



**TTI Inspection Services Co., Ltd.**

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101  
 Tel : +86 512 65023786  
 E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)  
 Web: [www.tti-inspection.com](http://www.tti-inspection.com)

**INSPECTION REPORT**

REPORT NO.	CLIENT P/O NO.	DATE OF REPORT	TOTAL PAGES
TTI 20180628-***	1515	28 <sup>th</sup> Jun. 2018	14

CLIENT	*****	VENDOR	*****
INSPECTOR	Bob	PLACE OF INSPECTION	Wenzhou city
DATE OF VISIT	27 <sup>th</sup> ~28 <sup>th</sup> Jun. 2018	TYPE OF INSPECTION	1- 6pc valves pressure testing 2- 20% dimension check 3- 100% visual check 4- certificates review
VALVE TYPE	14"-300lb ball valves		
ORDER QTY	12PCS		

**INSPECTION AND FINDINGS**

1. Pressure test per API598

1.0 Witness Hydraulic Shell test ,Hydraulic Seat test and air seat test for 6pcs valves, please find the detail as follow

No.	Description	Series No.	Heat No.			Result
			Body	cover	Ball	
1	14"300 RF ball Valve WCB GO	9641-001-12	L5221	L5221	N/A	OK
2	14"300 RF ball Valve WCB GO	9641-001-08	L5221	L5221	N/A	OK
3	14"300 RF ball Valve WCB GO	9641-001-09	L5221	L5221	N/A	OK
4	14"300 RF ball Valve WCB GO	9641-001-01	L5221	L5221	N/A	OK
5	14"300 RF ball Valve WCB GO	9641-001-02	L5221	L5221	N/A	OK
6	14"300 RF ball Valve WCB GO	9641-001-05	L5221	L5221	N/A	OK

1.1 Pictures:



TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



Shell testing



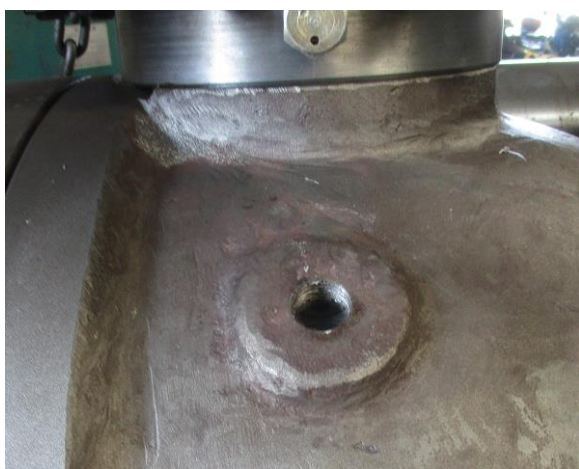
Testing pressure



Left Hydraulic seat testing



Testing pressure



Right Hydraulic seat testing



Testing pressure





TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



Left Air seat testing



Testing pressure



Right Air seat testing



Testing pressure

## 2. visual check

2.0 pictures



valve



valve



TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



Body marking



Bonnet marking and stud/nut marking

2.1 Findings



S/N: 9641-001-01 valve casting defects





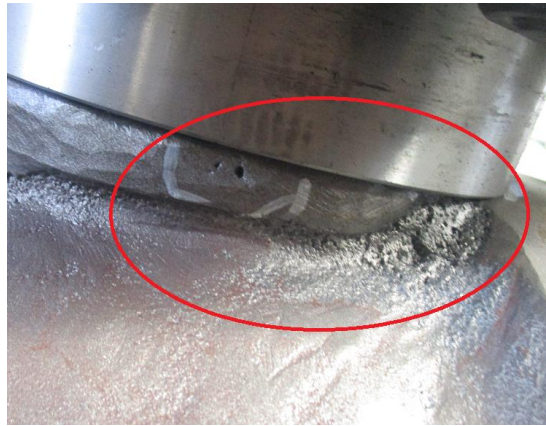
TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



