



TTI Inspection Services Co., Ltd.

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INSPECTION REPORT

REPORT NO.	CLIENT P/O NO.	DATE OF REPORT	TOTAL PAGES
TTI20151126-**	/	26 th Nov. 2015	7

CLIENT	*****	VENDOR	*****
INSPECTOR	Mark	PLACE OF INSPECTION	*****
DATE OF VISIT	26 th Oct. 2015	TYPE OF INSPECTION	1- 20% Pressure test witness 2- 20% Visual check. 3- 20% Dimension check
VALVE TYPE	Gate valve		
ORDER QTY	858PCS		

INSPECTION AND FINDINGS

1. Pressure test per API598

1.0 Witness Hydraulic Backseat test, Shell test, Hydraulic Seat test , Air Seat test of 14pcs valves, please find the detail as follow

Item	Valves	Series No.	Heat No.			Result
			Body	Bonnet	Disc	
12	DN100-PN16 Gate valve, L=230,WCB body,	15101910	0808	No	8888	OK
12	DN100-PN16 Gate valve, L=230,WCB body,	15101939	0808	No	8888	Disc casting leakage, repairing
12	DN100-PN16 Gate valve, L=230,WCB body,	15101957	0808	No	8888	Hydraulic seat leakage, repairing
16	12"-150lb RF Gate valve, WCB body TRIM5	15104003	8888	L898	No	First testing air seat leakage, after cleaning, it passed testing
17	DN150-PN16 Gate valve, L=280, WCB body	15102008	8889	No	8888	OK
17	DN150-PN16 Gate valve, L=280, WCB body	15102009	8889	No	8889	OK
17	DN150-PN16 Gate valve, L=280, WCB body	15102011	8889	No	8888	OK
17	DN150-PN16 Gate valve, L=280, WCB body	15102020	8889	No	8889	OK



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17	DN150-PN16 Gate valve, L=280, WCB body	15102021	8889	No	8889	First testing hydraulic seat leakage, after cleaning, it passed testing
21	DN200-PN16 Gate valve, L=330, WCB body	15102103	6868	No	No	OK
22	DN200-PN16 Gate valve, L=330, WCB body	15102105	6868	No	No	OK
28	DN250-PN16 Gate valve, L=450, WCB body	15102601	9668	No	No	First testing hydraulic seat leakage, after cleaning, it passed testing
30	DN300-PN16 Gate valve, L=750, WCB body	15102701	0687	8889	0687	OK
48	8"-300lb RF Gate valve, WCB body TRIM5	15101801	DY8888	DY8888	DY8888	OK

2.0 Pictures:



Item30 valve testing



Item 16 valve testing



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Item48 valve testing



Item28 valve testing



Item21 valve testing



Item12 valve testing



Item12,S/N:15101939, disc casting leakage



Item12,s/n:15101957,hydraulic seat leakage



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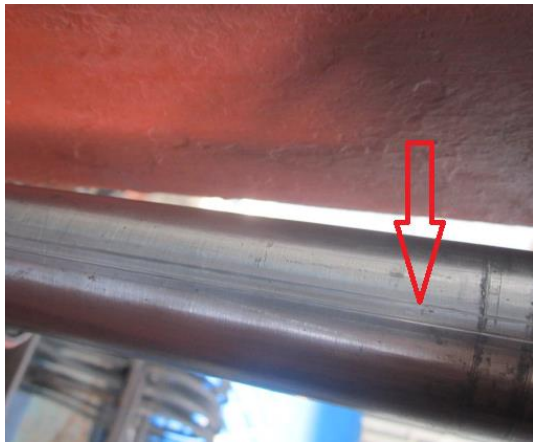
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2. Visual check

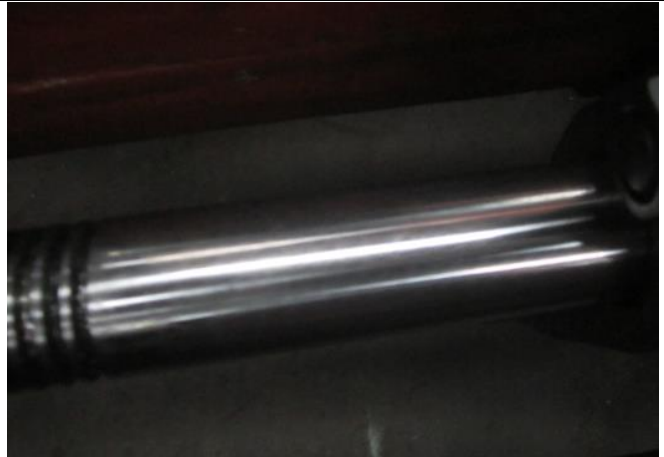
Check the visual of above 14pcs valves. Please find the detail as follow:

1.0 Findings and correction actions:

Please see following detail and comment!



Item16, the stem is damaged



After repairing, it is ok!



Item 21, the bore has sand inclusion



After repairing, it is ok!



Item 28, 1pcs stud is short



After replacing new one, it is ok!



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Item12, s/n:15101939, the body and bonnet flange misalign



Item12, s/n:15101957, the disc has air hole



Item16, the bore and disc are rusty, the disc has air hole, the "WCB" marking isn't clear



Item17, s/n:15102009, the body and bonnet flange misalign



Item17, s/n:15102011/15102022, the disc surface roughness isn't good



Item21/22, the disc surface roughness isn't good



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Item28, the bore and disc rusty, bore has defects



Item30, s/n:15102701, the disc surface roughness isn't good



Item48, s/n:15101801, the bore has air holes

3. Check dimensions of 14pcs valves.

Finding:

1. item 22, s/n:15102105, the face to face dimension is 325.5mm, which is shorten than drawing dimension $330\pm 3\text{mm}$, factory promised to replace a new body!

All other valves dimensions are ok!

Pictures:





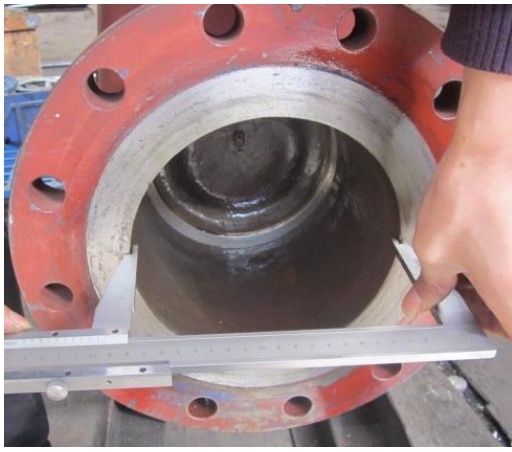
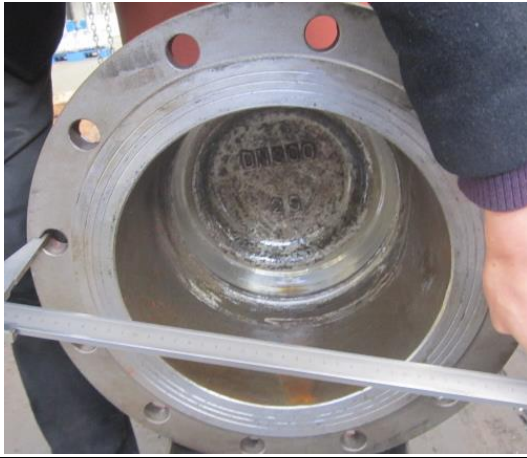
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END OF THE REPORT

WRITTEN BY: Mark

CHECKED AND APPROVED BY Ruiyong