

INSPECTION CO. LTD

Inspection Report

Client eng. & const. Company	Vendor: Gesellschaft	
Project Name: Refinery Gasoline Production Project	Sub-Vendor:	
MH P.O. No.:	Location Germany	
Inspection P.O. No.: Final	Req. No.:	
PO Delivery Date	Report No.:	Date of Visit: 10

MATERIAL INSPECTED THIS VISIT

Item No.	Q'ty	Description	Inspection Items
1		Outer casing 7/09	
2		Outer casing 6/09	

RESULTS OF INSPECTION:	<input type="checkbox"/> Accepted	<input type="checkbox"/> Non-compliance with comments.	ORDER STATUS:	<input type="checkbox"/> Complete	<input type="checkbox"/> Incomplete
Customer Inspector	<input type="checkbox"/> Attended by .:			<input type="checkbox"/> Not attended	
Customer's Inspector Comments	<input type="checkbox"/> Yes,			<input type="checkbox"/> None	

SUMMARY OF THIS VISIT :

- Final dimensional inspection
- Hydrostatic pressure test
- Helium Leak test
- Visual inspection of items
- Review of Manufacturer Data Report and documentation

Next Visit Schedule	-	
Inspecting Engineer: Willi Geschwentner Date: 9. Signed:	Reviewed by: Date: Signed:	Page 1 of 5

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Detailed Report

Client eng. & const. Company

Vendor : Gesellschaft

Material Equipment Inspected.:

Outer casing 7/09

Outer casing 6/09

Participants: Mr. N, Quality Assurance Gesellschaft

Mr. M, Project manager

Mr. Willi Geschwentner, Inspector

Intervention Required:

- Final dimensional inspection
- Hydrostatic pressure test
- Helium Leak test
- Visual inspection of items
- Review of Manufacturer Data Report and documentation

Date & Place of inspection.

Gesellschaft

Documents Utilized During The Inspection :

Control report No. 9

Pressure test certification

Test and inspection plan QP6

Plates

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Certificate Tightness test EN10204/3.1
Inspection certificate Liquid-penetrant test PT
Quality Checklist QP5

2. Detailed Activities :

Visual Inspection :

Control drawings

Control casings

Test- Inspection:

Casing Plate 7/09:

Pressure test:

	Shell	bundle	channels
Water:	17° C 2h Bar 129	17° C 2h bar 16.5	17° C 2h bar16.5
Manometer No.	254233	256	256

Tightness test EN 10204/3.1:

Tested parts: Welds
Tube-tubesheet joint

Test method: Helium vacuum test
Test equipment-external
Test leak $9,2 \times 10^{-6}$ mbar l/sec

Test medium: Helium
Holding time 1h

Liquid penetrant test PT:

Cover: Part 30.30
Weld preparation:
100 % , without objection, Halogen light 1550

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Casing Plate 6/09:

Pressure test:

	Shell	bundle	channels
Water:	17° C 2h Bar 129	17° C 2h bar 16.5	17° C 2h bar16.5
Manometer No.	253.2590	203	203

Tightness test EN 10204/3.1:

Tested parts: Welds
Tube-tubesheet joint

Test method: Helium vacuum test
Test equipment-external
Test leak $9,2 \times 10^{-6}$ mbar l/sec

Test medium: Helium
Holding time 1h
Temperature 17° C

Liquid penetrant test PT:

Cover: Part 30.30
Weld preparation:
100 % , without objection, Halogen light 1500

CONCLUSION:

Results of inspection showed no objections

ENCLOSURES :

- Photos
- Document Register
- Technical Datas

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Remarks :

The inspector verified the technical specification requirements according to the following details :

ITEM No. 1 and ITEM No. 2

Photos:



Bundle ITEM 1



Bundle ITEM 2



Casing 1



Casing 2

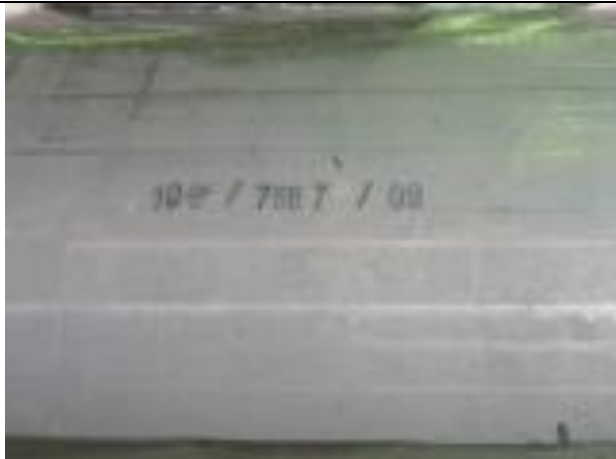
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Casing 1



Casing 2



Serial No.. ITEM 1



Casing 2