S/N: 9641-001-02 valve casting defects



S/N: 9641-001-03 valve casting defects



TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



S/N: 9641-001-04 valve casting defects



S/N: 9641-001-05 valve casting defects





TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



S/N: 9641-001-06 valve casting defects





TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



N/A

S/N: 9641-001-07 valve casting defects



S/N: 9641-001-08 valve casting defects





TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

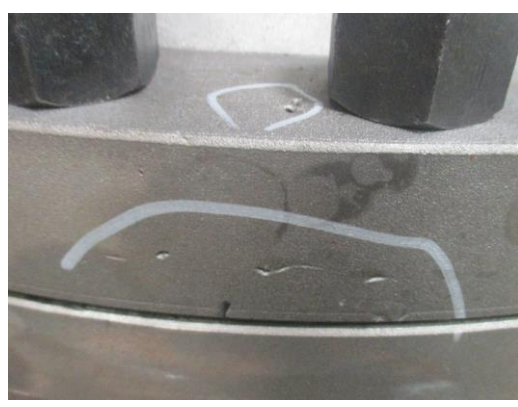
Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



S/N: 9641-001-09 valve casting defects





TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



N/A

S/N: 9641-001-10 valve casting defects







TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



S/N: 9641-001-11 valve casting defects



TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

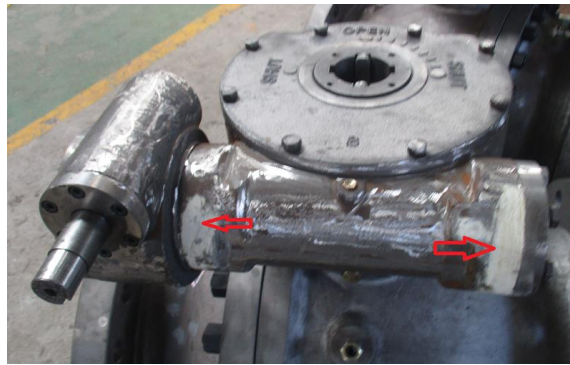
Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



S/N: 9641-001-12 valve casting defects



All casting defects of gearbox repaired by glue

## 2.2 Factory's corrective actions

Factory used casting glue to repair above casting defects, TTI inspector can't accept this repairing, please see following sample pictures and comment!





**TTI Inspection Services Co., Ltd.**

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



**3. Dimension check**

All dimensions are acceptable

3.0 pictures



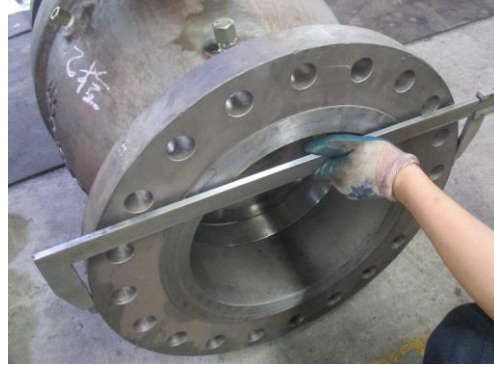
TTI Inspection Services Co., Ltd.

Add: Room B2-401, Dongchuang Tech Park, No.216 Jinfeng Rd., Mudu town, Suzhou, China, 215101

Tel : +86 512 65023786

E-mail: [info@tti-inspection.com](mailto:info@tti-inspection.com)

Web: [www.tti-inspection.com](http://www.tti-inspection.com)



#### 4. certificates review

##### Findings:

1. MTC missing the fire safe standard, signature and stamp;
2. Body raw material certificate should use English format, moreover missing tensile and heat treatment data;
3. Seat raw material certificate should use English format.
4. Ball raw material certificate missing tensile and hardness data.

END OF THE REPORT

WRITTEN BY: Bob

CHECKED AND APPROVED BY Ruiyong