ABTER

# INSPECTION REPORT

**Report No.: MIL100901409**
Issued on: Oct 08th, 2010
Inspection Time: Sep 30th,

| P.O. No. | 100901409 |
| --- | --- |

Inspection Of Item:        Flanges

Specification:            ASME B16.47/B        Inspector:        Lin Gaojie        Stamp No:

**Visit Summary:**

**Scope of Inspection**
- Visual inspection.
- Dimension inspection.
- Packaging and marking inspection.
- Weight and PMI Test verification.
- Documents review.
- Part photo service.

## Results of inspection to MIL 100901409

- **Process Verification**

**1. Visual Inspection**
    The flanges were good and the surface was bright
    and smooth. Photo attachment as below

## 2. Dimension inspection

We had measured dimensions of one CS flange and SS flange and they were all qualified. The detailed data is in the following table.
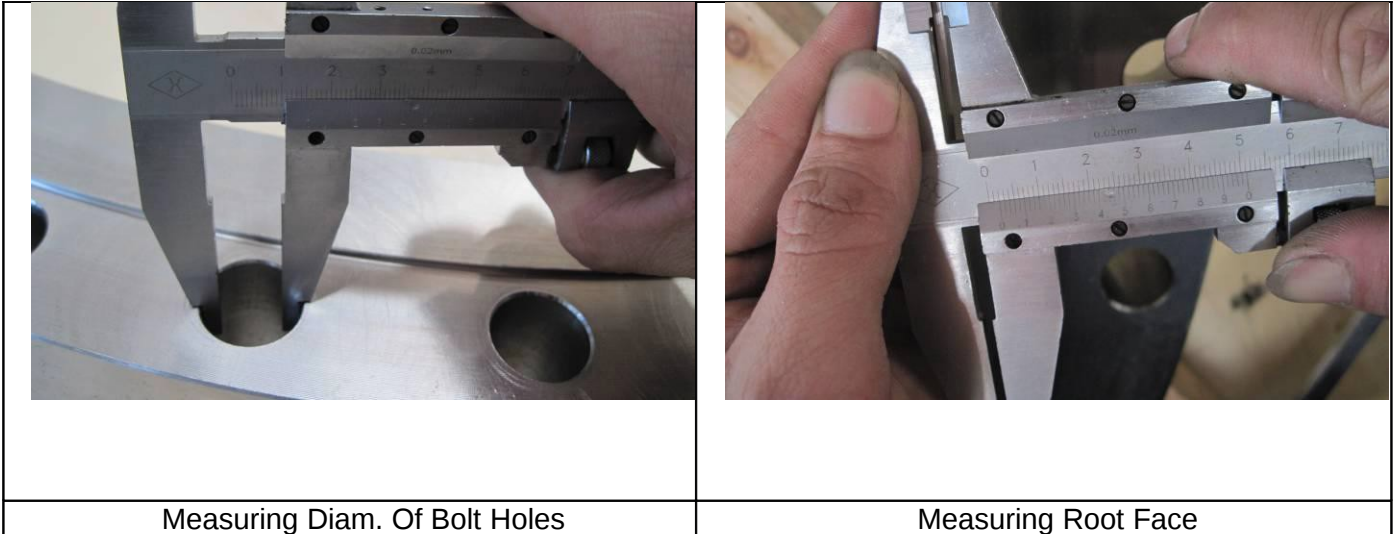
| Product | Size | O / mm | $t_f$ / mm | Y / mm | A / mm | R / mm | h / mm |
|---|---|---|---|---|---|---|---|
| SS Flange | 36" Sch 20 | 1060 | 51.3 | 115.9 | 920 | 971 | 2 |
| CS Flange | 36" Sch 20 | 1060 | 51.1 | 117.5 | 920 | 970 | 2 |

| Product | Size | Diam. Of bolt | No. Of Bolt | Diam. Of Bolt | Root Face | B / mm |
|---|---|---|---|---|---|---|
| SS Flange | 36" Sch 20 | 1009.6 | 44 | 25.4 | 2.1 | 891 |
| CS Flange | 36" Sch 20 | 1008.5 | 44 | 25.5 | 2.1 | 890 |

Photo attachment as below

| | |
|---|---|
| Measuring O | Measuring $t_f$ |
| Measuring A | Measuring R |
| Measuring h | Measuring Diam. Of bolt Circle |

| Measuring Diam. Of Bolt Holes | Measuring Root Face |
| --- | --- |

### 3. Packaging and marking inspection

1)       The Flanges were stacked one by one and filled with plywood plates between two flanges.;

2)  The pipes were completely legibly marked according to contract;

3)       Packing List was on the outside surface of the case.

Photo attachment as below

Packaging

| Plywood case | Packing List |
|:---:|:---:|





| Marking of SS flange | Marking of CS flange |
|:---:|:---:|

### 4. Weight and PMI Test verification

We had verified PMI Test.
The weight of SS flange is 120Kg.
Photo attachment as below

| PMI Test of SS flange | PMI Test of CS flange |
| --- | --- |

- **Review of Documentation**

The mill provided raw Material Test Certificate.

The mill provided PMI Test Report.

The mill provided Mill Test Certificate.