

Inspection Report

REPORT NO.

CW-20120322-DUPRO-001

PRODUCT DESCRIPTION



Client Name: Consorcio prisma	
Product Name: Seamless Carbon steel pipes	
Inspector: Jack Xu	
Report approver:	
Inspection type: DUPRO	
Inspection location:	CANGZHOU, HEBEI, CHINA
Inspection date:	22/Mar/2012
Your reference number: N/A	
P/O number: HB2011-12-05	
Buyers: Consorcio prisma	
Supplier: Heibei Zhonghai Steel Pipe Manufacturing Corporation	
Order quantity:	2607.8m/221pcs
Pcs ready for inspection:	2607.8m/221pcs
Reference sample available:	N/A

Departure time from home / office	Arrival time at the factory	Departure time from the factory
06:00	10:40	17:40

Factory cooperation	Factory organization	Inspector's opinion on the factory
Average	Average	Average

INSPECTION STANDARDS

Inspection type	Pre-Shipment Inspection
Sampling standard	ISO 2859-1 (MIL - STD -105E)
Sampling level	<input type="checkbox"/> Level I <input checked="" type="checkbox"/> Level II
AQL for Critical defective	Not Allowed
AQL for Major defective	<input type="checkbox"/> 1.0 <input checked="" type="checkbox"/> 2.5
AQL for Minor defective	<input type="checkbox"/> 2.5 <input checked="" type="checkbox"/> 4.0
Sampling size for Cri/Maj/Min	32 pcs

INSPECTION RESULTS					
Specifications Check:		Conform			
Tests:		Subject to client's decision			
AQL:	Beyond AQL	AQL:	CRI	MAJ	MIN
		Found	0	0	4
		Max	0	1	3
		Checked	32	32	32
OVERALL INSPECTION RESULT:		Not conform due to AQL (Client has the final decision to Reject or Approve)			

IMPORTANT REMARKS
<ol style="list-style-type: none"> 1. All of products had been finished cutting with 11.8m length standard, but the epoxy resin paint were not coated inside surface. Confirm total quantities of these semi-products are 221 pcs. Please see the attached product Video. 2. The factory states they will only coat the epoxy resin paint inside surface and the outside surface will does not. 3. The products were placed the outdoor position. Found the product surface has obviusse rust due to the rain at outdoor. Please see the attached product videos of page 13 and confirm whether it is accepted or not. 4. Confirm it is plain end on both sides. Found there were many sharp burr on plain ends. Required the factory should clear the sharp burr on plain ends before the inside surface is coated the epoxy resin paint. 5. Found there are many metal oxide films on inside surface. Required the factory should clear these oxide flims before the inside surface is coated the epoxy resin paint. 6. Perform the Product Analysis Test. Please check the record list and test report below. 7. Perform the Product Flattening Test. Confirm without developing cracks. 8. The product Rockwell Hardness Test couldn't be tested at factory because there was not hardness test equipment at factory. 9. The product Tensile Ttrength Test couldn't be tested because there was not lathe equipment at factory. The factory states they will send the test samples to outer manufactory to be cutted by lathe equipment. So the Tensile Ttrength Test could be not finished in same one day. 10. The factory states they have not the test equipment of weight for per unit. I could not test weight during this inspection. So could not count the average weight per m. 11. Randomly drew 7 pcs test samples to post to the specialized test agencies for testing , including one pc for composition Analysis. One pc with 25X25X11mm for rockwell hardness and 5pcs for Tensile properties.

QUALITY CRITERIA

1. Quantity

Expected Result	Result	Actual Finding / Comments
About 30%-50% finished product should be ready for inspection, with the balance under production:	Conform	The epoxy resin paint were not coated on inside surface.
Quantity of packed products:	0	
Quantity of finished & unpacked products:	Total quantities of semi-products are 221 pcs.	
Quantity of semi-finished products:	N/A	

2. Shipping Marks

a. Carton Front Mark

Expected Result	Result	Actual Finding / Comments
	N/A	No packed.

b. Carton Side Mark

Expected Result	Result	Actual Finding / Comments
	N/A	No packed.

