

AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED

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AFTER REPAIR INSPECTION CERTIFICATE OF 9" DRILL COLLAR

Client Name:	DAQING DRILLING	Report No.:	QC-2024-04-DQ-37-003
Acceptance Criteria:	☒ API SPEC 7-2	Date Of Inspection:	29.MAY.2024
Work Location:	ABERDEEN WORKSHOP	Rig Name	DQ-37
Test Equipment & Consumeable Details			
WHITE CONTRAST WCP-2	Batch #: 220602 Manufacture: Magnaflux Exp Date: JUN,2025	TECHNICAL DETAILS	Wet Visible Continuous
BLACK INK 7HF	Batch#:220605 Manufacture: Magnaflux Exp Date: JULY.2025	COIL(1200 AMP-TURNS/IN	SC 22713 Cal.15.FEB.2024 Cal Due14.AUG.2024
FLUORESCENT 14HF	Batch #: 220306 Manufacture: Magnaflux Exp Date: March.2025	A.C HAND YOKE	201504053 Cal.15.FEB.2024 Cal Due14.AUG.2024
INTENSITY METER	SR#1608000134 CAL.Date Cal. 15.FEB.2024 Cal Due 14.AUG.2024	UV BLACK LIGHT	SR#1900084 Cal.15.FEB.2024 Cal Due14.AUG.2024
LEAD GAGE	SR#AH07KF0027 GAEMAKER LG-5003 Cal. 13.FEB.2024 Cal Due 12.AUG.2024	THREAD PROFILE GAGE	SR#21336 Cal. 13.FEB.2024 Cal Due 12.AUG.2024 SR#21335 Cal. 15.FEB.2024 Cal Due 14.AUG.2024
Magnetic Partical Concentration 7 HF	1.2 TO 2.4 ML/100 ML	WMPT Light Intensity	3500 Lux
Magnetic particle concentration flourcent 14 HF	0.1 TO 0.4 ML/100 ML	UV LIGHT INTENSITY:	3050 $\mu\text{w}/\text{cm}^2$
Magnetism Direction (Longitudinal)			
METHODOLOGY:	• Through Visual inspection • Dimensional 3 • MPI inspection with Ultraviolet light *Lead Gaiging, & Thread Profile Gauging.		
Connection:	7 5/8" FF Reg	Size:	9"

Serial No.	Visual Inspection			MPI			Dimensional 3 Inspection																
	Pin	Box	Body	Pin	Box	Body	Pin						Box						Body				
							OD (in)	ID (in)	SRG ² (in)	SRG ² (in)	Pin ² (in)	Bevel ² (in)	OD (in)	CB ² (in)	CB ² (in)	BB ² (in)	BB ² (in)	Bevel ² (in)	Pin Tong ² (in)	Box Tong ² (in)	EGR ² (in)	SGR ² (in)	Overall ² (in)
37-37	-	Acc	-	-	Acc	-	-	-	-	-	-	9	7 1/8	21/3 ₂	5 7/8	8 23/32	8 1/2	-	11 5/8	-	-	-	
57948-81	-	Acc	-	-	Acc	-	-	-	-	-	-	9	7 1/8	21/3 ₂	5 7/8	8 23/32	8 1/2	-	16 5/8	-	-	-	
948-71	-	Acc	-	-	Acc	-	-	-	-	-	-	9	7 1/8	21/3 ₂	5 7/8	8 23/32	8 1/2	-	15 3/8	-	-	-	
3736	-	Acc	-	-	Acc	-	-	-	-	-	-	9	7 1/8	21/3 ₂	5 7/8	8 23/32	8 1/2	-	17 1/8	-	-	-	
Conclusion:			■ 04 box connections of The above Mentioned 9” Drill Collar were found “Acceptable” from After Repair at time of Inspection ready to use.																				

Abbreviations

OD	Outside Diameter	ID	Inside Diameter	SRG	Stress Relief Groove	CB	Counter Bore	BB	Bore Back	FB	Float Bore
$\frac{\square}{\square}$	Diameter	$\frac{\square}{\square}$	Length	$\frac{\square}{\square}$	Width	$\frac{\square}{\square}$	Depth	NP.	Not Present	NA.	Not Applicable
EGR	Elevator Groove Recess	SGR	Slip Groove Recess	CR	Crack	B	Bent	PC	Premium Class	RF	Reface
GT	Galled Thread	TP	Thread Pitting	SP	Seal Pitting	TD	Thread Damage	SD	Seal Damage	M	Mashed
1	100 % Coating	2	99-71 % Coating	3	70-40 % Coating	4	Up to 40 %	5	Nil	WT	Wall Thickness
Colors Code:		White	No Defects	Red	Crack or Extreme	Blue	Damage	Green	Seal Damage	Yellow	ACFM

Inspector Name:		Review By					
Qualification:		Senior Inspector:	M.FAHAD	Supervisor:	WAQAS AWAN	Customer Name:	
Signature:						Customer Signature:	
Original - Client Files		Copy - Area Office	QC/FN/AF,REP/026	Rev.00	Dated 07 NOV 2021		

