

Industry & Facilities Division  WEEKLY REPORT FOR DND-20240317 J-PECO Job nr: DND-20240317	Page 1 / 15 <input checked="" type="checkbox"/> Interim <input type="checkbox"/> Final

PROJECT: Resident inspection		Ref: LNP/BJ-12/048	
J-PECO Client: D&D International Valves Ltd		P/o nr: N/A (client to J-PECO)	
Manufacturer: Yancheng Tongshang Valve Plant		P/o nr: TT/00072/JT DD/40777/MB TT/00073/JT (Client to Manufacturer)	
Inspection requested by: D&D International Valves Ltd			
No.	SUPPLY / SUBJECT OF INSPECTION	S.N	QTY
Please refer to attachment for production status list			
DOCUMENTS OF REFERENCE: See continuation sheet for additional documents: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No			
Title	Reference n°	Rev.	Approved by
Order specification	TT/00072/JT	0	D&D
Order specification	DD/40777/MB	0	D&D
Order specification	TT/00073/JT	0	D&D
INSPECTIONS :		Results of inspection : <input checked="" type="checkbox"/> Satisfactory <input type="checkbox"/> Unsatisfactory	
<u>Inspection place & Date or Period:</u> Place: East Industrial Zone, Nanyang Town, Dafeng, Jiangsu Province, China Date: 11 th , Mar, 2024~17 th , Mar, 2024 <u>Stage of inspection :</u> <input type="checkbox"/> Before manufacturing <input checked="" type="checkbox"/> During manufacturing <input checked="" type="checkbox"/> Final <input type="checkbox"/> Packing <u>Kind of inspection:</u> <input type="checkbox"/> Pre-inspection meeting <input checked="" type="checkbox"/> Witnessing tests <input type="checkbox"/> Final inspection <input type="checkbox"/> Document review <input type="checkbox"/> Packing (for details see continuation sheet) <u>Stamping :</u> <input checked="" type="checkbox"/> No		<u>Non Conformities Reports (NCR):</u> NCR's issued during reported period : None List of outstanding NCR's : None <u>Main Conclusions & Remarks:</u> (for details see continuation sheet) J-PECO inspector Feng Jiafei performed resident inspection according to client's and order requirements during 11 th , Mar, 2024~17 th , Mar, 2023 at Yancheng Tongshang Valve Plant. The inspection results were acceptable for this week. <u>Next week working scheduled</u> 18 th , Mar, 2024~24 th , Mar, 2024	

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Description of the inspections carried out:

➤ Introduction

J-PECO inspector Feng Jiafei from **Anhui JiPeng Project Supervision and Consulting Co., Ltd.** performed resident inspection for the valves listed in attachment during 11th, Mar, 2024~17th, Mar, 2024 at **Yancheng Tongshang Valve Plant**.

The inspection results were acceptable.

J-PECO Scope of work

1. Performed visual inspection for part of valve castings.
2. Monitored the production process of valve machining.
3. Checked the dimensions of item 004 and 012 of TT/00072 randomly.
4. Witnessed the pressure test of item 004 of TT/00072 randomly.
5. Checked and recorded the heat numbers of valves which have been tested of TT/00072.

➤ Manufacturer process status

Please see the below for the production status list.

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

1. Performed visual inspection for part of valve castings.

J-PECO inspector checked the casting appearance conditions according to MSS-SP-55 with an acceptable result.



Casting logo check



Casting interior check



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Casting appearance check



Casting backside check



H2"150LB WT acc. to API600 8.6 mm



Wall thickness check



Wall thickness check



Wall thickness check



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Casting logo check



Casting interior check



Casting appearance check



Casting backside check



J2"150LB WT acc. to API600 8.6 mm



Wall thickness check

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Wall thickness check



Wall thickness check

2. Monitored the production process of valve machining.

J-PECO inspector monitored the production process and checked the machining surface of valve parts. No obvious scratches or other defect was found.