3. Product dimensions:

a. Dimensions

Expected Result	Result	Actual Finding / Comments
- Carton Size	N/A	No packed.
Product size	Subject to client's decision	Pls. refer to the below dimension record.

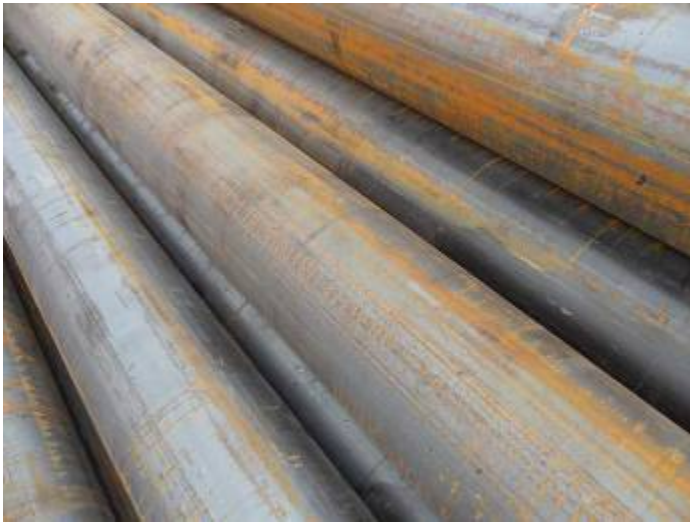
Size records :

Test Item	Std. (mm)	Tol. (+)	Tol. (-)	1	2	3	4	5
Length	11800	N/A	N/A	11812	11804	11800	11805	11806
Outside diameter	355.6	2.38	0.79	356.6	356	356	356	356.1
Wall thickness of one end	11.3	N/A	12.5%	10.8	11.2	11.1	11.3	10.8
Wall thickness of other end	11.3	N/A	12.5%	10.9	10.8	10.5	11.4	10.7
Test Item	Std. (mm)	Tol. (+)	Tol. (-)	6	7	8	9	10
Length	11800	N/A	N/A	11806	11807	11810	11804	11802
Outside diameter	355.6	2.38	0.79	356.3	356.1	356.1	356.2	355.7
Wall thickness of one end	11.3	N/A	12.5%	10.9	10.5	11	10.5	10.6
Wall thickness of other end	11.3	N/A	12.5%	10.4	10.7	11.1	10.8	10.5
Test Item	Std. (mm)	Tol. (+)	Tol. (-)	11	12	13	14	15
Length	11800	N/A	N/A	11807	11800	11804	11803	11805
Outside diameter	355.6	2.38	0.79	356.1	356.6	356	356.4	355.9
Wall thickness of one end	11.3	N/A	12.5%	11.1	10.4	10.8	10.9	10.8
Wall thickness of other end	11.3	N/A	12.5%	10.6	10.9	11	11.3	10.4

b. Weight		
Expected Result	Result	Actual Finding / Comments
- Carton weight	N/A	No packed
- Product weight	PENDING	No test equipment at factory

Remark photos





Found the product surface has obvious rust due to the rain at outdoor. Please see the photos and confirm whether it is accept or not.





Confirm it is plain end on both sides. Found there were many sharp burr on plain ends. Required the factory should clear the sharp burr on plain ends before the inside surface is coated the epoxy resin paint.





Found there are many oxide films on inside surface. Required the factory should clear these oxide films before the inside surface is coated the epoxy resin paint.

