

Inspection Report

REPORT NO.

CW-20120405-PSI-001

PRODUCT DESCRIPTION



Client Name: XXX Trading	
Product Name: Seamless Carbon steel pipes	
Inspector: Jack Xu	
Report approver: Jason Wan	
Inspection type: PSI	
Inspection location:	CANGZHOU, HEBEI, CHINA
Inspection date:	05/Apr/2012
Your reference number: N/A	
P/O number: HB2011-12-05	
Buyers: XXX Trading	
Supplier: Heibei XXX Steel Pipe Manufacturing Corporation	
Order quantity:	2607.8m/221pcs
Pcs ready for inspection:	141pcs
Reference sample available:	N/A

Departure time from home / office	Arrival time at the factory	Departure time from the factory
06:00	10:30	17:00

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 <input type="checkbox"/> Level III
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	8
		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"> Please be noted that all of products were only coated the epoxy resin paint inside surface and the outside surface did not.(Please see the product videos of page 9 or remark photos) 141 pcs products were finished the epoxy resin paint coating on inside surface when I performed inspection. The rest 80 pcs products were only finished the primer coating inside surface or being prepared to coat the epoxy resin paint inside surface. 26 pcs out of 141pcs(about 20%) were found that poor epoxy resin paint coating inside surface. Have required the factory to wipe off it and re-coat epoxy resin paint inside surface and they factory promised they will fix those well.(Please see the attached photos.) Found there was not any package around products. The products were placed the outdoor. Found the product surface still had obvious rust due to the rain at outdoor. (Please see the remark photos.) Confirm the factory had cleared the sharp burr on both ends. Checked the inside surface by wiping off epoxy resin paint. Confirmed the factory had cleared the oxide films before the inside surface was coated the epoxy resin paint. (Please see the attached photos.) The products analysis test and other function test couldn't be tested in this inspection because there were no relevant test equipments available at factory of coating paint but I ever performed the Product Analysis Test and Product Flattening Test on Mar 22nd. Please check the Test description below. I could not test the weight per unit during this inspection because there was not the test equipment. So could not count the average weight per meter. 	

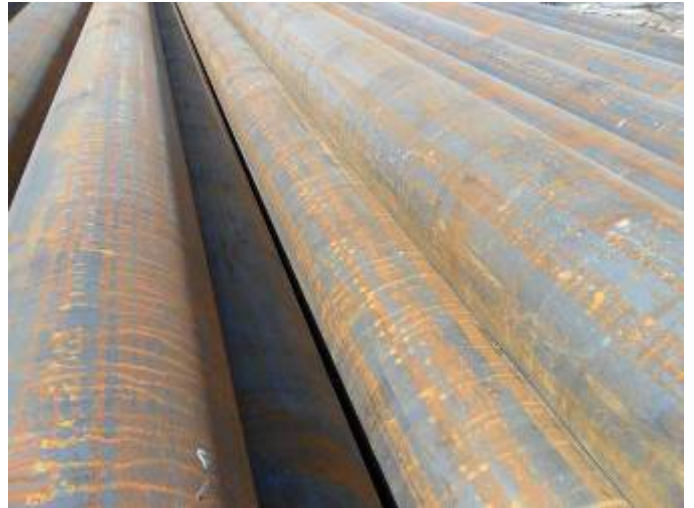
QUALITY CRITERIA		
1. Quantity		
Expected Result	Result	Actual Finding / Comments
100% finished and at least 80% packed product should be ready for inspection:	Not Conform	The epoxy resin paint were coated on inside surface for 141 pcs. The others 80 pcs products were only finished the primer coating on inside surface.
Quantity of packed products:	The products is naked packing.	
Quantity of finished & unpacked products:	141 pcs finished	
Quantity of semi-finished products:	N/A	

2. Shipping Marks		
a. Carton Front Mark		
Expected Result	Result	Actual Finding / Comments
	N/A	Naked packing.
b. Carton Side Mark		
Expected Result	Result	Actual Finding / Comments
	N/A	Naked packing.

