

بازرسی فنی

و

خوردگی فلزات

دستورالعمل بازرسی خرید و ساخت کالا

تاریخ: ۱۳۹۸/۰۲/۳۱

شماره مدرک: ICE-EID-MI-SP01-Rev01



جدول شماره ۳- حداقل الزامات بازرسی سطح ۴ برای خرید کالا/تجهیزات از انبار تامین کننده (Stock)

Table 2 - Inspection Level 4 (Stock)

"INCOMPLETE DOCUMENTS (Final book is not available or incomplete)"

No.	Items ¹	Pipe	Flange	Fitting	Valve	Gasket	Nut & Bolt	Casing & Tubing	Well Head	Completion	Bit	Movable
1	Manufacturer and/or Mill Certificate	R	R	R	R	R	R	R	R	R	R	R
2	Tally Sheet and/or Packing List	R	R	R	R	R	R	R	R	R	R	R
3	Heat treatment ^{2,3}	R	R	R	R	R	R	R	R	R	R	R
4	Hydrostatic Test ^{2,3}	R	R	R	T 4	N/A	N/A	R	T 4	R	N/A	R
5	Non-destructive Test (NDT) ^{2,3}	R	R	R	R	R	R	R	R	R	R	R
6	Chemical Composition ⁵	T	T	T	T	T	T	T	T	T	T	T
7	Tensile Test ²	T 6	R	R	R	R	R	T 6	R	R	R	R
8	Impact Test ²	T 6	R	R	R	R	R	T 6	R	R	R	R
9	Hardness Test ^{2,5}	T	T	T	T	T	T	T	T	T	T	T
10	HIC and SSC Tests ^{2,7}	T 8	R	R	R	R	R	T 8	R	R	R	R
11	Visual Inspection ⁹	T	T	T	T	T	T	T	T	T	T	T
12	Dimensional Check ^{9,10}	T	T	T	T	T	T	T	T	T	T	T
13	Weight Measurement ^{2,9}	T	T	T	T	T	T	T	T	T	T	T
14	End bevel Inspection ^{2,9}	T	T	T	T	N/A	N/A	N/A	T	T	N/A	T
15	Thread Inspection ^{2,9}	N/A	T	T	T	N/A	T	T	T	T	T	T
16	Drift Test ^{2,9}	N/A	N/A	N/A	N/A	N/A	N/A	T	T	T	N/A	T
17	Marking on Product ⁹	R	R	R	R	R	R	R	R	R	R	R
18	Traceability of Product and Documents ⁹	R	R	R	R	R	R	R	R	R	R	R
19	TPI Documents ¹¹	R	R	R	R	R	R	R	R	R	R	R

HIC - Hydrogen Induced Cracking SSC - Sulfide Stress Cracking OD - Outside Diameter ID - Inside Diameter W.T - Wall Thickness TPI - Third Party Inspector N/A - Not Applicable R - Review T - Test

Notes:

- Items 1 to 19 are minimum requirements for evaluation quantity and quality of stock product based on complete final book; Further related documents or conducting specific tests may be required according to client discretion.
- It shall be considered according to relevant standards and purchase order requirements.
- It shall be carried out by manufacturer and mentioned in manufacturer and/or mill certificate.
- Considering same heat and manufacturing conditions, up to 10 pieces - All products shall be tested; Otherwise - At least, 30% of them shall be tested.
- All products shall be tested by portable non-destructive test devices with respect to at least, 2 samples be tested destructively from same heat or 50 pieces of the products whichever is lesser. If destructive test is not applicable, it may be ignored via client discretion.
- Considering same manufacturing conditions, at least, 2 samples shall be tested destructively from same heat or 50 pieces of the products whichever is lesser.
- Material shall be evaluated according to requirements of NACE MR 0175-ISO 15156 from standpoint of chemical analysis, heat treatment and hardness.
- Considering same manufacturing conditions, at least, 1 sample shall be tested from same heat or 50 pieces of the products whichever is lesser.
- 100% of ordered products.
- Including OD, ID, W.T, length, straightness and roundness whichever is relevant.
- Inspection reports, release note and certificate.

