



Velosi China Inspection Report

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Client: Metals International Limited	PO No: 09786	
SO No.: N/A	Job No.: N/A	Report No.: IR-08162
Client Account Code: N/A	WO No.: N/A	Date of Visit: 15, Dec, 2013

MATERIAL INSPECTED THIS VISIT

Item No.	Quantity (pcs)	Description
1	225	ASME SA335 P22 (PART1) 508*26.19;
2	62	ASME SA335 P11 (PART1) 508*9.53;
3	84	ASME SA335 P11 (PART1) 457.2*14.27;
4	93	ASTM A106 GR.B (PART1) 323.9*10.31;
5	112	ASTM A106 GR.B (PART1) 273.1*9.27;
6	51	ASTM A106 GR.B (PART2) 273.1*9.27;
7	81	ASTM A106 GR.B (PART2) 406.4*9.53;
8	63	ASTM A106 GR.B (PART1) 457.2*14.27;

RESULTS OF INSPECTION:	Acceptable	Non-compliance	ORDER STATUS:	Complete	Incomplete
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1.0 INSPECTION SUMMARY

Inspector from Velosi China, Liu Xiaotao, visited Wuxi Special Steel Material Co., Ltd on Dec. 15, 2013 to carry out the pre-shipment inspection for the pipes above mentioned. The details of inspection activities can be referred to the report in following pages:

- Quantity check
- Visual inspection
- Dimensional check
- Witness Spectrographic Analysis test (PMI)
- Check packing and pipe marking
- Document review

The inspection results were seen to be acceptable.

Record Hours

Vendor / Report Hours: 6/2	Traveling Hours: 5 (round)	Distance Traveled: 300 km.
Inspecting Engineer: Liu Xiaotao Date: 15, Dec, 2013 Signed: Liu Xiaotao 	Reviewed by: Austin Tian Date: 15, Dec, 2013 Signed: Austin Tian 	Page 1 of 5

2.0 PERSONS PRESENT

Mr. Gao Jianjun --- Supervisor of Quality Dept.

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Ms. Wang Bei --- Engineer of the factory

Mr. Liu Xiaotao --- Inspector of Velosi-China

3.0 DOCUMENTATION USED

Purchase Order 09786

ASME A335/A335M-95a; ASTM A106

EN 10204 3.1B

4.0 INSPECTION CARRIED OUT

- **Quantity check**

The writer verified the quantity of pipes for all items. The tolerances is -0/+3% per item, some items have exceeded the limit a little, such as ASME SA335 P11 (PART1) 457.2*14.27 (required length: 30meter; actual: 31.91meter), ASTM A106 GR.B (PART1) 323.9*10.31 (required length: 30meter; actual: 31.10) and ASTM A106 GR.B (PART1) 273.1*9.27 (required length: 110meter; actual: 114.28meter). The manufacturer explained that they had confirmed the quantity with client, so accepted.

- **Visual inspection**

The writer checked the appearance for all pipes; No burrs, scales and other defects were found on the inside or outside surface, but some mill scale and scrap iron were found inside the pipes, the manufacturer has ensured that they would clean them before shipping.

- **Dimension check**

The writer randomly checked the dimensions according to ASME A335/A335M-95a and ASTM A106.

The length of all cutting pipes is between 6-11.8 meter, conformed to purchase order demands; and the writer randomly checked the length for some pipes, the test results were in compliance with the length marked on pipe surface.

The writer also randomly checked the outside diameter and wall thickness. The tolerance of wall thickness is $\pm 12.5\%$; and the tolerance of outside diameter is $-0.79/+2.38$ (NPS over 8 to 18 inches) and $-0.79/+3.18$ (NPS over 18 to 26 inches). All measured diameter were in control limits.

The inspector also checked the gauge's validity & calibration.

- **Witness Spectrographic Analysis test (PMI)**

The writer randomly witnessed the PMI tests for all item pipes, all tested results have been recorded in photos, and the writer also checked the results according to specifications, no chemical components were out of control limits.

The results can be accepted.

- **Check packing and pipe marking**

The writer visually checked the packing and ensured that both ends of every pipe had been fitted with metal end protectors.

The writer also checked product marking according to specifications and shipping mark according to purchase order 09786. The results were acceptable.

- **Document review**

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- The inspector reviewed & duly endorsed the MTC of pipes of the PO. The MTC met the requirements of EN 10204 3.1B. The content & description was accepted.
- The writer also reviewed the test records of manufacturer, such as hydro-test records, heat treatment records, dimension check records, chemical components analysis records, ultrasonic test records and Eddy-Current Examination records.
- No error was found, the results were acceptable.