3. Product dimensions:								
a. Dimensions								
Expected Result		Result			Actual Finding / Comments			
- Carton Size		N/A			Naked packing.			
Product size		Subject to client's decision			Pls. refer to the below dimension record.			
Size records(Note: The tested wall thickness including epoxy resin paint thickness)								
Test Item	Std. (mm)	Tol. (+)	Tol. (-)	1	2	3	4	5
Length	11800	N/A	N/A	11803	11810	11800	11808	11814
Outside diameter	355.6	2.38	0.79	356.8	356.9	356.2	356.3	356
Wall thickness of one end	11.3	N/A	12.5%	11.9	10.7	11.5	11.5	11.3
Wall thickness of other end	11.3	N/A	12.5%	11.4	11	11.2	11.1	10.9
Epoxy resin paint thickness	410μm	N/A	N/A	450μm	570μm	550μm	510μm	460μm
Test Item	Std. (mm)	Tol. (+)	Tol. (-)	6	7	8	9	10
Length	11800	N/A	N/A	11802	11806	11805	11810	11812
Outside diameter	355.6	2.38	0.79	356.9	356.5	356.3	356.8	356
Wall thickness of one end	11.3	N/A	12.5%	11	10.9	11.9	11.2	11.6
Wall thickness of other end	11.3	N/A	12.5%	11.4	11	11.6	11.4	11.5
Epoxy resin paint thickness	410μm	N/A	N/A	500μm	410μm	450μm	450μm	500μm
Test Item	Std. (mm)	Tol. (+)	Tol. (-)	11	12	13	14	15
Length	11800	N/A	N/A	11807	11810	11805	11806	11803
Outside diameter	355.6	2.38	0.79	356.4	356	356.2	356.3	356.7
Wall thickness of one end	11.3	N/A	12.5%	11.4	10.7	11.2	11.8	11
Wall thickness of other end	11.3	N/A	12.5%	11.2	11	11.5	11.4	11.2
Epoxy resin paint thickness	410μm	N/A	N/A	490μm	500μm	550μm	500μm	450μm

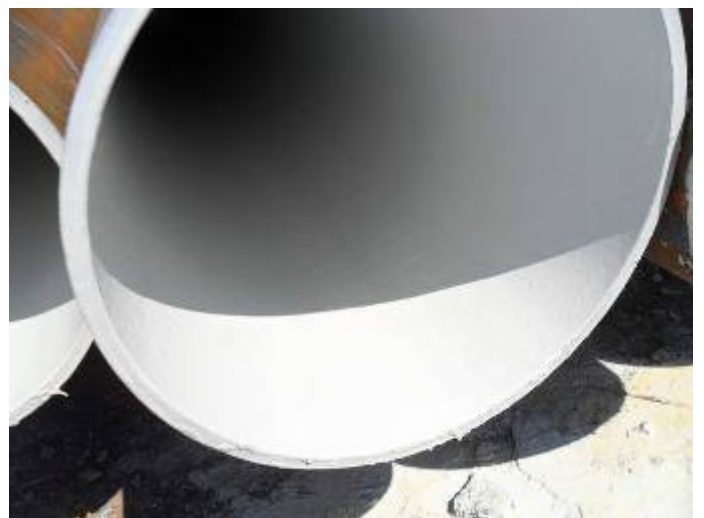
b. Weight		
Expected Result	Result	Actual Finding / Comments
- Carton weight	N/A	No packed
- Product weight	PENGING	No test equipment at factory

Remark photos





The products were placed the outdoor position. Found the product surface still had obviouse rust due to the rain at outdoor.

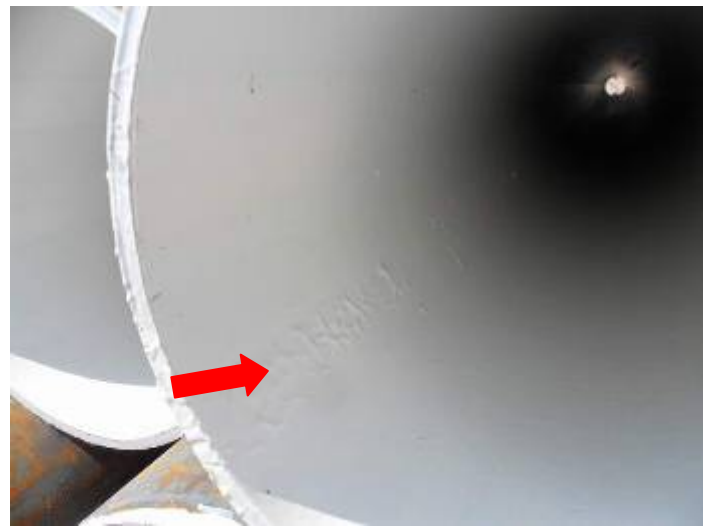


Confirm it is plain on ends of pipe. Confirm the factory had cleared the sharp burr on the ends.



Checked the inside surface by wiping off epoxy resin paint. Confirmed the factory had clear the oxide films before the inside surface was coated the epoxy resin paint.





26 pcs out of 141pcs(about 20%) were found that poor epoxy resin paint coating inside surface. Have required the factory to wipe off it and re-coat epoxy resin paint inside surface and they factory promised they will fix those well.

