

INSPECTION-REPORT-JP-Chaoda-20210603

J-PECO Job nr: SVSI-210601-Chaoda-20210603

PROJECT: DS03 Project	Ref: JP- SVSI-20210601
J-PECO Client: Chaoda Valves Group Co. Ltd.	P/o nr: / (client to J-PECO)
Manufacturer: Chaoda Valves Group Co. Ltd.	P/o nr: SSO-015-2021 (Client to Manufacturer)
Inspection requested by: Chaoda Valves Group Co. Ltd.	

Item No.	SUPPLY / SUBJECT OF INSPECTION	Qty (pcs)
127298	2" FLOATING BALL CL300, RF, FB, BODY: CW6MC, BALL: N06625 + TCC, STEM: N06625, SEAT: N06625 +TCC, B8M / 8M BOLTS AND NUTS, LEVER OPERATED (AS PER PIPING CLASS A03E3B, DATA SHEET BF03G01)	10
125980	3" FLOATING BALL CL150, RF, FB, BODY: CW6MC, BALL: N06625 + TCC, STEM: N06625, SEAT: N06625 +TCC, B8M CL2 / 8M BOLTS AND NUTS, LEVER OPERATED (AS PER PIPING CLASS A01E3B, DATA SHEET BF01G01)	1

DOCUMENTS OF REFERENCE : See continuation sheet for additional documents: ☒ Yes ☐ No

Title	Reference n°	Rev.	Approved	Date
GENERAL ARRANGEMENT DRAWINGS	0301RP-128866-B01-002	02	Approved	2021-04-14
INSPECTION AND TEST PLAN (ITP)	0301RP-128866-Q03-002	01	Approved	2021-03-02
SPECIFICATION FOR PIPING VALVES TECHNICAL REQUIREMENTS	0000RP-C-G0-G000-PE-SPC-0017	B01	Approved	2018-03
DATA SHEETS	0301RP-128866-D03-001	03	Approved	2020-10-01
HYDROSTATIC & LEAK TEST PROCEDURES	0301RP-128866-J06-0001	03	Approved	2020-05-29
Petroleum and Natural Gas Industries - Pipeline Transportation Systems – Pipeline Valves	ISO 14313	-	-	-
Specification for Pipeline Valves	API 6D	-	-	-
Industrial valves — Pressure testing of metallic valves	ISO 5208	-	-	-

INSPECTIONS :**Results of inspection** : ☒ Satisfactory ☐ Unsatisfactory**Inspection place & Date or Period:**

Place: Jiangbee street, Ouebei Town, Yongjia, Wenzhou, China

Date: June, 3rd, 2021**Stage of inspection :**

- ☐ Before manufacturing
☒ During manufacturing
☐ Final
☐ Packing

Kind of inspection:

- ☐ Pre-inspection meeting
☒ Witnessing tests
☐ Final inspection
☐ Document review
☐ Expediting & vendor assessment
☐ Packing

(for details see continuation sheet)

Stamping :

- ☒ No

Non Conformities Reports (NCR):

◦ NCR's issued during reported period :

None

◦ List of outstanding NCR's :

None

Main Conclusions & Remarks: (for details see continuation sheet)

As per request of CLIENT, the inspector Zhao Junchao performed post-assembly tests at Chaoda Valves Group Co. Ltd. The inspection including hydro pressure test, pneumatic pressure test, torque/thrust test, gas leak test and functional test.

Note: Cavity Overpressure Relief Test (ITP item 11) was not applicable for floating ball valves.

The inspection result was acceptable.

The inspection details refer to the following report content.

Next visit scheduled:

/

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Description of the inspections carried out:

➤ Introduction

As the request of the client, the inspector Zhao Junchao from **Anhui Jipeng Project Supervision and Consulting Co., Ltd.** in China performed visit inspection at **Chaoda Valves Group Co. Ltd** (hereinafter referred to as "supplier") on June, 3rd, 2021.
The inspection result was acceptable.

J-PECO Scope of work

1. Witnessed hydro pressure test, pneumatic pressure test, torque/thrust test, gas leak test and functional test

Attendees

Name	Company	Title
Mr. Zhao Junchao	J-PECO	Inspector
Mr. Yang Youjie	Chaoda	Quality Control Manager

➤ Manufacturing Progress Status and Inspected Product List

When JPECO inspector arrived in the factory, all the valves were ready for inspection.