Machining surface check



Machining surface check



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Machining surface check



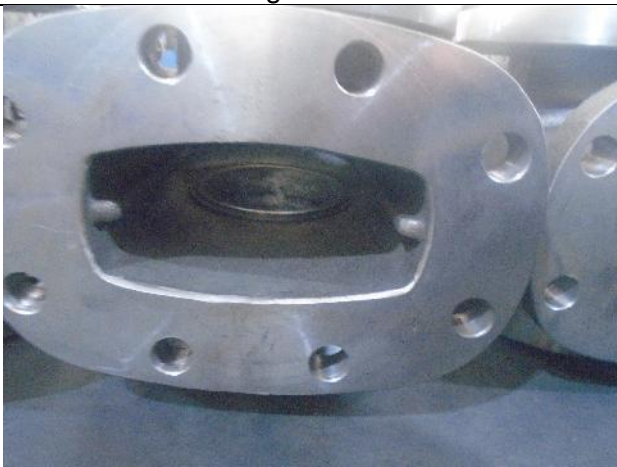
Machining surface check



Machining surface check



Machining surface check



Machining surface check



Machining surface check

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3. Checked the dimensions of item 004 and 012 of TT/00072 randomly.

J-PECO inspector checked the dimensions according to the drawings and performed test by sampling of 10%. The results met the requirement of drawings. Machining of all the above items mentioned were completed.

TT/00072/JT

	Size	Face to face (mm) ± 1.5	Bolts hole center distance(mm) ± 1.5	Flange thickness (mm)+3.0	Flange OD (mm) ± 2.0	RF OD (mm) ± 1.0	Diameter of hole*No.s of hole(mm)
Drg. Req.		229	190.5	24	230	157	8*19
004	4"	229.4~230	190.3~190.5	24.5~25.6	229.6~229.8	156.7~157.8	8*19.1
Drg. Req.		356	432	32	485	381	12*25
012	12"	357.5	432.2	34	484.3	381.7	12*25.1



00072-012 12" valve F.T.F



Measurement result



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OD check



RF OD check



Bolts hole center distance



Measurement result



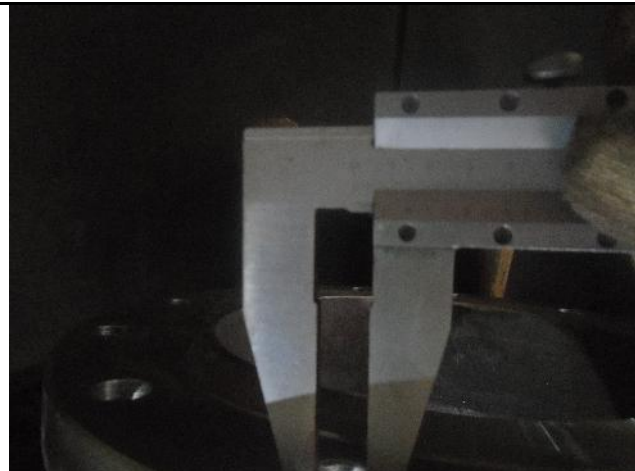
RF OD check



Measuring result

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Hole diameter



Measurement result



Flange thickness check



Measurement result

4. Witnessed the pressure test of item 004 of TT/00072 randomly.

J-PECO inspector witnessed pressure test according to API598. 150LB gate valves and check valves were witnessed by sampling of 10%, 300LB gate valves and check valves were witnessed by sampling of 20%, 600LB gate valves and check valves and above were witnessed by sampling of 100%. All globe valves were witnessed by sampling of 100%. The results please see following table. Assembly and pressure test of above items mentioned were completed.

Series Number	Hydraulic test of body (Mpa)	Hydraulic back seat test (Mpa)	Hydraulic seal test (Mpa)	Pneumatic test of seat seals (Mpa)	Duration (Min)	Leakage	Result
00072-004-	3.0	2.2	2.2	0.7	2/1/2/2	No obvious	Acceptable

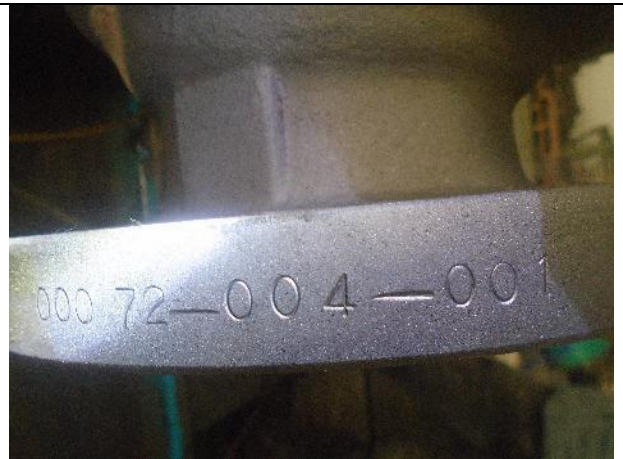
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001						leakage	
00072-004-013	3.0	2.2	2.2	0.7	2/1/2/2	No obvious leakage	Acceptable
00072-004-023	3.0	2.2	2.2	0.7	2/1/2/2	No obvious leakage	Acceptable
00072-004-035	3.0	2.2	2.2	0.7	2/1/2/2	No obvious leakage	Acceptable