Defect photos



Minor : Few oxide films on outer surface.-2pcs from random 32 samples



Minor : Poor epoxy resin paint coating on inside surface.-6pcs from random 32 samples.(Please refer to the Important Remark 3 above)

DEFECTIVES LIST SUMMARY

	Cri	Maj	Min
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AQL result

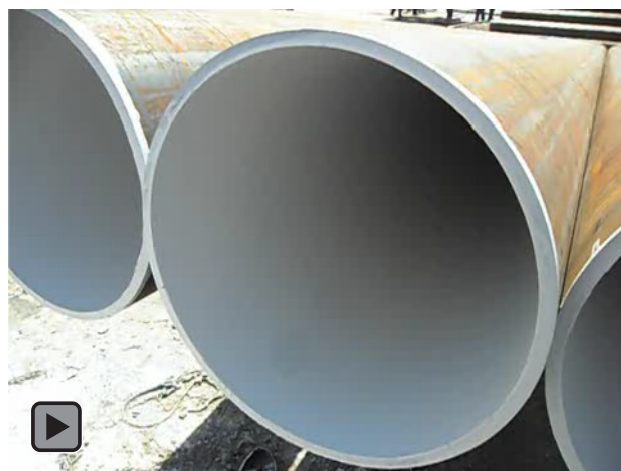
Few oxide films on outer surface	0	0	2
Poor epoxy resin paint coating on inside surface	0	0	6
Number of Defectives found	0	0	8
Maximum Allowed	0	1	3
No. of Inspected samples	0	32	32

