



## 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.  
G2NG-5-0001-01

Inspection	SMLS Pipes			
Purchaser:	Santos (Australia) Pty Ltd.			
Specification:	API 5L 44 <sup>th</sup> Edition Gr.B / ASTM A106 Gr. B	Inspector:	Lin 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

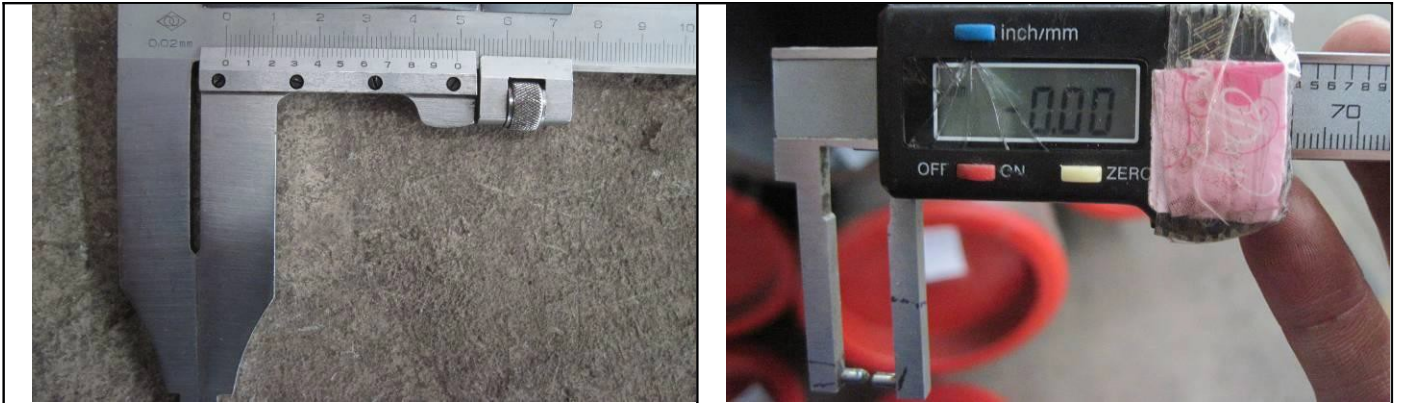
We had measured pipe dimensions randomly. The detailed data is in the following table.

Dimensio (mm)	Heat No.	Batch No. & Bundle	OD (mm)	WT (mm)	Length (m)	Bevel angl	Bevel angl	Height of bevel	Root fa
219.1*25.4	1133073	82Z300340 K001	218.4 219	25.51~ 26.66	6.88	8.8/9.5	37.0/36.5	19.5/20.4	1.2~2.3
219.1*25.4	1133073	82Z300340 K003	218.3 220.3	25.82~ 26.86	7.05	9.0/9.4	36.0/37.0	19.4/19.9	1.1~2.3
406.4*40.49	1127562V	71Z400015 J217	408.2 409	39.73~ 41.33	8.32	9.6	37.7	18.8	1.2~1.9
406.4*40.49	1127562V	71Z400015 J218	406.9 409.1	38.57~ 41.48	8.48	10	37.4	20.5	1.0~2.0
406.4*30.96	1127551V	71Z400008 J173	407.2 409	30.14~ 31.87	8.54	9.3	38	20	1.4~1.9
406.4*30.96	1127551V	71Z400008 J174	408.5 409.7	29.65~ 33.10	8.45	9	36.9	20.4	1.1~2.1
457.2*14.27	1127672V	71Z100103 J082	458.5 460.4	13.34~ 16.48	9.8	/	37.6	/	0.9~2.0
457.2*14.27	1127672V	71Z100103 J084	460.2 461.7	14.34~ 14.79	10.55	/	37.1	/	1.1~1.8
457.2*14.27	1221884V	72Z300387 J075	458.8 459.6	13.15~ 14.43		/	38	/	0.8~1.2
457.2*14.27	1221884V	72Z300387 J077	458.8 459.2	13.96~ 14.28		/	37.5	/	1.0~1.2
508*50.01	1127404V	71Y200129 J284	508.0 509.2	49.10~ 52.81	8.77	9.5	38.2	19.4	1.3~2.0
508*50.01	1127402V	71Y200127 J236	509.4 510.8	50.57~ 54.44	8.86	9.8	37	20	1.6~2.0
508*50.01	1127404V	71Y200129 J281	508.9 510.8	49.77~ 53.44	8.82	9	37.5	19.7	1.6~2.2