Defect photos



Minor : Few oxide films on outer surface. -2pcs



Minor : Scraped surface.-2pcs

DEFECTIVES LIST SUMMARY

	Cri	Maj	Min	AQL result
Few oxide films on outer surface	0	0	2	Beyond AQL
Scraped surface	0	0	2	
Number of Defectives found	0	0	4	
Maximum Allowed	0	1	3	
No. of Inspected samples	0	32	32	

Product photos

Item No.:14"XSCH40

Order quantity: 2607.8m/221pcs



1. Finished semi-products on outdoor



2. Finished semi-products on outdoor



3. Finished semi-products in outdoor



4. Finished semi-products in outdoor



5. Finished semi-products on outdoor



6. Plain ends on both sides



7. Plain ends on both sides



8. Plain ends on both sides



9. Plain ends on both sides



10. Length testing



11. Length test : 11805mm



12. Length test: 11800mm



13. Length test : 11812mm



14. Length test : 11806mm



15. Outside diameter



16. Outside diameter : 356.6mm



17. Outside diameter



18. Outside diameter : 356mm



19. Outside diameter : 356.0mm



20. Outside diameter : 356.1mm



21. Wall thickness test : 10.8mm



22. Wall thickness test : 10.9mm



23. Wall thickness test : 11.3mm



24. Wall thickness test : 10.8mm



25. Wall thickness test : 10.4mm



26. Wall thickness test : 10.6mm



27. Wall thickness test :10 .6mm



28. Wall thickness test : 10.5mm



29. Wall thickness test :10.6mm



30. Wall thickness test :11.3mm

Loading Videos



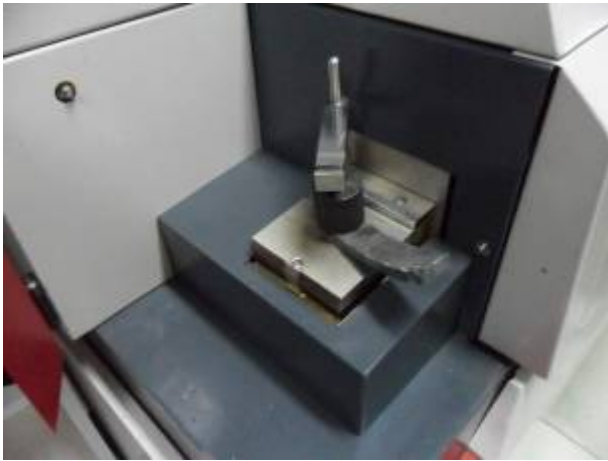
Finished semi-products in outdoor position-1



Finished semi-products in outdoor position-2

TESTS AND SPECIAL REQUIREMENTS

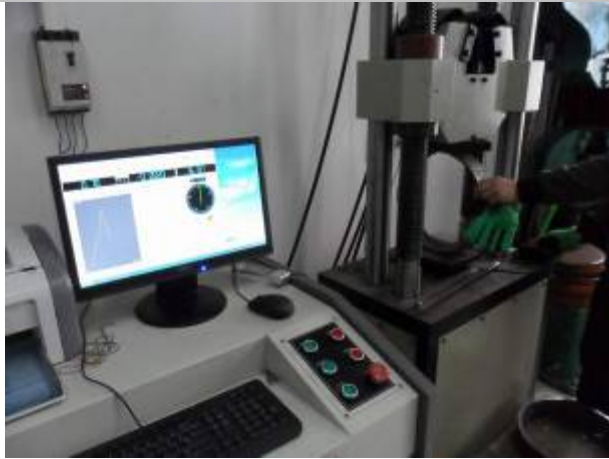
Test description					Comments from Inspector					Result
1. Product Analysis Test—3 pcs					Please check Test Report records as below					Pending
Content	C	Si	Mn	P	S	Cr	Ni	CU	Mo	
Test time										
1	0.205	0.259	0.548	0.013	0.011	0.040	0.036	0.123	0.003	Pending
2	0.207	0.258	0.549	0.013	0.011	0.038	0.035	0.124	0.002	Pending
3	0.206	0.256	0.547	0.013	0.011	0.035	0.034	0.123	0.0001	Pending



2. Product Flattening Test: -2 pcs

Confirm without developing cracks

Passed



3.Pull test --S1

Check 1pc per items

passed

Others photos



Randomly drew 7 pcs samples for testing



Randomly drew 7 pcs samples for testing



Randomly drew 7 pcs samples for testing



Randomly drew 7 pcs samples for testing



Factory Entrance



Factory Office



Factory Building



Factory Building

End of the Report