: Oct.17,2008

Inspection centre: BV Shanghai

Distribution: ☒ CLIENT

☒ MANUFACTURER

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