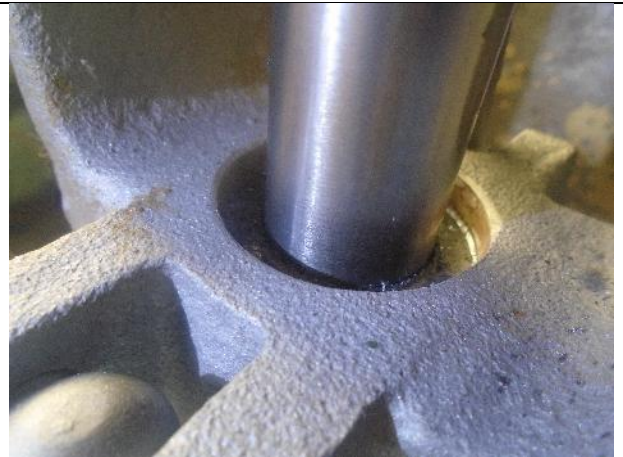
00072-004 4" valve



Series number



Pressure gauge



Backseat test



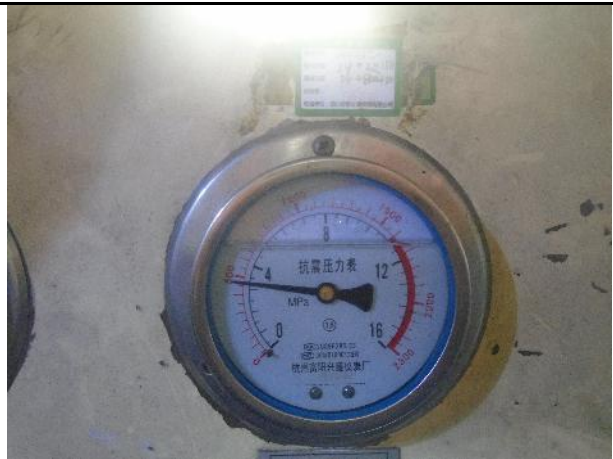
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Shell test



Pressure gauge



Hydraulic seat sealing test



Hydraulic seat sealing test



Pneumatic seat sealing test



Pneumatic seat sealing test

5. Checked and recorded the heat numbers of valves which have been tested of TT/00072.



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Item	SN.	Valve description	Body	Bonnet	Gate	-	-	-	-
00072-004	1	Z4"150LB WCB/RF	F1046	F9145	K1733	-	-	-	-
	2		F1047	F9145	K3529	-	-	-	-
	3		F1047	F9145	K3529	-	-	-	-
	4		F1047	F9145	K3529	-	-	-	-
	5		F1047	F9145	K3005	-	-	-	-
	6		F1047	F9145	K3529	-	-	-	-
	7		F1047	F9145	K3529	-	-	-	-
	8		F1046	F9145	K1665	-	-	-	-
	9		F1047	F9145	K3529	-	-	-	-
	10		F1047	F9145	K3152	-	-	-	-
	11		F1046	F9145	K0091	-	-	-	-
	12		F1046	F9145	K3529	-	-	-	-
	13		F1047	F9145	K3529	-	-	-	-
	14		F1047	F9145	K3529	-	-	-	-
	15		F1047	F9145	K3152	-	-	-	-
	16		F1047	F9145	K3529	-	-	-	-
	17		F1047	F9145	K3529	-	-	-	-
	18		F1047	F9145	K3152	-	-	-	-
	19		F1047	F9145	K3529	-	-	-	-
	20		F1046	K3366	K1219	-	-	-	-
	21		F1047	F9145	K3529	-	-	-	-
	22		F1047	F9145	K3529	-	-	-	-
	23		F1046	F9145	K3152	-	-	-	-
	24		F1046	F9145	K3152	-	-	-	-
	25		F1046	F9145	K3529	-	-	-	-
	26		F1047	F9145	K3529	-	-	-	-
	27		F1046	F9145	F1048	-	-	-	-
	28		F1047	F9145	K3529	-	-	-	-
	29		F1047	F9145	K3529	-	-	-	-
	30		F1046	F9145	K3529	-	-	-	-
	31		F1046	F9145	K3152	-	-	-	-
	32		F1047	F9145	K3152	-	-	-	-
	33		F1046	F9145	K1689	-	-	-	-
	34		F1046	F9145	K3152	-	-	-	-
	35		F1047	F9145	K3529	-	-	-	-
	36		F1047	F9145	K3152	-	-	-	-
	37		F1046	F9145	K3529	-	-	-	-
	38		F1046	F9145	K3529	-	-	-	-
	39		F1047	F9145	K3529	-	-	-	-