5.0 RESULTS/CONCLUSIONS





The inspection results were seen to be acceptable.

6.0 NEXT VISIT / EXIT CALL

TBD

7.0 PHOTOS

For all details

	<p>Photo 1. Appearance and quantity check.</p>		<p>Photo 2. Appearance and quantity check.</p>
	<p>Photo 5. Inner surface check.</p>		<p>Photo 6. Dimension check.</p>

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Photo 7.
Dimension
check.



Photo 8.
Dimension
check.



Photo 9.
Dimension
check.



Photo 10.
PMI test.

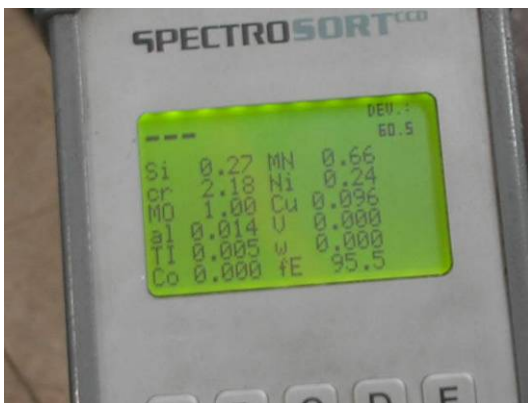


Photo 11.
PMI test.

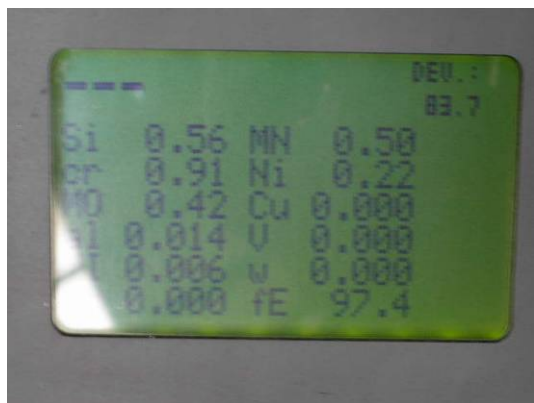


Photo 12.
PMI test.

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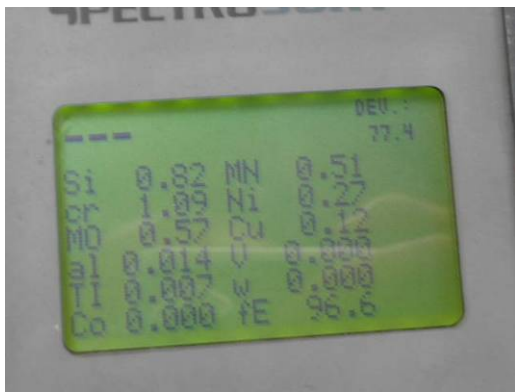


Photo 13.
PMI test.



Photo 14.
PMI test.

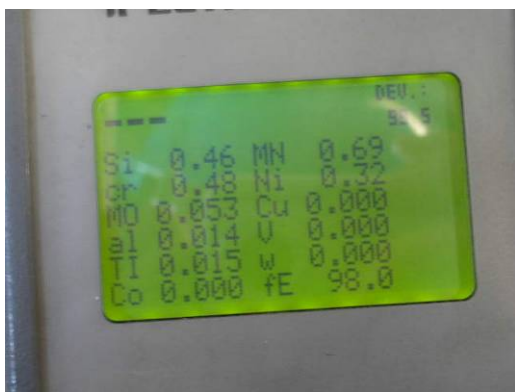


Photo 15.
PMI test.

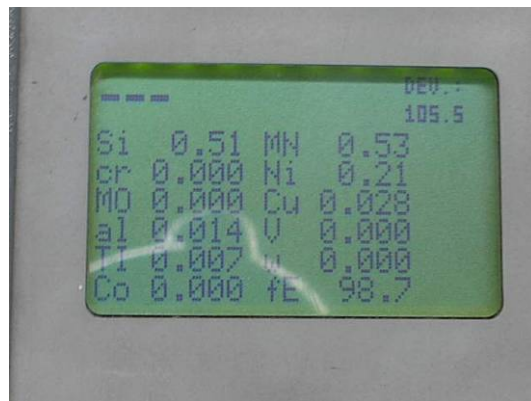


Photo 16.
PMI test.

The End