➤ Details of inspection activities carried out with respect to scope of work

1. Post-Assembly Tests.

Before test, inspector reviewed all test equipment calibration labels and all in validity date.
1.1 According to the ITP item 7 to 10 and 12, J-PECO inspector witnessed hydro pressure test, pneumatic pressure test, torque/thrust test, gas leak test and functional test.
The results meet the requirements of ITP, ISO 14313 (API 6D) and 0000RP-C-G0-G000-PE-SPC-0017.
The results were acceptable.

Table 1: Valve pressure test record

Item No.	Serial No.	Test Qty/ Total Qty	Size/Type	Hydrostatic		Pneumatic	Gas Test		Torque Test	Result
				Shell	Seat		External	Seat		
127298	B21010030-1-8	1/10	2"-CL300 Floating Ball Valve	7.7Mpa /15Min	5.7Mpa /5Min	0.6Mpa /5Min	5.7Mpa /15Min	5.7Mpa /5Min	119.41 N.m	Acc.
125980	B21010030-2-1	1/1	3"-CL150 Floating Ball Valve	3.0Mpa /15Min	2.2Mpa /5Min	0.6Mpa /5Min	2.2Mpa /15Min	2.2Mpa /5Min	137.62 N.m	Acc.

Note: Cavity Overpressure Relief Test (ITP item 11) was not applicable for floating ball valves.

➤ Problems pending / Areas of Concern

None

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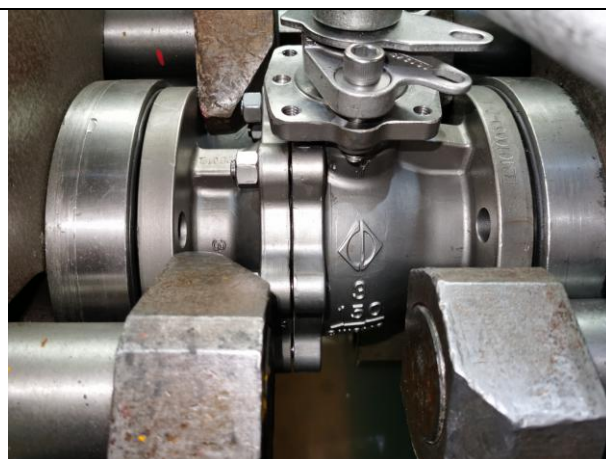
➤ Results of Inspection

The inspection result was acceptable for this visit.

➤ Photos on Site



Hydrostatic Shell Test



Hydrostatic Shell Test



Hydrostatic Seat Test



Hydrostatic Seat Test



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Pneumatic Seat Test



Pneumatic Seat Test



Torque Test



Torque Test



Gas Leak Shell Test



Gas Leak Shell Test



Gas Leak Seat Test

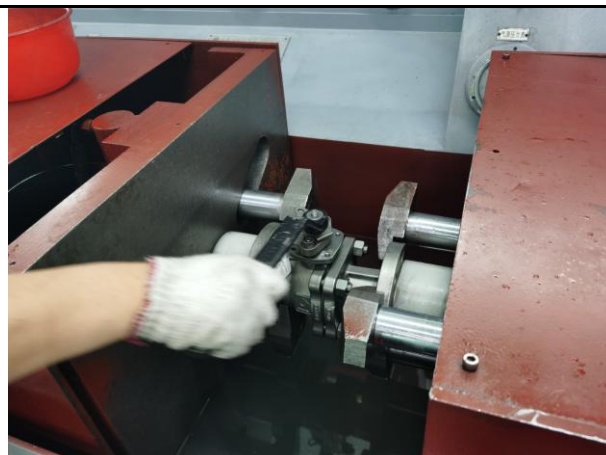
Gas Leak Seat Test

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Functional Test - Cycled Close-Open-Close



Functional Test - Cycled Close-Open-Close



Functional Test - Cycled Close-Open-Close



Functional Test - Cycled Close-Open-Close

ANNEXES ☐ Yes ☒ No**Inspected by:**

Name: Zhao Junchao

Signature: *Zhao Junchao*Date of issue: June, 3rd, 2021**Inspection centre:** J-PECO inspector**Checked by:**

Name: Liu Xiaonan

Signature: *Liu Xiaonan*Distribution: ☒ CLIENT ☐ MANUFACTURER ☒ J-PECO CHINA