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F1047

F9145

K3152

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Manufacturing Process Status

TT/00072/JT

Item	Size	Type	Body Mtr.	Qty.	Raw castings checked	Machining completed	Assembly completed	Pressure test completed	Painting completed	Packing completed
001	2" - 150LB	Gate Valve	WCB	50						
002	2" - 150LB	Gate Valve	WCB	25						
003	3" - 150LB	Gate Valve	WCB	40						
004	4" - 150LB	Gate Valve	WCB	40	40	40	40	40		
005	6" - 150LB	Gate Valve	WCB	24						
006	6" - 150LB	Gate Valve	WCB	24						
007	8" - 150LB	Gate Valve	WCB	24						
008	8" - 150LB	Gate Valve	WCB	6						
009	10" - 150LB	Gate Valve	WCB	12						
010	10" - 300LB	Gate Valve	WCB	6						
011	10" - 150LB	Gate Valve	WCB	4						
012	12" - 150LB	Gate Valve	WCB	8	8	8	6			
013	14" - 150LB	Gate Valve	WCB	2	2					
014	16" - 150LB	Gate Valve	WCB	4	4					
015	6" - 300LB	Swing Check	WCB	4						
016	3" - 300LB	Gate Valve	WCB	12						
017	2" - 600LB	Gate Valve	WCB	6						
018	6" - 300LB	Swing Check	WCB	10						



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019	4" - 300LB	Gate Valve	WCB	10						
020	2" - 150LB	Globe	WCB	20	10					
021	6" - 150LB	Swing Check	WCB	4						

DD/40777/MB


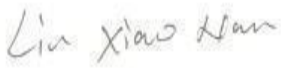
Item	Size	Type	Body Mtr.	Qty.	Raw castings checked	Machining completed	Assembly completed	Pressure test completed	Painting completed	Packing completed
001	3" - 600LB	Gate Valve	WCB	1						

TT/00073/JT

Item	Size	Type	Body Mtr.	Qty.	Raw castings checked	Machining completed	Assembly completed	Pressure test completed	Painting completed	Packing completed
001	2" - 150LB	Gate Valve	WCB	25						
002	2" - 150LB	Gate Valve	WCB	25						
003	3" - 150LB	Gate Valve	WCB	10						
004	6" - 150LB	Gate Valve	WCB	12						
005	4" - 300LB	Gate Valve	WCB	10						
006	4" - 600LB	Gate Valve	WCB	4						
007	2" - 150LB	Swing Check	WCB	10	10					
008	4" - 150LB	Swing Check	WCB	20						
009	8" - 150LB	Swing Check	WCB	8						
010	10" - 150LB	Swing Check	WCB	4						
011	6" - 300LB	Swing Check	WCB	2						
012	6" - 300LB	Swing Check	WCB	4						
013	2" - 150LB	Globe	WCB	5						

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014	8" - 150LB	Globe	WCB	2						
015	8" - 150LB	Gate Valve	WCB	24						
016	16" - 150LB	Gate Valve	WCB	2						
017	18" - 150LB	Gate Valve	WCB	2						

Inspected by:	Checked by:
Name: Feng Jiafei	Name: Vincent Liu
Signature: 	Signature: 
Date of issue: 2024-3-17	
Inspection centre: J-PECO Engineering Services CHINA	
Distribution: <input checked="" type="checkbox"/> CLIENT <input type="checkbox"/> MANUFACTURER <input checked="" type="checkbox"/> J-PECO CHINA	