

AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED

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AFTER REPAIR INSPECTION CERTIFICATE OF X-OVER#KZS-K16554

Client Name:	HILONG OIL SERVICE&ENGINEERING CO,Ltd IRAQ BRANCH.	Report No.:	HL-22-QC-24-11-RS-001
Acceptance Criteria:	<input checked="" type="checkbox"/> API SPEC 7-2	Date of Inspection:	24.NOV.2024
Work Location:	ABERDEEN WORKSHOP BASRA IRAQ	Rig No.:	HL-22
TEST EQUIPMENT & CONSUMABLE 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	3520 Lux
Magnetic particle concentration flourcent 14 HF	0.1 TO 0.4 ML/100 ML	UV LIGHT INTENSITY:	2950 μw/cm ²
Magnetism Direction (Longitudinal)			
METHODOLOGY:	• Through Visual inspection • Dimensional • MPI inspection with Ultraviolet light *Lead Gaiging, & Thread Profile Gaiging.		

Serial No.	Description	Connections		Inspection Results		Dimensional Inspection															
		Box		Body		Box					Box					Body					
		Box	Box	Box	Box	Body	OD(In)	CB φ(In)	CB δ(In)	BBD φ(In)	BBL λ(In)	Bevel φ(In)	OD(In)	CB φ(In)	CB δ(In)	BB φ(In)	BB λ(In)	Bevel φ(In)	Box Tong λ (in)	Overall λ (in)	Box Tong (In)
KZS-K16554	X-OVER	NC50	NC50	Acc.	Acc.	-	6 5/8"	5 5/16"	5/8"	-	-	6 5/16"	6 5/8"	5 5/16"	5/8"	-	-	6 5/16"	-	17 3/8"	-

Conclusion :

01 - The Above Mentioned X-OVER was found "Acceptable" From Box Side 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
φ	Diameter	λ	Length	σ	Width	δ	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	ACFM	Green	Field Repair	Yellow	Damage

Inspector Name:	RAO SOHAIL		Review By			
Qualification:	ASNT Level 3		Senior Inspector:	M.SARWAR	Supervisor:	AHMED MOHAMMED
Signature:			Customer Name:			
			Customer Signature:			
Original - Client Files Copy - Area Office QC/FN/AF,REP/026 Rev.00 Dated 01 AUG 2021						

