

# AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED

Basra, North Rumaila, Quality Control Yard - Iraq  
Tel: +9647810009138 / +9647834964657

Email: [OP@qualitycontrol-iraq.com](mailto:OP@qualitycontrol-iraq.com) / [hany.akafi@qualitycontrol-iraq.com](mailto:hany.akafi@qualitycontrol-iraq.com)



## AFTER REPAIR INSPECTION CERTIFICATE OF 5 1/2" HWDP

<b>Client Name:</b>	<b>HILONG OIL SERVICE&amp;ENGINEERING CO,Ltd IRAQ BRANCH.</b>	<b>Report No.:</b>	<b>QC-24-AUG-HL-22-001</b>
<b>Acceptance Criteria:</b>	<input checked="" type="checkbox"/> <b>API SPEC 7-2</b>	<b>Date Of Inspection:</b>	<b>18.AUG.2024</b>
<b>Work Location:</b>	<b>ABERDEEN WORKSHOP</b>	<b>Rig Name</b>	<b>HL-22</b>
<b>Test Equipment &amp; Consumable Details</b>			
<b>WHITE CONTRAST WCP-2</b>	Batch #: 220602 Manufacture: Magnaflux Exp Date: JUN,2025	<b>TECHNICAL DETAILS</b>	<b>Wet Visible Continuous</b>
<b>BLACK INK 7HF</b>	Batch#.220605 Manufacture: Magnaflux Exp Date: JULY.2025	<b>COIL(1200 AMP-TURNS/IN</b>	<b>22713 Cal.25.JUL.2024 Cal Due24.FEB.2025</b>
<b>FLUORESCENT 14HF</b>	Batch #: 220306 Manufacture: Magnaflux Exp Date: March.2025	<b>A.C HAND YOKE</b>	<b>PY-10 Cal.25.JUL.2024 Cal Due24.FEB.2025</b>
<b>INTENSITY METER</b>	SR#1608000134 CAL.Date Cal. 25.JUL.2024 Cal Due 24.FEB.2025	<b>UV BLACK LIGHT</b>	<b>SR#1895313 Cal.25.JUL.2024 Cal Due24.FEB.2025</b>
<b>LEAD GAGE</b>	SR#AH07KF0026 GAEMAKER LG- Cal. 25.JUL.2024 Cal Due 24.FEB.2025	<b>THREAD PROFILE GAGE</b>	<b>SR#21336 Cal. Cal.25.JUL.2024 Cal Due24.FEB.2025 SR#21335 Cal. Cal.25.JUL.2024 Cal Due24.FEB.2025</b>
<b>Magnetic Partical Concentration 7 HF</b>	<b>1.2 TO 2.4 ML/100 ML</b>	<b>WMPT Light Intensity</b>	<b>3500 Lux</b>
<b>Magnetic particle concentration flourcent 14 HF</b>	<b>0.1 TO 0.4 ML/100 ML</b>	<b>UV LIGHT INTENSITY:</b>	<b>3050 μw/cm<sup>2</sup></b>
<b>Magnetism Direction (Longitudinal)</b>			
<b>METHODOLOGY:</b>	<ul style="list-style-type: none"> <li>• Through Visual inspection</li> <li>• Dimensional Inspection</li> <li>• MPI inspection with Ultraviolet lig</li> <li>*Lead Gaiging, &amp; Thread Profile Gaiging.</li> </ul>		
<b>Connection:</b>	<b>5 1/2"FH</b>	<b>Size:</b>	<b>5 1/2"</b>

Serial No.	Visual Inspection			Black Light		Dimensional 3 Inspection																
	Pin	Box	Body	Pin	Box	Pin						Box						Body				
						OD (in)	ID (in)	SRG DIA (in)	SRG (in)	Bevel (in)	pin (in)	OD (in)	CB (in)	CB (in)	BB (in)	BB (in)	Bevel (in)	Pin Tong (in)	Box Tong (in)	C.W Pad OD (in)	length (in)	
25624	Acc	-	-	Acc	-	7 1/4"	3 1/4"	5 8/32"	3/8"	6 1/4"	5"	-	-	-	-	-	-	-	20 15/16"	-	-	-
155624	Acc	-	-	Acc	-	7 1/4"	3 5/16"	5 8/32"	3/8"	6 1/4"	5"	-	-	-	-	-	-	-	18 1/8"	-	-	-
51355	Acc	-	-	Acc	-	7 1/4"	3 5/16"	5 8/32"	3/8"	6 1/4"	5"	-	-	-	-	-	-	-	17 1/8"	-	-	-
85624	Acc	-	-	Acc	-	7 1/4"	3 1/2"	5 8/32"	3/8"	6 1/4"	5"	-	-	-	-	-	-	-	16 7/8"	-	-	-
<b>Conclusion :</b>		<b>The Above Mentioned 5 1/2" Heavy Weight Drill Pipe Were Found Acceptable from Pin Connection After Repair at the time of Inspection, Ready to use.</b>																				

### Abbreviations :

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

<b>Inspector Name:</b>	<b>PAD SOHAN</b>	<b>Review By</b>			
<b>Qualification:</b>	<b>NDT LEVEL 1</b>	<b>Senior Inspector:</b>	<b>NAVEED HUSSAIN</b>	<b>Supervisor:</b>	<b>M.SARWAR</b>
<b>Signature:</b>					<b>Customer Name:</b>
					<b>Customer Signature:</b>

Original – Client Files

Copy - Area Office

QC/FN/DPI/NDT/006 Rev.00 DATED 07.NOV.2021