Beyond AQL

Product Videos



Finished products at outdoor position



The epoxy resin paint on inside surface

Product photos

Item No.:14"XSCH40

Order quantity: 2607.8m/221pcs



1. Finished products on outdoor



2. Finished products on outdoor



3. Finished products in outdoor



4. Finished products in outdoor



5. Finished products on outdoor



6. Finished products on outdoor



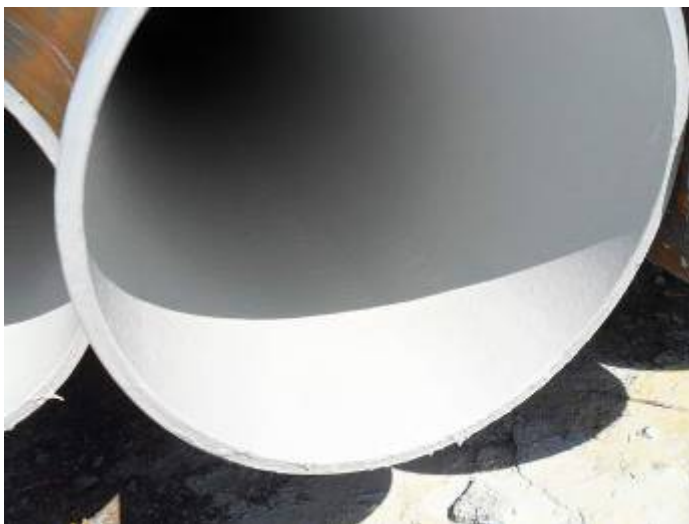
7. Plain ends on both sides



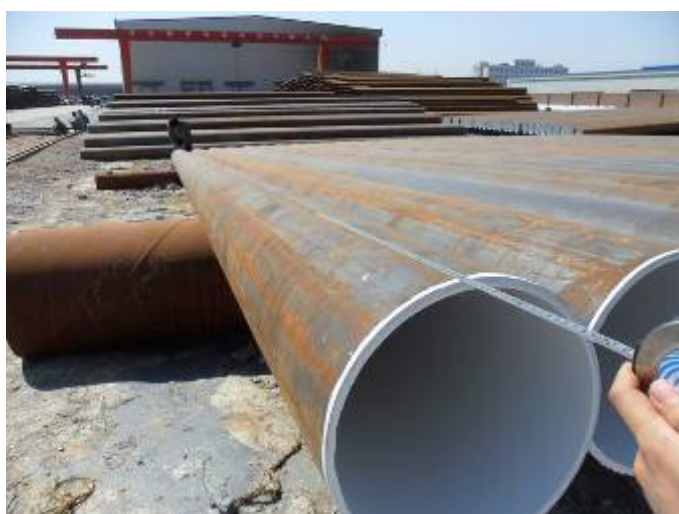
8. Plain ends on both sides



9. Plain ends on both sides



10. Plain ends on both sides



11. Length test



12. Length test: 11803mm



13. Length test : 11810mm



14. Length test : 11800mm



15. Length test : 11808mm



16. Length test : 11814mm



17. Outside diameter



18. Outside diameter : 356.8mm



19. Outside diameter356.9



20. Outside diameter : 356.2mm



20. Outside diameter : 356.3mm



21. Outside diameter : 356.9mm



23. Wall thickness test :11.9mm



24. Wall thickness test :11.4mm



25. Wall thickness test :10.7mm



26. Wall thickness test :11mm



27. Wall thickness test :11.5mm



28. Wall thickness test : 11.3mm



29. Wall thickness test :11.5mm



30. Wall thickness test :11.1mm



31. Epoxy resin paint thickness : 450μm



32. Epoxy resin paint thickness : 570μm



33. Epoxy resin paint thickness : 550µm



34. Epoxy resin paint thickness : 510µm



35. Epoxy resin paint thickness : 460µm



36. Epoxy resin paint thickness : 500µm



37. Epoxy resin paint thickness : 410µm

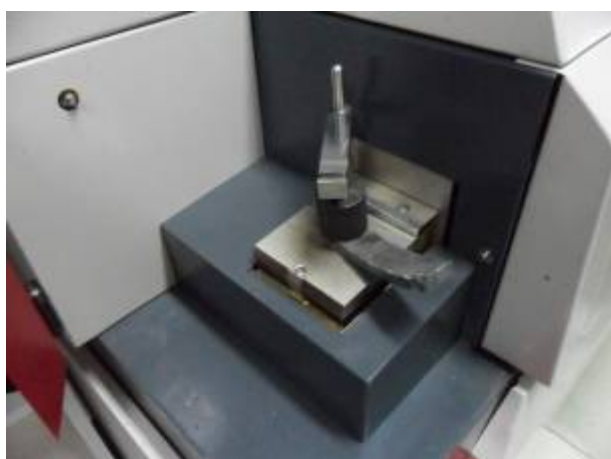


38. Epoxy resin paint thickness : 450µm

TESTS AND SPECIAL REQUIREMENTS (Had ever performed the Product Test a on Mar 22nd)

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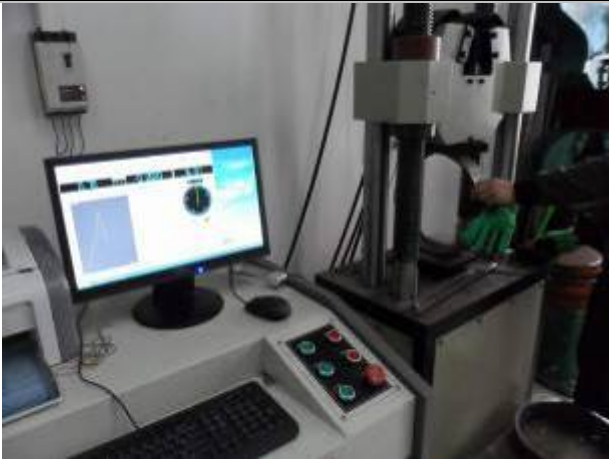
1. Product Analysis Test—3 pcs					Please check Test Report records as below					Pending
Content Test time	C	Si	Mn	P	S	Cr	Ni	CU	Mo	
1	0.205	0.259	0.548	0.013	0.011	0.040	0.036	0.123	0.003	Pending
2	0.207	0.258	0.549	0.013	0.011	0.038	0.035	0.124	0.002	Pending
3	0.206	0.256	0.547	0.013	0.011	0.035	0.034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



2. Product Flattening Test: -2 pcs

Confirm without developing cracks

Passed



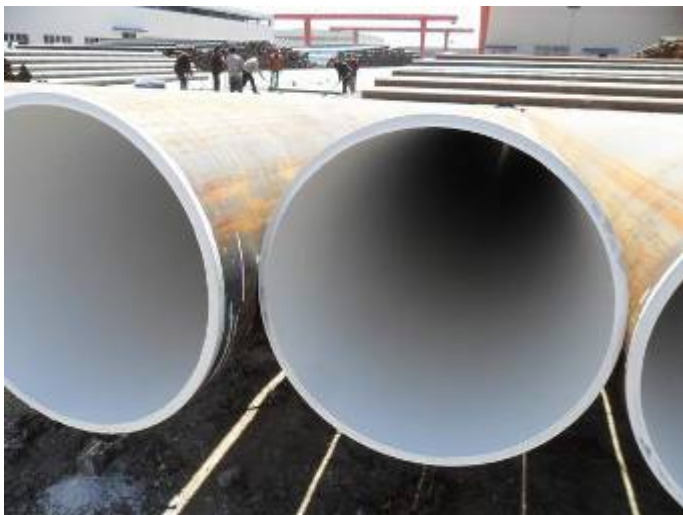
Others photos



Coating Paint Factory Entrance



Coating Paint Factory Entrance



Fine epoxy resin paint coating on inside surface



Fine epoxy resin paint coating on inside surface

End of the Report