

AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED

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AFTER REPAIR INSPECTION CERTIFICATE OF 5" HWDP

Client Name:	DAQING DRILLING	Report No.:	QC-2024-AUG-DQ-12-001
Acceptance Criteria:	☒ API SPEC 7-2	Date Of Inspection:	27.AUG.2024
Work Location:	ABERDEEN WORKSHOP	Rig Name	DQ-12
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	22713 Cal.25.JUL.2024 Cal Due24.FEB.2025
FLUORESCENT 14HF	Batch #: 220306 Manufacture: Magnaflux Exp Date: March,2025	A.C HAND YOKE	PY-10 Cal.25.JUL.2024 Cal Due24.FEB.2025
INTENSITY METER	SR#1608000134 CAL.Date Cal. 25.JUL.2024 Cal Due 24.FEB.2025	UV BLACK LIGHT	SR#1895313 Cal.25.JUL.2024 Cal Due24.FEB.2025
LEAD GAGE	SR#AH07KF0026 GAEMAKER LG- Cal. 25.JUL.2024 Cal Due 24.FEB.2025	THREAD PROFILE GAGE	SR#21336 Cal. Cal.25.JUL.2024 Cal Due24.FEB.2025 SR#21335 Cal. Cal.25.JUL.2024 Cal Due24.FEB.2025
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:	2950 $\mu\text{w}/\text{cm}^2$
Magnetism Direction (Longitudinal)			
METHODOLOGY:	- Through Visual inspection - Dimensional Inspection		
Connection:	NC-50	Size:	5"
- MPI inspection with Ultraviolet light *Lead Gaiging, & Thread Profile Gaiging.			

Serial No.	Visual Inspection			Black Light		Dimensional 3 Inspection															
	Pin	Box	Body	Pin	Box	Pin						Box						Body			
						OD (in)	ID (in)	SRG $\square$ (in)	SRG $\square$ (in)	Bevel $\square$ (in)	pin $\square$ (in)	OD (in)	CB $\square$ (in)	CB $\square$ (in)	BB $\square$ (in)	BB $\square$ (in)	Bevel $\square$ (in)	Pin Tong $\square$ (in)	Box Tong $\square$ (in)	C.W Pad OD(in)	length (in)
06000199	Acc	-	-	Acc	-	6 9/16"	3 1/16"	4 23/32"	3/4"	6 1/16"	4 7/16"	-	-	-	-	-	-	15 1/2"	-	-	-
2021	Acc	-	-	Acc	-	6 9/16"	3 1/16"	4 23/32"	1"	6 1/16"	4 7/16"	-	-	-	-	-	-	12 1/4"	-	-	-
06000231	Acc	-	-	Acc	-	6 9/16"	3 1/16"	4 23/32"	3/4"	6 1/16"	4 7/16"	-	-	-	-	-	-	15 7/16"	-	-	-
04000125	Acc	-	-	Acc	-	6 9/16"	3 1/16"	4 23/32"	1"	6 1/16"	4 7/16"	-	-	-	-	-	-	15 1/8"	-	-	-
006000020	Acc	-	-	Acc	-	6 9/16"	3 1/16"	4 23/32"	3/4"	6 1/16"	4 7/16"	-	-	-	-	-	-	15 1/16"	-	-	-
0400045	Acc	-	-	Acc	-	6 9/16"	3 1/16"	4 23/32"	3/4"	6 1/16"	4 7/16"	-	-	-	-	-	-	11 1/4"	-	-	-
06000914	Acc	-	-	Acc	-	6 9/16"	3 1/16"	4 23/32"	3/4"	6 1/16"	4 7/16"	-	-	-	-	-	-	11 7/16"	-	-	-
Conclusion :	The Above Mentioned 5" Heavy Weight Drill Pipe Were Found Acceptable from Pin Connection After Repair at the 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
$\square$	Diameter	$\square$	Length	$\square$	Width	$\square$	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 Damage.	Blue	Damage	Green	Seal Damage	Yellow	ACFM	

Inspector Name:		Review By					
Qualification:		Senior Inspector:	M.SARWAR	Supervisor:	NAVEED HUSSIN	Customer Name:	
Signature:						Customer Signature:	
Original – Client Files		Copy - Area Office	QC/FN/DPI/NDT/006	Rev.00	DATED 07.NOV.2021		