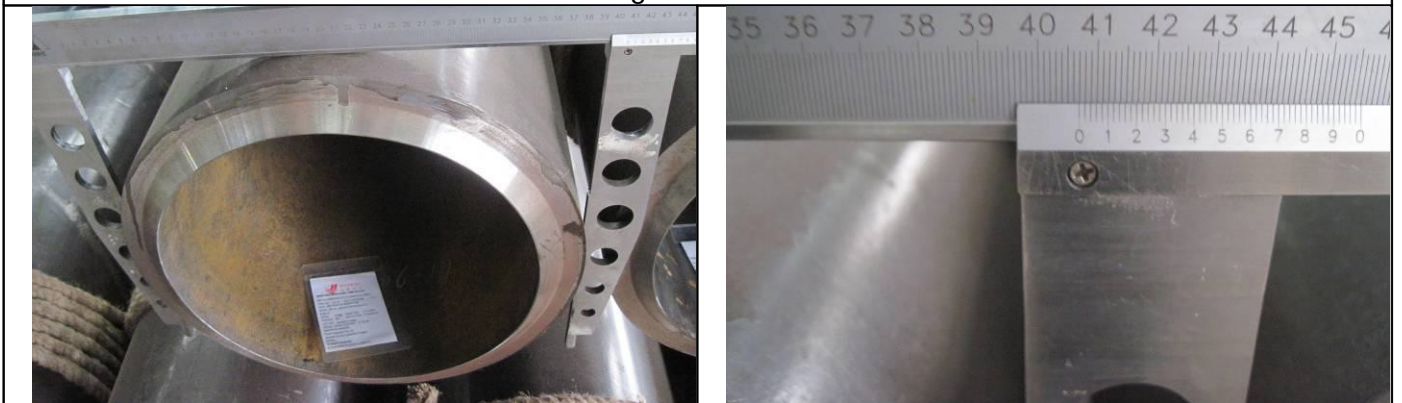


508*15.09	1221882 V	72Z100311 J108	509.2 511.5	14.75~ 16.43	9.73	/	37.0/36.5	/	1.0~2. 0
508*15.09	1221882 V	72Z100311 J084	510.7 512.4	14.84~ 16.48	9.57	/	37.0/37.5	/	1.1~1. 8
508*50.01	1210803 V	72Z400245 J185	508.1 510.8	48.65~ 52.16	8.9	9.5/9.0	37.5/36.5	18.0/19.5	0.9~1. 8
508*50.01	1210803 V	72Z400245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

Photo attachment as below



Gage calibration



Measuring OD

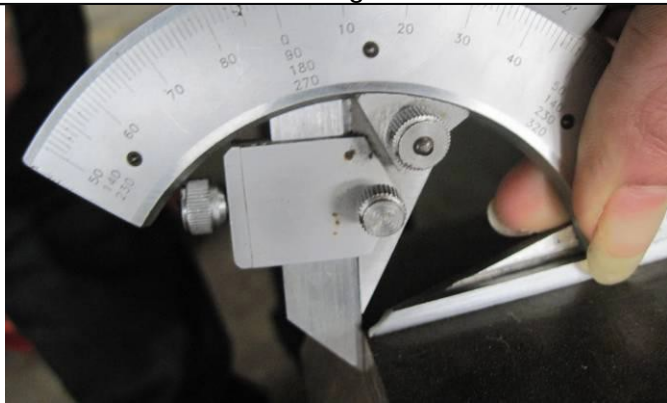
Measuring OD of pipe end



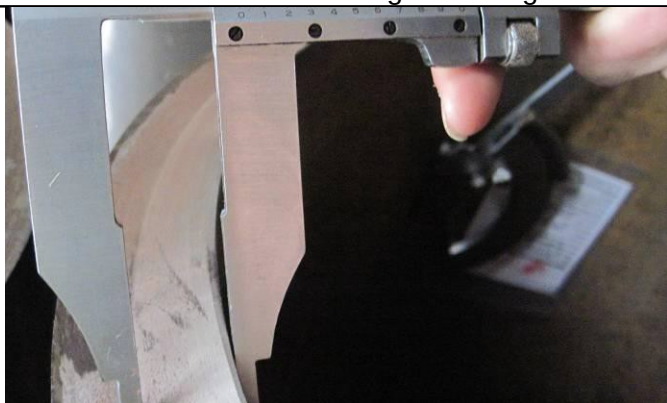
Measuring WT



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.